

PPM

PIPE PURGE MASTERS

DECEMBER 2022

PURGE BAG SYSTEMS





PURGE BAG SYSTEM

Sizes: 2 - 24" (50 - 610 mm)

Double inflatable pipe weld purging systems

Used for 90% of the traditional pipe weld purging applications to provide bright, shiny, oxide free weld roots. The PPM Purge Bag system is quick and easy to use, providing a very rapid weld purge. High quality materials are used in the production of these systems, guaranteeing perfect oxide-free weld roots in very little time.



4" Purge Bag system



The gas release valve is pre-set and sealed, so it requires no adjustment



A luminous strip allows the operator to locate and centre the Purge Bag system to the weld gap with ease

Due to the design of this system, the volume of gas used to purge is minimized, resulting in significant reduction of both time and inert gas consumption. Return on investment can be achieved in as little as just one or two welds. These robust systems can be used over and over again paying for themselves in very little time.

Features and advantages

- PPM's Purge Bag system dramatically reduces purging times, leading to significant savings
- **Typical purge times for 4" pipe = 1½ mins; 8" pipe = 4 mins; 12" pipe = 8 mins**
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate up to 20l a min.
- Gas pressure control ensures an even positive root bead with no notching
- Quick and easy to install, simplifying the process of inert gas purging
- Heat resistant up to 70°C continuously
- Use less inert gas. The volume of purge gas used is less than 2% of a conventional purge

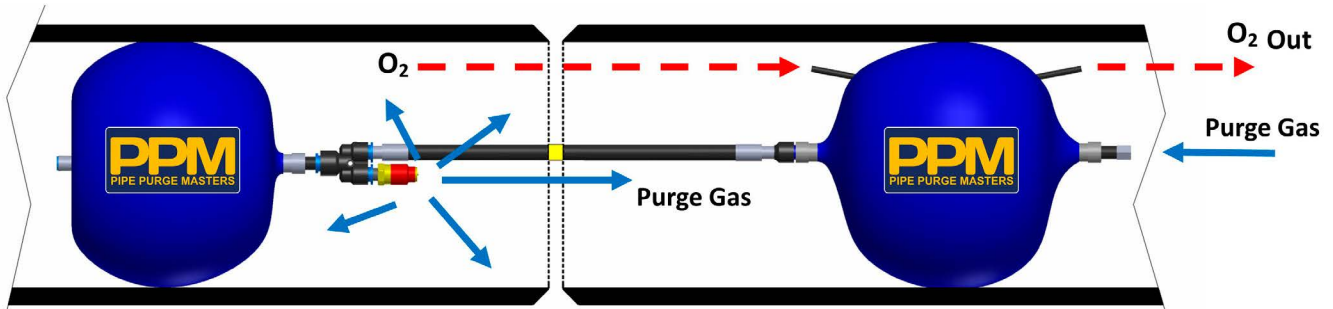


How it works

The Purge Bag system is designed around the principle of using 2 dams, that are connected by an armoured spinal tube, to create a seal either side of the weld. These dams are just far enough away from the weld not to be affected by heat, but close enough to the joint to provide the fastest weld purge time.

Once ready to start purging, the system is inserted into the bore of the pipe using the luminous strip to centre the system to the weld gap.

When the gas flow is started, the dams inflate and upon reaching the pre-set pressure, the valve releases the gas gently into the weld chamber, to purge the interspace without turbulence. The oxygen is removed from the weld chamber by the inert gas through the integral exhaust tubes in the bags, enabling the welder to produce an even oxidation free penetration weld bead. Used in conjunction with PPM's oxygen monitors, indicating when the required low level of oxygen has been reached, welding can then commence. Afterwards, the dams are deflated simply by disconnecting the purge gas feed and the system easily withdrawn. The design of this system requires only one gas connection for both dam inflation and weld purging.



Sizing and specification

PART NO	DESCRIPTION	NOMINAL PIPE SIZE		INTERNAL DIAMETER RANGE (I/D)		WEIGHT (LBS. / KG)	
PB02	2" Purge Bag system	50 mm	2"	1.49" - 2.37"	38 - 60 mm	1 lbs.	0.34 kg
PB03	3" Purge Bag system	75 mm	3"	2.17" - 3.53"	55 - 90 mm	1 lbs.	0.34 kg
PB04	4" Purge Bag system	100 mm	4"	3.51" - 4.51"	89 - 115 mm	1 lbs.	0.34 kg
PB05	5" Purge Bag system	125 mm	5"	4.14" - 5.50"	105 - 140 mm	1 lbs.	0.38 kg
PB06	6" Purge Bag system	150 mm	6"	5.32" - 6.68"	135 - 170 mm	1 lbs.	0.38 kg
PB07	7" Purge Bag system	175 mm	7"	6.30" - 7.66"	160 - 195 mm	2 lbs.	0.70 kg
PB08	8" Purge Bag system	200 mm	8"	7.09" - 8.45"	180 - 215 mm	2 lbs.	0.90 kg
PB09	9" Purge Bag system	225 mm	9"	8.08" - 9.43"	205 - 240 mm	2 lbs.	0.95 kg
PB10	10" Purge Bag system	250 mm	10"	9.26" - 10.61"	235 - 270 mm	2 lbs.	1.00 kg
PB11	11" Purge Bag system	275 mm	11"	10.03" - 11.41"	255 - 290 mm	2 lbs.	1.05 kg
PB12	12" Purge Bag system	300 mm	12"	11.03" - 12.39"	280 - 315 mm	2 lbs.	1.10 kg
We strongly recommended using our Rapid Purge™ system over 12"							
PB13	13" Purge Bag system	325 mm	13"	11.41" - 12.79"	290 - 325 mm	2 lbs.	1.20 kg
PB14	14" Purge Bag system	350 mm	14"	12.41" - 13.76"	315 - 350 mm	3 lbs.	1.30 kg
PB15	15" Purge Bag system	375 mm	15"	13.38" - 14.76"	340 - 375 mm	3 lbs.	1.50 kg
PB16	16" Purge Bag system	400 mm	16"	14.38" - 15.73"	365 - 400 mm	3 lbs.	1.70 kg
PB17	17" Purge Bag system	425 mm	17"	15.35" - 16.73"	390 - 425 mm	4 lbs.	1.75 kg
PB18	18" Purge Bag system	450 mm	18"	16.34" - 17.70"	415 - 450 mm	4 lbs.	1.80 kg
PB19	19" Purge Bag system	475 mm	19"	17.32" - 18.70"	440 - 475 mm	4 lbs.	1.85 kg
PB20	20" Purge Bag system	500 mm	20"	18.31" - 19.67"	465 - 500 mm	4 lbs.	1.90 kg
PB22	22" Purge Bag system	550 mm	22"	19.69" - 21.05"	500 - 535 mm	5 lbs.	2.20 kg
PB24	24" Purge Bag system	600 mm	24"	22.45" - 23.80"	570 - 605 mm	6 lbs.	2.50 kg

(Larger sizes and specials available upon request with 35 mm / 1.37" expansion range)

The Purge Bag come with fittings:
Outside USA = 21 KA series Male connector
Inside USA = 1/4" NPT Male connector



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