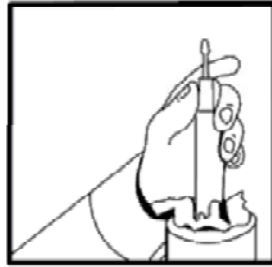


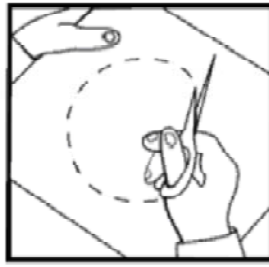


How to Use Dissolvo Purge Dams for TIG Welding



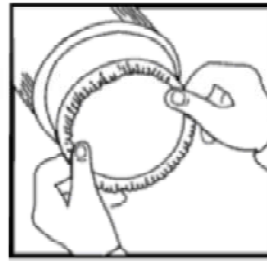
A

For small diameter pipes (less than 4" inner diameter), simply position a wad of Dissolvo paper several inches down into each section to be joined.



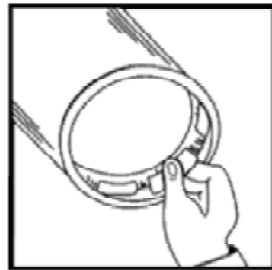
B

For larger pipes (4" inner diameter and larger), cut the paper into a circle with a diameter several inches larger than the pipe ID
Example: for a 6" ID pipe, cut an 8" diameter paper circle.



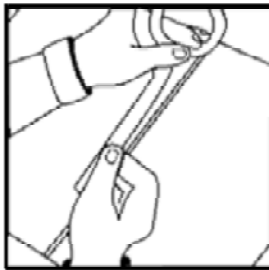
C

Trace or impress the pipe inner diameter on the paper and fold on this line to form a 90 degree lip. Insert the dam into the pipe with the lip towards the weld prep.



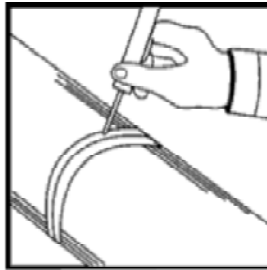
D

Peel tape from backing and tape dam in place. *Optional:* Punch a small hole in the dam to facilitate the evacuation of air when purging.



E

For pipes larger than 28" diameter, simply splice two or more sheets of Dissolvo paper together with Dissolvo tape, and proceed as in steps B,C, and D.



F

After the dams are in place, Argon or another purge gas may be introduced through the root gap with a needle valve connected to the gas line.



G

If one end of the pipe is accessible, the purge gas may be introduced through a hole at the lower end of one dam. A vent hole should be made at the upper end of the other dam to allow air and gases to escape.
Optional: cover the open root joint on the outside of the pipe with tape to prevent gas leakage.

