

Twin Bag Purge Systems

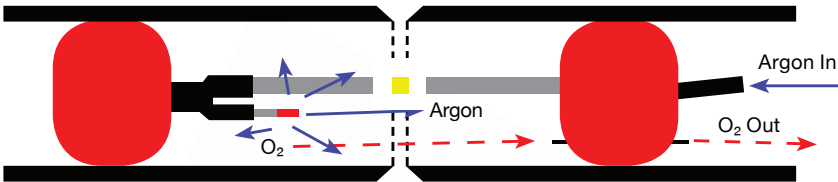
Sizes: 2" - 48" (50mm - 1200mm)

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drops to below oxidation levels, then the purge gas feed is disconnected, the bags deflate and the system can be withdrawn.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.

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

Part Nos & Sizing

Part No.	Nominal Pipe Size (mm / inch)		Internal Diameter Range (mm)	Weight (kg)
TP01	25mm	1"	13 - 38mm	0.20kg
TP1.5	40mm	1.5"	32 - 45mm	0.20kg
TP02	50mm	2"	44 - 57mm	0.34kg
TP03	75mm	3"	58 - 84mm	0.34kg
TP04	100mm	4"	80 - 110mm	0.34kg
TP05	125mm	5"	103 - 135mm	0.38kg
TP06	150mm	6"	124 - 162mm	0.38kg
TP08	200mm	8"	175 - 213mm	0.90kg
TP10	250mm	10"	230 - 265mm	1.0kg
TP12	300mm	12"	265 - 305mm	1.1kg
TP14	350mm	14"	330 - 355mm	1.3kg
TP16	400mm	16"	380 - 405mm	1.7kg
TP20	500mm	20"	485 - 510mm	1.9kg
TP24	600mm	24"	585 - 610mm	2.5kg
AFH30	30 meter argon feed hose assembly for GBC TWIN BAG PURGE SYSTEM.			

* Larger sizes available upon request

Speedy Purge Systems

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

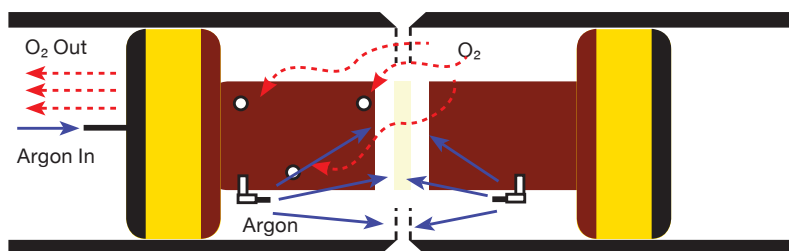
The GBC Speedy Purge System for pipe and vessel purging comprises a tandem inflatable dam system connected by an umbilical hose and collar to reduce the volume being purged. A gas exhaust valve is installed between the primary and secondary dam, along with an auxillary Argon purge line. The system is 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

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.

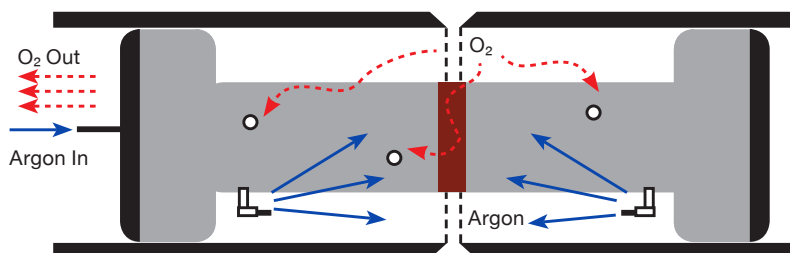


Twin purge heat resistant bags



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