

PIPE PURGING EQUIPMENT



AN SFE GROUP BRAND

BROCHURE

www.PURGEMASTERS.COM



The **Specialized Fabrication Equipment Group** (in short: **S.F.E. Group**) was founded in 2019 after the merger of three world leading OEM's in the field of pipe fabrication tooling and machinery: B&B Pipe and Industrial Tools LLC (USA), Mathey Dearman Inc. (USA) and TAG Pipe Equipment Specialists (UK). In a time span of 5 years, another 4 renowned and market leading companies were acquired and added to the **S.F.E. Group** portfolio: Axxair (France, 2022), Magnatech (USA, 2023), Climax (USA, 2023) and Sumner (USA, 2025).

The vision and philosophy of the **S.F.E. Group** is to offer globally a comprehensive innovative and cost-effective range of specialized fabrication, welding and machining equipment and derived rental solutions, for a wide range of applications within all critical industries, while optimizing performance, efficiency and safety.

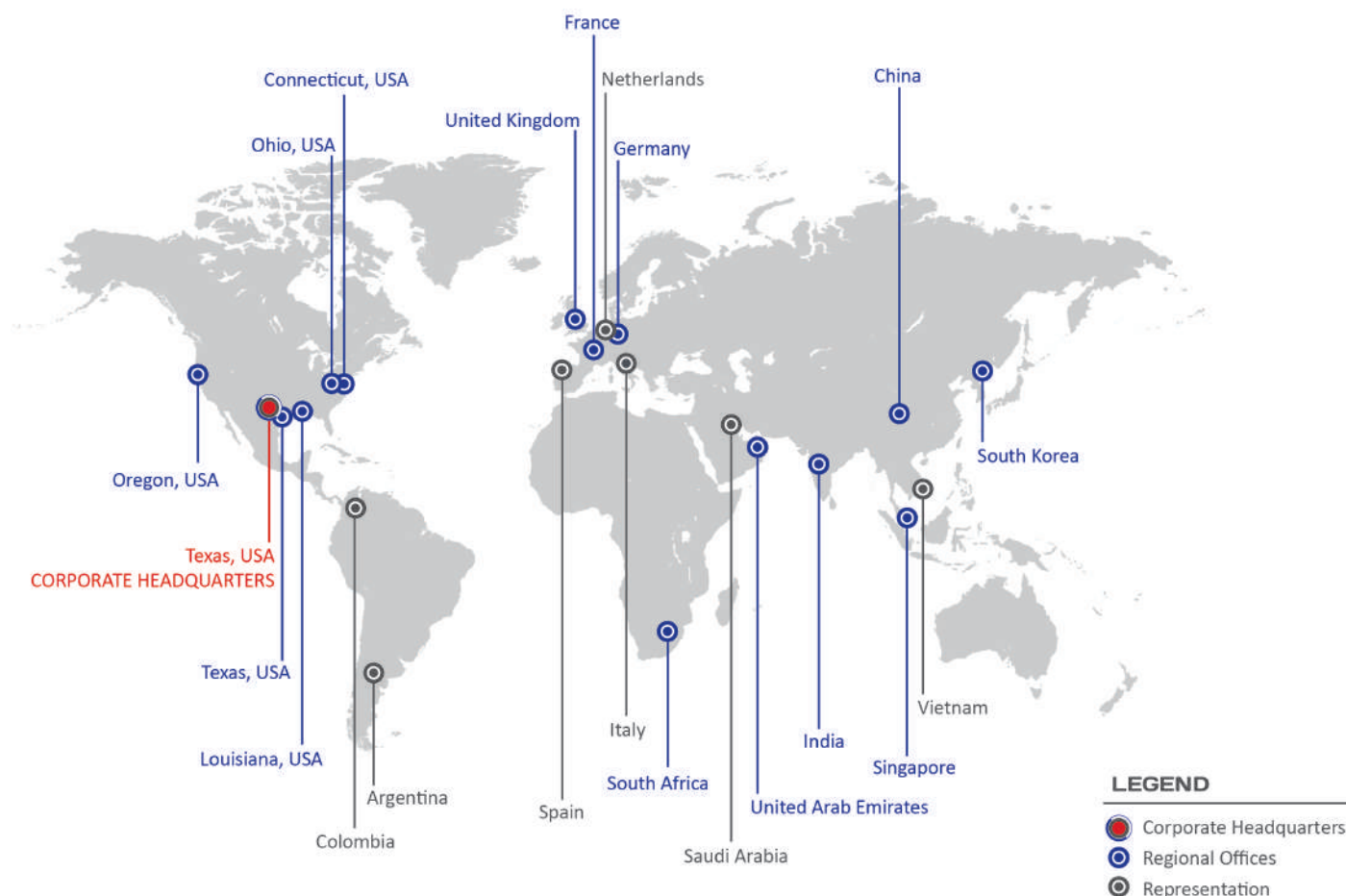
Leveraging over 200 years of combined experience in engineering, manufacturing, and field applications, the **S.F.E. Group** is committed to driving innovation. Through continuous product development and strategic acquisitions, the **S.F.E. Group** is actively growing its portfolio and expanding its global presence to meet the demands of industries around the world. Currently, the **S.F.E. Group** consists of 12 complimentary brands, each supporting the others in delivering cutting-edge solutions.

With offices and warehousing on 5 continents, 400+ employees and more than 500 partnerships and distributors worldwide, **S.F.E. Group** prides itself on consistently offering the highest standards of both product quality and service locally to all its customers.

S.F.E. Group looks forward to welcoming you into its global network as a partner, distributor or end user customer and remains at your disposal at any time.

Contact Americas: sales@sfe-brands.com
Contact International: sales-int@sfe-brands.com

S.F.E. GROUP GLOBAL PRESENCE





Backed by nearly 25 years of development, S.F.E. Group is proud to present its brand dedicated to pipe purging products, applications and solutions: **Pipe Purge Masters (PPM)**. With the **PPM brand**, the S.F.E. Group aims to not only emphasize its focus on pipe purging products but also meet the growing demand for on-site pipe purging equipment across the industries it already serves. Additionally, PPM products integrate seamlessly with other S.F.E. Group offerings, such as the orbital welding solutions provided by the AXXAIR brand.

As an OEM, S.F.E. Group prides itself on being renowned for its innovations, ground-breaking developments and creative designs within the **Pipe Purge Masters'** product range. Leveraging its engineering expertise, customer-centric approach, and flexibility, the PPM brand delivers innovative pipe purging solutions tailored to meet the specific needs of customer projects, while also addressing the demands of ever-evolving industries.

The **PPM brand** portfolio consists of a comprehensive range of pipe purging equipment: inflatable pipe purge bag systems, welding purge plugs, formed double seal purge systems, purge oxygen monitors, inflatable as well as mechanical pipe stoppers and accessories.

Pipe Purge Masters' products are available from the international S.F.E. Group locations on 5 continents, as well as from S.F.E. Group's extensive and continuously expanding global network of partners and can be consulted on the dedicated website **www.PURGEMASTERS.com**.

INDUSTRIES SERVED



OUR BRANDS



Our group policy is one of continuous improvements and acquisitions. Products and data tables are subject to change and may vary from those illustrated. Copyright © 2025 Specialized Fabrication Equipment Group, All rights reserved.

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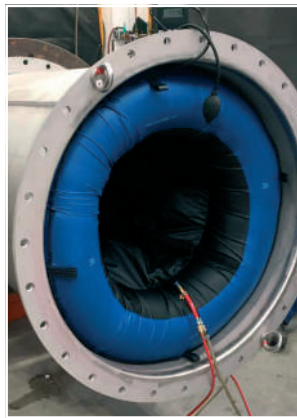
HEAT RESISTANT PURGING SYSTEM
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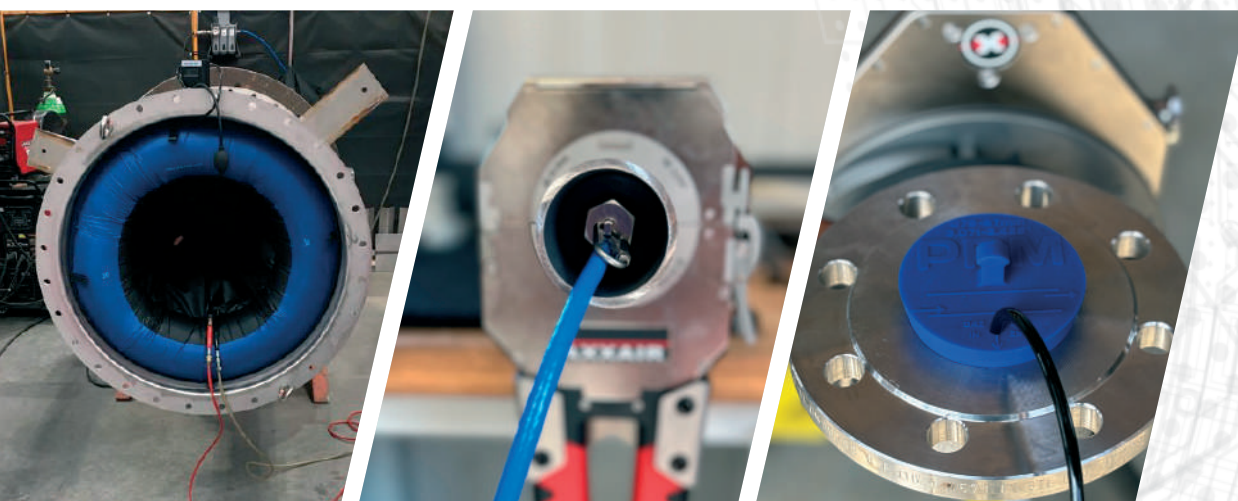
STEEL PLUGS
1.5 - 36" / 40 - 900 mm

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INFLATABLE PIPE STOPPERS
2 - 80" / 50 - 2,035 mm

PIPE PURGING SYSTEMS

0.75 - 80" / 16 - 2,044 mm



The perfect environment for welding is paramount to maintaining the corrosion resistant properties when welding stainless steel, titanium and other corrosion resistant materials.

If the correct processes are not adhered to during the welding process, the weld seam is subjected to heat and air, which can cause oxidation. For the best results, oxidation must be prevented.

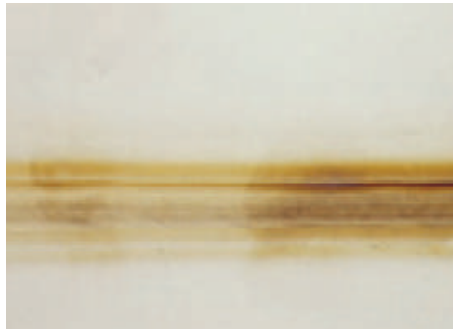
The quality of the exotic corrosion resistant material welding is dependent on the correct purging methods to minimize or eliminate oxidation.

All PPM (Pipe Purge Masters) purging systems are designed to efficiently remove oxygen as fast as possible. This can be achieved by isolating a small area of the pipe, resulting in the fastest purge times, while also minimising the amount of purge gas used.

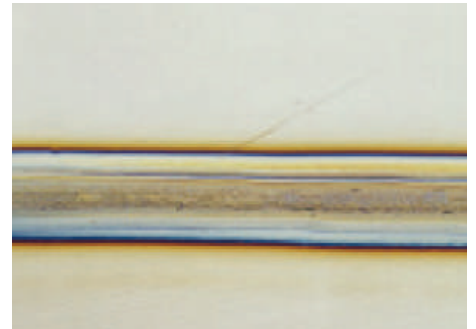
The below pictures show the different levels of weld quality depending on oxidation present at the point of welding.



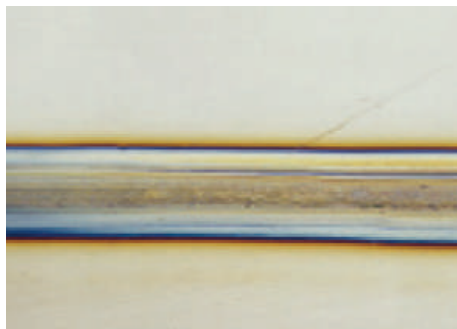
Argon purge 12 ppm
Vol. O₂ content



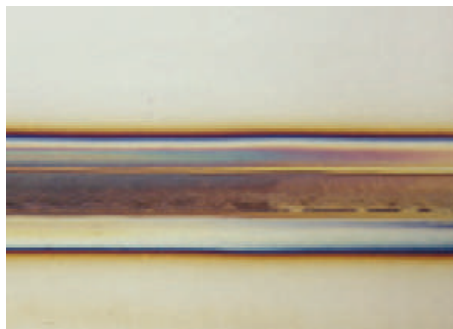
Argon purge 60 ppm
Vol. O₂ content



Argon purge 70 ppm
Vol. O₂ content



Argon purge 200 ppm
Vol. O₂ content



Argon purge 250 ppm
Vol. O₂ content



Argon purge 500 ppm
Vol. O₂ content

WELD QUALITY

The effective welding of stainless steel, titanium and other exotic materials for the nuclear, petrochemical, pharmaceutical, semiconductor, aerospace and food industries requires the proper tools to create a perfect weld environment.

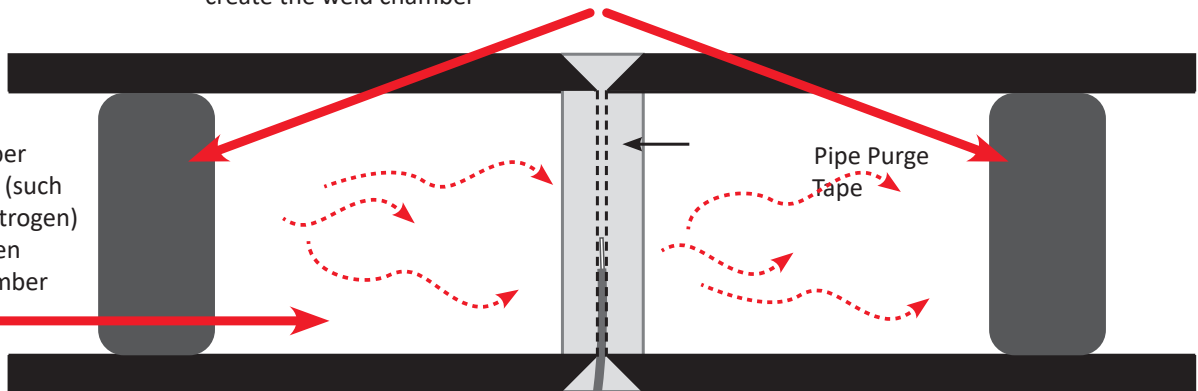
Purging equipment and its use have a major impact on preventing oxidation and improving the final weld quality. The basic principles of purging can be seen below.

PPM supplies a comprehensive range of systems to create the correct welding environment, whatever the application.

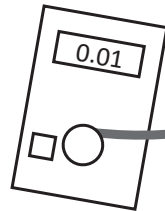
PRINCIPLES OF PURGING

1. Create a seal (dam) either side of the weld and close off the weld gap with purge tape to create the weld chamber

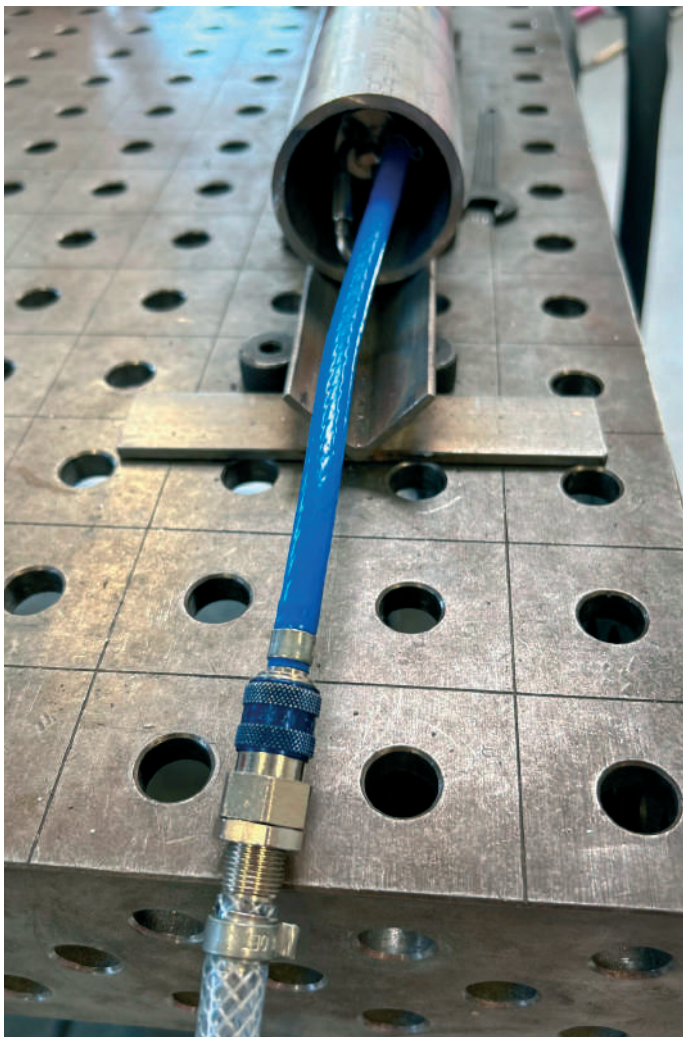
2. Fill the chamber with inert gas (such as argon or nitrogen) to expel oxygen from the chamber



3. Use a weld purge monitor to indicate when the required level of oxygen has been met



4. Welding can then be performed, guaranteeing no oxidation or discolouration of the weld





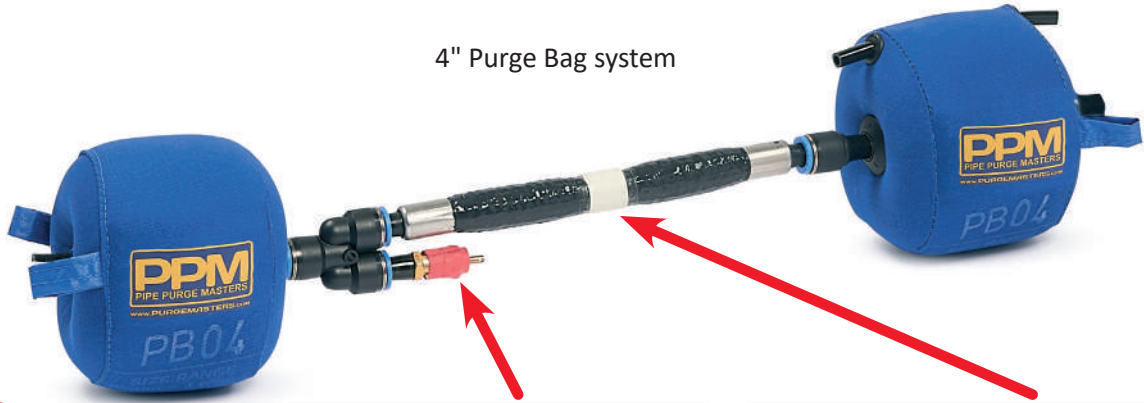
Nominal Pipe Sizes: 2 - 24" / 50 - 600 mm

Internal Diameter (i/d) Range: 1.65 - 23.80" / 42 - 605 mm

Double inflatable pipe weld purging systems

Used for 90% of the traditional pipe weld purging applications to provide bright, shiny, oxide free weld roots. The PPM Purge Bag system is quick and easy to use, providing a very rapid weld purge. High quality materials are used in the production of these systems, guaranteeing perfect oxide-free weld roots in very little time.

4" Purge Bag system



**HEAT
RESISTANT
70°C /
158°F**



The gas release valve is pre-set and sealed, so it requires no adjustment



A luminous strip allows the operator to locate and centre the Purge Bag system to the weld gap with ease

Due to the design of this system, the volume of gas used to purge is minimized, resulting in significant reduction of both time and inert gas consumption. Return on investment can be achieved in as little as just one or two welds. These robust systems can be used over and over again paying for themselves in very little time.

FEATURES AND ADVANTAGES

- PPM's Purge Bag system dramatically reduces purging times, leading to significant savings
- **Typical purge times for 4" pipe = 1½ mins; 8" pipe = 4 mins; 12" pipe = 8 mins**
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate up to 20l a min.
- Gas pressure control ensures an even positive root bead with no notching
- Quick and easy to install, simplifying the process of inert gas purging
- Heat resistant up to 70°C (158°F) continuously
- Use less inert gas. The volume of purge gas used is less than 2% of a conventional purge

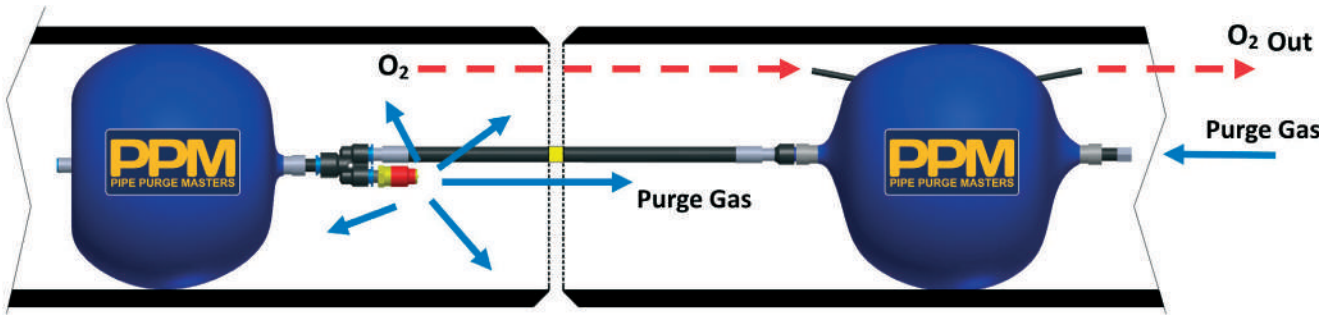


HOW IT WORKS

The Purge Bag system is designed around the principle of using 2 dams, that are connected by an armoured spinal tube, to create a seal on either side of the weld. These dams are just far enough away from the weld not to be affected by heat, but close enough to the joint to provide the fastest weld purge time.

Once ready to start purging, the system is inserted into the bore of the pipe using the luminous strip to centre the system to the weld gap.

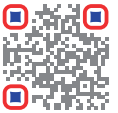
When the gas flow is started, the dams inflate and upon reaching the pre-set pressure, the valve releases the gas gently into the weld chamber to purge the interspace without turbulence. The oxygen is removed from the weld chamber by the inert gas through the integral exhaust tubes in the bags, enabling the welder to produce an even oxidation free penetration weld bead. Used in conjunction with PPM’s oxygen monitors, indicating when the required low level of oxygen has been reached, welding can then commence. Afterwards, the dams are deflated simply by disconnecting the purge gas feed and the system easily withdrawn. The design of this system requires only one gas connection for both dam inflation and weld purging.



SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	NOMINAL PIPE SIZE		INTERNAL DIAMETER RANGE (I/D)		WEIGHT (LBS / KG)	
PB02	2" Purge Bag system	2"	50 mm	1.65 - 2.37"	42 - 60 mm	1 lbs	0.34 kg
PB03	3" Purge Bag system	3"	75 mm	2.17 - 3.53"	55 - 90 mm	1 lbs	0.34 kg
PB04	4" Purge Bag system	4"	100 mm	3.51 - 4.51"	89 - 115 mm	1 lbs	0.34 kg
PB05	5" Purge Bag system	5"	125 mm	4.14 - 5.50"	105 - 140 mm	1 lbs	0.38 kg
PB06	6" Purge Bag system	6"	150 mm	5.32 - 6.68"	135 - 170 mm	1 lbs	0.38 kg
PB07	7" Purge Bag system	7"	175 mm	6.30 - 7.66"	160 - 195 mm	2 lbs	0.70 kg
PB08	8" Purge Bag system	8"	200 mm	7.09 - 8.45"	180 - 215 mm	2 lbs	0.90 kg
PB09	9" Purge Bag system	9"	225 mm	8.08 - 9.43"	205 - 240 mm	2 lbs	0.95 kg
PB10	10" Purge Bag system	10"	250 mm	9.26 - 10.61"	235 - 270 mm	2 lbs	1.00 kg
PB11	11" Purge Bag system	11"	275 mm	10.03 - 11.41"	255 - 290 mm	2 lbs	1.05 kg
PB12	12" Purge Bag system	12"	300 mm	11.03 - 12.39"	280 - 315 mm	2 lbs	1.10 kg
We strongly recommended using our Rapid Purge™ system over 12"							
PB13	13" Purge Bag system	13"	325 mm	11.41 - 12.79"	290 - 325 mm	2 lbs	1.20 kg
PB14	14" Purge Bag system	14"	350 mm	12.41 - 13.76"	315 - 350 mm	3 lbs	1.30 kg
PB15	15" Purge Bag system	15"	375 mm	13.38 - 14.76"	340 - 375 mm	3 lbs	1.50 kg
PB16	16" Purge Bag system	16"	400 mm	14.38 - 15.73"	365 - 400 mm	3 lbs	1.70 kg
PB17	17" Purge Bag system	17"	425 mm	15.35 - 16.73"	390 - 425 mm	4 lbs	1.75 kg
PB18	18" Purge Bag system	18"	450 mm	16.34 - 17.70"	415 - 450 mm	4 lbs	1.80 kg
PB19	19" Purge Bag system	19"	475 mm	17.32 - 18.70"	440 - 475 mm	4 lbs	1.85 kg
PB20	20" Purge Bag system	20"	500 mm	18.31 - 19.67"	465 - 500 mm	4 lbs	1.90 kg
PB22	22" Purge Bag system	22"	550 mm	19.69 - 21.05"	500 - 535 mm	5 lbs	2.20 kg
PB24	24" Purge Bag system	24"	600 mm	22.45 - 23.80"	570 - 605 mm	6 lbs	2.50 kg
Larger sizes and custom solutions available upon request with 35 mm / 1.37" expansion range							

The Purge Bag comes with fittings:
International = 21 KA series male connector
Americas = ¼" (0.25") NPT male connector



Sizes: 8 - 80" / 190 - 2,044 mm

Purge larger diameter pipes faster than ever!

Used for stainless, duplex, chrome steels, titanium, nickel and other alloy materials, the PPM Rapid Purge™ system enables high speed welding of larger diameter pipe joints that need to be purged.

The system is designed to enable the user to produce high quality, reliable and repeatable welding of stainless steel tube and pipe joints free from oxidation and discolouration. A 36" diameter pipe will purge to below 0.1% oxygen in less than 10 minutes and all smaller pipes correspondingly faster.

Due to the quality of the materials used, the Rapid Purge™ system can be used over and over again, reducing manufacturing costs. The Rapid Purge™ system has been developed specifically to enable high speed purging for any pipe welding application.



FEATURES AND ADVANTAGES

- Dramatic savings of time, gas and money can be made by using these systems.
- **Typical purge times of less than 10 minutes!**
- The unique thru-bore design of the central sleeve minimizes the area to be purged, dramatically reducing the gas consumption
- Friction free coatings allow easy movement through pipes from one joint to another, even around bends and elbows
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate up to 80 l / min through the twin pre-set purge valve
- A central luminous strip allows fast and accurate alignment of the system to the centre point of the weld area
- The inflatable dams and umbilical hose are covered with a heat resistant material and insulated accordingly for use at temperatures up to 250°C (482°F)

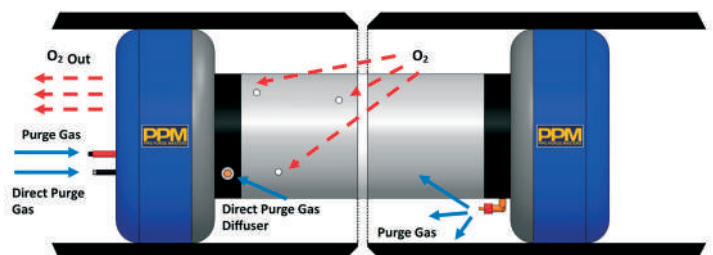
HOW IT WORKS

The Rapid 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 auxiliary argon purge line. This Rapid Purge™ system valve is pre-set, making it ready to use 'straight out of the box'.

Each Rapid Purge™ system is covered with heat protective material, so that the higher temperatures closer to the weld do not damage the system.

The robust design of the Rapid Purge™ system allows for many years of repeatable trouble free use.



RAPID PURGE SYSTEM SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	NOMINAL PIPE SIZE		INTERNAL DIAMETER RANGE (I/D)		WEIGHT (LBS / KG)	
RP08	8" Rapid Purge system	8"	200 mm	7.09 - 8.45"	180 - 215 mm	3 lbs	1.40 kg
RP10	10" Rapid Purge system	10"	250 mm	9.26 - 10.61"	235 - 270 mm	3 lbs	1.70 kg
RP12	12" Rapid Purge system	12"	300 mm	11.03 - 12.39"	280 - 315 mm	4 lbs	2.10 kg
RP14	14" Rapid Purge system	14"	350 mm	12.41 - 13.76"	315 - 350 mm	5 lbs	2.50 kg
RP16	16" Rapid Purge system	16"	400 mm	14.38 - 15.73"	365 - 400 mm	5 lbs	2.70 kg
RP18	18" Rapid Purge system	18"	450 mm	16.34 - 17.70"	415 - 450 mm	6 lbs	3.00 kg
RP20	20" Rapid Purge system	20"	500 mm	18.31 - 19.67"	465 - 500 mm	7 lbs	3.40 kg
RP22	22" Rapid Purge system	22"	550 mm	19.69 - 21.05"	500 - 535 mm	7 lbs	3.60 kg
RP24	24" Rapid Purge system	24"	600 mm	22.45 - 23.80"	570 - 605 mm	8 lbs	3.80 kg
RP26	26" Rapid Purge system	26"	650 mm	24.41 - 25.77"	620 - 655 mm	9 lbs	4.50 kg
RP28	28" Rapid Purge system	28"	700 mm	26.38 - 27.74"	670 - 705 mm	12 lbs	5.50 kg
RP30	30" Rapid Purge system	30"	750 mm	28.35 - 29.71"	720 - 755 mm	13 lbs	6.00 kg
RP32	32" Rapid Purge system	32"	800 mm	30.32 - 31.68"	770 - 805 mm	18 lbs	8.00 kg
RP34	34" Rapid Purge system	34"	850 mm	32.48 - 33.86"	825 - 860 mm	19 lbs	8.50 kg
RP36	36" Rapid Purge system	36"	900 mm	34.45 - 35.81"	875 - 910 mm	20 lbs	9.10 kg
RP38	38" Rapid Purge system	38"	950 mm	36.61 - 37.99"	930 - 965 mm	21 lbs	9.50 kg
RP40	40" Rapid Purge system	40"	1,000 mm	38.98 - 39.95"	990 - 1015 mm	22 lbs	9.90 kg
RP42	42" Rapid Purge system	42"	1,050 mm	40.56 - 41.91"	1,030 - 1,065 mm	29 lbs	13.20 kg
RP44	44" Rapid Purge system	44"	1,100 mm	42.52 - 43.90"	1,080 - 1,115 mm	30 lbs	13.70 kg
RP46	46" Rapid Purge system	46"	1,150 mm	44.29 - 45.67"	1,125 - 1,160 mm	32 lbs	14.50 kg
RP48	48" Rapid Purge system	48"	1,200 mm	46.46 - 47.82"	1,180 - 1,215 mm	33 lbs	15.00 kg
RP50	50" Rapid Purge system	50"	1,250 mm	48.42 - 49.80"	1,230 - 1,265 mm	35 lbs	16.00 kg
RP52	52" Rapid Purge system	52"	1,300 mm	50.59 - 51.97"	1,285 - 1,320 mm	37 lbs	17.00 kg
RP54	54" Rapid Purge system	54"	1,350 mm	52.36 - 53.74"	1,330 - 1,365 mm	39 lbs	18.00 kg
RP60	60" Rapid Purge system	60"	1,500 mm	58.46 - 59.84"	1,485 - 1,520 mm	44 lbs	20.00 kg
RP66	66" Rapid Purge system	66"	1,650 mm	64.38 - 65.73"	1,635 - 1,670 mm	55 lbs	25.00 kg
RP72	72" Rapid Purge system	72"	1,800 mm	70.27 - 71.65"	1,785 - 1,820 mm	62 lbs	28.00 kg
RP80	80" Rapid Purge system	80"	2,000 mm	78.35 - 79.72"	1,990 - 2,025 mm	66 lbs	30.00 kg

Larger sizes and custom solutions available upon request with 35 mm / 1.37" expansion range



The Rapid Purge Bag comes with fittings:
International = 21 KA series male connector
Americas = ¾" (0.25") NPT male connector





Sizes: 3 - 80" / 63 - 2,044 mm

Systems for the fast purging of high temperature pipe work

The PPM Purge Bag and Rapid Purge™ systems are both available in a heat resistant version. They are designed to be used when high temperatures will be encountered during the process of pipe welding; such as pre-heated pipe work, and pipes where very high temperatures are required for welding.

These versions of the inflatable pipe purging systems are heat resistant up to 350°C (662°F) for up to 24 hours, or up to 500°C (932°F) for short periods of time. The heat resistant systems are available for all pipe diameters from 3 - 80" / 63 - 2,035 mm.

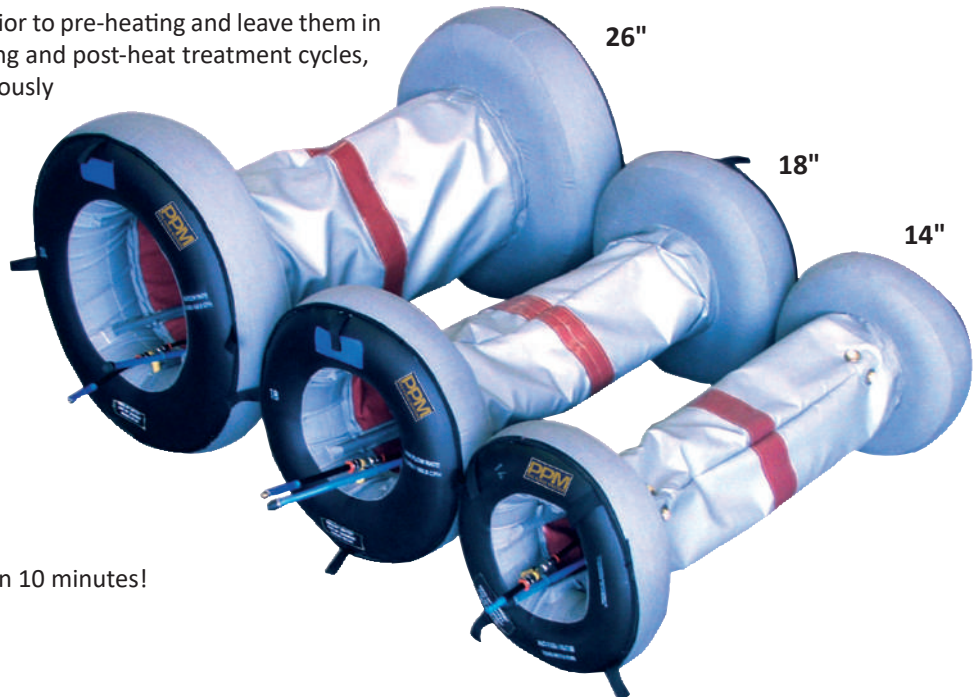
Mirroring the features of the standard range of inflatable purging systems, the heat resistant range comes with a central luminous band for rapid centring of the system to the weld root.

The welder can position these systems prior to pre-heating and leave them in place throughout the pre-heating, welding and post-heat treatment cycles, allowing the weld to be purged continuously for up to 24 hours if necessary.



Heat Resistant Rapid Purge

e.g. 36" pipe will purge in less than 10 minutes!

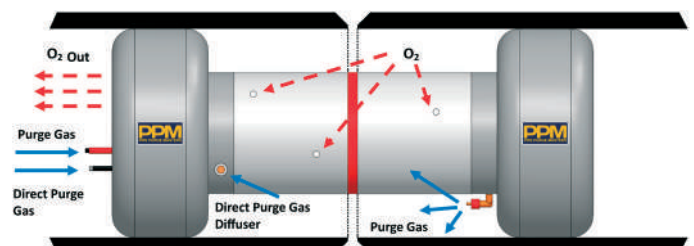


FEATURES AND ADVANTAGES

- Heat resistant up to 350°C (662°F) for up to 24 hours, or up to 500°C (932°F) for short periods
- Available for all pipe diameters from 3 to 80" / 63 to 2,044 mm
- Designed to be flexible, for ease of insertion, use and withdrawal from pipes, bends, elbows etc.
- Suitable for 24 hour cycles including pre-heat, welding and post-weld heat treatment
- A central luminous strip allows fast and accurate alignment of the system to the centre point of the weld area
- Manufactured to nuclear quality standards with nuclear approved materials, these systems guarantee bright, shiny, coke and oxide-free welds
- Designed and manufactured specifically for the power industry where high strength chrome alloy steels are more frequently used
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate (purge bags - up to 20 l / min / Rapid Purge™ up to 80 l / min) through the twin pre-set purge valve

HOW IT WORKS

Both the heat resistant Purge Bag system and the heat resistant Rapid Purge™ system work identically to the standard systems, but are made of a purposely designed Nomex and Kevlar mix material to withstand the temperatures typically encountered when welding exotic materials.



PURGE BAG HEAT RESISTANT SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	NOMINAL PIPE SIZE		INTERNAL DIAMETER RANGE (I/D)		WEIGHT (LBS / KG)	
PB02/HR	2" Purge Bag - Heat Resistant to 500 degrees	2"	50 mm	1.49 - 2.37"	38 - 60 mm	1 lbs	0.40 kg
PB03/HR	3" Purge Bag - Heat Resistant to 500 degrees	3"	75 mm	2.17 - 3.53"	55 - 90 mm	1 lbs	0.50 kg
PB04/HR	4" Purge Bag - Heat Resistant to 500 degrees	4"	100 mm	3.51 - 4.51"	89 - 115 mm	1 lbs	0.60 kg
PB05/HR	5" Purge Bag - Heat Resistant to 500 degrees	5"	125 mm	4.14 - 5.50"	105 - 140 mm	1 lbs	0.70 kg
PB06/HR	6" Purge Bag - Heat Resistant to 500 degrees	6"	150 mm	5.32 - 6.68"	135 - 170 mm	2 lbs	0.90 kg
PB07/HR	7" Purge Bag - Heat Resistant to 500 degrees	7"	175 mm	6.30 - 7.66"	160 - 195 mm	2 lbs	1.20 kg
Larger sizes and custom solutions available upon request with 35 mm / 1.37" expansion range							



PB06/HR

e.g. 6" pipe will purge in less than 4 minutes!

RAPID PURGE™ HEAT RESISTANT SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	NOMINAL PIPE SIZE		INTERNAL DIAMETER RANGE (I/D)		WEIGHT (LBS / KG)	
RP08/HR	8" Rapid Purge - Heat Resistant up to 500 degrees	8"	200 mm	7.09 - 8.45"	180 - 215 mm	3 lbs	1.40 kg
RP10/HR	10" Rapid Purge - Heat Resistant up to 500 degrees	10"	250 mm	9.26 - 10.61"	235 - 270 mm	3 lbs	1.70 kg
RP12/HR	12" Rapid Purge - Heat Resistant up to 500 degrees	12"	300 mm	11.03 - 12.39"	280 - 315 mm	4 lbs	2.10 kg
RP14/HR	14" Rapid Purge - Heat Resistant up to 500 degrees	14"	350 mm	12.41 - 13.76"	315 - 350 mm	5 lbs	2.50 kg
RP16/HR	16" Rapid Purge - Heat Resistant up to 500 degrees	16"	400 mm	14.38 - 15.73"	365 - 400 mm	5 lbs	2.70 kg
RP18/HR	18" Rapid Purge - Heat Resistant up to 500 degrees	18"	450 mm	16.34 - 17.70"	415 - 450 mm	6 lbs	3.00 kg
RP20/HR	20" Rapid Purge - Heat Resistant up to 500 degrees	20"	500 mm	18.31 - 19.67"	465 - 500 mm	7 lbs	3.40 kg
RP22/HR	22" Rapid Purge - Heat Resistant up to 500 degrees	22"	550 mm	19.69 - 21.05"	500 - 535 mm	7 lbs	3.60 kg
RP24/HR	24" Rapid Purge - Heat Resistant up to 500 degrees	24"	600 mm	22.45 - 23.80"	570 - 605 mm	8 lbs	3.80 kg
RP26/HR	26" Rapid Purge - Heat Resistant up to 500 degrees	26"	650 mm	24.41 - 25.77"	620 - 655 mm	9 lbs	4.50 kg
RP28/HR	28" Rapid Purge - Heat Resistant up to 500 degrees	28"	700 mm	26.38 - 27.74"	670 - 705 mm	12 lbs	5.50 kg
RP30/HR	30" Rapid Purge - Heat Resistant up to 500 degrees	30"	750 mm	28.35 - 29.71"	720 - 755 mm	13 lbs	6.00 kg
RP32/HR	32" Rapid Purge - Heat Resistant up to 500 degrees	32"	800 mm	30.32 - 31.68"	770 - 805 mm	18 lbs	8.00 kg
RP34/HR	34" Rapid Purge - Heat Resistant up to 500 degrees	34"	850 mm	32.48 - 33.86"	825 - 860 mm	19 lbs	8.50 kg
RP36/HR	36" Rapid Purge - Heat Resistant up to 500 degrees	36"	900 mm	34.45 - 35.81"	875 - 910 mm	20 lbs	9.10 kg
RP38/HR	38" Rapid Purge - Heat Resistant up to 500 degrees	38"	950 mm	36.61 - 37.99"	930 - 965 mm	21 lbs	9.50 kg
RP40/HR	40" Rapid Purge - Heat Resistant up to 500 degrees	40"	1,000 mm	38.98 - 39.95"	990 - 1015 mm	22 lbs	9.90 kg
RP42/HR	42" Rapid Purge - Heat Resistant up to 500 degrees	42"	1,050 mm	40.56 - 41.91"	1,030 - 1,065 mm	29 lbs	13.20 kg
RP44/HR	44" Rapid Purge - Heat Resistant up to 500 degrees	44"	1,100 mm	42.52 - 43.90"	1,080 - 1,115 mm	30 lbs	13.70 kg
RP46/HR	46" Rapid Purge - Heat Resistant up to 500 degrees	46"	1,150 mm	44.29 - 45.67"	1,125 - 1,160 mm	32 lbs	14.50 kg
RP48/HR	48" Rapid Purge - Heat Resistant up to 500 degrees	48"	1,200 mm	46.46 - 47.82"	1,180 - 1,215 mm	33 lbs	15.00 kg
RP50/HR	50" Rapid Purge - Heat Resistant up to 500 degrees	50"	1,250 mm	48.42 - 49.80"	1,230 - 1,265 mm	35 lbs	16.00 kg
RP52/HR	52" Rapid Purge - Heat Resistant up to 500 degrees	52"	1,300 mm	50.59 - 51.97"	1,285 - 1,320 mm	37 lbs	17.00 kg
RP54/HR	54" Rapid Purge - Heat Resistant up to 500 degrees	54"	1,350 mm	52.36 - 53.74"	1,330 - 1,365 mm	39 lbs	18.00 kg
RP60/HR	60" Rapid Purge - Heat Resistant up to 500 degrees	60"	1,500 mm	58.46 - 59.84"	1,485 - 1,520 mm	44 lbs	20.00 kg
RP72/HR	72" Rapid Purge - Heat Resistant up to 500 degrees	72"	1,800 mm	70.27 - 71.65"	1,785 - 1,820 mm	62 lbs	28.00 kg
RP80/HR	80" Rapid Purge - Heat Resistant up to 500 degrees	80"	2,000 mm	78.35 - 79.72"	1,990 - 2,025 mm	66 lbs	30.00 kg

Larger sizes and custom solutions available upon request with 35 mm / 1.37" expansion range

The Heat Resistant Purge Bag comes with fittings:
International = 21 KA series male connector
Americas = ¼" (0.25") NPT male connector



Sizes: 3/4 - 12" / 16 - 320 mm

Purge pipes fast with minimal gas usage

PPM also manufactures the silicone Double Seal purging system that has been designed to further reduce both inert gas use and purging time. This system uses silicon discs to form an airtight seal, reducing purge times and gas usage for maximum efficiency.

There are 2 styles of silicon Double Seal systems available:

- the Gas Finger system is designed for small pipes and tubes from 3/4 - 1.5" / 16 - 38 mm
- the Double Seal system is made for pipes from 3/4 - 12" / 16 - 320 mm

FEATURES AND ADVANTAGES

- Extremely short purge times resulting in valuable cost savings
- Typical purge times of less than 2 minutes (e.g. an 8" pipe will purge to below 0.01% oxygen in less than 2 minutes)
- High quality silicon sealing discs that prevent them tilting or falling over inside the pipe
- Guaranteed gas tight seal
- UV and temperature resistant up to 330°C (626°F) continuously or 450°C (842°F) for short periods
- Suitable for purging pipes, elbows and fittings
- The silicon seal units can be separated and used as a gas finger and pipe stopper respectively
- Fully interchangeable and individually exchangeable system, reducing cost of ownership



Available as a kit in 3 sizes:

DSK16-165 (16 - 165 mm i/d)

DSK16-220 (16 - 220 mm i/d)

DSK16-320* (16 - 320 mm i/d)

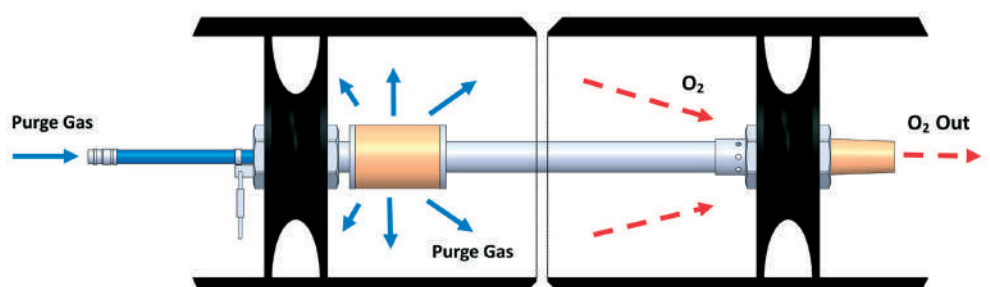
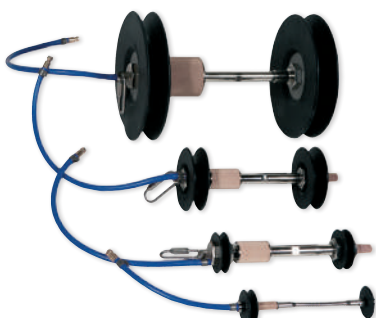
*** Contains two cases**

HOW IT WORKS

The gas inlet and outlet are provided with twin sealing discs separated by a flexible, rigid or a spring-type tube. The design guarantees that at least one disc will always remain tight to the pipe wall creating a 100% seal. The discs are UV and temperature-resistant up to 330°C (626°F) continuously or up to 450°C (842°F) for short periods. The gas is diffused into the chamber via the built-in centred diffuser and exits through the exhaust holes in the secondary twin disc unit.

This extremely short process of gas diffusion provides an equal gas flow and prevents any gas turbulence behind the weld, thereby minimising the risk of oxygen re-entering the welding chamber.

Besides the very short purging time, the double seal system also offers the possibility to cover various nominal pipe diameters by one pair of seals enabling highly economic use of the device. The double seal system can be purchased individually or in kit form for a range of pipe diameters.



DOUBLE SEAL KITS SIZING AND SPECIFICATION - **RECOMMENDED**

PART NO.	DESCRIPTION	PIPE I/D RANGE		WEIGHT (LBS / KG)		CONNECTOR LENGTH
DSK16-165	Double Seal Kit - complete kit 16 - 165 mm i/d	0.62 - 6.49"	16 - 165 mm	24 lbs	11.00 kg	Variable - check kit list
DSK16-220	Double Seal Kit - complete kit 16 - 220 mm i/d	0.62 - 8.66"	16 - 220 mm	33 lbs	15.00 kg	Variable - check kit list
DSK16-320	Double Seal Kit - complete kit 16 - 320 mm i/d	0.62 - 12.59"	16 - 320 mm	42 lbs	19.00 kg	Variable - check kit list

DOUBLE SEAL GAS FINGERS SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	PIPE I/D RANGE		WEIGHT (LBS / KG)		CONNECTOR LENGTH
DSF16-19	Double Seal Gas Finger 16 - 19 mm i/d	0.62 - 0.74"	16 - 19 mm	0.5 lbs	0.20 kg	n/a
DSF19-24	Double Seal Gas Finger 19 - 24 mm i/d	0.74 - 0.94"	19 - 24 mm	0.5 lbs	0.20 kg	n/a
DSF24-29	Double Seal Gas Finger 24 - 29 mm i/d	0.94 - 1.14"	24 - 29 mm	0.5 lbs	0.20 kg	n/a
DSF29-34	Double Seal Gas Finger 29 - 34 mm i/d	1.14 - 1.33"	29 - 34 mm	0.6 lbs	0.30 kg	n/a
DSF34-38	Double Seal Gas Finger 34 - 38 mm i/d	1.33 - 1.49"	34 - 38 mm	0.6 lbs	0.30 kg	n/a

DOUBLE SEAL PURGE SYSTEM SIZING AND SPECIFICATION

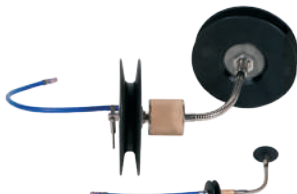
PART NO..	DESCRIPTION	PIPE I/D RANGE		WEIGHT (LBS / KG)		CONNECTOR LENGTH
DS16-19	Double Seal purge system - Flexible 16 - 19 mm i/d	0.62 - 0.74"	16 - 19 mm	1.5 lbs	0.65 kg	3.94" / 100 mm
DS19-24	Double Seal purge system - Flexible 19 - 24 mm i/d	0.74 - 0.94"	19 - 24 mm	1.5 lbs	0.70 kg	3.94" / 100 mm
DS24-29	Double Seal purge system - Flexible 24 - 29 mm i/d	0.94 - 1.14"	24 - 29 mm	1.5 lbs	0.75 kg	3.94" / 100 mm
DS29-34	Double Seal purge system - Flexible 29 - 34 mm i/d	1.14 - 1.33"	29 - 34 mm	1.5 lbs	0.75 kg	3.94" / 100 mm
DS34-38	Double Seal purge system - Flexible 34 - 38 mm i/d	1.33 - 1.49"	34 - 38 mm	1.5 lbs	0.80 kg	3.94" / 100 mm

DS38-43 to DS290-320 are supplied with rigid connector as standard
Optional flexible connectors are available as accessory in two lengths FC120 (4.7" / 120 mm) / FC240 (9.4" / 240 mm)

DS38-43	Double Seal purge system - Rigid 38 - 43 mm i/d	1.49 - 1.69"	38 - 43 mm	1.5 lbs	0.85 kg	3.94" / 100 mm
DS43-48	Double Seal purge system - Rigid 43 - 48 mm i/d	1.69 - 1.88"	43 - 48 mm	2 lbs	0.90 kg	3.94" / 100 mm
DS47-53	Double Seal purge system - Rigid 47 - 53 mm i/d	1.85 - 2.08"	47 - 53 mm	2 lbs	0.95 kg	3.94" / 100 mm
DS52-58	Double Seal purge system - Rigid 52 - 58 mm i/d	2.04 - 2.28"	52 - 58 mm	2 lbs	1.00 kg	3.94" / 100 mm
DS64-72	Double Seal purge system - Rigid 64 - 72 mm i/d	2.51 - 2.83"	64 - 72 mm	2 lbs	1.10 kg	3.94" / 100 mm
DS78-86	Double Seal purge system - Rigid 78 - 86 mm i/d	3.07 - 3.38"	78 - 86 mm	3 lbs	1.20 kg	3.94" / 100 mm
DS90-101	Double Seal purge system - Rigid 90 - 101 mm i/d	3.54 - 3.97"	90 - 101 mm	3 lbs	1.30 kg	3.94" / 100 mm
DS100-112	Double Seal purge system - Rigid 100 - 112 mm i/d	3.93 - 4.40"	100 - 112 mm	3 lbs	1.40 kg	3.94" / 100 mm
DS120-130	Double Seal purge system - Rigid 120 - 130 mm i/d	4.72 - 5.11"	120 - 130 mm	3 lbs	1.50 kg	3.94" / 100 mm
DS124-138	Double Seal purge system - Rigid 124 - 138 mm i/d	4.88 - 5.43"	124 - 138 mm	3 lbs	1.60 kg	3.94" / 100 mm
DS144-155	Double Seal purge system - Rigid 144 - 155 mm i/d	5.66 - 6.10"	144 - 155 mm	4 lbs	1.70 kg	3.94" / 100 mm
DS150-165	Double Seal purge system - Rigid 150 - 165 mm i/d	5.90 - 6.49"	150 - 165 mm	4 lbs	1.80 kg	7.08" / 180 mm
DS197-206	Double Seal purge system - Rigid 197 - 206 mm i/d	7.75 - 8.11"	197 - 206 mm	4 lbs	2.00 kg	7.08" / 180 mm
DS209-220	Double Seal purge system - Rigid 209 - 220 mm i/d	8.22 - 8.66"	209 - 220 mm	5 lbs	2.20 kg	7.08" / 180 mm
DS246-257	Double Seal purge system - Rigid 246 - 257 mm i/d	9.68 - 10.11"	246 - 257 mm	5 lbs	2.40 kg	7.08" / 180 mm
DS260-280	Double Seal purge system - Rigid 260 - 280 mm i/d	10.23 - 11.02"	260 - 280 mm	5 lbs	2.60 kg	7.08" / 180 mm
DS290-320	Double Seal purge system - Rigid 290 - 320 mm i/d	11.41 - 12.59"	290 - 320 mm	6 lbs	3.00 kg	7.08" / 180 mm



Single Gas Finger for smaller pipe and tubes



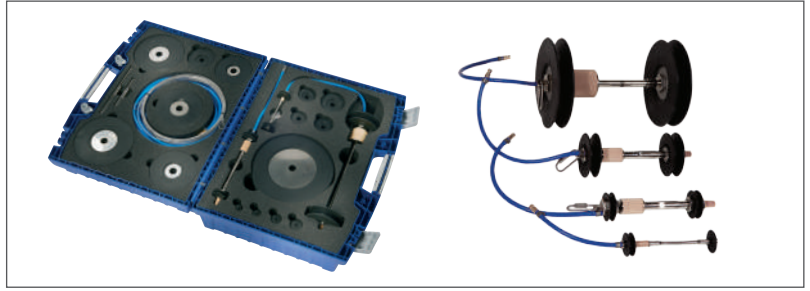
Shown with flexible hose connection for purging elbows and fittings.



Included in the case (depending on model)*

- Single replacement seals 16 - 38 mm i/d
- Pair of replacement seals 38 - 280 mm i/d
- Pair of double replacement seals 290 - 320 mm i/d
- Flexible and rigid connectors
- Gas inlet / gas outlet
- Gas diffuser
- Draw wire, gas hose

* DSK16-320 contains two cases



PART NO.	PIPE I/D RANGE		DSK16-165	DSK16-220	DSK16-320*	PICTURE
SEAL DISC (SINGLE) - 3 units of each size, per case						
RSF16-19	0.62 - 0.74"	16 - 19 mm	•	•	•	
RSF19-24	0.74 - 0.94"	19 - 24 mm	•	•	•	
RSF24-29	0.94 - 1.14"	24 - 29 mm	•	•	•	
RSF29-34	1.14 - 1.33"	29 - 34 mm	•	•	•	
RSF34-38	1.33 - 1.49"	34 - 38 mm	•	•	•	
SEAL DISC (PAIR) - 2 pairs of each size, per case (depending on model)						
RS38-43	1.49 - 1.69"	38 - 43 mm	•	•	•	
RS43-48	1.69 - 1.88"	43 - 48 mm	•	•	•	
RS47-53	1.85 - 2.08"	47 - 53 mm	•	•	•	
RS52-58	2.04 - 2.28"	52 - 58 mm	•	•	•	
RS64-72	2.51 - 2.83"	64 - 72 mm	•	•	•	
RS78-86	3.07 - 3.38"	78 - 86 mm	•	•	•	
RS90-101	3.54 - 3.97"	90 - 101 mm	•	•	•	
RS100-112	3.93 - 4.40"	100 - 112 mm	•	•	•	
RS120-130	4.72 - 5.11"	120 - 130 mm	•	•	•	
RS124-138	4.88 - 5.43"	124 - 138 mm	•	•	•	
RS144-155	5.66 - 6.10"	144 - 155 mm	•	•	•	
RS150-165	5.90 - 6.49"	150 - 165 mm	•	•	•	
RS197-206	7.75 - 8.11"	197 - 206 mm	-	•	•	
RS209-220	8.22 - 8.66"	209 - 220 mm	-	•	•	
RS246-257	9.68 - 10.11"	246 - 257 mm	-	-	•	
RS260-280	10.23 - 11.02"	260 - 280 mm	-	-	•	
DOUBLE SEAL (PAIR) - 2 pairs in DSK16-320						
RS290-320	11.41 - 12.59"	290 - 320 mm	-	-	•	

Flexible connector 100 mm | 120 mm | 240 mm



Rigid connector

5 mm | 100 mm | 180 mm



Gas inlet

M6 x 35 mm | M16 16 mm | M20 20 mm



Gas outlet

M6 6 mm | M16 16 mm | M20 20 mm



Gas diffuser

10 x 14 mm | 25 x 35 mm | 50 x 45 mm

Exhaust diffuser M10 10 mm



Stainless steel nuts

M6 - 6 mm | M16 - 16 mm | M20 - 20 mm

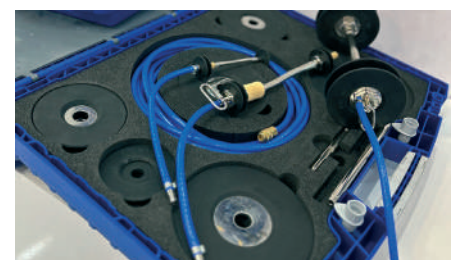
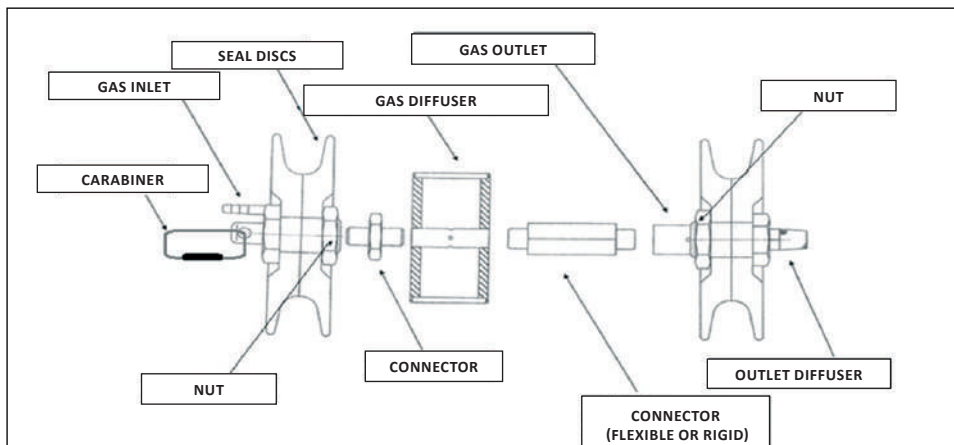


Draw wire 2 mm x 10 meters

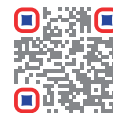
Gas hose 10 meters



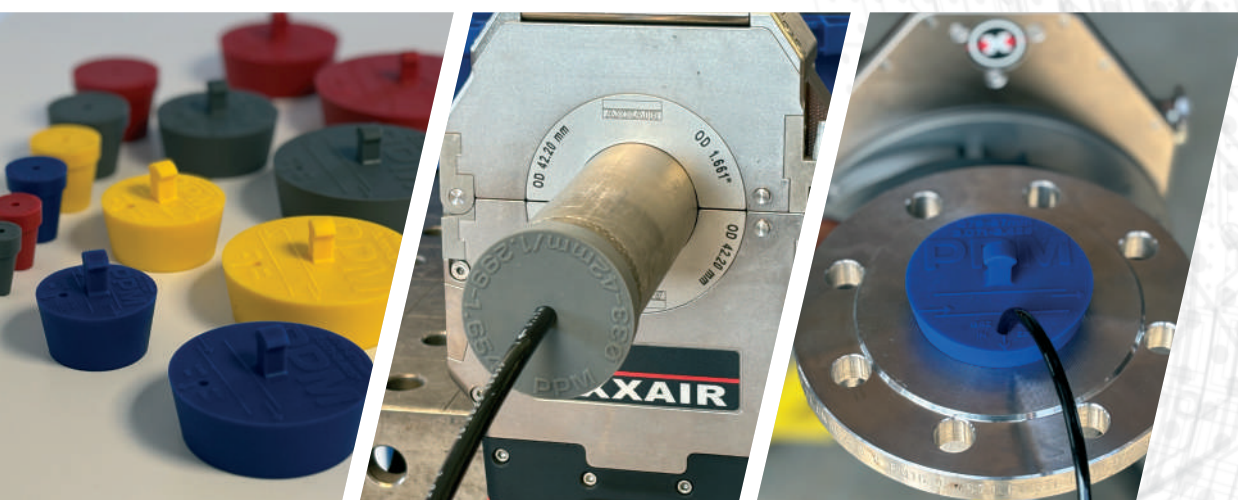
DOUBLE SEAL SYSTEM CONFIGURATION



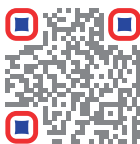
WELDPURE PURGE PLUGS



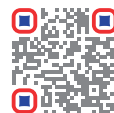
0.35 - 4.33" / 9 - 110 mm i/d



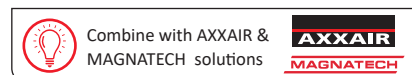
SCAN QR CODE
TO WATCH VIDEO



AN EGG GROUP BRAND



Sizes: 0.35 - 4.33" / 9 - 110 mm i/d



Purging kit for optimal welding quality

Achieve flawless welds with our all-in-one purging solution designed for precision, efficiency, and durability. Engineered to deliver superior oxygen removal and consistent gas flow, this kit ensures perfect conditions for high-quality welds every time.

FEATURES AND ADVANTAGES

- Optimized gas flow with an off-center gas inlet and outlet: ensures superior oxygen removal for high-quality results.
- Gas diffuser: provides consistent and efficient gas distribution.
- Professional storage case: the kit is neatly organized in a robust, custom foam-lined case, offering maximum protection and easy access during transport or on-site use.
- Each plug is clearly marked with its diameter range for quick selection and simplified operation.

OPERATION AND PURGING TECHNOLOGY

Our WeldPure purging system has been specifically designed to ensure optimal and uniform purging of the welding zone. Depending on the plug size, it features an off-center gas inlet and outlet - a unique solution on the market - allowing for progressive and directional diffusion of the inert gas inside the pipe. This distinctive design promotes efficient oxygen displacement, prevents the formation of stagnant air pockets, and ensures a perfectly inert atmosphere at the weld joint. The gas is distributed in a controlled manner through the integrated diffuser, providing a stable and consistent flow for reliable, repeatable welding quality.

The result: faster, more reliable purging and welds of impeccable quality, even for the most demanding applications.

The WeldPure purge plug system can be purchased individually or in kit form for a range of pipe diameters.



Included in the kit:

14 plug sizes: from 0.35 - 4.33" / 9 - 110 mm

1 gas diffuser

1 polyurethane gas hose (5 m)

Quick-connect fitting for simplified connection to the AXXAIR SAXX power supply

Standard fitting for gas cylinder

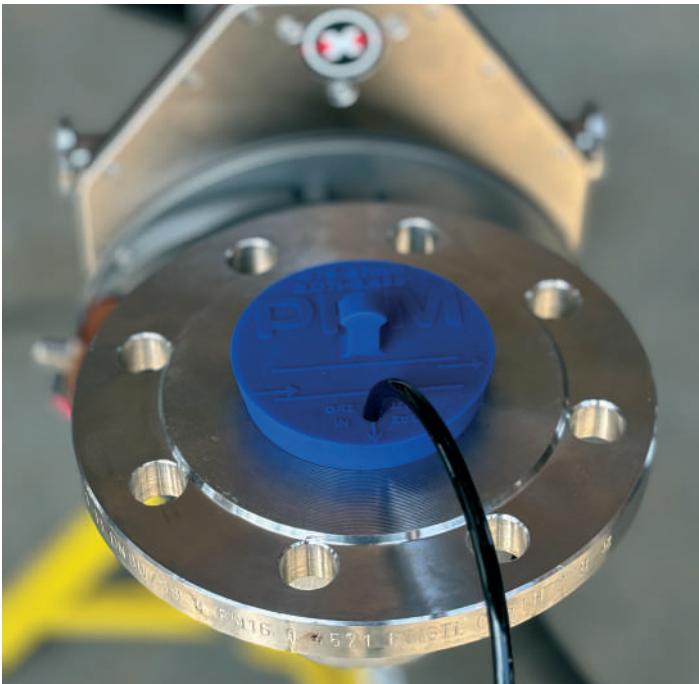
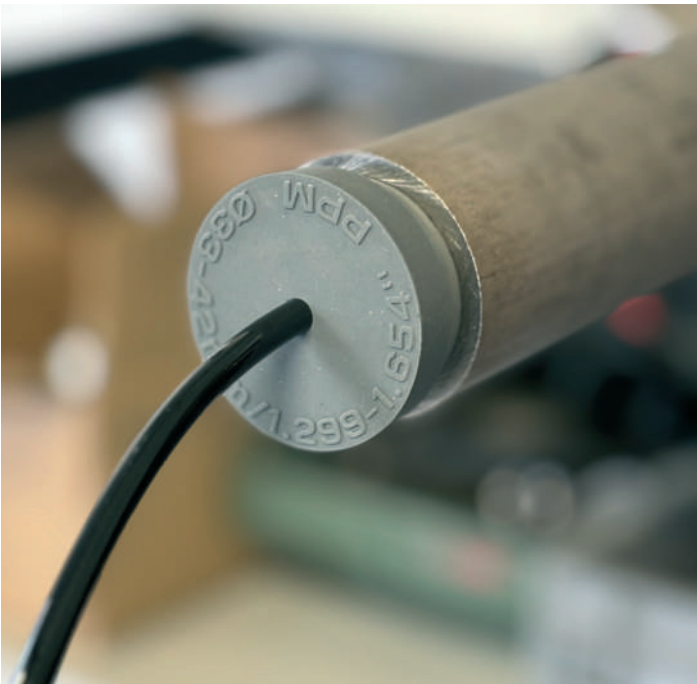


WELDPURE PURGE PLUG KIT SIZING AND SPECIFICATION - **RECOMMENDED**

PART NO.	DESCRIPTION	PIPE I/D RANGE		WEIGHT (LBS / KG)	
SPSK09-110	WeldPure purge plug Kit - complete kit 9 - 110 mm i/d	0.35 - 4.33"	9 - 110 mm	9.5 lbs	4.3 kg

WELDPURE PURGE PLUGS SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	PIPE I/D RANGE		WEIGHT (LBS / KG)	
SPS09-16	WeldPure purge plug (pair) - 9 - 16 mm i/d	0.35 - 0.62"	9 - 16 mm	0.03 lbs	0.014 kg
SPS15-22	WeldPure purge plug (pair) - 15 - 22 mm i/d	0.74 - 0.94"	15 - 22 mm	0.06 lbs	0.029 kg
SPS21-28	WeldPure purge plug (pair) - 21 - 28 mm i/d	0.94 - 1.14"	21 - 28 mm	0.09 lbs	0.040 kg
SPS27-34	WeldPure purge plug (pair) - 27 - 34 mm i/d	1.14 - 1.33"	27 - 34 mm	0.13 lbs	0.058 kg
SPS33-42	WeldPure purge plug (pair) - 33 - 42 mm i/d	1.33 - 1.49"	33 - 42 mm	0.19 lbs	0.087 kg
SPS41-49	WeldPure purge plug (pair) - 41 - 49 mm i/d	1.49 - 1.69"	41 - 49 mm	0.26 lbs	0.117 kg
SPS48-56	WeldPure purge plug (pair) - 48 - 56 mm i/d	1.69 - 1.88"	48 - 56 mm	0.24 lbs	0.110 kg
SPS55-64	WeldPure purge plug (pair) - 55 - 64 mm i/d	1.85 - 2.08"	55 - 64 mm	0.34 lbs	0.154 kg
SPS63-72	WeldPure purge plug (pair) - 63 - 72 mm i/d	2.04 - 2.28"	63 - 72 mm	0.39 lbs	0.178 kg
SPS71-79	WeldPure purge plug (pair) - 71 - 79 mm i/d	2.51 - 2.83"	71 - 79 mm	0.44 lbs	0.198 kg
SPS78-87	WeldPure purge plug (pair) - 78 - 87 mm i/d	3.07 - 3.38"	78 - 87 mm	0.51 lbs	0.233 kg
SPS86-95	WeldPure purge plug (pair) - 86 - 95 mm i/d	3.54 - 3.97"	86 - 95 mm	0.58 lbs	0.264 kg
SPS94-103	WeldPure purge plug (pair) - 94 - 103 mm i/d	3.93 - 4.40"	94 - 103 mm	0.66 lbs	0.298 kg
SPS101-110	WeldPure purge plug (pair) - 101 - 110 mm i/d	4.72 - 5.11"	101 - 110 mm	0.71 lbs	0.321 kg





PURGE OXYGEN MONITOR



0.01 % - 20.9 % Oxygen (O_2) / 100 ppm - 209,000 ppm



AN OGG GROUP BRAND



Self calibrating

The welders' toolbox monitor

Inert gas welding requires the exclusion of oxygen from the weld zone during the welding process. Prior to the welding process, the residual oxygen concentration must be reduced to a required minimum. The Handy Purge 100 is specifically designed to indicate oxygen concentration up to 0.01% and to exactly measure oxygen concentration up to 0.1%.

The Handy Purge 100 can be used both for continuous monitoring during the welding process and for taking samples. Routine inspections for quality control are extremely simplified using this device. The analyser works with all purge systems and argon welding systems. It is small, easy to handle and has a rugged enclosure.

FEATURES AND ADVANTAGES

- Self calibrating
- Minimum waiting time: the device indicates exactly when the residual oxygen concentration of a purge gas is low enough to start welding
- Reduced purge gas consumption: exact monitoring of the residual oxygen avoids unnecessary purge gas consumption and allows producing oxygen-free weld seams
- Top-quality weld seams
- Top quality is guaranteed, as too early welding and hence porous, coloured or even charred weld seams can be avoided
- Eliminates guess work



Plastic carry case box (HP100SCP7)



Replacement sensor (HP100SCS)

The kit consists of:

- Handy Purge 100 Monitor
- 1 m hose with flow adapter
- Stainless steel probe
- Vacuum hand pump
- Plastic carry case
- Instructions
- Calibration certificate

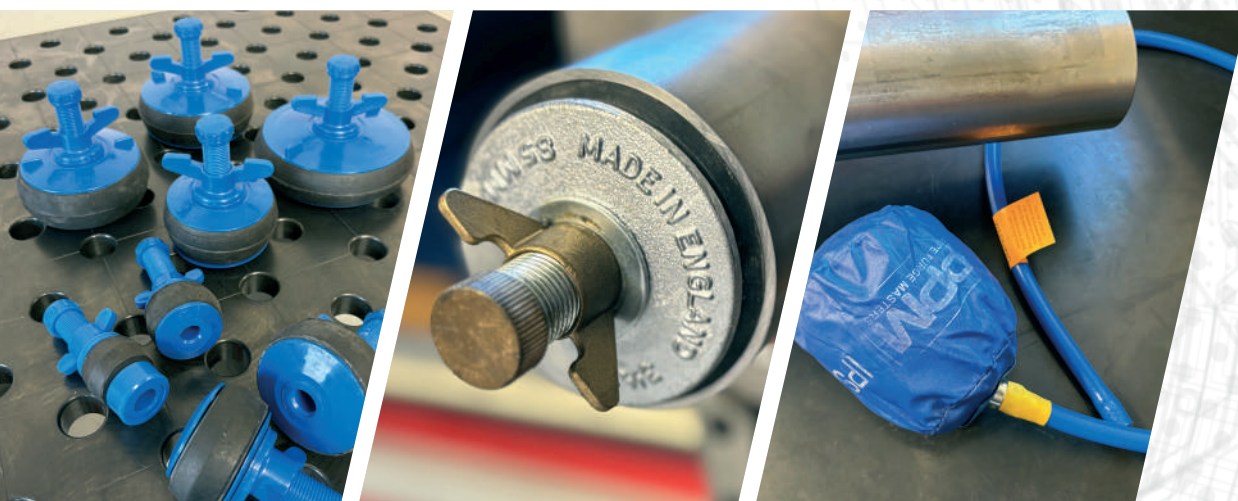
TECHNICAL SPECIFICATION

DESCRIPTION	MEASUREMENTS
Part Number	HP100SC
Measuring range	0.01 % - 20.9 % Oxygen (O ₂) (100 ppm - 209,000 ppm)
Accuracy	at 20% ± 0.2% at 2% ± 0.02%
Dimensions	6 x 3 x 1" / 155 x 81 x 38 mm
Power source	Battery type PP3 9V
Display	LCD (Liquid Crystal Display)
Weight	0.5 lbs / 0.20 kg
SHIPPING WEIGHTS AND DIMENSIONS	
Dimensions	9.05 x 7.48 x 1.96" / 230 x 190 x 50 mm
Weight	1.5 lbs / 0.60 kg



PIPE STOPPERS

1.5 - 72" / 40 - 1,800 mm





Expandable test plugs for purging and general pipe blocking

Pipe stoppers (or drain plugs) 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 pipe work systems that are under repair.

PPM's range of pipe stoppers is available in a number of different styles to suit many applications for pipe sizes. Bespoke pipe stoppers are also available upon request for pressure testing.

HOW IT WORKS

The pipe stopper consists of a central spindle/shaft on which two plates are fitted with a natural rubber tyre (ring) between them. A wing nut on the shaft moves 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.



Sizes: 1.5 - 6" / 38 - 150 mm

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.



NYLON EXPANDING PIPE STOPPER SIZING AND SPECIFICATION

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		WEIGHT (LBS / KG)	
NES38	1.5"	38 mm	1.49 - 1.65"	38 - 42 mm	1.4"	36 mm	58 mm	n/a solid	15 psi	1 bar	1 lbs	0.05 kg
NES50	2"	50 mm	1.90 - 2.44"	48.5 - 62.2 mm	1.4"	36 mm	110 mm	0.5" bsp	15 psi	1 bar	1 lbs	0.05 kg
NES63	2.5"	63 mm	2.55 - 3.03"	65 - 77 mm	1.4"	36 mm	110 mm	0.5" bsp	10 psi	0.7 bar	1 lbs	0.10 kg
NES75	3"	75 mm	2.91 - 3.38"	74 - 86 mm	1.4"	36 mm	110 mm	0.5" bsp	10 psi	0.7 bar	1 lbs	0.10 kg
NES88	3.5"	88 mm	3.22 - 3.77"	82 - 96 mm	1.4"	36 mm	110 mm	0.5" bsp	10 psi	0.7 bar	1 lbs	0.10 kg
NES100	4"	100 mm	3.74 - 4.13"	95 - 105 mm	1.4"	36 mm	110 mm	0.5" bsp	5 psi	0.3 bar	1 lbs	0.15 kg
NES115	4.5"	115 mm	4.48 - 4.88"	114 - 124 mm	1.4"	36 mm	110 mm	0.5" bsp	5 psi	0.3 bar	1 lbs	0.20 kg
NES125	5"	125 mm	4.60 - 5.00"	117 - 127 mm	1.6"	40 mm	110 mm	0.5" bsp	5 psi	0.3 bar	1 lbs	0.20 kg
NES150	6"	150 mm	5.74 - 6.10"	146 - 155 mm	1.65"	42 mm	110 mm	0.5" bsp	5 psi	0.3 bar	1 lbs	0.25 kg

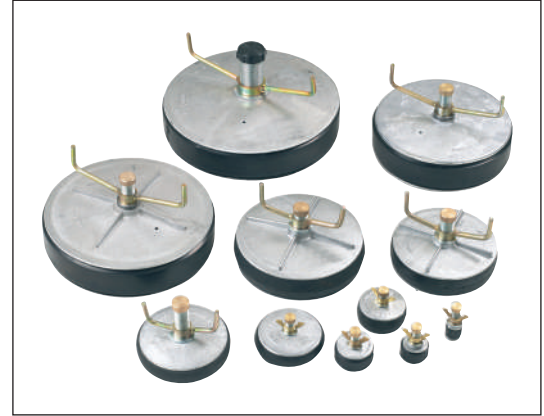
All plugs conform to British Standards BS8005 for low pressure testing and sealing of pipes.

Sizes: 1.5 - 24" / 40 - 600 mm

To complement the range of nylon expanding plugs, we offer all sizes of aluminium plugs.

These are provided in sizes from 1.5" / 40 mm upwards and are suitable for more heavy duty applications, heat resistant up to 90°C (194°F).

These plugs are typically used for general sealing of pipes and purging.



ALUMINIUM EXPANDING PIPE STOPPER SIZING AND SPECIFICATION

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		WEIGHT (LBS / KG)	
AES1.5	1.5"	40 mm	1.49 - 1.96"	38 - 50 mm	1.8"	45 mm	94 mm	0.5"	30 psi	2 bar	1 lbs	0.17 kg
AES2	2"	50 mm	1.92 - 2.44"	49 - 62 mm	1.7"	43 mm	90 mm	0.5"	30 psi	2 bar	1 lbs	0.22 kg
AES2.5	2.5"	65 mm	2.44 - 3.03"	62 - 77 mm	1.7"	43 mm	92 mm	0.5"	30 psi	2 bar	1 lbs	0.27 kg
AES3	3"	75 mm	2.87 - 3.50"	73 - 89 mm	1.7"	43 mm	94 mm	0.5"	20 psi	1.4 bar	1 lbs	0.31 kg
AES3.5	3.5"	90 mm	3.30 - 4.05"	84 - 103 mm	2.1"	53 mm	96 mm	0.5"	15 psi	1 bar	1 lbs	0.36 kg
AES4	4"	100 mm	3.70 - 4.33"	94 - 110 mm	1.9"	47 mm	94 mm	0.5"	10 psi	0.7 bar	1 lbs	0.36 kg
AES4.5	4.5"	114 mm	4.40 - 5.11"	112 - 130 mm	2.2"	56 mm	140 mm	0.5"	10 psi	0.7 bar	1 lbs	0.47 kg
AES5	5"	125 mm	4.92 - 5.59"	125 - 142 mm	2.3"	60 mm	95 mm	0.5"	10 psi	0.7 bar	1 lbs	0.79 kg
AES6	6"	150 mm	5.74 - 6.61"	146 - 168 mm	1.9"	48 mm	96 mm	0.5"	10 psi	0.7 bar	1 lbs	0.70 kg
AES7	7"	175 mm	6.88 - 7.87"	175 - 200 mm	2.5"	64 mm	100 mm	1"	7 psi	0.5 bar	4 lbs	1.92 kg
AES8	8"	200 mm	7.59 - 8.66"	193 - 220 mm	2.5"	64 mm	100 mm	1"	7 psi	0.5 bar	3 lbs	1.59 kg
AES9	9"	225 mm	8.66 - 9.44"	220 - 240 mm	2.5"	64 mm	170 mm	1"	7 psi	0.5 bar	4 lbs	2.06 kg
AES10	10"	250 mm	9.64 - 10.62"	245 - 270 mm	2.9"	73 mm	178 mm	1"	7 psi	0.5 bar	5 lbs	2.52 kg
AES11	11"	275 mm	10.78 - 12.91"	274 - 328 mm	4"	100 mm	200 mm	1"	7 psi	0.5 bar	7 lbs	3.45 kg
AES12	12"	300 mm	11.61 - 12.79"	295 - 325 mm	3"	77 mm	200 mm	1"	7 psi	0.5 bar	7 lbs	3.42 kg
AES14	14"	350 mm	13.77 - 15.15"	350 - 385 mm	4.3"	110 mm	215 mm	1"	5 psi	0.3 bar	15 lbs	6.95 kg
AES15	15"	375 mm	14.56 - 16.14"	370 - 410 mm	4.3"	110 mm	225 mm	1"	5 psi	0.3 bar	11 lbs	5.35 kg
AES16	16"	400 mm	15.35 - 17.12"	390 - 435 mm	4.3"	110 mm	225 mm	1"	5 psi	0.3 bar	13 lbs	5.90 kg
AES18	18"	450 mm	17.51 - 19.48"	445 - 495 mm	4.3"	110 mm	225 mm	2"	5 psi	0.3 bar	19 lbs	8.75 kg
AES20	20"	500 mm	19.48 - 21.65"	495 - 550 mm	5.7"	145 mm	255 mm	2"	5 psi	0.3 bar	24 lbs	11.3 kg
AES21	21"	525 mm	19.48 - 21.65"	495 - 550 mm	5.7"	145 mm	255 mm	2"	3 psi	0.2 bar	24 lbs	11.3 kg
AES24	24"	600 mm	21.65 - 25.59"	595 - 650 mm	5.7"	145 mm	255 mm	2"	3 psi	0.2 bar	34 lbs	15.85 kg

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

Sizes: 1.5 - 36" / 40 - 900 mm

PPM also manufactures a range of steel plugs from 1.5" / 40 mm upwards in diameter.

These plugs are typically suitable for more heavy duty applications, heat resistant up to 90°C (194°F).

These plugs are typically used for general sealing of pipes and purging.



**Steel
multilock
stopper**

STEEL EXPANDING PIPE STOPPER SIZING AND SPECIFICATION

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		WEIGHT (LBS / KG)	
SES1.5	1.5"	40 mm	1.45 - 1.96"	37 - 50 mm	1.2"	31 mm	81.5 mm	0.5"	30 psi	2 bar	1 lbs	0.16 kg
SES2	2"	50 mm	1.96 - 2.40"	50 - 61 mm	1.3"	32.7 mm	82.8 mm	0.5"	30 psi	2 bar	1 lbs	0.18 kg
SES2.5	2.5"	65 mm	2.40 - 2.95"	61 - 75 mm	1.3"	33.2 mm	80.5 mm	0.5"	30 psi	2 bar	1 lbs	0.26 kg
SES3	3"	75 mm	2.87 - 3.34"	73 - 85 mm	1.3"	34 mm	80.5 mm	0.5"	20 psi	1.4 bar	1 lbs	0.28 kg
SES3.5	3.5"	89 mm	3.30 - 3.93"	84 - 100 mm	1.6"	41 mm	81 mm	0.5"	15 psi	1 bar	1 lbs	0.36 kg
SES4	4"	100 mm	3.70 - 4.25"	94 - 108 mm	1.5"	37.5 mm	83.3 mm	0.5"	10 psi	0.7 bar	1 lbs	0.41 kg
SES4.5	4.5"	114 mm	4.33 - 4.92"	110 - 125 mm	1.6"	40 mm	83.3 mm	0.5"	10 psi	0.7 bar	1 lbs	0.58 kg
SES5	5"	125 mm	4.88 - 5.47"	124 - 139 mm	1.5"	37 mm	83.3 mm	0.5"	10 psi	0.7 bar	1 lbs	0.60 kg
SES6	6"	150 mm	5.90 - 6.29"	150 - 160 mm	1.6"	39.7 mm	83.3 mm	0.5"	10 psi	0.7 bar	2 lbs	0.75 kg
SES7	7"	175 mm	6.88 - 7.87"	175 - 200 mm	1.8"	46 mm	130 mm	1"	7 psi	0.5 bar	3 lbs	1.56 kg
SES8	8"	200 mm	7.67 - 8.46"	195 - 215 mm	1.5"	37 mm	130 mm	1"	7 psi	0.5 bar	3 lbs	1.47 kg
SES9	9"	225 mm	8.26 - 9.05"	210 - 230 mm	2.3"	58 mm	150 mm	1"	7 psi	0.5 bar	4 lbs	1.93 kg
SES10	10"	250 mm	9.64 - 10.23"	245 - 260 mm	2.2"	55 mm	150 mm	1"	7 psi	0.5 bar	6 lbs	2.55 kg
SES12	12"	300 mm	11.65 - 12.59"	296 - 320 mm	3.3"	85 mm	150 mm	1"	7 psi	0.5 bar	8 lbs	3.72 kg
SES14	14"	350 mm	13.38 - 15.15"	340 - 385 mm	3.3"	85 mm	210 mm	1"	5 psi	0.3 bar	14 lbs	6.54 kg
SES15	15"	375 mm	14.56 - 16.33"	370 - 415 mm	3.9"	100 mm	210 mm	1"	5 psi	0.3 bar	15 lbs	7.00 kg
SES16	16"	400 mm	15.35 - 16.92"	390 - 430 mm	3.7"	95 mm	210 mm	1"	5 psi	0.3 bar	19 lbs	8.45 kg
SES18	18"	450 mm	17.63 - 19.48"	448 - 495 mm	3.9"	100 mm	220 mm	1"	5 psi	0.3 bar	23 lbs	10.6 kg

Below stoppers are multilock

SES20	20"	500 mm	19.29 - 20.86"	490 - 530 mm	3.7"	95 mm	126 mm	2"	5 psi	0.3 bar	23 lbs	10.38 kg
SES21	21"	525 mm	20.27 - 21.85"	515 - 555 mm	3.7"	95 mm	126 mm	2"	3 psi	0.2 bar	25 lbs	11.28 kg
SES24	24"	600 mm	23.22 - 24.80"	590 - 630 mm	3.7"	95 mm	126 mm	2"	3 psi	0.2 bar	34 lbs	15.57 kg
SES28	28"	700 mm	27.16 - 28.74"	690 - 730 mm	3.7"	95 mm	126 mm	2"	3 psi	0.2 bar	44 lbs	19.90 kg
SES30	30"	750 mm	29.13 - 30.70"	740 - 780 mm	3.7"	95 mm	126 mm	2"	3 psi	0.2 bar	55 lbs	25.09 kg
SES32	32"	800 mm	31.10 - 32.67"	790 - 830 mm	3.7"	95 mm	125 mm	2"	3 psi	0.2 bar	64 lbs	28.90 kg
SES36	36"	900 mm	35.03 - 36.61"	890 - 930 mm	3.7"	95 mm	126 mm	2"	3 psi	0.2 bar	77 lbs	35.08 kg

**All plugs conform to British Standards BS8005 for low pressure testing and sealing of pipes.
Larger sizes available upon request.**



Sizes: 2 - 72" / 50 - 1,800 mm

Single inflatable dams for blocking and testing

PPM offers a range of inflatable stoppers in various shapes and sizes, suitable for many applications. Made from a natural rubber bladder covered in waterproof polyurethane coated nylon to prevent friction and static electricity build up.

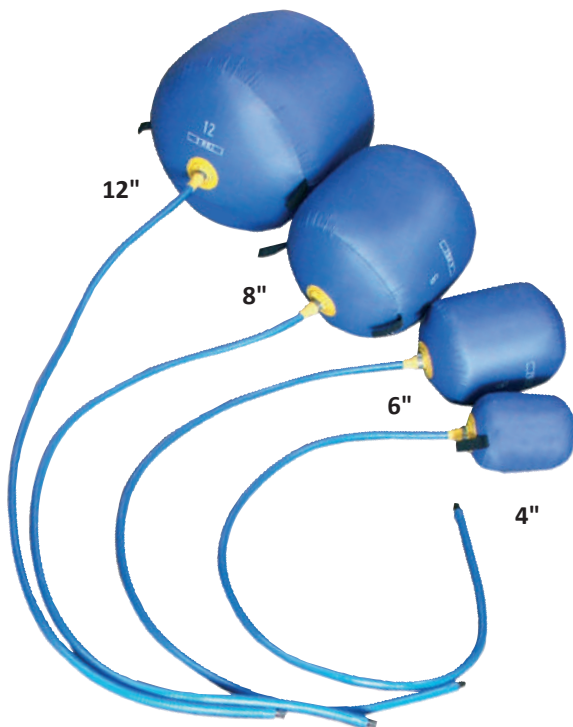
There are six different types available:

- **Cylindrical** - this stopper is generally used for blocking pipes where access is restricted
- **Spherical** - this stopper has less contact area than cylindrical stoppers, and is most suited to applications where access is further limited. Due to its shape the spherical inflatable stopper can be used at any angle
- **Square / rectangular** - this stopper has a variety of applications, including in air conditioning ducting and venting
- **Doughnut** - this stopper requires minimal space and is perfectly suited to larger diameter pipes as there is less inflation required
- **Sausage** - this stopper has more contact area between the stopper and the pipe wall enabling it to hold back more pressure
- **Heat resistant** - this stopper is made of a specially designed Kevlar and Nomex mix material to withstand temperatures up to 500°C (932°F) for applications involving higher temperatures such as pre heating



Holdback pressure - unsupported back pressure is 20% of the inflation pressure

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

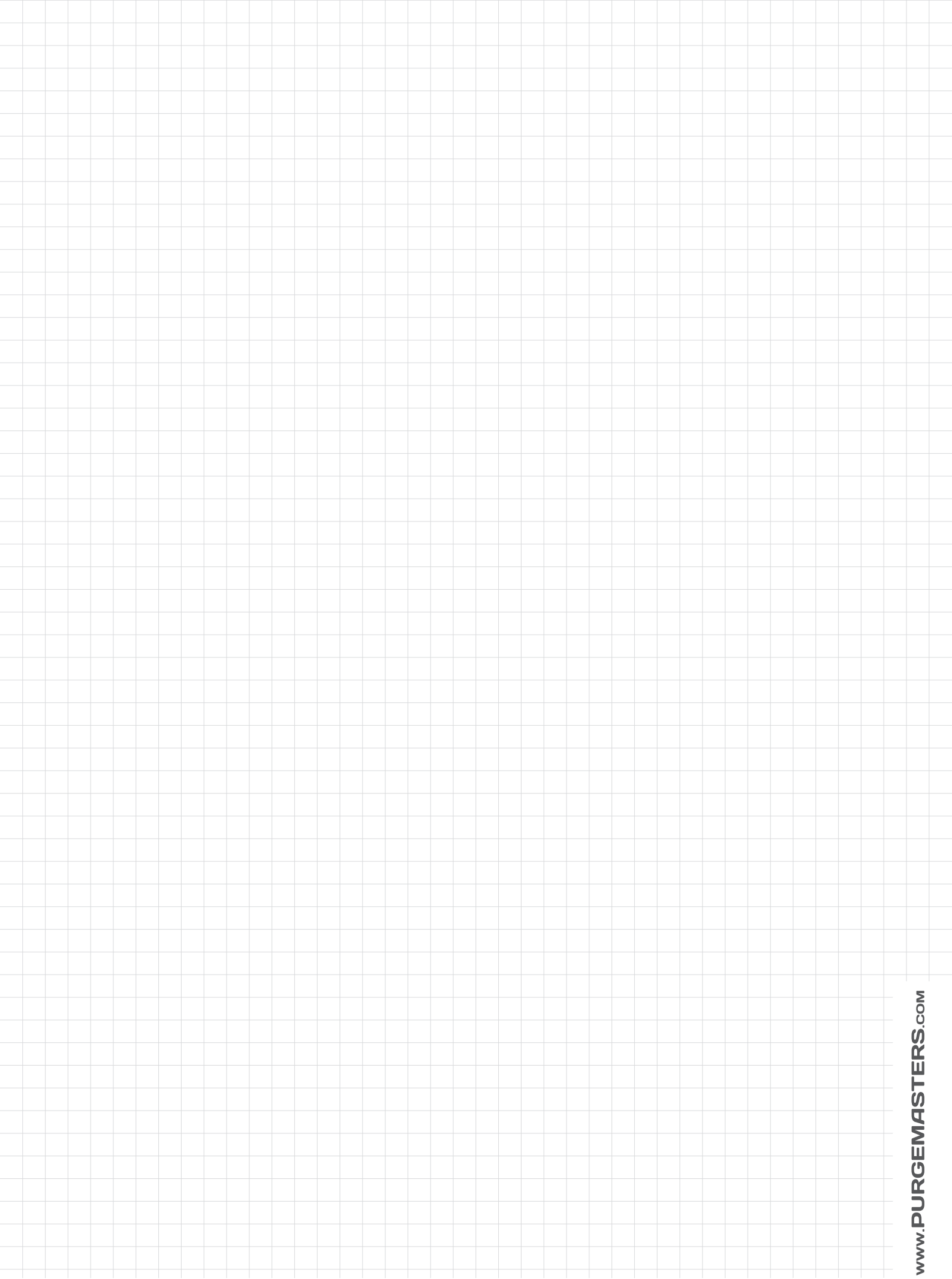


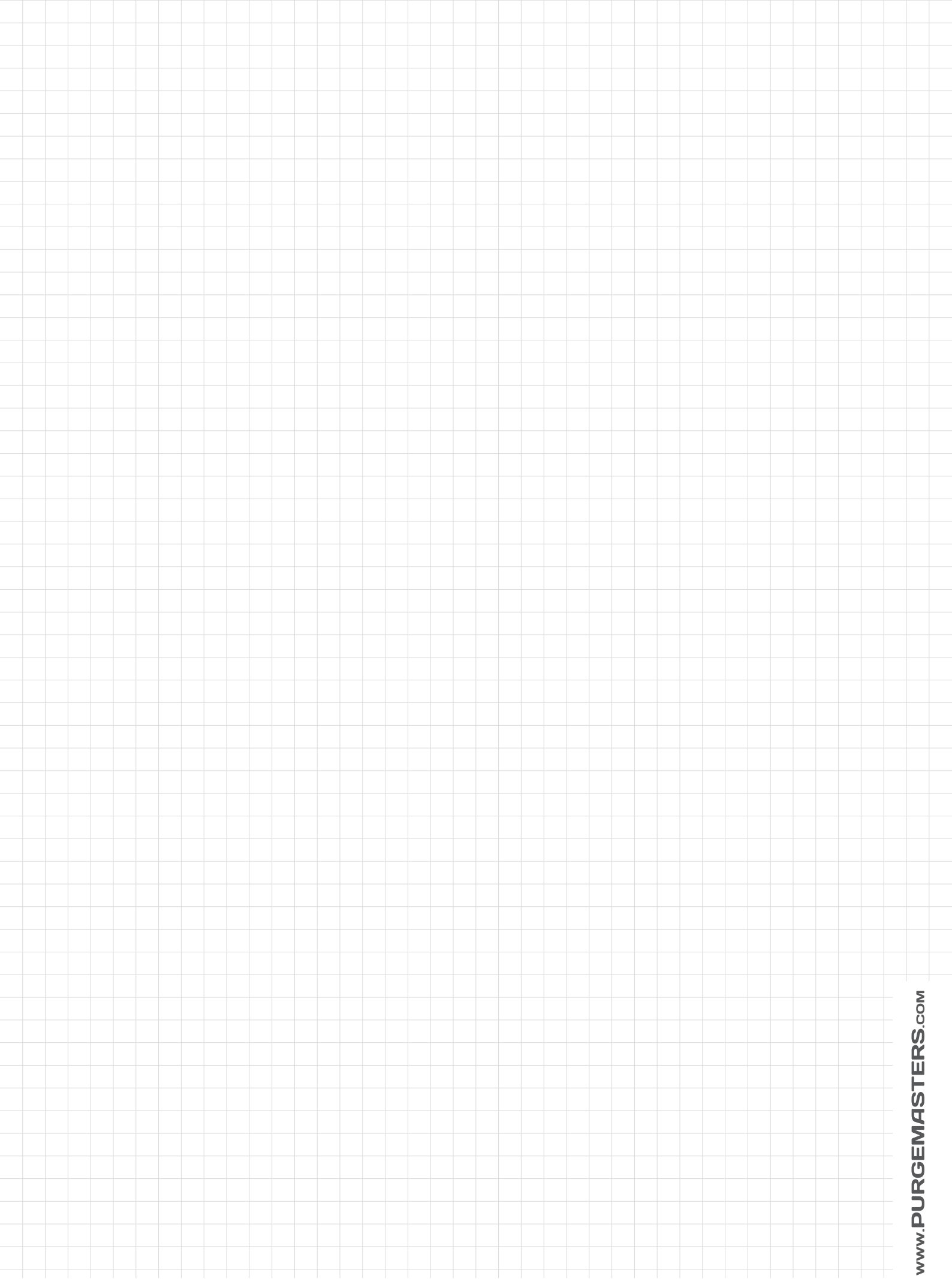
PPM's inflatable stoppers are supplied standard with no through tube. Through tubes can be supplied on request at extra cost when the stoppers are required for weld purging applications. When deflated, the inflatable stoppers can be inserted and withdrawn with ease when access is restricted.

INFLATABLE PIPE STOPPERS SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	NOMINAL PIPE SIZE		INTERNAL DIAMETER RANGE (I/D)		WEIGHT (LBS / KG)		INFLATION PRESSURE	
IPS2	2" Inflatable Pipe Stopper	2"	50 mm	1.77 - 2.16"	45 - 55 mm	0.74 lbs	0.34 kg	10 psi	0.7 bar
IPS3	3" Inflatable Pipe Stopper	3"	75 mm	2.75 - 3.14"	70 - 80 mm	0.74 lbs	0.34 kg	10 psi	0.7 bar
IPS4	4" Inflatable Pipe Stopper	4"	100 mm	3.74 - 4.13"	95 - 105 mm	0.74 lbs	0.34 kg	10 psi	0.7 bar
IPS5	5" Inflatable Pipe Stopper	5"	125 mm	4.72 - 5.11"	120 - 130 mm	0.83 lbs	0.38 kg	10 psi	0.7 bar
IPS6	6" Inflatable Pipe Stopper	6"	150 mm	5.70 - 6.10"	145 - 155 mm	0.83 lbs	0.38 kg	6 psi	0.4 bar
IPS7	7" Inflatable Pipe Stopper	7"	175 mm	6.69 - 7.08"	170 - 180 mm	1.54 lbs	0.70 kg	6 psi	0.4 bar
IPS8	8" Inflatable Pipe Stopper	8"	200 mm	7.67 - 8.07"	195 - 205 mm	2 lbs	0.90 kg	6 psi	0.4 bar
IPS9	9" Inflatable Pipe Stopper	9"	225 mm	8.66 - 9.05"	220 - 230 mm	2 lbs	0.95 kg	4 psi	0.3 bar
IPS10	10" Inflatable Pipe Stopper	10"	250 mm	9.64 - 10.03"	245 - 255 mm	2 lbs	1.00 kg	4 psi	0.3 bar
IPS11	11" Inflatable Pipe Stopper	11"	275 mm	10.62 - 11.02"	270 - 280 mm	2 lbs	1.05 kg	4 psi	0.3 bar
IPS12	12" Inflatable Pipe Stopper	12"	300 mm	11.61 - 12.00"	295 - 305 mm	2 lbs	1.10 kg	3 psi	0.2 bar
IPS13	13" Inflatable Pipe Stopper	13"	325 mm	12.59 - 12.99"	320 - 330 mm	3 lbs	1.20 kg	3 psi	0.2 bar
IPS14	14" Inflatable Pipe Stopper	14"	350 mm	13.58 - 13.97"	345 - 355 mm	3 lbs	1.30 kg	3 psi	0.2 bar
IPS15	15" Inflatable Pipe Stopper	15"	375 mm	14.56 - 14.96"	370 - 380 mm	3 lbs	1.50 kg	3 psi	0.2 bar
IPS16	16" Inflatable Pipe Stopper	16"	400 mm	15.55 - 15.94"	395 - 405 mm	4 lbs	1.70 kg	3 psi	0.2 bar
IPS17	17" Inflatable Pipe Stopper	17"	425 mm	16.53 - 16.92"	420 - 430 mm	4 lbs	1.75 kg	3 psi	0.2 bar
IPS18	18" Inflatable Pipe Stopper	18"	450 mm	17.51 - 17.91"	445 - 455 mm	4 lbs	1.80 kg	2 psi	0.1 bar
IPS19	19" Inflatable Pipe Stopper	19"	475 mm	18.50 - 18.89"	470 - 480 mm	4 lbs	1.85 kg	2 psi	0.1 bar
IPS20	20" Inflatable Pipe Stopper	20"	500 mm	19.48 - 19.88"	495 - 505 mm	4 lbs	1.90 kg	2 psi	0.1 bar
IPS21	21" Inflatable Pipe Stopper	21"	525 mm	20.47 - 20.86"	520 - 530 mm	5 lbs	2.20 kg	2 psi	0.1 bar
IPS22	22" Inflatable Pipe Stopper	22"	550 mm	21.45 - 21.85"	545 - 555 mm	5 lbs	2.40 kg	2 psi	0.1 bar
IPS24	24" Inflatable Pipe Stopper	24"	600 mm	23.42 - 23.81"	595 - 605 mm	5 lbs	2.50 kg	2 psi	0.1 bar
IPS28	28" Inflatable Pipe Stopper	28"	700 mm	27.36 - 27.75"	695 - 705 mm	5 lbs	2.70 kg	2 psi	0.1 bar
IPS30	30" Inflatable Pipe Stopper	30"	750 mm	29.33 - 29.72"	745 - 755 mm	6 lbs	3.00 kg	2 psi	0.1 bar
IPS32	32" Inflatable Pipe Stopper	32"	800 mm	31.29 - 31.69"	795 - 805 mm	7 lbs	3.40 kg	1.5 psi	0.1 bar
IPS34	34" Inflatable Pipe Stopper	34"	850 mm	33.26 - 33.66"	845 - 855 mm	7 lbs	3.60 kg	1.5 psi	0.1 bar
IPS36	36" Inflatable Pipe Stopper	36"	900 mm	35.23 - 35.62"	895 - 905 mm	8 lbs	3.80 kg	1 psi	0.07 bar
IPS42	42" Inflatable Pipe Stopper	42"	1,050 mm	41.34 - 41.73"	1,050 - 1,060 mm	11 lbs	5.00 kg	0.5 psi	0.03 bar
IPS44	44" Inflatable Pipe Stopper	44"	1,100 mm	43.11 - 43.50"	1,095 - 1,105 mm	12 lbs	5.50 kg	0.5 psi	0.03 bar
IPS48	48" Inflatable Pipe Stopper	48"	1,200 mm	47.04 - 47.44"	1,195 - 1,205 mm	13 lbs	6.00 kg	0.5 psi	0.03 bar
IPS54	54" Inflatable Pipe Stopper	54"	1,350 mm	53.35 - 53.74"	1,355 - 1,365 mm	17 lbs	7.50 kg	0.5 psi	0.03 bar
IPS60	60" Inflatable Pipe Stopper	60"	1,500 mm	58.85 - 59.25"	1,495 - 1,505 mm	19 lbs	8.50 kg	0.5 psi	0.03 bar
IPS72	72" Inflatable Pipe Stopper	72"	1,800 mm	71.45 - 71.85"	1,815 - 1,825 mm	24 lbs	11.00 kg	0.5 psi	0.03 bar

Pipe stoppers are supplied with Schrader valve.
Larger sizes available upon request with 10 mm / 0.39" expansion range.





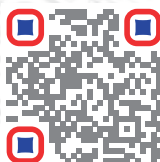


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