



# WATER SOLUBLE PURGE DAM & TAPE



Heavy Weight  
Water Soluble Paper

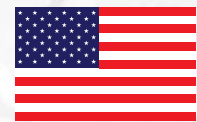


Light Weight  
Water Soluble Paper



Self Adhesive  
Water Soluble Tape

- Easy to use
- Dissolves in water or steam
- No residue or trace elements
- Non - Toxic and Non - corrosive
- Wide range of welding applications
- Saves time and money
- Available in several grades and sizes

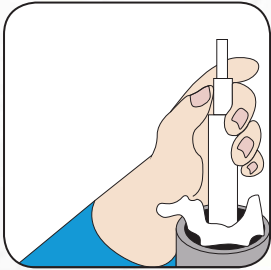


**Made in U.S.A.**

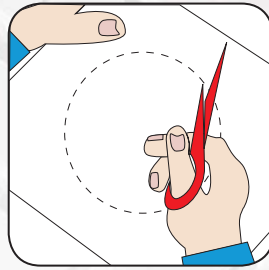
Part Number	Description
TM35-811S	Light Weight Water Soluble Paper 8.5" x 11" Sheet (21.6 cm x 27.9 cm)
TM35-814S	Light Weight Water Soluble Paper 8.5" x 14.5" Sheet (21.6 cm x 36.8 cm)
TM35-1722S	Light Weight Water Soluble Paper 17" x 22" Sheet (43.2 cm x 55.9 cm)
TM35-9165R	Light Weight Water Soluble Paper 9"x 165' Roll (22.9 cm x 5029.2 cm)
TM35-15165R	Light Weight Water Soluble Paper 15.5" x 165' Roll (39.4 cm x 5029.2 cm)
TM60-1522S	Heavy Weight Water Soluble Paper 15.5" x 22" Sheet (39.4 cm x 55.9 cm)
TM60-15165R	Heavy Weight Water Soluble Paper 15.5" x 165' Roll (39.4 cm x 5029.2 cm)
TM60-31165R	Heavy Weight Water Soluble Paper 31" x 165' Roll (78.7 cm x 5029.2 cm)
TM-2301T	Self Adhesive Water Soluble Paper 2" x 300' Roll (5.1 cm x 9144 cm) (1" core)
TM-1303T	Self Adhesive Water Soluble Paper 1" x 300' Roll (2.5 cm x 9144 cm) (3" core)



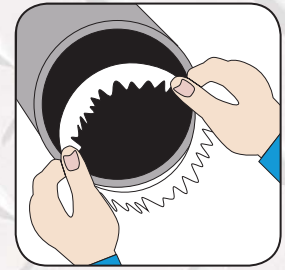
**INDEPENDENT WHOLESALE WELDING SUPPLY**  
Ph: 02 8834 2400 Email: [iwws@iwws.net](mailto:iwws@iwws.net) Website: [www.iwws.net](http://www.iwws.net)



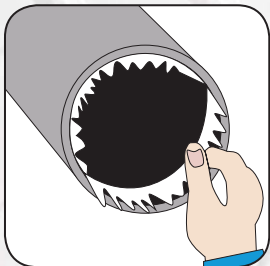
**1.** For small diameter pipes (less than 4" inner diameter) Simply position a wad of Dissolvo paper several inches down into each section to be joined.



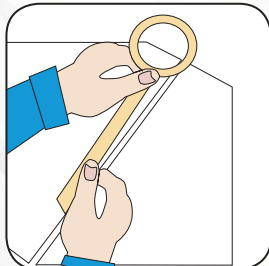
**2.** For larger diameter pipes (4" inner diameter & larger) Cut the paper onto a circle with a diameter several inches larger than the pipe ID. Example: for a 6" pipe, cut an 8" diameter paper circle.



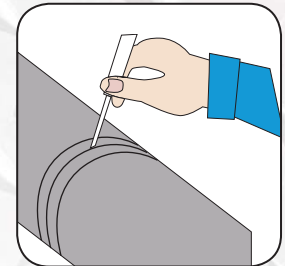
**3.** Trace or impress the pipe and inner diameter on the paper and fold on this line to form a 90° lip. Insert the dam into the pipe and with the lip towards the weld pipe.



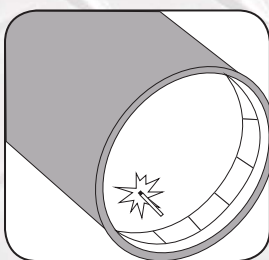
**4.** Peel the tape from the backing and tape dam in place.  
Optional: Punch a small hole in the dam to facilitate the evacuation of air when purging.



**5.** For pipe larger than 28" diameter, simply splice two or more sheets of Dissolvo paper together with Dissolvo tape and proceed as in steps 2, 3 & 4.



**6.** After the dams are in place, Argon may be introduced through the root gap with needle valve connected to the line.



**7.** If one end of the pipe is accessible, the purge gas may be introduced through a hole at the lower end of one dam. A vent hole should be made at the upper end of the other dam air and gases to escape.

Optional: Cover the open root joint on the outside of the pipe with tape to prevent gas leakage.

