



PURGING ACCESSORIES



PURGE BUNGS

Item number



PURGE HOSE with shutoff valve, 8 m

1.3.0126



SINTERED METAL VENT, 6 X 15 X 48 MM
(suitable for silicone plugs with 6 mm hole from tube, ID 15 mm)

1.3.0127



ALUMINIUM ADHESIVE TAPE, 50 x 0.09 mm, roll measuring 55 m

1.1.4129



PURGE BUNGS

- Conical
- Hole: Ø 6 mm | 0.236"
- Material: Silicone, clear
- Temperature-resistant up to 250 °C



Purge bungs for ID		
mm	inch	
10.5 – 14.5	0.413 – 0.571	1.3.5510
12.5 – 16.5	0.492 – 0.650	1.3.5512
14.0 – 18.0	0.551 – 0.709	1.3.5514
18.0 – 24.0	0.709 – 0.945	1.3.5518
23.0 – 29.0	0.906 – 1.142	1.3.5523
26.0 – 32.0	1.024 – 1.260	1.3.5526
29.0 – 35.0	1.142 – 1.378	1.3.5529
31.0 – 38.0	1.220 – 1.496	1.3.5531
36.0 – 44.0	1.417 – 1.732	1.3.5536
41.0 – 49.0	1.614 – 1.929	1.3.5541
47.0 – 55.0	1.850 – 2.165	1.3.5547
50.5 – 59.5	1.988 – 2.343	1.3.5550
56.0 – 65.0	2.205 – 2.559	1.3.5556
60.0 – 70.0	2.362 – 2.756	1.3.5560
64.5 – 75.5	2.539 – 2.972	1.3.5564
71.0 – 83.0	2.795 – 3.268	1.3.5571
79.0 – 92.0	3.110 – 3.622	1.3.5579
87.0 – 100.0	3.425 – 3.937	1.3.5587
94.0 – 107.0	3.701 – 4.213	1.3.5594



PURGE BUNGS SET

For an ID of 10.5 – 49 mm / 0.413" – 1.929" (10 x 2 bungs) in a case

1.3.5501

PURGE BUNGS SET

For an ID of 47 – 107 mm / 1.850" – 4.213" (9 x 2 bungs) in a case

1.3.5502



FLEXIBLE PURGE DAMS

- Saves gas and time
- Heat-resistant up to 340 °C
- Can be used in all positions
- Easy to pull through elbows

SC Profi, fully mounted with two sealing lips (340 °C), connecting axis and connection hose with a type 21 rectus nipple

Type	Connection	ID (mm)	ID (inch)	Item number
SC Profi Ø 17 mm	80 mm spring connection	13 – 16	0.512" – 0.630"	1.1.6017
SC Profi Ø 21 mm		16 – 20	0.630" – 0.787"	1.1.6021
SC Profi Ø 24 mm		18 – 23	0.709" – 0.906"	1.1.6024
SC Profi Ø 30 mm		23 – 29	0.906" – 1.141"	1.1.6030
SC Profi Ø 39 mm		29 – 38	1.141" – 1.496"	1.1.6039
SC Profi Ø 45 mm		36 – 43	1.417" – 1.693"	1.1.6045
SC Profi Ø 57 mm	120 mm flex connection	42 – 53	1.654" – 2.087"	1.1.6057
SC Profi Ø 60 mm		45 – 58	1.772" – 2.283"	1.1.6060
SC Profi Ø 70 mm		55 – 67	2.165" – 2.638"	1.1.6070
SC Profi Ø 82 mm	150 mm flex connection	68 – 80	2.677" – 3.150"	1.1.6082
SC Profi Ø 95 mm		79 – 92	3.110" – 3.622"	1.1.6095
SC Profi Ø 117 mm		98 – 114	3.858" – 4.488"	1.1.6117
SC Profi Ø 145 mm		120 – 136	4.724" – 5.354"	1.1.6145
SC Profi Ø 176 mm		150 – 168	5.905" – 6.614"	1.1.6176
SC Profi Ø 182 mm		155 – 170	6.102" – 6.693"	1.1.6182
SC Profi Ø 220 mm	250 mm flex connection	190 – 205	7.480" – 8.070"	1.1.6220
SC Profi Ø 231 mm		195 – 215	7.677" – 8.464"	1.1.6231

WS PLUS PURGE GAS CYLINDER



Type	ID (mm)	ID (inch)	Item number
WS Plus purge gas cylinder, 8" (340 °C)	180 - 215	7.086" – 8.465"	1.1.6180
WS Plus purge gas cylinder, 9" (340 °C)	215 - 240	8.465" – 9.449"	1.1.6215
WS Plus purge gas cylinder, 10" (340 °C)	240 - 265	9.449" – 10.433"	1.1.6240
WS Plus purge gas cylinder, 11" (340 °C)	265 - 290	10.433" – 11.417"	1.1.6265
WS Plus purge gas cylinder, 12" (340 °C)	290 - 315	11.417" – 12.402"	1.1.6290
WS Plus purge gas cylinder, 13" (340 °C)	315 - 330	12.402" – 12.992"	1.1.6315

Other flexible purge dams available on request.



10 M PULL ROPE (insulated) with carabiner hook

1.1.6232

FLEXIBLE PURGE DAMS / PURGE HOSE COUPLING

OD 6 mm

1.1.6234



Flexible purge dam / OXY measurement connection (from SC Profi Ø 57 mm) available on request.

MEASURING DEVICES

The first step to the perfect weld joint



Proper purging is absolutely essential to guarantee high-quality welding of high-alloyed, corrosion-resistant components.

Our Oxy EVO oxygen analyser can be connected to our orbital welding controllers for the purpose of inspecting and documenting the residual oxygen content and evaluated.

You are free to choose the value in ppm entered in the controller.

Unless specified otherwise, a value < 30 ppm is generally sufficient for starting welding. The controller will not allow welding to commence until the measured value drops below the entered value.

The equipment is calibrated so that it measures with an accuracy of ± 2 ppm in the welding-related area below 30 ppm in the case of inert gases.

Analysers that display values as percentages are not recommended
→ 0.1% = 1,000 ppm!

Examples of tempering colours:



7 ppm
0.0007%



27 ppm
0.0027%



500 ppm
0.05%

Oxy-SMART



OXY SMART OXYGEN ANALYSER, incl. accessories

- Battery-powered equipment
- For inert gases
- For gases containing H₂ (max. 10%)
- Measuring cell made of zirconium oxide (maintenance-free), long service life thanks to smart software
- Robust for use on construction sites (rubber protective frame)
- Dust- and splash-proof, also for use in high humidity
- Intuitive user guidance due to symbols
- Colour-illuminated display
- Battery charge indicator
- Error message if a fault occurs

1.2.5004

Measuring device technical data:

Measuring range	5 – 999 ppm O ₂
Dimensions (L x W x H)	160 mm x 80 mm x 35 mm
Weight	0.35 kg
Supply voltage	12 V
Charge cable	100 – 240 V with various adapter plugs
Battery life	9 h due to Li-ion technology



Package includes:

- Oxygen analyser
- Charging cable with adapter plugs for worldwide use
- Hose set, 1 m, incl. filter and probe
- Calibration certificate
- Transport case



SPARE PLASTIC HOSE for OXY SMART,
1 m, with particle filter and stainless steel probe

1.3.5016



SPARE FILTER

1.3.5015

OXYGEN ANALYSERS AND PURGE PRESSURE ANALYSERS

OXY EVO, OXY EVO PPA

Oxy-EVO



OXY EVO OXYGEN ANALYSER (Aurorange)

- Extremely easy menu navigation
- For inert gases and gases containing H₂ (max. 10%)
- Measuring cell made of zirconium oxide (maintenance-free)
- 3.5" colour touch display
- USB interface for exporting documentation
- Digital and analogue interface and Bluetooth for communication with our orbital welding controllers and other SPS
- Activation and evaluation exclusively using the digital interface
- User-definable threshold and alarm adjustment
- Acoustic signal generator
- Display has a coloured background outside the target values
- Aurorange 100 – 240 V

Technical data:

Measuring range	5 ppm – 21% O ₂
Ambient temperature	0 – 45 °C
Measuring accuracy	+/- 0.3 mV (EMK sensor)
Heat-up time	3 – 5 min
Response time	approx. 2 seconds for changes
Dimensions (L x W x H)	180 mm x 210 mm x 85 mm without handle
Mains voltage	100 – 240 V AC
Heating cycle load	approx. 40 VA
Standard load	approx. 20 VA
Weight	2.1 kg

Package includes:

- Oxygen analyser
- Power cable
- Hose set, 3 m, incl. filter and probe
- Calibration certificate
- Transport case



OXY EVO PPA OXYGEN ANALYSER (Aurorange)

The additionally installed purge pressure module can be used to measure the purge gas pressure inside the tube before and during welding. Perfectly flat, repeatable root formations can be achieved by regulating the internal pressure – especially for smaller tube diameters.

Documentation can take place by connecting to the TIGTRONIC ORBITAL, TIGTRONIC COMPACT and EVO controllers. Current values can also be saved on a USB stick following a previously defined interval.

Technical data (in addition to OXY EVO):

Input voltage	24 V (POWER supplied by Oxy EVO)
Calibrated measuring range	0 – 2,500 Pa

Package includes (in addition to OXY EVO):

- In-built purge pressure module
- 3 m measuring hose
- 6 mm T-piece
- Calibration certificate (pressure)



PPA COM CABLE FOR OXY EVO

for connecting to TIGTRONIC ORBITAL and EVO, 3 m

Item number

1.2.5000

Orbital welding systems

Welding tools

Welding accessories

Joint preparation

1.2.5003

Purging accessories

Measuring devices

1.3.5035

Service / general

PURGE PRESSURE ANALYSER



ACCESSORIES, PPA 2500

Item number



EVO COM CABLE FOR COMMUNICATION AND DOCUMENTATION

COM CABLE for OXY EVO for connecting to TIGTRONIC ORBITAL and EVO controllers

1.3.5011



USB DATA CABLE for OXY EVO for connecting to EVO and PC controllers, 2 m

1.2.5008



SPARE PLASTIC HOSE for OXY EVO, 3 m, with particle filter and stainless steel probe

1.3.5014



SPARE FILTER

1.3.5015



PPA 2500 PURGE PRESSURE ANALYSER

The PPA 2500 purge pressure analyser can measure the purge gas pressure inside the tube before and during welding. Perfectly flat, repeatable root formations can be achieved by regulating the internal pressure – especially for smaller tube diameters. Documentation can take place by connecting to the TIGTRONIC ORBITAL and EVO controllers.

1.3.5200

Technical data:

Input voltage	24 V (using the controller)
Calibrated measuring range	0 – 2.500 Pa
Weight	0.6 kg
Dimensions (L x W x H)	41 mm x 80 mm x 160 mm

Package includes:

- Purge pressure analyser
- Measuring hose
- 6 mm T-piece
- Calibration certificate
- Transport case