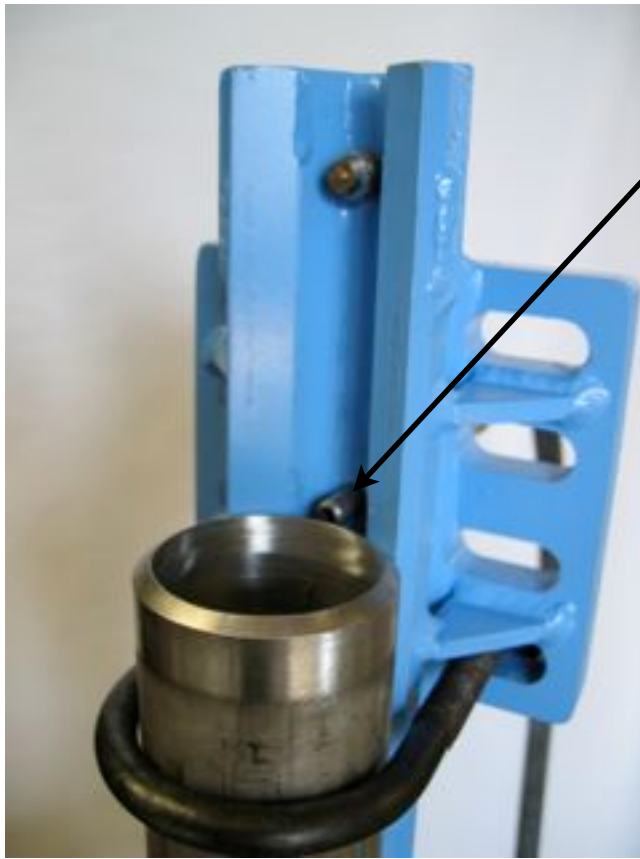


Purging Instructions



Install clamp so that the purge tube aligns with the center of the root gap.



After blocking the inside of both ends with water soluble paper or equivalent align the root gap and insert the purge tube until it touches the bevel. Block both ends of the clamp with tape.

Set purge flow meter to approx.
(10 to 15 CFH)



After welding as much of the root as possible, remove the clamp and attach a short piece of argon hose with a football inflator needle in one end to the valve and insert the needle into the tube as usual to complete welding.

(If you prefer not to use a valve to save argon, use a piece of 1/4" OD tubing)