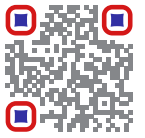


PURGE BAG SYSTEM



Sizes: 2 - 24" / 50 - 600 mm



AN S&B GROUP BRAND

PRODUCT BROCHURE

www.PURGEMASTERS.COM



The **Specialized Fabrication Equipment Group** (in short: **S.F.E. Group**) was founded in 2019 after the merger of three world leading OEM's in the field of pipe fabrication tooling and machinery: B&B Pipe and Industrial Tools LLC (USA), Mathey Dearman Inc. (USA) and TAG Pipe Equipment Specialists (UK). In a time span of 5 years, another 4 renowned and market leading companies were acquired and added to the **S.F.E. Group** portfolio: Axxair (France, 2022), Magnatech (USA, 2023), Climax (USA, 2023) and Sumner (USA, 2025).

The vision and philosophy of the **S.F.E. Group** is to offer globally a comprehensive innovative and cost-effective range of specialized fabrication, welding and machining equipment and derived rental solutions, for a wide range of applications within all critical industries, while optimizing performance, efficiency and safety.

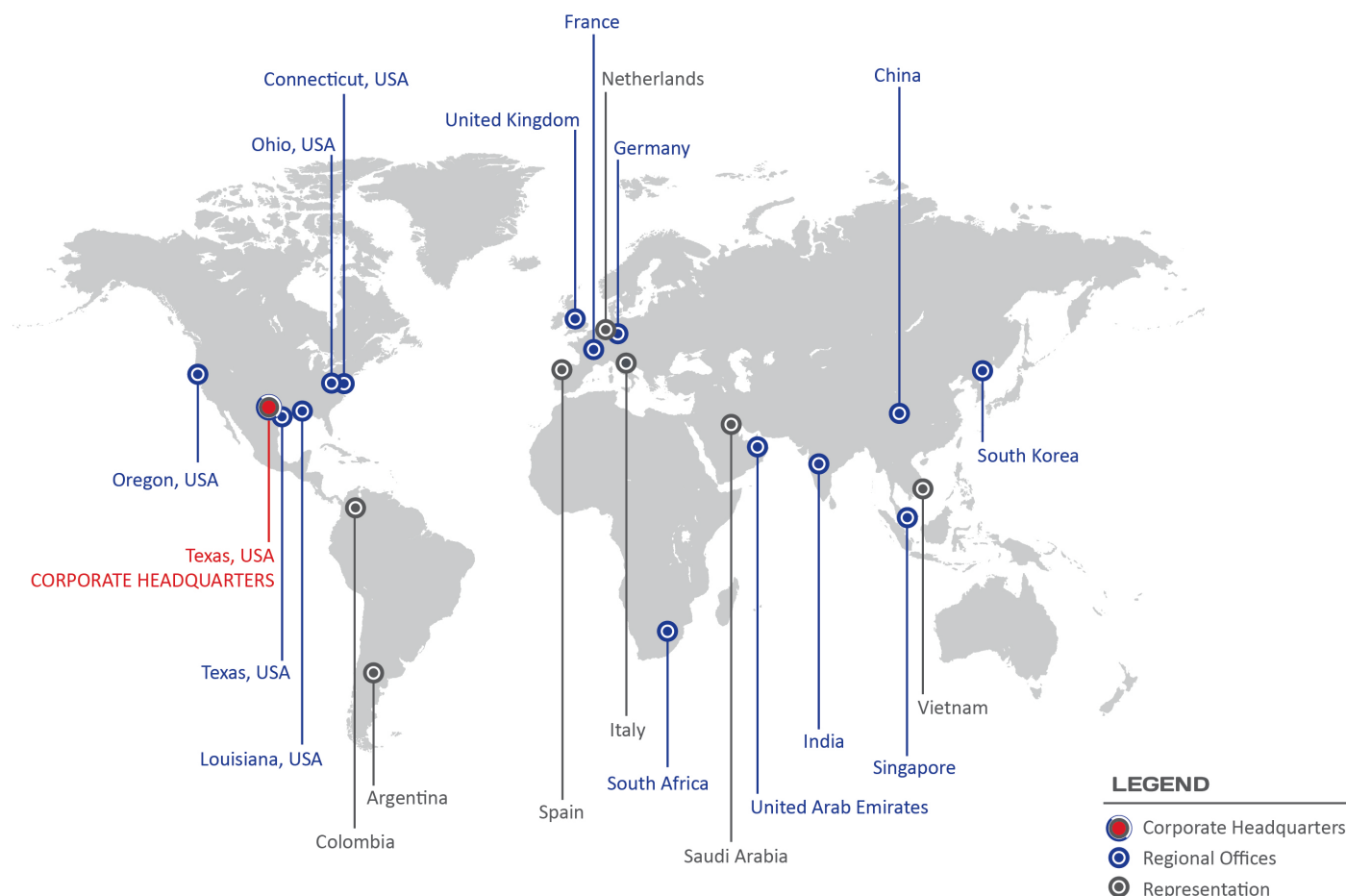
Leveraging over 200 years of combined experience in engineering, manufacturing, and field applications, the **S.F.E. Group** is committed to driving innovation. Through continuous product development and strategic acquisitions, the **S.F.E. Group** is actively growing its portfolio and expanding its global presence to meet the demands of industries around the world. Currently, the **S.F.E. Group** consists of 12 complimentary brands, each supporting the others in delivering cutting-edge solutions.

With offices and warehousing on 5 continents, 400+ employees and more than 500 partnerships and distributors worldwide, **S.F.E. Group** prides itself on consistently offering the highest standards of both product quality and service locally to all its customers.

S.F.E. Group looks forward to welcoming you into its global network as a partner, distributor or end user customer and remains at your disposal at any time.

Contact Americas: sales@sfe-brands.com
Contact International: sales-int@sfe-brands.com

S.F.E. GROUP GLOBAL PRESENCE





Backed by nearly 25 years of development, S.F.E. Group is proud to present its brand dedicated to pipe purging products, applications and solutions: **Pipe Purge Masters (PPM)**. With the **PPM brand**, the S.F.E. Group aims to not only emphasize its focus on pipe purging products but also meet the growing demand for on-site pipe purging equipment across the industries it already serves. Additionally, PPM products integrate seamlessly with other S.F.E. Group offerings, such as the orbital welding solutions provided by the AXXAIR brand.

As an OEM, S.F.E. Group prides itself on being renowned for its innovations, ground-breaking developments and creative designs within the **Pipe Purge Masters'** product range. Leveraging its engineering expertise, customer-centric approach, and flexibility, the PPM brand delivers innovative pipe purging solutions tailored to meet the specific needs of customer projects, while also addressing the demands of ever-evolving industries.

The **PPM brand** portfolio consists of a comprehensive range of pipe purging equipment: inflatable pipe purge bag systems, welding purge plugs, formed double seal purge systems, purge oxygen monitors, inflatable as well as mechanical pipe stoppers and accessories.

Pipe Purge Masters' products are available from the international S.F.E. Group locations on 5 continents, as well as from S.F.E. Group's extensive and continuously expanding global network of partners and can be consulted on the dedicated website **www.PURGEMASTERS.com**.

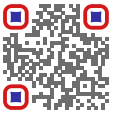
INDUSTRIES SERVED



OUR BRANDS



Our group policy is one of continuous improvements and acquisitions. Products and data tables are subject to change and may vary from those illustrated. Copyright © 2025 Specialized Fabrication Equipment Group, All rights reserved.



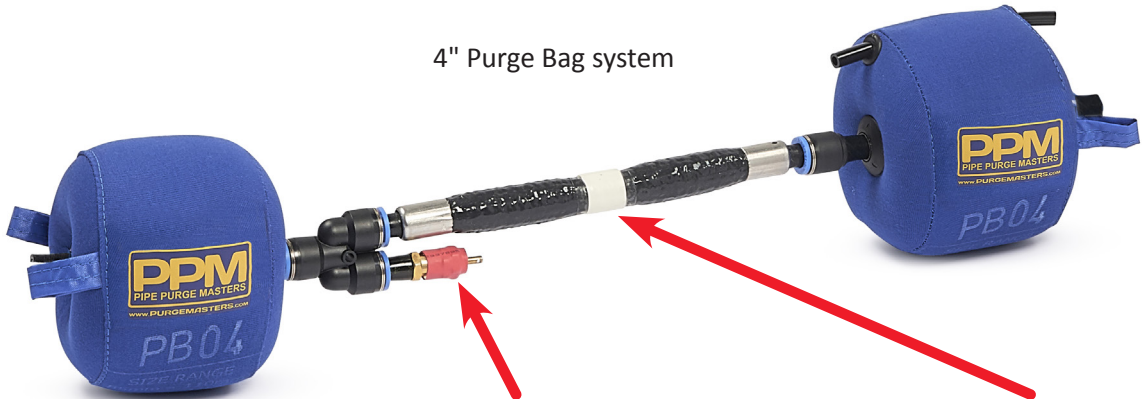
Nominal Pipe Sizes: 2 - 24" / 50 - 600 mm

Internal Diameter (i/d) Range: 1.65 - 23.80" / 42 - 605 mm

Double inflatable pipe weld purging systems

Used for 90% of the traditional pipe weld purging applications to provide bright, shiny, oxide free weld roots. The PPM Purge Bag system is quick and easy to use, providing a very rapid weld purge. High quality materials are used in the production of these systems, guaranteeing perfect oxide-free weld roots in very little time.

4" Purge Bag system



**HEAT
RESISTANT
70°C /
158°F**



The gas release valve is pre-set and sealed, so it requires no adjustment



A luminous strip allows the operator to locate and centre the Purge Bag system to the weld gap with ease

Due to the design of this system, the volume of gas used to purge is minimized, resulting in significant reduction of both time and inert gas consumption. Return on investment can be achieved in as little as just one or two welds. These robust systems can be used over and over again paying for themselves in very little time.

FEATURES AND ADVANTAGES

- PPM's Purge Bag system dramatically reduces purging times, leading to significant savings
- **Typical purge times for 4" pipe = 1½ mins; 8" pipe = 4 mins; 12" pipe = 8 mins**
- Ready to use, connects to a dedicated and regulated gas supply. Choose any flow rate up to 20l a min.
- Gas pressure control ensures an even positive root bead with no notching
- Quick and easy to install, simplifying the process of inert gas purging
- Heat resistant up to 70°C (158°F) continuously
- Use less inert gas. The volume of purge gas used is less than 2% of a conventional purge

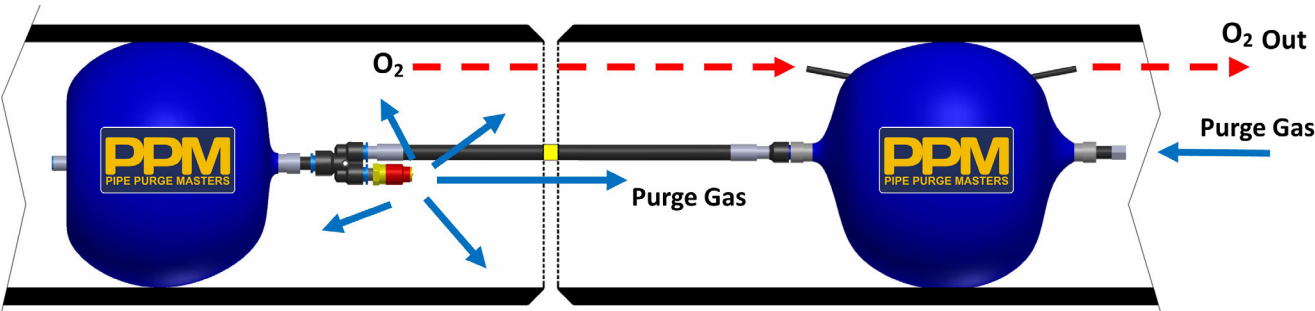


HOW IT WORKS

The Purge Bag system is designed around the principle of using 2 dams, that are connected by an armoured spinal tube, to create a seal on either side of the weld. These dams are just far enough away from the weld not to be affected by heat, but close enough to the joint to provide the fastest weld purge time.

Once ready to start purging, the system is inserted into the bore of the pipe using the luminous strip to centre the system to the weld gap.

When the gas flow is started, the dams inflate and upon reaching the pre-set pressure, the valve releases the gas gently into the weld chamber to purge the interspace without turbulence. The oxygen is removed from the weld chamber by the inert gas through the integral exhaust tubes in the bags, enabling the welder to produce an even oxidation free penetration weld bead. Used in conjunction with PPM’s oxygen monitors, indicating when the required low level of oxygen has been reached, welding can then commence. Afterwards, the dams are deflated simply by disconnecting the purge gas feed and the system easily withdrawn. The design of this system requires only one gas connection for both dam inflation and weld purging.



SIZING AND SPECIFICATION

PART NO.	DESCRIPTION	NOMINAL PIPE SIZE		INTERNAL DIAMETER RANGE (I/D)		WEIGHT (LBS / KG)	
PB02	2" Purge Bag system	2"	50 mm	1.65 - 2.37"	42 - 60 mm	1 lbs	0.34 kg
PB03	3" Purge Bag system	3"	75 mm	2.17 - 3.53"	55 - 90 mm	1 lbs	0.34 kg
PB04	4" Purge Bag system	4"	100 mm	3.51 - 4.51"	89 - 115 mm	1 lbs	0.34 kg
PB05	5" Purge Bag system	5"	125 mm	4.14 - 5.50"	105 - 140 mm	1 lbs	0.38 kg
PB06	6" Purge Bag system	6"	150 mm	5.32 - 6.68"	135 - 170 mm	1 lbs	0.38 kg
PB07	7" Purge Bag system	7"	175 mm	6.30 - 7.66"	160 - 195 mm	2 lbs	0.70 kg
PB08	8" Purge Bag system	8"	200 mm	7.09 - 8.45"	180 - 215 mm	2 lbs	0.90 kg
PB09	9" Purge Bag system	9"	225 mm	8.08 - 9.43"	205 - 240 mm	2 lbs	0.95 kg
PB10	10" Purge Bag system	10"	250 mm	9.26 - 10.61"	235 - 270 mm	2 lbs	1.00 kg
PB11	11" Purge Bag system	11"	275 mm	10.03 - 11.41"	255 - 290 mm	2 lbs	1.05 kg
PB12	12" Purge Bag system	12"	300 mm	11.03 - 12.39"	280 - 315 mm	2 lbs	1.10 kg
We strongly recommend using our Rapid Purge™ system over 12"							
PB13	13" Purge Bag system	13"	325 mm	11.41 - 12.79"	290 - 325 mm	2 lbs	1.20 kg
PB14	14" Purge Bag system	14"	350 mm	12.41 - 13.76"	315 - 350 mm	3 lbs	1.30 kg
PB15	15" Purge Bag system	15"	375 mm	13.38 - 14.76"	340 - 375 mm	3 lbs	1.50 kg
PB16	16" Purge Bag system	16"	400 mm	14.38 - 15.73"	365 - 400 mm	3 lbs	1.70 kg
PB17	17" Purge Bag system	17"	425 mm	15.35 - 16.73"	390 - 425 mm	4 lbs	1.75 kg
PB18	18" Purge Bag system	18"	450 mm	16.34 - 17.70"	415 - 450 mm	4 lbs	1.80 kg
PB19	19" Purge Bag system	19"	475 mm	17.32 - 18.70"	440 - 475 mm	4 lbs	1.85 kg
PB20	20" Purge Bag system	20"	500 mm	18.31 - 19.67"	465 - 500 mm	4 lbs	1.90 kg
PB22	22" Purge Bag system	22"	550 mm	19.69 - 21.05"	500 - 535 mm	5 lbs	2.20 kg
PB24	24" Purge Bag system	24"	600 mm	22.45 - 23.80"	570 - 605 mm	6 lbs	2.50 kg
Larger sizes and custom solutions available upon request with 35 mm / 1.37" expansion range							

The Purge Bag comes with fittings:
International = 21 KA series male connector
Americas = ¼" (0.25") NPT male connector

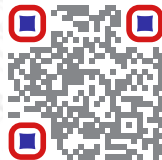


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SUMNER
MATERIAL LIFTS

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