



The Welding Accessory Experts™

Purge Bladders Save Time and Money

Minimize purge gas use and maximize your time with the Argweld® Purge Bladder System, creating a localized purge environment for your tube and pipe welding applications.



PRACTICAL.... Argweld® Bladder Systems are easy to use and simplify the purge gas process.

ECONOMICAL... Use less than 2% of the purge gas required for a conventional purge.

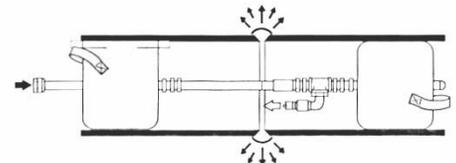
RELIABLE... Easy to install and inflates quickly to minimize preparation time.

EFFECTIVE... The sealed, localized purge area promotes a clean, even penetration bead for high quality welds.

CUSTOMIZABLE... Argweld® Purge Bladders can be custom designed to meet your specific purge welding needs.

The objective of purging is to shield the backside of the weld from contamination by displacing air inside a pipe with an inert gas. The most common approach, purging the entire system with gas, can be expensive and time consuming.

The Argweld® Purge Bladder System creates a localized purge area, minimizing the use of purge gas and wait time. Two protected bladders, connected by a spinal tube, are inserted into the bore of the pipe or tube to be welded and centered to the middle of the weld root. The bladders are inflated, forming a seal and at the same time releasing a purge valve which floods the space between the bladders with purge gas.



The oxygen is displaced, ensuring a clean even penetration bead. Once welding is complete, the bladders are deflated and the entire system is easily removed.

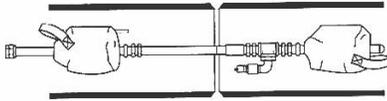
With the Argweld® System, only one inlet is required to inflate both bladders and to introduce the purge gas. The relief valve can be set to work at any desired flow up to 20 liters/ minute and can be set to inflate the bladders and purge the interspace simultaneously every time.

Arc-Zone.com® offers a variety of standard sizes, from 2" to 72" as well as custom configurations . One bladder size handles all schedules of that size pipe. Additionally, the systems are manufactured with quick disconnect fittings for quick removal and change- over. Arc-Zone also carries a complete line of replacement bladders, extensions and fittings.

Constructed of rugged rubber, the bladders are fitted with nylon covers to minimize abrasion during insertion and extraction. The bladders can also be fitted with high-temperature protection covers for applications where pre-heating is required.

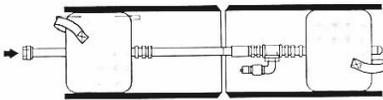
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RECOMMENDED STEPS FOR OPTIMAL WELDING



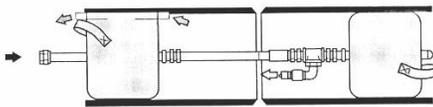
Position the Argweld® purge bladder assembly, centering the bladders to the middle of the weld root, using the positioning straps or, if necessary, additional cords or wires.

The system is set up for optimal purging with a 16" spinal tube between the two bladders, although the tube can be shortened or lengthened depending on specific welding application needs.

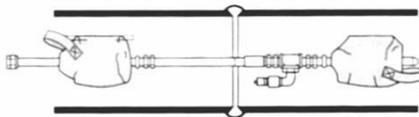


Inflate the bladders using the inert gas supply. Be sure to set the inlet valve correctly according the instructions for that bladder size, otherwise you may burst the purge bladder.

If you need to fit the bladder system inside longer pipes, use any standard gas hose to extend the length of the supply line. Be sure you're using the correct bladder for the pipe. A bladder larger than the pipe will not inflate properly and will not create a sealed, oxygen-free environment.



Maintain the flow rate of purge gas once the bladders are inflated. The pressure in the system opens the purge valve, introducing purge gas to displace the air between the bladders. Also be sure to maintain the flow rate while welding.



Allow the weld area to cool slightly when complete, then deflate the bladders and remove the Argweld® system. The nylon covered bladders are very flexible and once deflated can be easily extracted through relatively small areas.

ARGWELD® PURGE TIME (to 1% oxygen)

The chart below shows purge times for various pipe diameters to reduce the air space to less than 1% oxygen.

Pipe Length	Pipe Diameter	Normal Purge Time at 24 L/M (50 CFH)	Argwled® Purge Time at 10L/M (CFH)
33' (10m)	4" (100mm)	26 minutes	1.5 minutes
33' (10m)	8" (200mm)	83 minutes	4 minutes
33' (10m)	12" (300mm)	173 minutes	8 minutes