

## Quick Instruction guide for I-Purge®

1. Ensure I-Purge is fully assembled (i.e. modules are securely connected to harness).
2. If necessary, connect rope, chain, or wire to the pull loops on the ends of the bladder modules.
3. Connect inert gas lines to the blue and black hoses.

**BLUE** gas hose is required to inflate the purge bladders

**BLACK** gas hose is optional to expedite the purging process

4. Position the purge unit in the pipe to align the luminescent indicator as a guide to center the system across the root gap.
5. Turn the gas supply on to inflate the bladders and purge the weld zone.

*Recommended Flow Rates for Purging:* **BLUE** gas hose should transfer inert gas at 20-30 SCFH (10-15 LPM)

6. Once a tight seal has been achieved, commence welding.

*Recommended Flow Rates During Welding:* BLUE gas hose should transfer inert gas at 15-30 SCFH (7.5-15 LPM)

7. After the weld is complete, turn off the gas supply to deflate the bladders. Once the heat zone has sufficiently cooled, remove I-Purge from the pipe. Be sure to disconnect all gas lines and monitoring equipment.
8. Clean I-Purge and store in the provided carrying bag when it is not in use.

