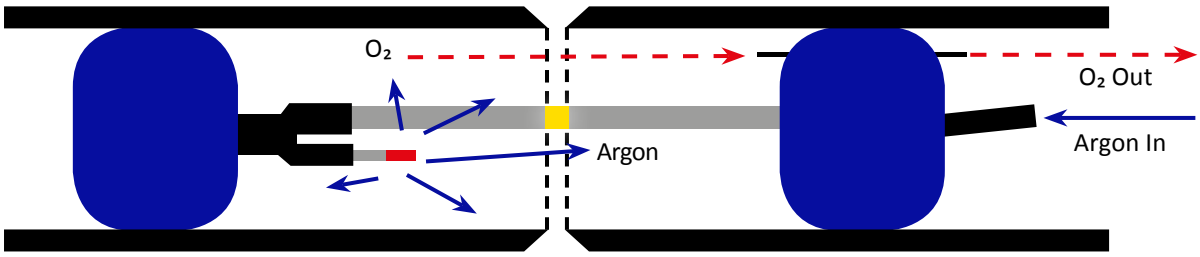
How it works

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

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 through the integral exhaust tubes in the bags. Used in conjunction with TAG's Oxygen Monitors to indicate when the required low level of oxygen has been reached, welding can then commence, with the inert gas enabling the welder to produce an even oxidation free penetration weld bead. Afterwards, the dams are deflated simply by disconnecting the purge gas feed and the system easily withdrawn. The design of these systems means that only one gas connection is required for both dam inflation and weld purging.



Sizing and Specification

PART NO.	NOMINAL PIPE SIZE (MM / INCH)		WEIGHT (KG)	INTERNAL DIAMETER RANGE (MM)
PB02	50mm	2"	0.34kg	44 - 57mm
PB03	75mm	3"	0.34kg	58 - 84mm
PB04	100mm	4"	0.34kg	80 - 110mm
PB05	125mm	5"	0.38kg	103 - 135mm
PB06	150mm	6"	0.38kg	124 - 162mm
PB08	200mm	8"	0.90kg	175 - 213mm
PB10	250mm	10"	1.0kg	230 - 265mm
PB12	300mm	12"	1.1kg	265 - 305mm
PB14	350mm	14"	1.3kg	330 - 355mm
PB16	400mm	16"	1.7kg	380 - 405mm
PB18	450mm	18"	1.8kg	430 - 455mm
PB20	500mm	20"	1.9kg	485 - 510mm
PB22	550mm	22"	2.2kg	535 - 560mm
PB24	600mm	24"	2.5kg	585 - 610mm
PBS401	30 meter argon feed hose assembly for The TAG Pipe Purge Bag System to dedicated and regulated gas supply. Fitted at one end with a ⅜" female gas regulator connector and at the other end with a fitting to attach to the inflation hose.			

**** Larger sizes and specials available on request, however Rapid Purge on pages 32 & 33 strongly recommended over 12"***

Rapid Purge recommended above 12"