

# Twin Purge Bag - Instructions

## INSTRUCTIONS FOR USE

The following instructions are a guide to ensure this purging equipment is used correctly. Failure to follow these instructions may result in inadequate purging of the work piece or damage to the purging system.

### PROCEDURE

1. The system can be pulled into position using the lanyard loops. Insert the Inflatable Purge System into the bore of the pipe and pull into position using the lanyard lops. Ensure that the glow band is central to the pipe joint as this will position the sealing bags either side of the weld joint.
2. Connect the system to a dedicated and regulated gas supply, inflate the bags and begin purging using the correct flow rate.

Approximate guide to flow rate

Flow rate l/min = Pipe Bore Diameter in mm x 10%

E.g. 200mm x 10% = 20 litres/minute

The above formulae is correct up to 80 litres/min max flow rate

**Note:** To ensure optimum purge quality a purge monitor should be used

3. During welding the correct flow rate must be maintained to remove any oxygen produced by the welding process
4. Once the weld is completed it must be allowed to cool below oxidation temperature before the purge gas can be shut off. The bags will then deflate and the system can be removed from the pipe.

### GUIDELINES

- Beware of burrs and sharp edges which may puncture the purge bags
- Never inflate the system outside the pipe
- Always use a dedicated and regulated gas supply for the purge system (separate to the welding gas supply)
- Do not over inflate past the maximum specified size
- Do not exceed specified flow rate
- Purge valves are pre-set and should not be adjusted