

Aquasol[®] Purge Paper and Water Soluble Paper Tape: How it Works

Step 1:

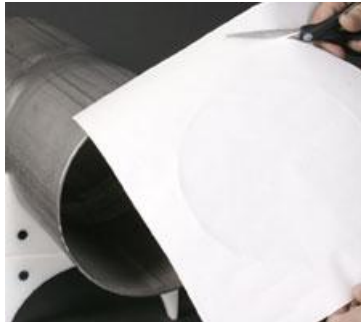
Clean area to be welded.



Clean area to be welded with wire brush.

Step 2:

Construct Dam.



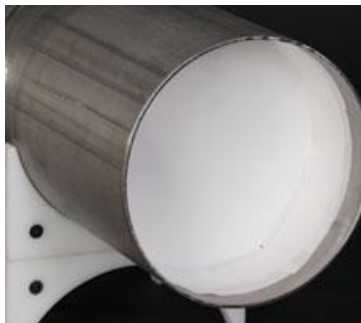
Trace the pipe's inner diameter on the paper by pressing against the pipe to create an impression of the pipe.

Cut Aquasol Paper into a circle with a diameter about 1.3 times the inner diameter of the pipe.

Slit approximately 1" to 2" segments perpendicular to impression on paper. Do not exceed inner diameter circle.

Step 3:

Insert Dam and tape in place.



Insert dam 6-8" from root gap with

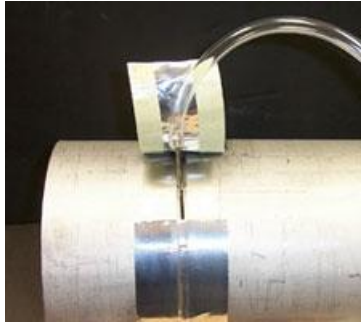
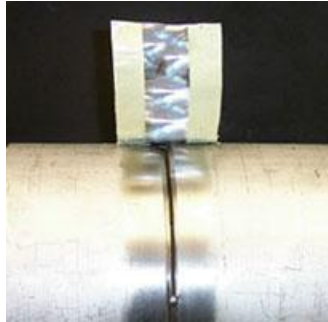
Tape dam in place.

Repeat Step 2. Insert and tape dam on

the lip toward the
weld preparation.

opposite pipe.

Step 4:
Introduce
gas and
weld.

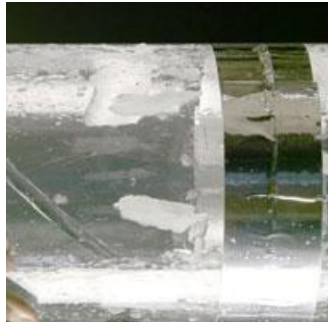


Cover root gap with
EZ Zone Tape, a
contaminant-free
gas retaining tape.

Insert purge gas
needle into root gap.
Ensure connection to
gas line.

Introduce noble gas
and start welding.

Step 5:
Dissolve
Aquasol
Water
Soluble
Purge
Dam.



Simulation of
hydro-test (flushing
line).