



CLAMPS, STANDS PURGING AND TOOLS

- Pipe Beveling Machines
- Pipe Cutting Machines
- Grinding Machines
- Pipe Stands and Clamps
- Pipe Purging
- Plate Bevellers
- Heat Exchanger, Boiler & Bundle
- Plus so much more.....



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Gold Bridge Clamps

Pipe welding clamp 1-14" o/d

- Quick and easy to use
- Combines accuracy with safety
- Instant centering
- A quality product at low cost
- Forged steel construction for maximum strength
- Wing bolts with stainless steel bearings

OPTIONAL ACCESSORIES

Stainless Steel Shoes can be fitted quickly to the clamps. This makes the contact points of the clamp stainless, thus eliminating contamination of the pipe.



STAINLESS STEEL SHOES & SCREWS

Part No.	Pipe Diameter Imperial	Pipe Diameter Metric	Weight KG/LBS
GBC3	1"-3"	20-90 mm	1.4 / 3
GBC5	2"-5"	50-150 mm	3 / 7
GBC7	4"-7"	90-190 mm	3.3 / 7.5
GBC9	5"-9"	125-225 mm	7 / 15.5
GBC14	10"-14"	225-370 mm	9 / 20

Part No.	Pipe Clamp Size
GBC3SSK	1"-3"
GBC5SSK	2"-5"
GBC7SSK	4"-7"
GBC9SSK	5"-9"
GBC14SSK	10"-14"

GBC Clamps must not be used as a lifting device.
Fittings must be independently supported at all times.

Black Bridge Clamps

Pipe alignment clamps 1" - 12"

- Quick and easy to use
- Combines accuracy with safety
- Instant centering
- A quality product at low cost
- Stainless steel clamping feet & wing bolt bearings



Black Bridge Clamps can be used for the welding of all kinds of materials.

Adjusting screws have stainless steel bearings, thus reducing the risk of carbon contamination and corrosion.

The welding of pipe to pipe and pipe to fittings is easily performed with BB Clamps.

Part No.	Pipe Diameter Imperial	Pipe Diameter Metric	Weight KG/LBS
BBC2	1"-2"	25-65 mm	1.5 / 3.50
BBC6	2"-6"	50-168 mm	3.75 / 8.0
BBC12	5"-12"	127-325 mm	7.50 / 15.0

GBC Clamps must not be used as a lifting device.
Fittings must be independently supported at all times.

Chain Clamps

Double Jackscrew clamps for aligning & reforming pipes

All clamps include:

- Length of chain required for the pipe range
- Double jackscrew jackbars listed for the pipe range
- Main block
- Fine adjustment
- Fitting alignment device
- Jackscrew wrench
- Parts and operating manual
- Metal Storage box
- Hi-Lo gauge



Features and advantages:

- Alignment - can align all pipe schedules accurately.
- Reforming - jackscrews enable the elimination of 'Hi-Lo' points either side of the weld joint. Can reform up to schedule 40 pipes.
- Adaptable - one chain clamp covers the range of 8 cage clamps.
- No Tack Jackbars - joints can be fully welded without removing the clamp.
- Versatile - elbows, tees and other fittings can be accurately aligned using the Fitting Alignment Device.
- Quality - jackbars are cast from high quality steel alloys.
- Additional jackbars can be added if extra pressure is required.
- Jackscrews - Jackbars have two jackscrews with independently pivoting pads to compensate for uneven surfaces.
- Stainless Steel - available in both carbon and stainless steel versions.

Part No.	Pipe Diameter Range " /mm	No. Of Jackbars	Reforms Pipe to Schedule	Aligns Pipe to Schedule	Shipping WT KGS
SCC12	1-12	4	40	80	12
SCC12SS	1-12	4	40	80	12
SCC20	4-20	7	40	80	33
SCC20SS	4-20	7	40	80	33
SCC36	10-36	8	40	80	67
SCC36SS	10-36	8	40	80	67
SCC54	10-54	13	40	80	82
SCC54SS	10-54	13	40	80	82

GBC Chain Clamps must not be used as a lifting device.
Fittings must be independently supported at all times.

Double Chain Clamps

Ultra heavy duty double chain reforming alignment clamp

Features and advantages:

- **Precision Alignment** – The double jackbars, spaced around the outside diameter of the pipe, provide accurate alignment and reforming of the internal or external diameters of both pipes within 0.5mm.
- **Extremely Tough** – Reforms pipes on both sides of the weld joint to Sch80, and elbows, tees and other fittings.
- **Adaptable** – The Chain Clamp can be used to support, align, and reform elbow, tees and other fittings that a cage clamp cannot cope with. One Chain Clamp covers the range of eight (8) cage clamps.
- **Extra Heavy Duty Independent Jackbars** – Enable the operator to form the pipe to the required shape. Each Jackscrew has independently pivoting feet to cope with uneven surfaces.
- **Versatile** – Elbows, tees and other fittings can be aligned with the Fitting Alignment Device.



Double Chain Clamp includes:

- Length of chain required for the pipe range
- Extra heavy-duty jackbars listed for the pipe range
- Number of Main blocks listed for the pipe range
- Two (2) fine adjustments
- Fitting alignment device
(larger clamps supplied with come-a-long)

- Jackscrew wrench
- Operating instructions
- Hi-Lo gauge

Optional:

- Torque wrench
- Carbon or stainless steel spacing screws (optional)
- Additional jackbar

Part No.	Pipe Diameter Range "/>mm	No. Of Jackbars	Number of Main Blocks	Shipping WT KGS
DCC36	10-36 / 254-914	9	1	100 / 220
DCC36SS	10-36 / 254-914	9	1	100 / 220
DCC48	10-48 / 254-1219	12	1	126 / 278
DCC48SS	10-48 / 254-1219	12	1	126 / 278
DCC54	10-54 / 254-1372	14	1	136 / 300
DCC54SS	10-54 / 254-1372	14	1	136 / 300
DCC60	10-60 / 254-1524	16	1	149 / 328
DCC60SS	10-60 / 254-1524	16	1	149 / 328
DCC72	10-72 / 254-1829	20	1	176 / 387
DCC72SS	10-72 / 254-1829	20	1	176 / 387

Double chain clamps must not be used as a lifting device.

When using the Fitting Alignment Device fittings must be independently supported.

Pincer and Internal Alignment Clamps

Pincer Clamp

For quick and accurate alignment of pipes of equal or differing diameters on a common centre line. Automatic diameter compensation. All parts stay easily accessible for welding.

Part No.	Clamping Range (mm)	Weight KG/LBS
PC70	10-70	2.1 / 5
PC140	40-140	5.9 / 135
PC330	75-330	26 / 57.5



Mini Clamp

For quick and accurate alignment and clamping of flanges, nozzles, etc to pipes and cylindrical tanks. Available in stainless steel.

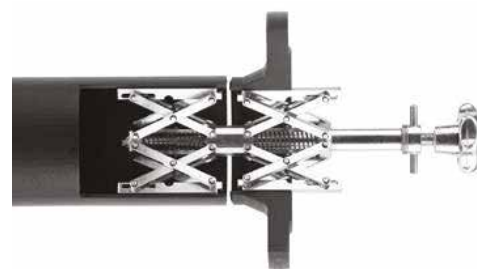
Part No.	Clamping Range (mm)	Weight KG/LBS
MC19	15-19	0.20 / 0.7
MC20	16-20	0.20 / 0.7
MC25	19-25	0.25 / 0.9
MC32	24-32	0.50 / 1
MC40	31-40	0.50 / 1
MC52	38-52	1.25 / 3
MC64	51-64	1.25 / 3



FTP Clamp SS READY

This model has two independent expanding clamps, allowing coaxial alignment of two hollow cylindrical components of different diameters. The bottom expanding clamp is inserted and clamped in the pipe by means of the knob. Then the other part (e.g. a flange) is placed over the top expanding clamp and clamped by means of the hand-bar.

Part No.	Clamping Range (mm)	Weight KG/LBS
FTP140	40-140	5.9 / 135
FTP220	85-220	20 / 44.0
FTP350	75-330	26 / 57.5
FTP520	180-520	27 / 60
FTP940	400-900	39 / 86



FTE Clamp SS READY

This model with two independent clamps is used for clamping flanges of all kinds and similar parts to elbows and pipe-bends of various diameters. The lower expanding clamp has strong gripping feet which insert into the bend and are tightened by means of the knob. The top expanding clamp is tightened by means of the handbar in the flange.

Part No.	Clamping Range (mm)	Weight KG/LBS
FTE115	54-115	1 / 3
FTE195	89-195	3.3 / 7
FTE315	120-315	9.5 / 21
FTE520	180-520	23.1 / 51



External Line Up Clamps

Cage Clamps

Cage or 'Tipton' Clamps are a cost effective method to align a single size of pipe. Three versions are available; manual, ratchet and hydraulic. These are available in two styles, either "Tack" or "No Tack". The tack type has straight cross bars and is removed from the pipe before welding. The more popular no tack model has arched cross bars to permit a 90% circumferential weld without removing the clamp.

Manual Cage Clamps - Range : 2-60"

- Will not back off while weld is being made.
- Simple and easy to use.
- Stainless steel versions available

Part No.	Pipe Size	Weight KG
CCM4	4"	8.00
CCM6	6"	14.00
CCM8	8"	15.00
CCM10	10"	23.00
CCM12	12"	24.00
CCM14	14"	30.00
SMALLER & LARGER SIZES AVAILABLE		



Ratchet Cage Clamps - Range : 6-60"

The ratchet type External Line-up Clamp is very strong and accurate, but is also lightweight with either 'standard' flat cross bars or 'no tack' arched cross bars.

- Precision Acme Threads ensure great strength and ease of operation.
- Will not back off while weld is being made.
- Mechanism is enclosed to eliminate dirt or mud.
- Standard 1" ratchet handle fits all sizes.

Part No.	Pipe Size	Weight KG
CCR6	6"	21.00
CCR8	8"	23.00
CCR10	10"	25.00
CCR12	12"	29.00
CCR14	14"	31.00
CCR16	16"	46.00
SMALLER & LARGER SIZES AVAILABLE		



Hydraulic Cage Clamps - Range : 12-80"

- Hydraulic jack capacity 10-12 ton.
- Specials upon request.
- Stainless steel versions available

Part No.	Pipe Size	Weight KG
CCH20	20"	61.00
CCH24	24"	66.00
CCH28	28"	69.00
CCH30	30"	74.00
CCH32	32"	78.00
CCH34	34"	83.00
SMALLER & LARGER SIZES AVAILABLE		



PJ3 Pipe Jacks

- 1,000kg / 2,205lbs load capacity
- Choice of fixed base or folding leg base
- Folding legs allow for easy storage and transportation
- Comprehensive range of head types
- Adjustable in height from 27"-48" (71cm-122cm)
- Independently load tested



STD V-Head options

Base Units



Part No.	Stand Type	Weight KG/LBS	Pipe Size
PJ3FXB	Fixed leg	7.0 / 15.4	up to 12"
PJ3FLB	Folding leg	7.0 / 15.4	up to 12"

Vee Head



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
PJ3V	1,000	3.4/7	up to 12"

Steel Wheels



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
SWK3	1,000/2,205	3.4/7	1"-12"
SWK3SS	1,000/2,205	3.4/7	1"-12"

Pipe Roller Head - Steel Wheels



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
SWK350	1,000/2,205	4.9/11	1"-12"
SWK350SS	1,000/2,205	3.4/7	1"-12"

Nylon Wheels



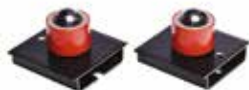
Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
NWK3	450/992	2/5	1"-12"

Pipe Roller Head - Nylon Wheels



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
NWK350	450/990	4.9/11	1"-12"

Ball Transfers



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
BTK3	600/1320	2.5/6	1"-12"
BTK3SS	600/1320	2.5/6	1"-12"

Stainless Steel - Exclusive to GBC UK



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
SSC3	1,000/2,205	1.0/2	1"-12"

Roller Bar Head



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
RBH	1,000/2,205	4.25/9	1/8"-10"

Pipe Hold Down Kit



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
HDK	N/A	7/16	1"-12" *

* up to 24" with chain extension

PJ3 Pipe Jacks

Large V-Head options

- 1,000kg / 2,205lbs load capacity
- Choice of fixed base or folding leg base
- Folding legs allow for easy storage and transportation
- Comprehensive range of head types
- Adjustable in height from 27"-48" (71cm-122cm)
- Independently load tested



Large Vee Head



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
LVH	1,000	7.6/17	up to 24"

Ball Transfers

Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
BTK4	600/1,320	2.3/5	1"-24"
BTK4SS	600/1,320	2.3/5	1"-24"



Steel Wheels



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
SWK4	1,000	3/6	1"-24"
SWK4SS	1,000	3/6	1"-24"

Stainless Steel Sleeves



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
SSC4	1,000/2,205	1/2	1"-24"

Nylon Wheels



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
NWK4	450/990	1.8/4	1"-24"

Hold Down Device



Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
HDK	N/A	7/16	1"-12" *

* up to 24" with chain extension

PJQ 'Quattro' Stands

Heavy duty pipe stands for large diameter and heavy wall pipe

Features and advantages

- Weight certified to 2500kg
- For pipe up to 36" diameter
- Variety of head options
- Optional castor wheel for pipe transportation
- Height adjustable
- Suitable for carbon or stainless steel

The Quattro Heavy Duty Pipe Stands are the ideal solution for heavy duty pipe handling, in the workshop or for site applications.

The Large Vee Head, heavy duty base and variety of head options make the Quattro the most durable and versatile pipe stand on the market.

The Quattro stand can be used as a simple jack stand, supplied as standard with levelling pads to accommodate uneven working surfaces. Weight load tested to 2500kgs per stand, the Quattro stands can also be supplied with lockable castor wheels so pipes of up to 36" diameter can be moved around a workshop or site.



Transport pipe around the site or workshop with ease

Quattro Stand Head Options

Heavy duty pipe stands for large diameter and heavy wall pipe



Base Unit
(complete with levelling pads)

Part No.	Load capacity KG	Weight KG	Pipe Size
PJQB	2,500	10	N/A

Large Vee Head



Part No.	Load capacity KG	Weight KG	Pipe Size
LVH	2,500	7.5	1"-36"



Wheel Kit Options

Part No.	Load capacity KG	Weight KG	Material
SWK4	2,000	10.5	Steel
SWK4SS	2,000	10.5	Stainless
NWK4	450	8.5	Nylon



Ball Transfer Kits

Part No.	Load capacity KG	Weight KG	Pipe Size
BTK4	600	8.5	1"-36"
BTK4SS	600	8.5	1"-36"



Hold Down Device

Part No.	Load capacity KG	Weight KG	Pipe Size
HDK	N/A	7/16	1"-12" *

* up to 24" with chain extension

Stainless Steel Sleeves



Part No.	Load capacity KG	Weight KG	Pipe Size
SSC4	2500	8	1"-36"

Roller Wheel Kit

Part No.	Load capacity KG	Weight KG	Pipe Size
RWK4	2000	11	N/A



PJ4 Multi Stand

Height adjustable, multi function, pipe roller stand

Features and advantages

- Height adjustable with two fine adjusters
- Maximum weight load: 2000 kgs
- Maximum pipe diameter: 48"
- 'Bolt On' head unit can be utilised as a floor or bench unit
- Exclusive to GBC UK!



Bolt On Wheel Carrier options



PJ4 Base Unit

Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
PJ4B	2,000/4400	20/45	up to 48"



Bolt On Wheel Carrier

Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
RPS4	2,000/4400	3.4/7	up to 48"



Wheel Kit Options

Part No.	Load capacity KG	Weight KG	Material
SWK3	1,000	3.4/7	Steel
SWK3SS	1,000	3.4/7	Stainless
NWK3	450	2/5	Nylon

Please double the weight load rating when using 2 sets of wheel heads



Ball Transfers

Part No.	Load capacity KG	Weight KG	Material
BTK3	600	2.5	Steel
BTK3SS*	600	2.5	Stainless

Large V Head options



Large V Head Options

Part No.	Load capacity KG	Weight KG	Pipe Size
LVH	2,000	7.6	1"-36"
SSC4	2,000	1	1"-36"
HDK	N/A	7/16	1"-12" *

* up to 24" with chain extension



Large V Head Wheel Kit Options

Part No.	Load capacity KG	Weight KG	Material
SWK4	2,000	10.5	Steel
SWK4SS	2,000	10.5	Stainless
NWK4	450	8.5	Nylon

PJ4 Multi Stand

Height adjustable, multi function, pipe roller stand



Small V Head options

PJ4 Base Unit

Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
PJ3V	1,000/2,205	3.4/7	up to 12"

Stainless Steel Sleeves

Part No.	Load capacity KG/LBS	Weight KG/LBS	Pipe Size
SSC3	1,000/2,205	1.0/2	1"-12"

Wheel Kit Options



Part No.	Load capacity KG	Weight KG	Pipe Size
SWK3	1,000	3.4/7	Steel
SWK3SS	1,000	3.4/7	Stainless
NWK3	450	2/5	Nylon

Please double the weight load rating when using 2 sets of wheel heads

Ball Transfers



Part No.	Load capacity KG	Weight KG	Pipe Size
BTK3	600	2.5	Steel
BTK3SS	600	2.5	Stainless

Roller Bar Head Options

Roller Bar Head



Part No.	Load capacity KG	Weight KG	Material
RBH3	500	4.25	Steel
RBH3SS	500	4.25	Stainless
RBH3N	500	4.25	Nylon

Please double the weight load rating when using 2 sets of wheel heads

Pipe Roller Head Options

Pipe Roller Head



Part No.	Load capacity KG	Weight KG	Pipe Size
SWK350	1,000/2,205	4.9/11	4"-12"
SWK350SS	1,000/2,205	3.4/7	4"-12"
NWK350	450/990	4.9/11	4"-12"

PJ1 'UNO' Pipe Stand

The PJ1 Stand is a basic single tubed pipe stand, simple to use and easy to setup

A favourite for low level work in all fab shops.
Heights from 7" (18cm) to 28" (72cm).

Optional roller heads from the PJ3 series can also be fitted to the Vee Head of the PJ1 Stand to suit varying applications.

Part No.	Min/Max height inches	Min/Max height metric	Weight Load
PJ1-1	7"-10.25"	175-260mm	450kgs
PJ1-2	10"-15.5"	250-395mm	450kgs
PJ1-3	15.5"-22.5"	395-570mm	450kgs
PJ1-4	21.5"-28"	545-715mm	450kgs



RPS4 Pipe Roller Stand

The RPS4 is a versatile floor or bench mountable pipe roller stand for pipe up to 48" diameter.

Features and advantages

- Choice of steel, stainless steel or nylon wheels
- Wheels are interchangeable and can be utilised on PJ3 & PJ4 stands
- Wheels are independently adjustable
- The RPS4 also bolts onto the PJ4 base unit to make a 4 leg, trestle style pipe roller stand.

Part No.	Description	Load capacity KG
RPS4B	Bolt on wheel carrier	2,000
SWK3	Steel wheel kit	1,000
SWK3SS	Stainless steel wheel kit	1,000
NWK3	Nylon wheel kit	450
BTK3	Ball transfer kit	600
BTK3SS	Stainless steel ball transfer kit	600



RPS6 Heavy Duty Roller Stands

These heavy duty stands are designed to be either floor or bench mounted. Available with 4 head styles to suit pipes from 4" to 48"

Part No.	Head Style	Load capacity KG/LBS	Weight KG/LBS
RPS6B	Base unit only	N/A	5.8/13
SWK6	Pair steel wheel heads	2,200/4,850	3.4/7
NWK6	Pair nylon wheel heads	450/990	2.2/5
BTK6	Pair ball transfer heads	650/990	3.8/8
FTK6N	Pair feed through roller - Nylon	450/990	3.5/6
FTK6S	Pair feed through roller - Steel	2,200/4,850	3.8/8



RPS8 Feed Through Roller Stands

Features and advantages

- Free standing or In-trench options
- Differing trench widths accommodated
- Multi positional
- Rubber coated rollers minimise pipe damage
- Three sizes available to suit pipes from 63mm to 1200mm

Part No.	Pipe Diameter Range	Load capacity KG	Weight KG
RPS8-1	63 - 355mm	200	5
RPS8-2	250 - 630mm	1000	12
RPS8-3	500 -1200mm	1000	13
RPS8-4	63 - 355mm	200	6
RPS8-5	1500mm	2000	90



Typical application

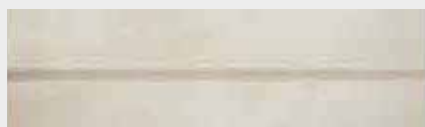
PIPE PURGING



Principles of Purging

Why Purge?

The primary reason for the wide use of stainless steels is their general corrosion resistance. To ensure the operational safety of weldments of high-alloy steels under corrosive conditions, it is further necessary to maintain the special characteristics of these materials when producing weld joints. The exposure to heat and oxygen during the welding process results in the formation of temper colours on stainless steels and other materials (e.g. titanium). These are bands of various colours around the penetration bead and adjacent parent material that can severely reduce the corrosion resistance of high-alloy materials, and usually must be avoided or removed.



Argon Purge 12ppm Vol. O₂ Content



Argon Purge 60ppm Vol. O₂ Content



Argon Purge 70ppm Vol. O₂ Content



Argon Purge 200ppm Vol. O₂ Content



Argon Purge 250ppm Vol. O₂ Content



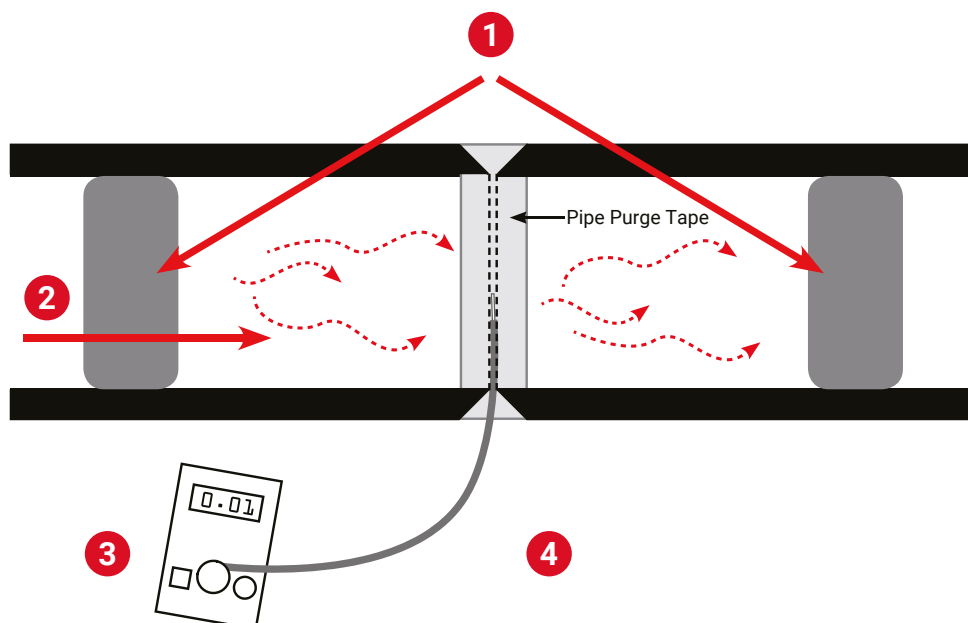
Argon Purge 500ppm Vol. O₂ Content

Weld Quality

The effective welding of stainless steel, titanium and other exotic materials for the nuclear, petrochemical, pharmaceutical, semi-conductor, aerospace and food industries requires the proper tools to create a perfect weld environment. Purging equipment and its use has a major impact on preventing oxidation and improving final weld quality. The basic principles of purging can be seen below. GBC UK supply a comprehensive range of systems to create the correct welding environment, whatever the application.

How it works

- 1 Create a seal (dam) either side of the weld and close off the weld gap with Pipe Purge Tape to create the weld chamber.
- 2 Fill the chamber with inert gas (such as argon or nitrogen) to expel oxygen from the chamber.
- 3 Use a weld purge monitor to recognise when the required level of oxygen has been met.
- 4 Welding can then be carried out, guaranteeing no oxidation or discolouration of the weld.



Twin Bag Purge Systems

Sizes: 2" - 48" (50mm - 1200mm)

GBC Twin Bag Purging Systems consist of two inflatable bags connected by a spinal tube and a pressure valve. The system is positioned by viewing the luminous tape through the weld joint gap. E-Z ZONE TAPE is used to seal the weld gap and purge gas flow can commence at up to 20 Ltr/min. The bags inflate, a seal is created either side of the weld joint and the pressure valve releases gas into the weld chamber. By using a GBC Oxygen Monitor to constantly measure the oxygen content in the weld chamber the welder will know when to reduce the gas flow and commence welding.

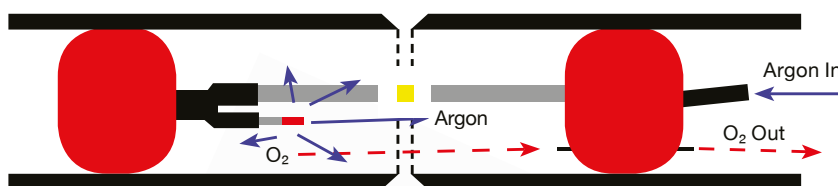
The system is left in position post welding until the weld joint temperature drops to below oxidation levels, then the purge gas feed is disconnected, the bags deflate and the system can be withdrawn.

* For more critical applications higher spec versions are available with non-scratch spinal tubes and a gas feed system to replace pressure release valves.

Part Nos & Sizing		
Part No.	Size inches	Expansion Range
TP02	2	44-57 mm
TP03	3	58-84 mm
TP04	4	80-110 mm
TP05	5	103-135 mm
TP06	6	124-162 mm
TP08	8	175-213 mm
TP10	10	230-265 mm
TP12	12	265-305 mm

* Larger sizes available upon request

How it works



Inflated Twin Purge Bag



The Gas Release Valve is pre-set and sealed, no adjustment required



Luminous strip aids the operator to centre system to the weld gap

Speedy Purge Systems

Sizes: 8 to 80" (190 to 2044mm)

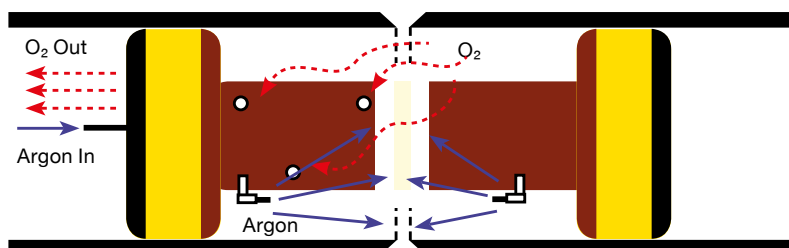
The GBC Speedy Purge System for pipe and vessel purging comprises a tandem inflatable dam system connected by an umbilical hose and collar to reduce the volume being purged. A gas exhaust valve is installed between the primary and secondary dam, along with an auxillary Argon purge line. The system is positioned by viewing the luminous tape through the weld joint gap. E-Z ZONE TAPE is used to seal the weld gap and purge gas flow can commence at up to 20 Ltr/min. The bags inflate, a seal is created either side of the weld joint and the pressure valve releases gas into the weld chamber. By using a GBC Oxygen Monitor to constantly measure the oxygen content in the weld chamber the welder will know when to reduce the gas flow and commence welding.

The system is left in position post welding until the weld joint temperature drops to below oxidation levels, then the purge gas feed is disconnected, the bags deflate and the system can be withdrawn.



Speedy Purge used to weld a stainless steel elbow.

How it works



Part Nos & Sizing

Part No.	Expansion Range	Weight kg
SP08	190 - 215 mm	1.4
SP10	242 - 267 mm	1.7
SP12	291 - 316 mm	2.1
SP14	318 - 343 mm	2.5
SP16	369 - 394 mm	2.7
SP18	420 - 445 mm	3.0
SP20	471 - 496 mm	3.4
SP22	553 - 577 mm	3.6
SP24	572 - 597 mm	3.8
SP26	620 - 645 mm	4.5
SP28	671 - 696 mm	5.5
SP30	722 - 747 mm	6.0
SP32	772 - 797 mm	8.0
SP36	874 - 899 mm	9.1
SP40	990 - 1015 mm	9.9
SP42	1023 - 1048 mm	13.2
SP44	1125 - 1150 mm	13.7
SP48	1175 - 1200 mm	15.0
SP54	1359 - 1384 mm	18.0
SP60	1512 - 1537 mm	20.0
SP72	1816 - 1841 mm	28.0
SP80	2019 - 2044 mm	30.0

Speedy Purge Heat Resistant Systems

Sizes: 3 to 80" (63 to 2044mm)

The GBC Twin Purge Bag & Speedy Purge Systems are both available as heat resistant versions. Designed for use when high temperatures are encountered in the welding process, such as pre & post-heating. They are heat resistant up to 350C for up to 24 hours and 500C for short periods.

Mirroring the features of the standard range of inflatable purging systems, the heat resistant range comes with a luminous positioning band for rapid centering and set up. These systems can be in place throughout the pre-heating, welding and postheat treatment cycles, allowing the weld to be purged continuously for up to 24 hours if necessary.

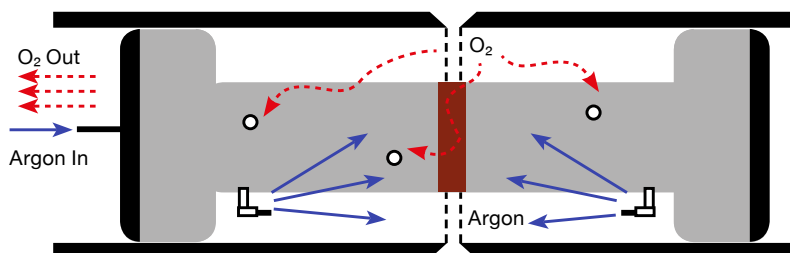


Twin purge heat resistant bags



Speedy purge heat resistant bags

How it works



Part Nos & Sizing

Part No.	Expansion Range	Weight kg
TP03/HR	63 - 75 mm	1.1
TP04/HR	92 - 100 mm	1.2
TP05/HR	113 - 125 mm	1.25
TP06/HR	138 - 150 mm	1.3
TP07/HR	163 - 175 mm	1.4
SP08/HR	190 - 215 mm	1.4
SP10/HR	242 - 267 mm	1.7
SP12/HR	291 - 316 mm	2.1
SP14/HR	318 - 343 mm	2.5
SP16/HR	369 - 394 mm	2.7
SP18/HR	420 - 445 mm	3.0
SP20/HR	471 - 496 mm	3.4
SP22/HR	553 - 577 mm	3.6
SP24/HR	572 - 597 mm	3.8
SP26/HR	620 - 645 mm	4.5
SP28/HR	671 - 696 mm	5.5
SP30/HR	722 - 747 mm	6.0
SP32/HR	772 - 797 mm	8.0
SP36/HR	874 - 899 mm	9.1
SP40/HR	990 - 1015 mm	9.9
SP42/HR	1023 - 1048 mm	13.2
SP44/HR	1125 - 1150 mm	13.7
SP48/HR	1175 - 1200 mm	15.0
SP54/HR	1359 - 1384 mm	18.0
SP60/HR	1512 - 1537 mm	20.0
SP72/HR	1816 - 1841 mm	28.0
SP80/HR	2019 - 2044 mm	30.0

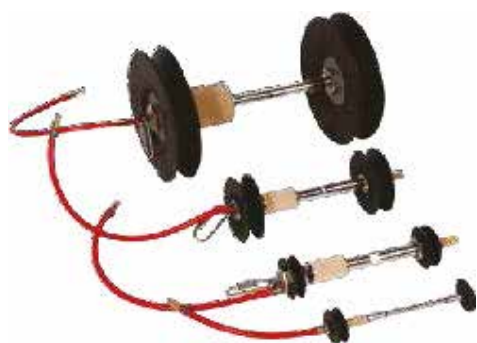
K Series Double Seal System

Sizes: ¾ to 12" (16 to 320mm)

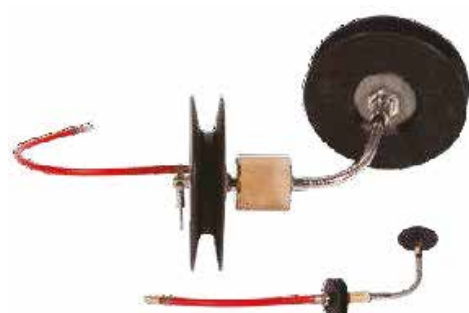
The inlet and outlets have twin sealing discs joined by a flexible or rigid connector. Purging gas is diffused into the weld chamber, air exits through the secondary twin disc unit. The even flow of gas reduces turbulence and the risk of oxygen in the welding chamber.

Features and advantages

- Typical purge times of less than 2 minutes
- High quality silicon sealing discs
- Guaranteed gas tight seal
- UV and temperature resistant up to 330°C
- Suitable for purging pipes, elbows and fittings
- Can be used as gas fingers and pipe stoppers
- Double Seal Systems increase productivity and reduce labour costs

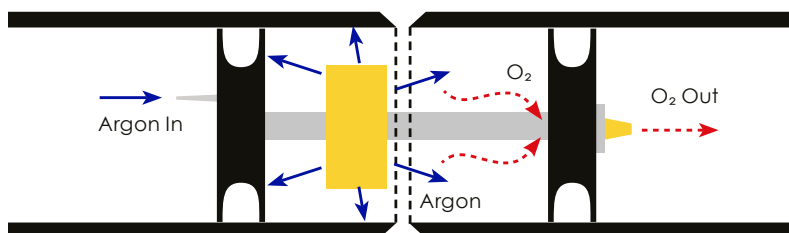


K series double seal systems



The K series double seal system with flexible connectors for working round bends

How it works



K Series Double Seal Systems are available individually or in kits

Part Nos & Sizing

Part No.	Pipe I/D Range (mm)	Connector Options	Connector Lengths (mm)
KDS16-19	16 - 19mm	Flex	100mm
KDS19-24	19 - 24mm	Flex	100mm
KDS24-29	24 - 29mm	Flex	100mm
KDS29-34	29 - 34mm	Flex	100mm
KDS34-38	34 - 38mm	Flex	100mm
KDS38-43	38 - 43mm	Flexible and Rigid	120/60mm
KDS43-48	43 - 48mm	Flexible and Rigid	120/60mm
KDS47-53	47 - 53mm	Flexible and Rigid	120/60mm
KDS52-58	52 - 58mm	Flexible and Rigid	120/60mm
KDS64-72	64 - 72mm	Flexible and Rigid	120/60mm
KDS78-86	78 - 86mm	Flexible and Rigid	120/60mm
KDS90-101	90 - 101mm	Flexible and Rigid	150/100mm
KDS100-112	100 - 112mm	Flexible and Rigid	150/100mm
KDS120-130	120 - 130mm	Flexible and Rigid	150/100mm
KDS124-138	124 - 138mm	Flexible and Rigid	150/100mm
KDS144-155	144 - 155mm	Flexible and Rigid	150/100mm
KDS150-165	150 - 165mm	Flexible and Rigid	150/100mm
KDS197-206	197 - 206mm	Flexible and Rigid	150/100mm
KDS209-220	209 - 220mm	Flexible and Rigid	150/100mm
KDS246-257	246 - 257mm	Flexible and Rigid	150/100mm
KDS260-280	260 - 280mm	Flexible and Rigid	150/100mm
KDS290-320	290 - 320mm	Flexible and Rigid	150/100mm
KDSK16-165	16 - 165mm	Complete Kit	120/60 150/100mm
KDSK16-220	16 - 220mm	Complete Kit	120/60 150/100mm
KDSK16-320	16 - 320mm	Complete Kit	120/60 150/100mm

K Series Gas Cylinders

Sizes: 8 to 40" (200 to 1000mm)

Large diameter silicon seal purging systems

The K Series Gas Cylinder system has been designed to reduce purge times and increase productivity when welding larger diameter pipes by localising the purge area to the weld root.

K Series Gas Cylinders are available for pipes from 200 to 705mm diameter. Two heat resistant silicon seals (300C up to one hour) create a greatly reduced weld chamber. Purge times are consequently reduced to around 1.5 to 2.5 minutes for all pipe sizes.

K Series Gas cylinders have 'pull through' systems to enable easy removal from straight pipes or round bends.

Features and advantages

- Minimal gas usage, the purge area is localised to the weld root
- Typical purge times of 1½ to 2½ mins
- Strong and robust
- Lightweight aluminium construction
- Heat Resistant to 330°C



The K series gas cylinder



The K series gas cylinder

Part Nos & Sizing

Part No.	Expansion Range
KPC - 1	330 - 360mm i/d
KPC - 2	380 - 410mm i/d
KPC - 3	420 - 450mm i/d
KPC - 4	470 - 505mm i/d
KPC - 5	570 - 605mm i/d
KPC - 6	625 - 660mm i/d
KPC - 7	670 - 705mm i/d

* Larger sizes available upon request

Water Soluble Purging Products

EZ Purge®



EZ Purge® is a pre-formed, self-adhesive, water soluble purge dam that enables welders to save time on weld preparation as well as improve project timeliness. Since EZ Purge® is preformed; there is no need to measure, cut or construct a purge dam. Setup and installation time is completed in minutes, making EZ Purge® the most efficient and economical purge dam available.

Part No.	Dimensions inches/mm	Case Qty
EZP-2	2" / 51mm	192
EZP-3	3" / 76mm	192
EZP-4	4" / 102mm	48
EZP-5	5" / 128mm	48
EZP-6	6" / 152mm	48
EZP-8	8" / 203mm	48
EZP-10	10" / 254mm	48
EZP-12	12" / 305mm	48
EZP-14	14" / 356mm	24
EZP-16	16" / 406mm	24
EZP-18	18" / 457mm	24
EZP-20	20" / 508mm	24
EZP-22	22" / 559mm	24
EZP-24	24" / 610mm	24
EZP-26	26" / 660mm	24
EZP-28	28" / 711mm	24
EZP-30	30" / 765mm	24
EZP-32	32" / 813mm	24
EZP-36	36" / 918mm	24

SoluGap Weld Spacers Rings

Provide the 1/16" (1.6 mm) minimum gap required by ANSI 31.1, Section III, ASME, US & Navy and Military Codes.

SoluGap® Water Soluble Socket Weld Spacer Rings are made of EPA Approved Aquasol® Water Soluble Board. Dissolves completely and rapidly in most liquids. Unique tabs secure placement regardless of orientation. Compatible with any metal.



Part No.	Pipe Size	Packaging
SGP-0.5	½" / 20 mm	50 pcs/bag
SGP-0.75	¾" / 25mm	50 pcs/bag
SGP-1.0	1" / 32mm	50 pcs/bag
SGP-1.25	1¼" / 40mm	50 pcs/bag
SGP-1.50	1½" / 50mm	50 pcs/bag
SGP-1.75	1¾" / 57mm	50 pcs/bag
SGP-2.0	2" / 63mm	50 pcs/bag
SGP-2.5	2½" / 73mm	50 pcs/bag

Water soluble cone purge dams



WS Purge Dams are preformed water soluble purge dams. These preformed dams are size specific and each cone can be used on all wall thicknesses and pipe schedules. Each pack includes 2 pcs of 'Fixing Tape' and the required length of water soluble tape. They will completely dissolve without any risk of residue. Available in all sizes from 2" to 36". Sold individually.

Water Soluble Purging Products

LiquiFilm®

LiquiFilm® is a water soluble plastic film used as a purge gas barrier during TIG welding. Highly flexible and transparent. Place 8"-12" from the weld joint on each side after applying water soluble adhesive to pipe. Brick format and adhesive sold separately. Kit format includes film wound on core plus two 250 ml bottles.



Part No.	Dimensions	Case Qty
AWSF-1/20RG Kit	39x66" / 1x20m	12
AWSF-1/20B Brick	39x66" / 1x20m	12
AWSG-500 Adhesive	16oz	24
AWSG-250 Adhesive	8oz	48

Water Soluble Paper

Aquasol® Water Soluble Paper is made of sodium carboxy methyl, a cellulose and wooden pulp that dissolves rapidly and completely in most liquids including water. Can be used to dam argon or helium gases during tungsten inert gas (TIG) welding of steel or aluminum pipes.

Part No.	Type	Dimensions	Case Qty
ASW-35/S-11RW	Sheet	8½" x 11" / 22cm x 28cm	500
AWSF-1/20B Brick	Sheet	8½" x 14" / 22cm x 36cm	500
AWSG-500 Adhesive	Sheet	17" x 22" / 43cm x 56cm	500
AWSG-250 Adhesive	Sheet	15½" x 22" / 39cm x 56cm	250
AWSG-250 Adhesive	Roll	15½" x 165' / 39cm x 50m	4
AWSG-250 Adhesive	Roll	9" x 165' / 23cm x 50m	4
AWSG-250 Adhesive	Roll	20½" x 165' / 52cm x 50m	4
AWSG-250 Adhesive	Roll	15½" x 165' / 39cm x 50m	4
AWSG-250 Adhesive	Roll	31" x 165' / 79 cm x 50 m	4



Environmentally friendly and non-toxic.
Aquasol® Paper can be formed into any size purge dam when used in conjunction with water soluble tape.

Purging Tape Products

EZ Zone® Tape

EZ Zone® Tape is a purge gas retaining tape used to seal the root gap between pipes to trap argon gas. Composed of two adhesive sections separated by an adhesive-free center zone. The adhesive portion of the tape never comes in contact with the pipe as it is welded; creating a clean, contaminant-free weld. Halogen and chlorofluorocarbon free.



Part No.	Dimensions	Adhesive Free Zone	Case Qty
EZ-ZT 2.5	2.5" x 75' / 64mm x 23m	1" / 25mm	18
EZ-ZT 4.0	4.0" x 75' / 102mm x 23m	2" / 51mm	12

EZ Tape®

EZ Tape® is a traditional aluminium tape that can be used for sealing the root gap while purging and sealing pipe ends for transport. Conventional uses include; sealing ducts for heating, air conditioning and refrigeration; and acting as a vapour barrier. EZ tape is a high temperature, halogen-free and conforms to irregular surfaces.

Part No.	Dimensions	Case Qty
EZ-T 2.0	2" x 75' / 51 mm x 23 m	24



Fiback®

Fiback® fiberglass backing tape is a heat resistant aluminum tape with a woven fiberglass center strip, designed to eliminate or reduce the need for back purging and post weld grinding. Available in 200 AMP & 600 AMP formats.

Part No.	Dimensions	Case Qty
200 AMP		
AFBT-2.0-200	2.0" x 41' / 51mm x 12.5m	5
AFBT-4.0-200	4.0" x 41' / 102mm x 12.5m	5
600 AMP		
AFBT-2.5	2.5" x 41' / 64mm x 12.5m	5
AFBT-4.0	4.0" x 41' / 102mm x 12.5m	5



Aquasol® Water Soluble Tape

Aquasol® Water Soluble Tape is a pressure sensitive water soluble tape recommended to hold purge dams in position, and when needed to splice two or more pieces of Aquasol paper together. Sold in rolls.

Part No.	Type	Dimensions	Case Qty
ASWT-1	Roll	1" x 300' / 2.5cm x 92m	24
ASWT-2	Roll	2" x 300' / 5.0cm x 92m	12



Expanding Pipe Stoppers

Sizes: Up to 72" (1828mm)

Expandable test plugs for purging and general pipe blocking Pipe stoppers, or drain plugs as they are sometimes known, are used to temporarily seal the end of a pipe or opening for many different testing applications. Pipe stoppers are mainly used to seal off from water, gases and foreign objects in newly laid pipes, or pipework systems that are under repair.

GBC's range of Pipe stoppers are available in a number of different styles to suit many applications for pipe sizes from 1/2" to 72". Special Pipestoppers are also available for pressure testing.

How it works

A central spindle/shaft on which two plates are fitted with a natural rubber tyre (ring) between them, a wing nut on the shaft moving the two plates together compressing the tyre and making the seal in the pipe. These stoppers can also be supplied with a hollow shaft version for screwing on standard hose connections or for using fixed or free nipple caps.

Expandable Pipe Stoppers are available in three different types.

Nylon Plugs

Nylon plugs are the standard 'Drain Plugs' for testing leak tightness of foul water lines at the time of installation. Furthermore, the range of sizes make these plugs ideal for a number of other applications in the water and gas industries as well as applications in all other industries where pipes are used or where there are holes to be blocked.

Aluminium Plugs

To complement the range of nylon expanding plugs, we offer all sizes of aluminium plugs. These are provided in sizes from 1.5" upwards and are suitable for more arduous duties such as immersion in chemicals and/or higher temperatures.

Steel Plugs

GBC also offer a range of Steel plugs from 2" to 72" in diameter. These plugs are typically suitable for more arduous duties such as long immersion in water and use at higher temperatures or for contact with acidic or alkaline environments for which the Nylon and Aluminium plugs may be unsuitable.



Steel, aluminium and nylon expanding stoppers



Aluminium expanding stoppers available in various sizes



Aluminium and Steel expanding pipe stoppers

All plugs conform to British standards BS8005 for low pressure testing and sealing of pipes.

Expanding Pipe Stoppers

Part No.	Pipe Size Internal Nominal Diameter		Will Fit Pipes With Internal Diameter		Minimum Insertion Into Pipe	Overall Length	Diameter of Waterway	Maximum Allowable Back Pressure	Approx. Weight
	METRIC	Imperial	Minimum	Maximum					
NYLON EXPANDING PIPE STOPPERS									
NS12	12mm	½	12mm	16mm			solid	100p.s.i.	0.01kg
NS18	18mm	¾	18mm	24mm			solid	100p.s.i.	0.01kg
NS25	25mm	1	23mm	32mm			solid	100p.s.i.	0.02kg
NS31	31mm	1¼	31mm	39mm			solid	70p.s.i.	0.04kg
NS38	38mm	1½	37mm	54mm			solid	60p.s.i.	0.05kg
NS12TB	12mm	½	12mm	16mm			M8	100p.s.i.	0.01kg
NS18TB	18mm	¾	18mm	26mm			M8	100p.s.i.	0.01kg
NS25TB	25mm	1	25mm	32mm			M8	100p.s.i.	0.02kg
NS31TB	31mm	1¼	31mm	39mm			M8	70p.s.i.	0.04kg
NS38TB	38mm	1½	38mm	42mm			M8	60p.s.i.	0.05kg
NS50	50mm	2	48mm	62mm			½	15p.s.i.	0.05kg
NS63	63mm	2½	65mm	77mm			½	10p.s.i.	0.10kg
NS75	75mm	3	74mm	86mm			½	10p.s.i.	0.10kg
NS88	88mm	3½	82mm	96mm			½	10p.s.i.	0.10kg
NS100	100mm	4	95mm	105mm			½	5p.s.i.	0.15kg
NS115	115mm	4½	114mm	124mm			½	5p.s.i.	0.2kg
NS125	125mm	5	117mm	127mm			½	5p.s.i.	0.2kg
NS150	150mm	6	146mm	155mm			½	5p.s.i.	0.25kg
ALUMINIUM EXPANDING PIPE STOPPERS									
AS1.5	40mm	1½	38mm	50mm	45mm	94mm	½	30p.s.i.	0.17kg
AS2	50mm	2	49mm	62mm	43mm	90mm	½	30p.s.i.	0.22kg
AS2.5	65mm	2½	62mm	77mm	43mm	92mm	½	30p.s.i.	0.27kg
AS3	75mm	3	73mm	89mm	43mm	94mm	½	20p.s.i.	0.31kg
AS3.5	90mm	3½	84mm	103mm	53mm	96mm	½	15p.s.i.	0.36kg
AS4	100mm	4	94mm	110mm	47mm	94mm	½	10p.s.i.	0.36kg
AS4.5	114mm	4½	112mm	130mm	56mm	140mm	½	10p.s.i.	0.47kg
AS5	125mm	5	125mm	142mm	60mm	95mm	½	10p.s.i.	0.79kg
AS6	150mm	6	146mm	168mm	48mm	96mm	½	10p.s.i.	0.70kg
AS7	175mm	7	175mm	200mm	64mm	100mm	1	7p.s.i.	1.92kg
AS8	200mm	8	193mm	220mm	64mm	100mm	1	7p.s.i.	1.59kg
AS9	225mm	9	220mm	240mm	64mm	170mm	1	7p.s.i.	2.06kg
AS10	250mm	10	245mm	270mm	73mm	178mm	1	7p.s.i.	2.52kg
AS11	275mm	11	274mm	328mm	100mm	200mm	1	7p.s.i.	3.45kg
AS12	300mm	12	295mm	325mm	77mm	200mm	1	7p.s.i.	3.42kg
AS13	325mm	13	325mm	360mm	120mm	230mm	1	5p.s.i.	4.75kg
AS14	350mm	14	350mm	385mm	110mm	215mm	1	5p.s.i.	6.95kg
AS15	375mm	15	370mm	410mm	110mm	225mm	1	5p.s.i.	5.35kg
AS16	400mm	16	390mm	435mm	110mm	225mm	1	5p.s.i.	5.9kg
AS18	450mm	18	445mm	495mm	110mm	225mm	2	5p.s.i.	8.75kg
AS20	500mm	20	495mm	550mm	145mm	255mm	2	5p.s.i.	11.3kg
AS21	525mm	21	520mm	575mm	145mm	255mm	2	3p.s.i.	11.8kg
AS24	600mm	24	595mm	650mm	145mm	255mm	2	3p.s.i.	15.85kg
STEEL EXPANDING PIPE STOPPERS									
SS1.5	40mm	1½	37mm	50mm	31mm	81.5mm	½	30p.s.i.	0.16kg
SS2	50mm	2	50mm	61mm	32.7mm	82.8mm	½	30p.s.i.	0.18kg
SS2.5	65mm	2½	51mm	75mm	33.2mm	80.5mm	½	30p.s.i.	0.26kg
SS3	75mm	3	73mm	85mm	34mm	80.5mm	½	20p.s.i.	0.28kg
SS3.5	89mm	3½	84mm	100mm	41mm	81mm	½	15p.s.i.	0.36kg
SS4	100mm	4	94mm	108mm	37.5mm	83.3mm	½	10p.s.i.	0.41kg
SS4.5	114mm	4½	110mm	125mm	40mm	83.3mm	½	10p.s.i.	0.58kg
SS5	125mm	5	124mm	139mm	37mm	83.3mm	½	10p.s.i.	0.60kg
SS6	150mm	6	145mm	160mm	39.7mm	83.3mm	½	10p.s.i.	0.75kg
SS7	175mm	7	175mm	200mm	46mm	130mm	1	7p.s.i.	1.56kg
SS8	200mm	8	195mm	215mm	37mm	130mm	1	7p.s.i.	1.47kg
SS9	225mm	9	210mm	230mm	58mm	150mm	1	7p.s.i.	1.93kg
SS10	250mm	10	245mm	260mm	55mm	150mm	1	7p.s.i.	2.55kg
SS12	300mm	12	296mm	320mm	85mm	150mm	1	7p.s.i.	3.72kg
SS14	350mm	14	340mm	385mm	85mm	210mm	1	5p.s.i.	6.54kg
SS15	375mm	15	370mm	415mm	100mm	210mm	1	5p.s.i.	7.00kg
SS16	400mm	16	390mm	430mm	95mm	210mm	1	5p.s.i.	8.45kg
SS18	450mm	18	448mm	495mm	100mm	210mm	1	5p.s.i.	10.6kg
SS20	500mm	20	495mm	550mm	145mm	255mm	2	3p.s.i.	11.3kg
SS21	525mm	21	520mm	575mm	145mm	255mm	2	3p.s.i.	11.5kg
SS24	600mm	24	595mm	650mm	145mm	255mm	2	3p.s.i.	15.85kg

Inflatable Pipe Stoppers

Sizes: 2 to 80" (50 to 2035 mm)

GBC Ltd offer a range of shapes and sizes of inflatable stoppers, suitable for all applications. Made from a natural rubber bladder covered in waterproof polyurethane coated nylon to prevent friction and static electricity build up.

Types of Pipe Stopper

Cylindrical

These are generally used for blocking pipes where access is restricted.

Spherical

These stoppers have less contact area than cylindrical stoppers, and are most suited to applications where access is further limited. Due to its shape the spherical inflatable stopper can be used at any angel.

Square / rectangular

These stoppers have a variety of applications, including in air conditioning ducting and venting.

Doughnut

These stoppers require minimal space and are perfectly suited to larger diameter pipes as there is less inflation required.

Sausage

The design of this type gives more contact area between the stopper and the pipe wall enabling these stoppers to hold back more pressure.

Heat resistant

These stoppers are made from a specially designed kevlar and nomex mix material to withstand temperatures up to 350°C for applications involving higher temperatures such as pre heating.

Each inflatable stopper comes with an inflation hose fitted with a schrader valve enabling inflation with a standard airline, bicycle or foot pump.

GBC Industrial Tools inflatable stoppers are supplied as standard with no through tube. Through tubes can be supplied when the stoppers are required for weld purging applications.

When deflated, the inflatable stoppers can be inserted and withdrawn with ease.



Inflatable Stopper Size	Min ID MM	Max ID MM
2" (50mm)	45	55
3" (75mm)	70	80
4" (100mm)	95	105
5" (125mm)	120	130
6" (150mm)	145	155
7" (175mm)	170	180
8" (200mm)	195	205
9" (225mm)	220	230
10" (250mm)	245	255
11" (275mm)	270	280
12" (300mm)	295	305
13" (325mm)	320	330
14" (350mm)	345	355
15" (375mm)	370	380
16" (400mm)	395	405
17" (425mm)	420	430
18" (450mm)	445	455
19" (475mm)	470	480
20" (500mm)	495	505
21" (525mm)	520	530
22" (550mm)	545	555
23" (575mm)	570	580
24" (600mm)	595	605
26" (650mm)	645	655
27" (675mm)	670	680
28" (700mm)	695	705
30" (750mm)	745	755
32" (800mm)	795	805
34" (850mm)	845	855
36" (900mm)	895	905
39" (1000mm)	995	1005
44" (1100mm)	1095	1105
48" (1200mm)	1195	1205
51" (1300mm)	1295	1305
55" (1400mm)	1395	1405
60" (1500mm)	1495	1505
63" (1600mm)	1595	1605
67" (1700mm)	1695	1705
71" (1800mm)	1795	1805
75" (1900mm)	1895	1905
79" (2000mm)	1995	2005
80" (2035mm)	2030	2040

* Larger sizes available upon request

WELD PURGE MONITORS



The GBC UK range of weld purge monitor systems are designed to accurately measure the level of oxygen within the weld chamber – essential for high quality welding of stainless steel and exotic materials.

From the entry level MasterPurge 100 to the top of the range MasterPurge Pro, GBC UK offers a weld purge monitor for every application.



Purge Monitors

MasterPurge 100

Handheld Weld Purge Monitor

The MasterPurge 100 is our easy to use entry level weld purge monitor.

It comes complete and ready to use straight from the carrycase. It is handheld, portable and ideal for the pipefitter's toolbox. Instructions are permanently on display inside the carrycase lid and the large 4 digit display is easy to view.

Its measuring range of oxygen in atmosphere is 0.01% to 20.9% and it accurately measures the concentration of oxygen to 0.1%.

Saves time and improves weld quality when welding stainless steel & Duplex pipework.



Digital display



Step by step instructions inside the carrycase lid.



Hand held/portable

Self calibrating
Manufactured in the UK

Package includes:

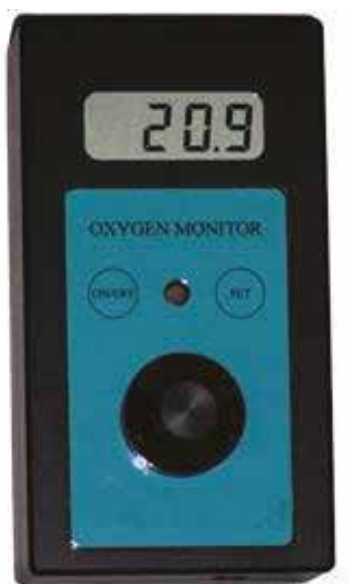
- Oxygen Monitor
- Hose
- Flow adaptor
- Stainless steel probe
- Aspirator bulb
- Carrycase
- Operating instructions

Technical Data:

Measuring range:	20.9% to 0.01%
Sensor response:	T90 < 15 secs
Operating Temp:	-10 to 40 degrees C
Power source:	P3 9 volt battery
Warranty:	Sensor 12 months
Dimensions:	Monitor: 150mm x 80mm x 55mm Case: 270mm x 230mm x 55mm

Purge Monitors

MasterPurge 1000P



Features:

- Push Button re-calibration for oxygen cell drift
- Built in audible alarm to warn of purge loss - variable alarm level
- Milled from solid aluminium case - fully RFI & EMI shielded
- Resolution - 0.1 %
- Accuracy - $\pm 1\%$ F.S.
- Hand bulb pump with sampling tubes and stainless steel capillary
- Re-chargeable batteries (charger included)
- No zero calibration required
- Two year oxygen cell life
- Simple and economical oxygen cell replacement

Technical Data:

Sensor:	Electrolytic, partial pressure type Working life - 2 years
Alarm:	Piezo buzzer - 80dba @ 30 cms
Batteries:	<ul style="list-style-type: none"> • 900mAh 6v NiCad pack • Time between charges - approx. 3 weeks • Charge time - 14 hours 900mAh 6v NiCad pack
Measuring range:	0-25% oxygen in Argon, Helium, Argon/Hydrogen mixes, etc
Response time:	Less than 20 seconds to 0.1%
Dimensions (L x W x H):	148mm x 80mm x 45mm
Weight:	600gms

Purge Monitors

MasterPurge 5

The new MasterPurge 5 oxygen analyzer is an innovative, reasonably priced weld purge monitor.

The durable, wear-proof zirconium sensor measures oxygen concentration down to 5ppm. High quality built-in components and charging management make this device the market leader in its sector.

It is lightweight (447g), handheld and easy to use. The pump and the heating of the sensor are activated by strong lateral shaking.

Automatic shutdown after 10 minutes of inactivity preserves battery and sensor capacity.



Technical Data:

Electrical voltage supply:	<ul style="list-style-type: none"> Input: 100 – 240 VAC (50/60 Hz) Output: 12 VDC, 1000 mA
Weight:	447 g (without suitcase)
Dimensions (L x W x H):	145 mm x 85 mm x 48 mm
Range:	1000 - 5ppm

Features:

- 1000 ppm - 5 ppm measuring range
- Coloured 1" OLED-display
- Power supply 110 VAC-240 VAC
- Internal Lithium Ion battery with 3,7 VDC, 4.300 mAh
- A green measurement value on the OLED display means "approved".
- Diffusion resistant FPM measurement hose
- Charging cable for car cigarette lighter available
- Display screen rotates when you turn the device due to position sensor
- Measuring up to 4 hours
- Ready to work in ca. 10 seconds
- Integrated, free programmable signal-horn. The analyzer can be programmed on the PC or Android mobile-phone with the optional Bluetooth adapter.



High quality storage case

Purge Monitors

MasterPurge Pro2 mobile

The keypad is a very robust snap dome film. Stable plastic plates are installed between the polycarbonate and the conductor-film. This allows the operator a save pressure, also with heavy welders or working-gloves. By pressing the keys, he gets a not overhearing confirmation signal.

Furthermore a practicable software supports the operator with several information (5-fold signal tone before readiness to measure, signal tones as alert - no welding readiness).



Features:

- Temperature regulated zirconium sensor
- Graphics compatible display (4 background colours)
- Plug-in power supply 110 VAC-240 VAC
- Internal akku with 7 VDC, 2750 mAh
- Integrated, free programmable horn
- Easy operated software
- Operator guidance in several languages
- Diffusion-proof special- FPM- measuring hose
- Charging cable for car-cigarette lighter available
- Measuring-data storable (Premium version)
- PC software for documentation
- Various surfaces for documentation or connection of external orbital welding equipment (Orbitec, AMI, ...)



Graphics compatible display (4 background colours)

Technical Data:

Electrical voltage supply:	<ul style="list-style-type: none"> • Input: 100 – 240 VAC (50/60 Hz) • Output: 12 VDC, 1000 mA
Weight:	0,570g
Dimensions (L x W x H):	225mm x 105mm x 45mm
Range:	1000 - 5ppm

Purge Monitors

MasterPurge 1

The MasterPurge 1 Oxygen Monitor incorporates a maintenance-free ceramic sensor, which can accurately display oxygen levels as small as 1 ppm (part per million).

High specification welds are now commonplace in the pharmaceutical, dairy, aerospace, petrochemical and many other industries. This oxygen monitor enables welders to more accurately recognise when extremely low rest oxygen atmospheres in the weld environment are reached.



Features:

- Robust zirconium cell
- 0 - 999 ppm measurement range
- Low maintenance
- Complete with carrycase



Technical Data:

Measuring range:	0 - 999 ppm O ₂
Temperature operating range:	0°C - 45°C
Accuracy:	+/- 0.3 mV Sensor EMF
Sensor warm-up time:	Approx. 90 Seconds
Stabilisation time:	15-20 Minutes
Response time:	Approx. 2 Seconds for variations
Dimensions (L x W x H):	225mm x 210mm x 140mm
Required voltage:	Multi Range 100 - 240 Volt AC
Warm-up load:	Approx. 200 VA
Normal load:	Approx. 40 VA
Measuring chamber Temp:	Approx. 700°C
Gas temperature:	Max. 50°C
Gas flow:	Approx. 50 l/h (1.8 ft ³ /h)
Moisture content:	Zero - Moisture must be separated out

Purge Monitors

MasterPurge Pro2 plus

The GBC MasterPurge Pro2plus Weld Purge Monitor is the ideal tool for welding applications where critical weld standards are required.

Used for production of Semi-conductors, Nuclear, Aerospace, Pharmaceutical, Energy, Dairy, Brewery and Food processing, anywhere strict welding guide lines apply to eliminate weld-quality issues associated with atmospheric contamination.

The MasterPurge Pro2plus Weld Purge Monitor contains a stabilised zirconium oxide cell with a regulated heater to maintain a cell temperature of 750°C, which enables it to accurately measure, levels down to as low as 0.5 ppm.



Features:

- Temperature regulated, low-maintenance zirconium sensor
- Accuracy of measurement up to 0,5 ppm
- Graphics compatible display
- Internal akku for wireless measurements up to 90 min.
- Integrated, free programmable horn
- Date and time for documentation
- Easy operated software
- Diffusion proof special FPM measuring hose
- Digital flow sensor
- Several surfaces: RS 232, 0-5 VDC (Orbitec), CAN-Bus, AUX (AMI)
- Calibration on the aerial oxygen for authorised personnel
- Internal memory up to 250 sets of parameters or external memory
- (PC-documentation)



Technical Data:

Electrical voltage supply:	100-240 VAC (50 / 60 Hz) Internal Akku: 12 VDC
Weight:	3.2kg
Dimensions (L x W x H):	240 mm x 215 mm x 85 mm (325mm with handle)
Range:	1000 - 1ppm

Trailing Shields

Secondary gas shielding for exotic & reactive metals

When welding exotic materials such as Titanium, a secondary gas shield is necessary to protect the cooling weld bead and HAZ (heat affected zone). Trailing shields prevent oxidation by shielding the weld from the atmosphere until it has cooled to a safe temperature. Trailing shields are essential to avoid weld rejects and costly re-working.

Flat versions are available for sheet or plate work as well as profiled versions for the internal and external welding of pipes, vessels and tanks.

Types of Trailing Shield

Stainless Steel

Made from stainless steel these shields utilise a sintered metal gas diffuser to help prevent turbulence in the welding zone. These versatile shields can be used on more than one pipe size.

Aluminium

These models use the same gas diffuser system as stainless steel versions. The seals are very easy and economical to replace.



Aluminium part nos and sizing:

Part No.	Description
ATS1	Trailing Shield 1"
ATS1.5	Trailing Shield 1¼"–1½"
ATS2	Trailing Shield 2"
ATS3	Trailing Shield 3"
ATS4	Trailing Shield 4"
ATS6	Trailing Shield 6"
ATS8	Trailing Shield 8"
ATS10	Trailing Shield 10"
ATS14	Trailing Shield 12"–14"
ATS16	Trailing Shield 16"
ATS18	Trailing Shield 18"
ATS22	Trailing Shield 20"–22"
ATS28	Trailing Shield 24"–28"
ATSS	Trailing Shield Straight

Stainless Steel part nos and sizing:

Part No.	Description
SSTS3/8	Trailing Shield 3/8"
SSTS0.5	Trailing Shield ½"
SSTS0.75	Trailing Shield ¾"
SSTS1	Trailing Shield 1"
SSTS1.5	Trailing Shield 1¼"–1½"
SSTS2	Trailing Shield 2"
SSTS3	Trailing Shield 2½"–3"
SSTS4	Trailing Shield 3½"–4"
SSTS8	Trailing Shield 5"–8"
SSTS16	Trailing Shield 8"–16"
SSTSS	Trailing Shield Straight
SSTSI	Trailing Shield 90° Internal
SSTS0	Trailing Shield 90° Outside

Other versions and models available on request.

Tungsten Grinders

MasterPoint Handy



Hand held tungsten electrode grinder with dust collection

Part No.	Range	Power	Type
MPH-1	1.6-3.2mm	110v	Dry
MPH-2	1.6-3.2mm	220v	Dry

MasterPoint TEG1



Portable Tungsten Electrode grinder

Part No.	Range	Power	Type
MPTEG1	1.6-5.0mm	220v	Dry

MasterPoint 1-4



Bench mounted tungsten electrode grinder



Dust Extraction Unit

Part No.	Description	Range	Power	Type
MP14-1	MasterPoint 1-4	1.0-4.0mm	110v	Dry
MP14-2	MasterPoint 1-4	1.0-4.0mm	220v	Dry
MP14-D	Dust Extraction Unit			Dry

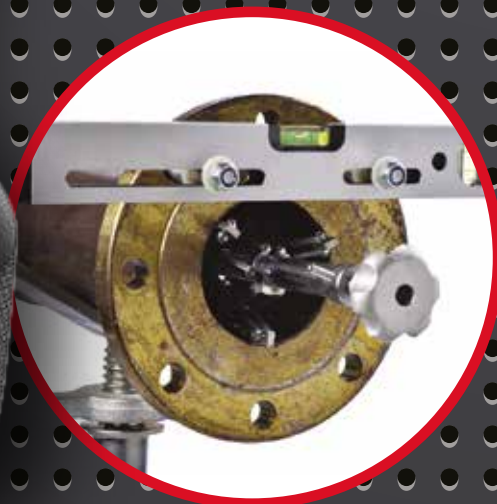
MasterPoint Ultimate



Wet tungsten electrode grinder

Part No.	Range	Power	Type
MPU-1	1.6-3.2mm	110v	Wet

PIPE FITTERS TOOLS



GBC UK offer a comprehensive range of high quality tools and aids for pipe and structural fabricators. Layout, marking and fit-up tools designed for welders by welders.



Pipe Fitter Tools

Pipe Wrap-a-Rounds

Screen printed tape measures which limits the need for an extra tape measure and makes mark-up much easier. $\frac{1}{4}$, $\frac{1}{2}$, $\frac{3}{4}$, exact circumference & actual diameter of pipes 2" through 30" is printed on the outside of the wraps. Packaged in durable, reusable containers that will hold up in your tool box.

Features and advantages

- All GBC Pipe Wraps are made from a non-asbestos, heat-resistant material.
- High density product for heavy duty service at temperatures up to 360° F.
- Outstanding resistance to oil, gasoline, kerosene, water and sea water.
- Thick and straight edges for easier, more accurate marking.

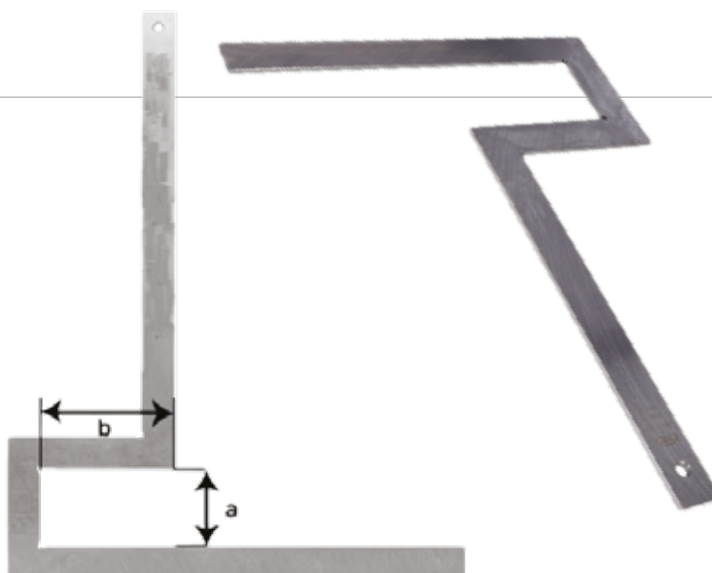


Part No.	Description	Size
WAR16	Wrap-a-Round	1 - 6"
WAR310	Wrap-a-Round	3 - 10"
WAR412	Wrap-a-Round	4 - 12"
WAR216	Wrap-a-Round	2 - 16"
WAR630	Wrap-a-Round	6 - 30"
WAR1248	Wrap-a-Round	12 - 48"

Flange Squares

GBC Flange Squares are manufactured from 30mm x 5mm hardened steel with machined working edges and flat sides.

Part No.	Description	Range
FS300F	Flange Square	300 x 300 MM
FS400F	Flange Square	400 x 400 MM
FS500F	Flange Square	500 x 500 MM
FS600F	Flange Square	600 x 600 MM
FS800F	Flange Square	800 x 800 MM



Pipe Fitter Tools

Two Hole Flange Pins



Part No.	Description	Size
42050-TM	Two Hole Flange Pin	Mini 5/16" - 63/64" Holes
42050-T	Two Hole Flange Pin	Standard 1/2" - 1 7/16"
42050-TL	Two Hole Flange Pin	Large up to 1 15/16"
42050-TXL	Two Hole Flange Pin	Extra Large 5/8" - 3.0"

Pipe Flange Aligner

The Pipe Flange Aligner will make 2 holes of the flange horizontally level with the ground and vertically level the face in ONE easy step.

Features and advantages

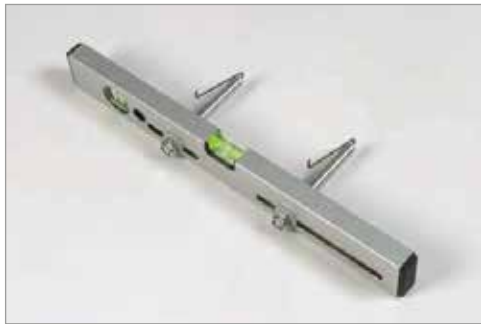
- Threaded models have fast release double lead threads.
- All models have one pin that has a 360° vial for easier vertical leveling
- The Pipe Flange Aligner can cut fit-up time in half saving valuable labour time.
- All models are machined from steel to make a very sturdy and lasting tool.



Part No.	Description	Size
38240-T	Pipe Flange Aligner	Up to 180mm hole distance
38420-TL	Pipe Flange Aligner	Up to 365mm hole distance

Pipe Fitter Tools

Flange Leveller



The Flange Leveller can be used on flanges with bolt holes 16mm and larger.



Part No.	Description	Size
FL500	Flange Leveller	Bolt holes 16mm and larger

Mag Centring Heads

Features and advantages

- Machined from high quality aluminum - anodized for lasting protection.
- One piece "Y" shaped body design with a 2-1/2° increment dial that turns 360°.
- Degree dial has a built-in dial for leveling the tool at various angles.
- Hardened center punch marks the set position by tapping with a hammer
- Vial and center punch are replaceable for lasting service.
- Magnets in the legs free up operators' hands for safer and more accurate layout.



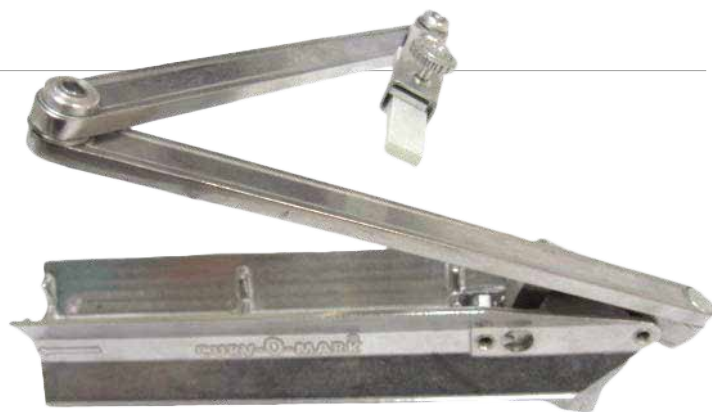
Part No.	Description	Size
CH500-S	Centring Head - small	1" +
CH500-L	Centring Head - large Centring	6" +
CH500-XL	Head - extra large	10" +

Pipe Fitter Tools

Contour Marker

Time saving tool designed to lay out pipe and structural joints. Precise layout of any angle, tees, wyres, crosses and elbows. Eliminates mathematical formulas / cut & try waste material.

Consists of x-shape frame, calibrated protractor and a triple jointed marking arm and holder. The protractor is calibrated on both sides, one in degrees, the other in rise - inches per foot.

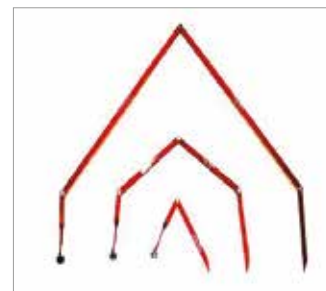


Part No.	Description	Size
CM500	Contour Marker	One size

Radius Markers

Features and advantages

- Machined from high quality aluminum - anodized for lasting protection.
- For laying out the smallest to the large circles (up to 100" in diameter).
- Precisely aligned arms with spring tension joints to guarantee accuracy and rigidity. The holder accommodates flat or round soap stone and pencils.
- Small and medium models fold to pocket size.
- Extra Large model can be adjusted tight in the centre to eliminate any movement



Part No.	Description	Size
RM500-S	Radius Marker - small	22"
RM500-L	Radius Marker - large	50"
RM500-XL	Radius Marker - extra large	100"

Pipe Fitter Tools

Universal Mag Level

The GBC Universal Mag Level is designed primarily for pipe fitters. This multi purpose tool has a 360 degree adjustable dial set level.

2 x 20 pound magnets exerting 50 pound pull will secure the unit on any carbon steel surface, enabling hands free levelling. Supplied with a pair of flange pins for flange alignment.



Part No.	Description	Size
UML500	Universal Mag Level	One size

GBC Mag Level

Professional 3 vial magnetic spirit level in a range of lengths from 400mm to 2000mm. Digital models also available.



Part No.	Description	Size
ML500-400mm	Mag Level	400mm
ML500-600mm	Mag Level	600mm
ML500-800mm	Mag Level	800mm
ML500-1000mm	Mag Level	1000mm
ML500-1200mm	Mag Level	1200mm
ML500-1500mm	Mag Level	1500mm
ML500-2000mm	Mag Level	2000mm

Pocket Mag Level

Small and convenient spirit level for level and plumb.



Part No.	Description	Size
PL500	Pocket Mag Level	One size

Pro Mag Level

The Pro Mag Level is a lightweight, easy to use tool for determining angles. It has two cast-in 25-pound pull magnets that hold securely to any carbon steel surface. The unit has a 360-degree adjustable DSL with two 90-degree quadrants graduated in 2-1/2-degree increments. Also cast in are tables used to convert degree-of-angle to rise-in-inches-per-foot or millimeters-per metre. A groove on the bottom edge permits use on a small pipe.



Part No.	Description	Size
PML500	Pro Mag Level	One size

Pipe Fitter Tools

Rotary Earth Clamp

Features and advantages

- Quick attaching and detaching
- 3 modes for earth lead connection - lug, clamp on & bare cable
- A simple and effective device to eliminate earth lead twisting, tangling and unnecessary wear.
- Provides a stable earth for circumferential welding of pipes and fittings.
- Eliminates weld porosity caused by poor earthing.
- Anti-arc bearings take loads of up to 400 amps.



Part No.	Description	Weight	
		Kg	Lbs
REC1	Rotary Earth Clamp	1.8	4.0

PJ3CV

Features and advantages

- Portable with folding legs
- For threading, cutting & deburring applications
- 1" - 6" chain vice
- Durable cast aluminium head
- Overhanging vice for clear tool swing
- Integral tool slots
- Rear pipe rest to keep pipes parallel
- Built in pipe benders
- Built in welding earth lug



Part No.	Description	Pipe Size	Pipe Size	Pipe Size
PJ3CV	Tri Stand w Vice	1" - 6"	20kg	90cm

Pipe Fitter Tools

GBC Saw Guides

Features and advantages

Easy Setup

The wing nut design allows the guide to be locked onto the pipe without the use of external devices. Just wrap the guide around the pipe and tighten the wing nut for the cutting operation.

Rollpin

A hardened solid pin is inserted into the guide just below the finished cut line that will stop the saw blade from cutting into the guide. If the saw blade comes in contact with the pin, the pin will spin and not damage the saw blade or the guide.

Nickel Plated

The hardened steel saw guide is nickel plated to ensure non contamination of the pipe or tube.

Double Slot (Patent Pending)

Double slot guide has two slots. Narrow for a portaband and a wider one for a sawzall blade. This is to insure that the tolerances are kept tighter on the cut on the ½" thru 3.5" sizes. The 4" and 6" have single slots.

Rounding

The design of the guides also allows it to be used as a rounding clamp in certain applications.



Tube Sizes:

Part No.	Size	O.D. mm
SG0.5T	½" Tube	12.7
SG0.75T	¾" Tube	19.05
SG1.0T	1" Tube	25.4
SG1.5T	1-½" Tube	38.1
SG2.0T	2" Tube	50.8
SG2.5T	2-½" Tube	63.5
SG3.0T	3" Tube	76.2
SG4.0T	4" Tube	101.6
SG6.0T	6" Tube	152.4

Pipe Sizes:

Part No.	Size	O.D. mm
SG0.5P	½" Pipe	21.3
SG0.75P	¾" Pipe	26.7
SG1.0P	1" Pipe	42.2
SG1.5P	1-½" Pipe	48.3
SG2.0P	2" Pipe	60.3
SG2.5P	2-½" Pipe	73.0
SG3.0P	3" Pipe	88.9
SG4.0P	4" Pipe	114.3
SG6.0P	6" Pipe	168.3



- **PEDIGREE - 35+ Years Experience**
- **QUALITY - ISO 9001 Since 1996**
- **PERFORMANCE - Guaranteed**