

## Types and Sizes

Type	Size/Format	Suggested Use
ASW-35	9" x 165'/roll 15 1/2" x 165'/roll 8 1/2" x 11" sheet 8 1/2" x 14" sheet 17" x 22" sheet	Use in pipes having 4 inches inner diameter or less.
ASW-40C	20 1/2" x 165'/roll	Water soluble coated paper used for greater volume of gas retention.
ASW-60	15 1/2" x 165'/roll 31" x 165'/roll 15 1/2" x 22" sheet	Use in pipes having 4 inches inner diameter or greater.
ASWT-1 ASWT-2	1" x 300'/roll 2" x 300'/roll	Pressure sensitive, adhesive water-soluble tape to hold Aquasol purge dams in place.

Custom sizes for Aquasol® are available upon request.

## Contact Information

For additional product information, quotations and ordering, please contact:

### Aquasol Corporation

1-800-564-WELD (9353)

Email [info@aquasolpaper.com](mailto:info@aquasolpaper.com)

Our engineers welcome your questions and will help you with your purge dam needs.

Distributed by:



**AQUASOL®**  
*The purge dam material that dissolves*



## Introduction

Aquasol® has significantly improved purge chamber technology in Tungsten Inert Gas (TIG) welding applications. Traditional cardboard purging systems are time-consuming and often leave dangerous residues upon removal. Bladders require excess argon gas, due to the distance of the bladder from the weld area. The bulkiness of bladders and cones results in inherent storage and transport concerns.

These product limitations have led the Aquasol Corporation to introduce Aquasol water-soluble paper, a purge dam material that dissolves.



## Description

Aquasol is made of Sodium Carboxy Methyl cellulose and wooden pulp that dissolves rapidly and completely in most liquids including water. Aquasol can be used to dam Argon or Helium gases during Tungsten Inert Gas (TIG) welding of Steel or Aluminum pipes. After welding is complete, Aquasol purge dams effortlessly dissolve by flushing the system with water or steam; leaving no residue in the pipeline.

Aquasol comes in a wide range of grades and sizes, permitting the construction of purge dams for literally any pipe diameter. The product is available in a variety of formats including sheets, rolls and pressure-sensitive tapes. It is extremely easy to store, environmentally friendly and non-toxic.

## Comparisons

Applications/Features	Cones/Bladders	Aquasol®
Purge Dam Construction	Difficult and time-consuming	<i>Extremely simple and fast</i>
Purge Dam Characteristics	Prone to malfunction High gas usage	<i>Reliable Low gas usage</i>
Purge Dam Removal	Cones: difficult to remove, leaving dangerous residue Bladders: must be deflated	<i>No special process required. Post-welding flushing of pipeline with water/steam disposes of purge dam</i>
Storage and Handling	Bulky Cumbersome	<i>Compact Convenient</i>

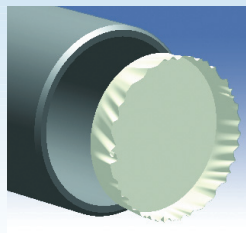
## Advantages

- Cost-effective
- Ease of use
- Availability of various shapes and sizes
- Durable
- Ease of removal

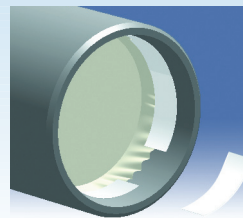
Cut the paper into a circle with a diameter about 1.3 times the inner diameter of the pipe.

Trace or impress the pipe's inner diameter 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 preparation.



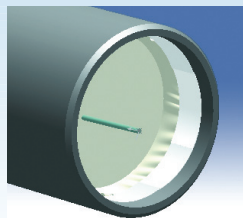
Peel tape from backing and tape dam in place.



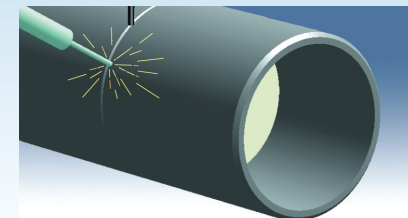
Punch a small hole in the dam to facilitate the evacuation of air when purging.

If one end of the pipe is accessible, the purge gas may be introduced through a hole at the lower end of one dam.

The vent hole should be made at the upper end of the other dam to allow air to escape.



After dams are in place, Argon or any purge gas may be introduced through the root gap with a needle valve connected to the gas line.



Clear view of the completed Aquasol purge dam.

