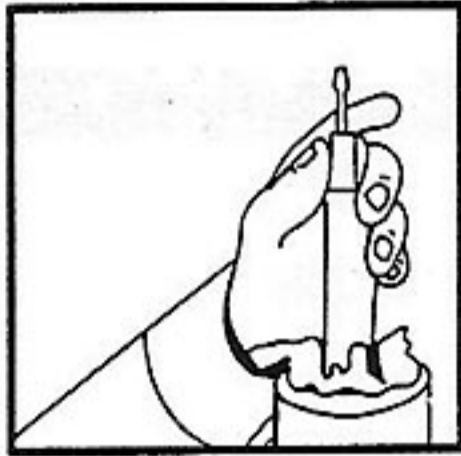


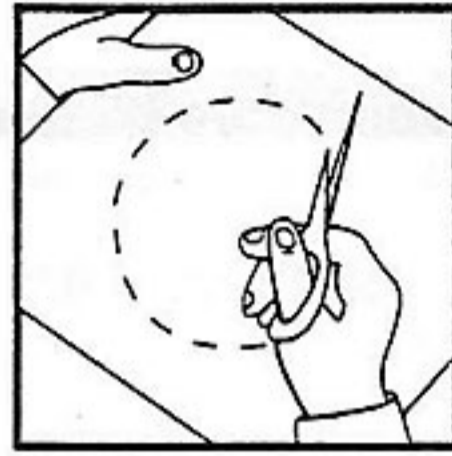
How to Use Dissolvo Purge Dams

Purge dam construction is easy with DISSOLVO paper and tape. Follow these step-by-step instructions.



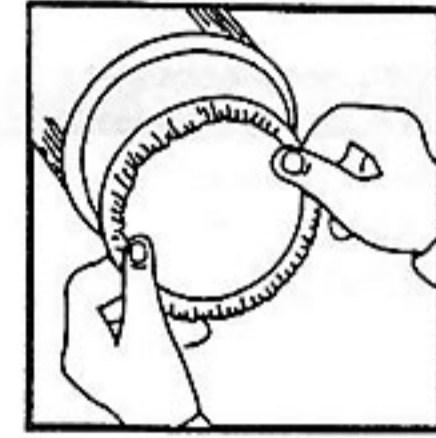
A

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



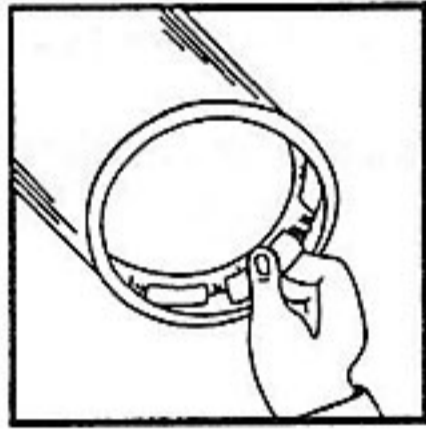
B

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



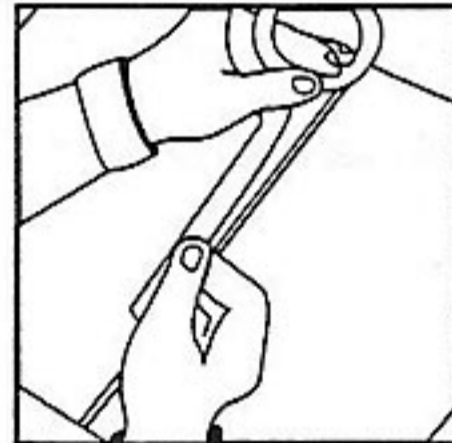
C

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



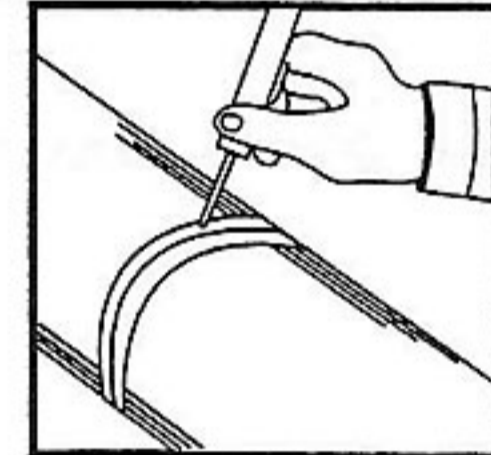
D

Peel tape from backing and tape dam in place. It may be desirable to punch a small hole in the dam to facilitate the evacuation of air when purging.



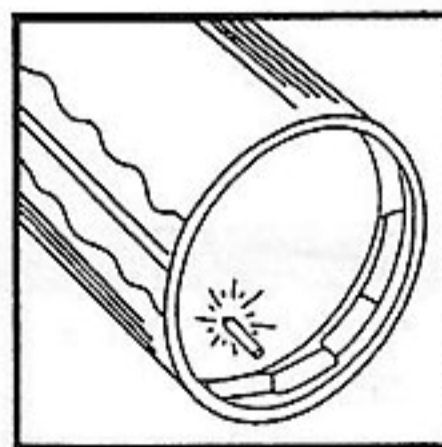
E

For pipes larger than 28" in 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. It may be desirable to cover the open root joint on the outside of the pipe with tape to prevent gas leakage.

**The purge damming process described above is covered by U.S. Pat. No. 3,736,400.*