

INFLATABLE PURGE SYSTEM

Especially insulated heat covered inflatable purge system for purging applications in pre-heated pipes can be supplied upon requested



- Made from fire-retardant “Flameshield” proban cotton for increased resistance to damage from scorching and burning.
- Armoured, robust connection hose.
- Bypass hose for additional gas inlet/exhaust.
- Reinforced stitching and crimping for improved tear-resistance.
- Strong eyelet pull loops.
- Reduces flow rate during hot passes to 5 to 10 lpm.
- Available for pipe diameters from 2” to 96”.
- Special hose barb connections available for easy connection to gas source.

Part No	Description
TMIPS002	50 mm Inflatable Purge Dam
TMIPS003	75 mm Inflatable Purge Dam
TMIPS004	100 mm Inflatable Purge Dam
TMIPS005	120 mm Inflatable Purge Dam
TMIPS006	150 mm Inflatable Purge Dam
TMIPS008	200 mm Inflatable Purge Dam
TMIPS010	250 mm Inflatable Purge Dam
TMIPS012	300 mm Inflatable Purge Dam

Part No	Description
TMIPS014	350 mm Inflatable Purge Dam
TMIPS016	400 mm Inflatable Purge Dam
TMIPS018	450 mm Inflatable Purge Dam
TMIPS020	500 mm Inflatable Purge Dam
TMIPS022	550 mm Inflatable Purge Dam
TMIPS024	600 mm Inflatable Purge Dam
TMIPS026	650 mm Inflatable Purge Dam
TMIPS028	700 mm Inflatable Purge Dam

Part No	Description
TMIPS030	750 mm Inflatable Purge Dam
TMIPS032	800 mm Inflatable Purge Dam
TMIPS034	850 mm Inflatable Purge Dam
TMIPS036	900 mm Inflatable Purge Dam
TMIPS040	1000 mm Inflatable Purge Dam
TMIPS048	1200 mm Inflatable Purge Dam
TMIPS052	1300 mm Inflatable Purge Dam

Option: No shadow x-ray clear hose

Part No	Description
TMPTFE1000	Non metal purge bag hose 1 m
TMPTFE500	Non metal purge bag hose 1/2 m



OPERATION OF INFLATABLE PURGE SYSTEM

Step 1

The deflated Purge System can be easily placed in the pipe by using the pull tags.

Step 2

Once the two dams of the Purge System are in position on either side of the weld joint, there is a glowtape in the middle of the dams to advise "in position".

The dams are inflated by opening the argon source to 5-10 lpm flow rate and will quickly seal the pipe.

The pressure will open the purge valve and purging of the space between the pipe and the purge dam begins once dams are inflated.

During purging, the air between the Purge System and the pipe is pushed through the exhausts of the purge system away from the vicinity of the weld until the oxygen level is low enough to start welding, as per the welding procedure.

Use a purge gas monitor to advise oxygen levels.

The Purge System requires a constant flow rate of inert shielding gas of up to 3-5l/min to maintain a positive purge pressure.

Step 3

After completion and the weld has cooled below oxidation temperature the Purge System can be easily deflated by interrupting the argon gas supply. Once deflated remove from the pipe.

Note: For best welding results, use inflatable weld purge together with a weld gas analyser (TMWGA001 or TMSCGA) and aluminium tape to seal the prep areas while purging to reduce gas usage.

Applications

The Purge System can be used whenever welding stainless steel and reactive metal pipework. Also suitable for purging autogenous weld fit ups as well as scheduled pipework that requires a gap between two bevelled pipe ends.

Standard Purge Bags: 100°C

Heat Resistant Purge Bags: 350°C continuous - 500°C short term