

# Aquasol®

WATER SOLUBLE PAPER AND TAPE



## DISSOLVABLE PURGE GAS BARRIER FOR TIG WELDING

### FEATURES

#### Low Air Permeable Purge Gas Barrier for Any Pipe Diameter

- Excellent Barrier For Retaining Noble Gas (Argon and Argon/Helium Mix)
- Wide Range of Sizes and Grades Permitting Construction of Any Pipe Diameter

#### Biodegradable, Safe & Easy Removal

- Made of Sodium Carboxy Methyl Cellulose & Wooden Pulp
- Effortlessly Dissolves During Water or Steam Hydro-test
- 100% Biodegradable Leaving No Residue In The Pipeline
- Safe for Nuclear, Petrochemical, Food, Beverage & More

# Aquasol®

WATER SOLUBLE PAPER AND TAPE

## WHAT IS AQUASOL® WATER SOLUBLE PAPER?

Aquasol® Water Soluble Paper provides a convenient and cost effective method for creating purge chambers for pipe welding.

---

## How Does It Work?

Aquasol® Water Soluble Paper is simply cut to shape, folded and taped to each side of the pipe. It creates a barrier for inert gases such as argon and helium. Once the weld is complete, the pipe is flushed with water or steam and the Aquasol® Water Soluble Paper dissolves instantaneously.

---

## Does It Work in Any Water Temperature?

Yes, Aquasol® will dissolve in either hot or cold water. However, the rate of dissolvability increases as the temperature of the water increases.

---

## How Do I Achieve a Perfect Seal?

Aquasol's Water Soluble Tape is engineered in such a way that it will allow the user to place the dam in the proper position before maximizing the adhesive seal. The strength of the "tack" or stickiness of the adhesive allows the user to have control and reposition the dam if not properly placed on the first attempt. Once the dam is positioned, the user can increase adhesion by reactivating the adhesive on the tape portion of the dam and form a tight seal as illustrated below:

## Activate the Water Soluble Tape



Moisten an ordinary sponge in water. Squeeze out excess water.



Lightly dab sponge along the water soluble tape portion of the dam.



The dampened sponge will reactivate the adhesive to ensure zero air permeability.

# HOW TO CREATE AN AQUASOL® WATER SOLUBLE PURGE DAM



1

## **TRACE & IMPRESS**

Trace pipe's inner diameter. Create an impression of the pipe. Fold to form 90° angle.



2

## **CUT**

Cut the circle 1.3 times greater than pipe diameter.



3

## **SLIT**

Slit approximately 1" to 2" segments perpendicular to impression on paper.

Make first slit at 12 o'clock position followed by 3 o'clock, 6 o'clock and so on.



4

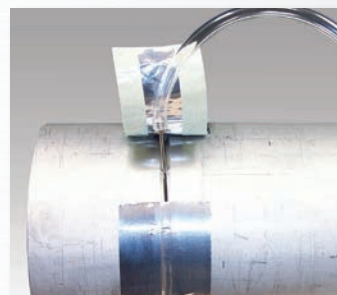
## **POSITION PIPE & TAPE IN PLACE**

Cut Aquasol® Water Soluble Tape into pieces and secure in place.

5

## **REPEAT**

Repeat process on other side.



- Cover root gap with EZ Zone® Tape.
- Your set up is complete.
- Introduce argon via the root gap.

## Recommended Proximity To Weld Joint

PIPE DIAMETER		RECOMMENDED DISTANCE	
ENGLISH	METRIC	ENGLISH	METRIC
2" - 8"	51 - 203 mm	6"	152 mm
10" - 22"	254 - 559 mm	8"	203 mm
24" - 36"	610 - 914 mm	12"	305 mm

## SPECIFICATIONS

### Aquasol® Purge Paper and Purge Tape: Types and Sizes

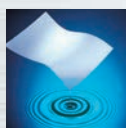
ITEM NO.	THICKNESS	DIMENSIONS		TYPE	CASE PACK
		ENGLISH	METRIC		
ASW-35/S-11RW	.0035"	8 ½" x 11"	22 cm x 28 cm	Sheet	500 sheets/ream
ASW-35/S-14R	.0035"	8 ½" x 14"	22 cm x 36 cm	Sheet	500 sheets/ream
ASW-35/S-22R	.0035"	17" x 22"	43 cm x 56 cm	Sheet	500 sheets/ream
ASW-60/S-22R	.0070"	15 ½" x 22"	39 cm x 56 cm	Sheet	250 sheets/ream
ASW-35/R-9	.0035"	9" x 165'	23 cm x 50 m	Roll	4 rolls/case
ASW-35/R-15	.0035"	15 ½" x 165'	39 cm x 50 m	Roll	4 rolls/case
ASW-40C/R20.5	.0050"	20 ½" x 165'	52 cm x 50 m	Roll	4 rolls/case
ASW-60/R-15	.0070"	15 ½" x 165'	39 cm x 50 m	Roll	4 rolls/case
ASW-60/R-31	.0070"	31" x 165'	79 cm x 50 m	Roll	4 rolls/case
ASWT-1	N/A	1" x 300'	2.5 cm x 92 m	Roll	24 rolls/case
ASWT-2	N/A	2" x 300'	5 cm x 92 m	Roll	12 rolls/case

## Selecting The Proper Grade

ASW-35	Use for pipes having 4" inner diameter or less
ASW-40C	Use for greater gas retention
ASW-60	Use for pipes having 4" inner diameter or greater
ASWT	Use in addition to water soluble paper for pipes greater than 2" in diameter

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

Distributed By:



### Aquasol Corporation

80 Thompson Street  
N. Tonawanda, NY 14120 USA

Toll Free: 1.800.564.WELD (9353)  
Phone: 716.564.8888  
Fax: 716.564.8889

Email: [info@aquasolcorporation.com](mailto:info@aquasolcorporation.com)  
[aquasolwelding.com](http://aquasolwelding.com)



**American Welding Society**  
Sustaining Company Member



MADE IN THE USA