



## PIPE WELDING ACCESSORIES



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## THE DWT COMPANY

is a private owned sales, production and service company in the Ruhr region, the industrial heart of Germany. The headquarter, warehouse, production and service centre are located in Bottrop. From there, numerous markets in Germany and abroad are served.

Since 1995, the export business has also been expanded, and customers are now supplied in over 30 countries around the world.

In many regions we have a representative office to support the local market.







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# Big projects?

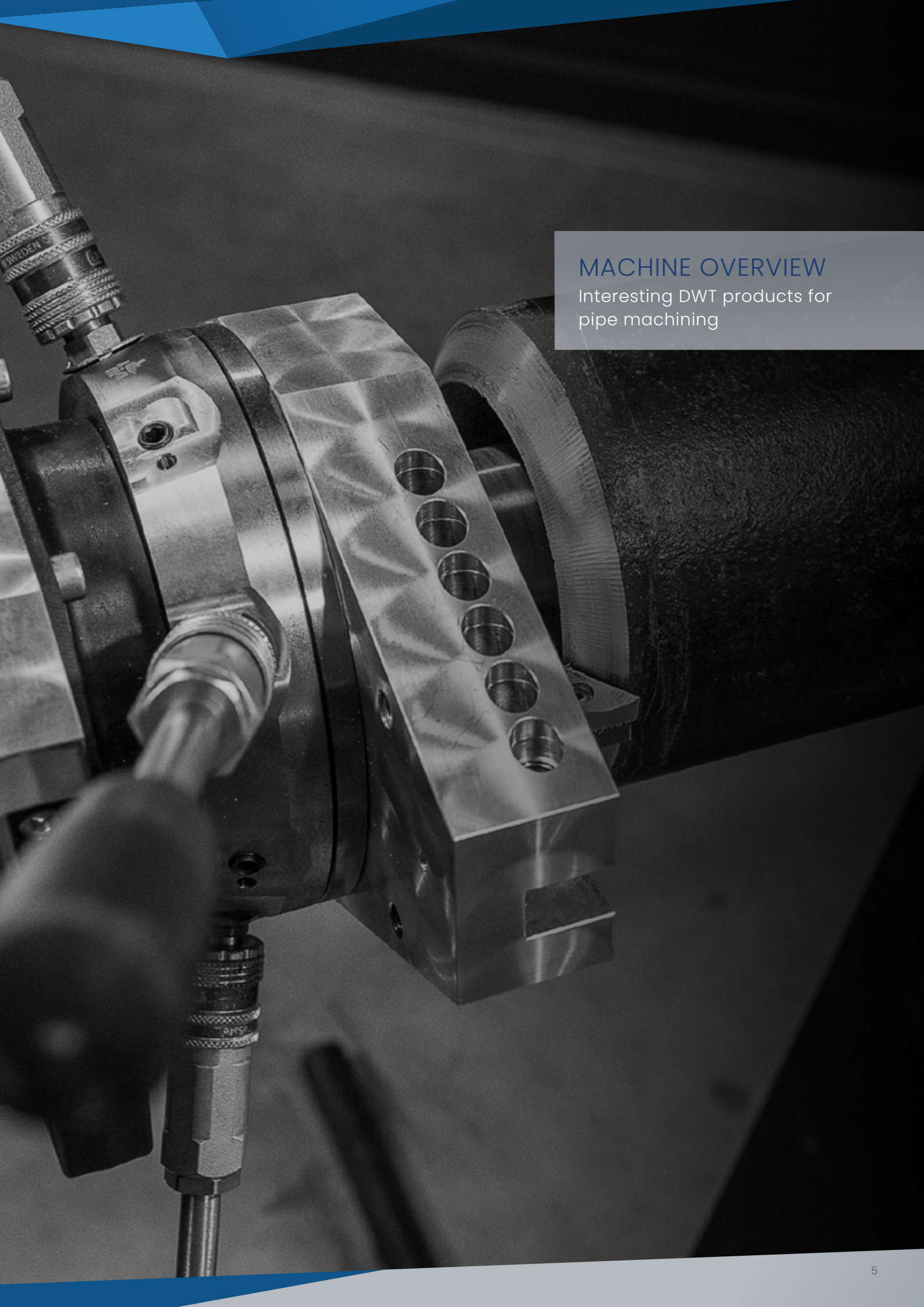
We have the solution for you!

Solutions for many pipe preparation applications  
Find out about our other products

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## MACHINE OVERVIEW

Interesting DWT products for pipe machining





## PIPE BEVELING MACHINES

Perfect weld seam preparation through mechanical chamfering of the pipes

The pipe beveling machines are used for beveling pipes and for pipe end machining of nozzles and headers. In addition, the machines are also suitable for fin tubes, boiler tubes, membrane wall and heat exchangers for pipe end machining in both workshop and construction site use.

Particularly in connection with orbital welding, economic manufacturing possibilities arise.

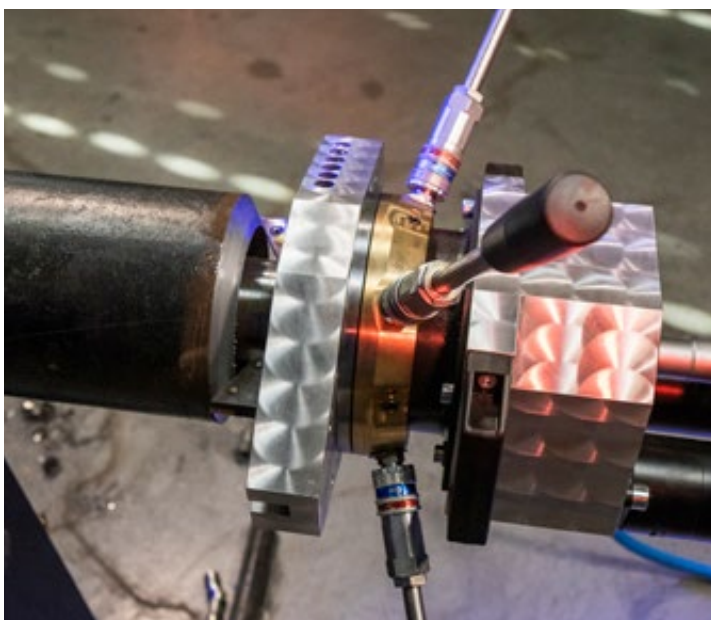


## Internal and external clamping pipe milling machines

Mobile pipe beveling machines for perfect weld seam preparation

The transportable pipe beveling machine is used for weld seam preparation when welding thick-walled pipes, boiler tubes and headers. Due to an extremely compact design, pipes can be beveled perfectly even in confined spaces.

- High cutting and separating performance
- Quick and safe clamping
- Easy handling, low weight







## DLW-Cut and Beveling machines Cutting thick-walled pipes on site

The pipe cutting and beveling machine is used to cut and bevel thick-walled pipelines in explosive areas such as e.g. oil and gas platforms, nuclear power plants and other explosion-protected areas.

- Cold cutting and beveling of thick-walled steel pipes (no heat-affected zone)
- For pipes up to an outer diameter of 1219,2 mm and a wall thickness of 80 mm
- Extremely light weight and small footprint

## Boiler Panel Saw Type BWC Separation of boiler and fin tubes

The cutting of boiler tubes during inspection and maintenance in boiler construction without a heat-affected zone is a prerequisite for good weld preparation.

- Higher occupational safety
- High productivity and cutting quality
- No heat-affected zone



## CPC / CPC-B Chain guided pipe cutting and beveling machine

Pipe cutting and beveling, directly on the construction site. The CPC-B type pipe cutting and beveling machine offers a versatile solution for almost all cutting and beveling applications. The machine is convincing in the most difficult conditions and can even be used under water and cut pipe thicknesses up to 50 mm separate.

- For pipes up to 276" (7,010 mm)
- Compressed air and hydraulic drives available for use in non-sparking environments
- Also suitable for beveling high-strength stainless steel pipes





## EXACT PIPE SAWS THE ORIGINAL PIPE CUTTING SYSTEM

The Exact pipe saws replace angle grinders and other bulky, dangerous tools that have to be readjusted after every cut. The light and comfortable Exact pipe saws increase your productivity and work quality many times over.

With the Exact Pipe Cutting System, pipes made of any material are cut quickly, easily and above all safely within seconds. They offer the highest level of safety for users and the environment and deliver perfect work quality.

By using the Exact pipe saw, the risk of an accident at work is minimised by almost 100%.



Since 2012, DWT GmbH has been promoting Exact pipe saws in more than 20 countries around the world. This gives us the optimal opportunity to offer you the complete service for your pipe saw.

Advice, product demonstration (online or at your premises), sales, rental, service and repair - all from a single source.

- Highest level of safety for users and the environment
- Perfect cut ends for direct further processing
- Excellent speed





## PIPE ALIGNMENT

Centre and align all materials and dimensions



# PIPE CLAMPS



## Pipe clamp steel

Clamping Range: 20 - 370 mm (1 - 14")

- For centering and aligning the pipes to be welded
- Easy assembly

Part No.	Description	Range OD Inch	Range OD mm	Weight kg
RG350004	Pipe clamp DWT S13 steel	1 - 3	25 - 76	1,5
RG350005	Pipe clamp DWT S25 steel	2 - 5	51 - 127	3,1
RG350006	Pipe clamp DWT S47 steel	4 - 7	102 - 177	3,3
RG350007	Pipe clamp DWT S59 steel	5 - 9	127 - 228	6,9
RG350008	Pipe clamp DWT S1014 steel	10 - 14	254 - 355	9,0



## Clamping screws

for quick-release pipe clamps  
steel and stainless steel

- Replacement screws suitable for steel and stainless steel pipe clamps



Part No.	Description
RG350009	Clamping screw steel for S13
RG350010	Clamping screw steel for S25 & 47
RG350011	Clamping screw steel for S59 & 1014
RG350096	Clamping screw stainless steel for SS13
RG350097	Clamping screw stainless steel for SS26
RG350098	Clamping screw stainless steel for SS614





## Pipe clamp stainless steel

Clamping Range: 20 - 370 mm (1 - 14")

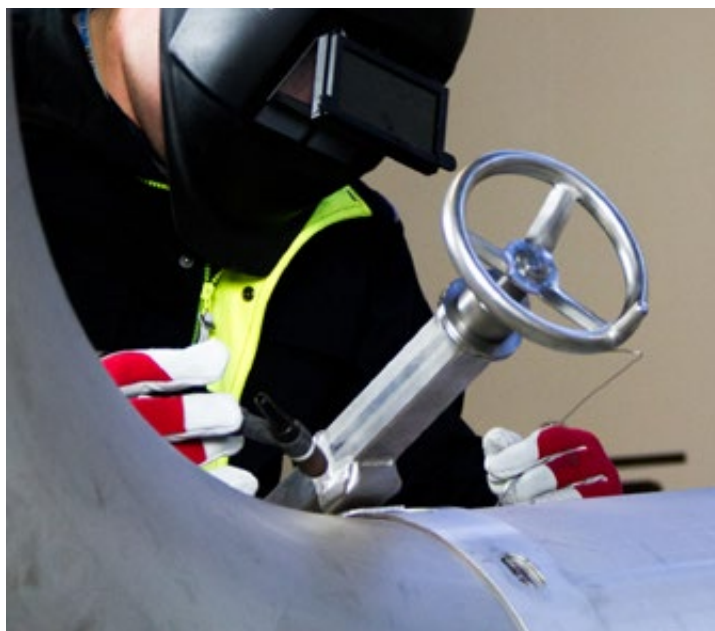
- For centering and aligning the pipes to be welded
- Easy assembly and centric clamping of the pipes
- Stainless steel contact points avoid corrosion
- Tensioning screws with stainless steel balls prevent scratching of stainless steel pipes

Part No.	Description	Range OD Inch	Range OD mm	Weight kg
RG350012	Pipe clamp DWT SS13 stainless steel	1 - 3	25 - 76	1,0
RG350013	Pipe clamp DWT SS26 stainless steel	2 - 6	51 - 152	3,5
RG350014	Pipe clamp DWT SS614 stainless steel	6 - 14	152 - 355	8,0

## Centering belts sets

Ultra-fast, accurate and easy-to-use centring sleeve made of stainless steel and acid-resistant. Pipe centring belts reduce installation and welding errors to a minimum.

Larger sizes up to 60" (1520 mm) are available.



Part No.	Description	Belt sizes DN	Weight kg
RG350284	Basic Centering Belts Set	150-500	2,2
RG350285	Mini Centering Belts Set	65-125	0,92

## Basic Centering Belts Set

For belt sizes DN150-DN500

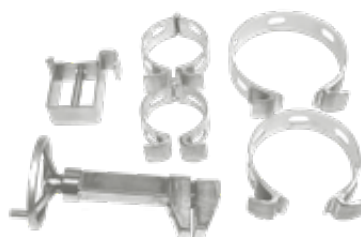
- Centering belts sizes DN150, DN200, DN250, DN300, DN350, DN400 and DN500
- Basic tightener (stainless steel)
- Fitted with thrust bearings
- Weight 2,2 kg



## Mini Centering Belts Set

For belt sizes DN65-DN125

- Centering belts sizes DN65, DN80, DN100 and DN125
- Mini tightener (stainless steel)
- Holder for the toolbox
- Fitted with thrust bearings
- Weight 920 g





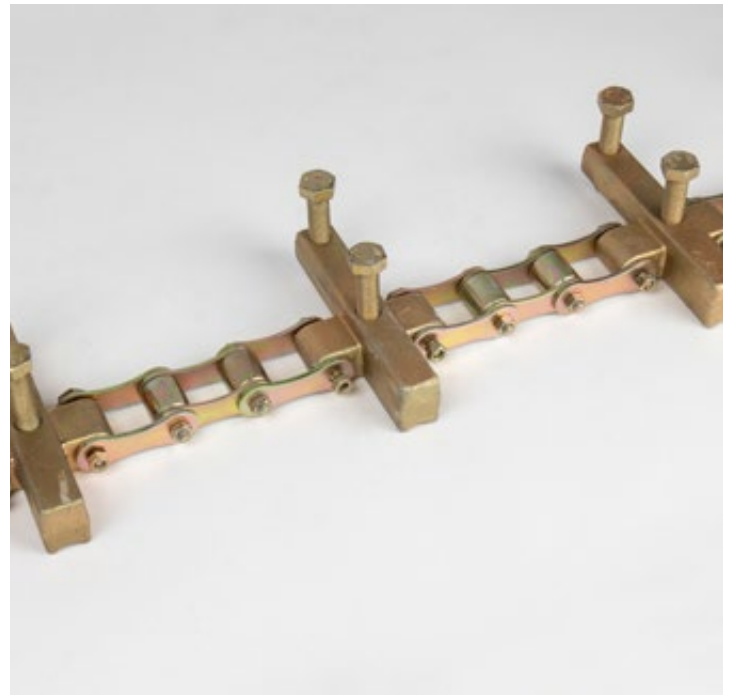


## Single chain clamp

Clamping ranges: 203 - 1.524 mm (8 - 60")

- Max. Wall thickness: 12,7 mm
- The chain can be adapted to the respective pipe dimension by removing the chain links and alignment levers

Part No.	Description	Range OD Inch	Range OD mm	Number jack-bars	Weight kg
RG350040	Single chain clamp	8 - 10	203 - 254	5	8,3
RG350041		8 - 12	203 - 304	6	9,5
RG350042		8 - 16	203 - 406	7	10,6
RG350043		8 - 20	203 - 508	9	13,0
RG350044		8 - 24	203 - 609	11	15,3
RG350045		8 - 28	203 - 711	13	17,7
RG350046		8 - 32	203 - 812	14	18,8
RG350047		8 - 36	203 - 914	16	21,2
RG350048		8 - 40	203 - 1.016	18	23,5
RG350049		8 - 44	203 - 1.117	19	24,7
RG350050		8 - 48	203 - 1.219	21	27,0
RG350051		8 - 52	203 - 1.320	23	29,4
RG350052		8 - 56	203 - 1.422	25	31,7
RG350053		8 - 60	203 - 1.524	26	32,9

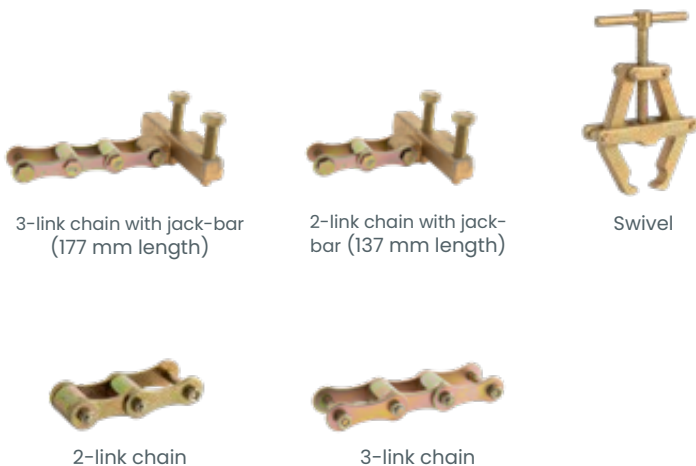


## Accessories

for single chain clamp

- Individual solutions through modular individual parts

Part No.	Description	Weight kg
RG350068	Swivel for single chain	2,2
RG350069	Single jack-bar	0,8
RG350070	2-link chain	0,2
RG350071	3-link chain	0,3
RG350072	2-link chain with jack-bar	2,5
RG350073	3-link chain with jack-bar	1,2



3-link chain with jack-bar  
(177 mm length)

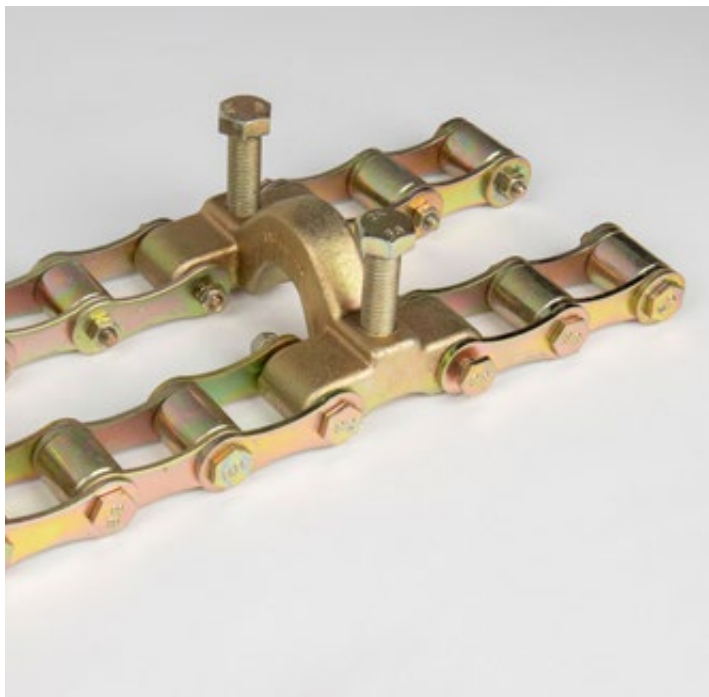
2-link chain with jack-bar  
(137 mm length)

Swivel

2-link chain

3-link chain





## Double chain clamp

Clamping ranges: 203 - 1.524 mm (8 - 60")

- Max. Wall thickness: 12,7 mm
- The chain can be adapted to the respective pipe dimension by removing the chain links and alignment jack-bars

Part No.	Description	Range OD Inch	Range OD mm	Pieces jack-bars	Weight kg
RG350054		8 - 12	203 - 304	6	19,3
RG350055		8 - 16	203 - 406	7	20,9
RG350056		8 - 20	203 - 508	9	24,0
RG350057		8 - 24	203 - 609	11	27,2
RG350058		8 - 28	203 - 711	13	30,4
RG350059		8 - 32	203 - 812	14	32,0
RG350060	Double chain clamp	8 - 36	203 - 914	16	35,2
RG350061		8 - 40	203 - 1.016	18	38,4
RG350062		8 - 44	203 - 1.117	19	40,0
RG350063		8 - 48	203 - 1.219	21	43,1
RG350064		8 - 52	203 - 1.320	23	46,3
RG350065		8 - 56	203 - 1.422	25	49,5
RG350066		8 - 60	203 - 1.524	26	51,1

## Accessories

for double chain clamp

- Individual solutions through modular components

Part No.	Description	Weight kg
RG350075	Swivel for double chain	9,3
RG350076	Double jack-bar	0,9
RG350070	2-link chain	0,2
RG350071	3-link chain	0,3
RG350077	2x 2-link chain with jack-bar	1,5
RG350078	2x 3-link chain with jack-bar	1,6



2x 3-link chain with jack-bar  
(177 mm length)



2x 2-link chain with jack-  
bar (137 mm length)



Swivel



2-link chain



3-link chain



## Internal clamping system (ISC)

### for pipes and flanges

Clamping range: ID 56 – 520 mm (2.25 – 20.4")

The manual internal clamping system (ISC) is suitable for clamping pipe to flange. It covers a range from 56 mm (2.25") to 520 mm (20.4").

The contact points of the systems are made of stainless steel, which means that both mild steel and stainless steel pipes can be centred.

Part No.	Description	Range ID Inch	Range ID mm	Weight kg
RG350015	Internal clamping system ISC56140	2.2 – 5.5	56 – 140	1,35
RG350016	Internal clamping system ISC85220	3.3 – 8.6	85 – 220	4,0
RG350017	Internal clamping system ISC120350	4.7 – 13.8	120 – 350	12,0
RG350018	Internal clamping system ISC180520	7 – 20.4	180 – 520	27,0



## Internal clamping system (ISEC)

### for flanges and elbows

Clamping range: ID 56 – 520 mm (2.25 – 20.4")

The manual internal clamping system (ISEC) is suitable for clamping pipe or flange to elbow. It covers a range from 56 mm (2.2") to 520 mm (20.4").

The contact points of the systems are made of stainless steel, which means that both mild steel and stainless steel pipes can be processed.

Part No.	Description	Range ID Inch	Range ID mm	Weight kg
RG350019	Internal clamping system ISEC56115	2.2 – 4.5	56 – 115	1,0
RG350020	Internal clamping system ISEC85195	3.3 – 7.6	85 – 195	3,0
RG350021	Internal clamping system ISEC120315	4.7 – 12.4	120 – 315	10,0
RG350022	Internal clamping system ISEC180520	7 – 20.4	180 – 520	24,0







## Hydraulic external cage clamp

Medium-duty version  
DN 300 up to DN 2.000

Due to the widely recessed bridges of the hydraulic external pipe centering, up to 90% of the root pass can be welded without loosening the centering. The edge offset is eliminated by driving the splitting iron under the obliquely chamfered bridges.

The product does not contain a hydraulic cylinder.



## Hydraulic cylinder

Hydraulic cylinder AHZ-5.4

For all nominal diameters of the external pipe centres mentioned on the right.

Part No.	Dimensions (LxWxH) mm	Weight kg
11 010 5000	600x200x200	15,3



Part No.	Pipe size	OD Inch	OD mm	Weight kg
11 001 0323	DN 300	12	323	20,0
11 001 0355	DN 350	14	355	21,0
11 001 0406	DN 400	16	406	21,5
11 001 0457	DN 450	18	457	24,0
11 001 0508	DN 500	20	508	28,5
11 001 0610	DN 600	24	610	30,0
11 001 0660	DN 650	26	660	32,5
11 001 0711	DN 700	28	711	34,0
11 001 0765	DN 750	30	762	38,0
11 001 0813	DN 800	32	813	39,5
11 001 0864	DN 850	34	864	44,0
11 001 0914	DN 900	36	914	53,0
11 001 1016	DN 1.000	40	1.016	60,0
11 001 1067	DN 1.050	42	1.067	66,0
11 001 1118	DN 1.100	44	1.118	71,0
11 001 1220	DN 1.200	48	1.219	77,0
11 001 1321	DN 1.300	52	1.320	79,0
11 001 1420	DN 1.400	56	1.420	82,0
11 001 1520	DN 1.500	60	1.520	84,0
11 001 1620	DN 1.600	64	1.620	95,0
11 001 1720	DN 1.700	68	1.720	102,0
11 001 1820	DN 1.800	72	1.829	104,0
11 001 1920	DN 1.900	76	1.920	108,0
11 001 2020	DN 2.000	80	2.032	115,0

Part No.	Pipe size	OD Inch	OD mm	Weight kg
11 SK1 0711	DN 700	28	711	95,0
11 SK1 0762	DN 750	30	762	100,0
11 SK1 0813	DN 800	32	813	106,0
11 SK1 0864	DN 850	34	864	115,0
11 SK1 0914	DN 900	36	914	123,0
11 SK1 1016	DN 1.000	40	1.016	130,0
11 SK1 1067	DN 1.050	42	1.067	135,0
11 SK1 1118	DN 1.100	44	1.118	138,0
11 SK1 1168	DN 1.150	46	1.168	141,0
11 SK1 1220	DN 1.200	48	1.219	145,0
11 SK1 1320	DN 1.300	52	1.321	149,0
11 SK1 1420	DN 1.400	56	1.422	153,0
11 SK1 1520	DN 1.500	60	1.524	160,0
11 SK1 1620	DN 1.600	64	1.626	170,0
11 SK1 1720	DN 1.700	68	1.720	179,0
11 SK1 1820	DN 1.800	72	1.820	185,0
11 SK1 1920	DN 1.900	76	1.920	195,0
11 SK1 2020	DN 2.000	80	2.020	210,0

## Hydraulic external cage clamp

Heavy-duty version  
DN 700 up to DN 2.000

Heavy-duty Hydraulic external cage clamp with built-in hydraulic jack and bent bridges, for perfect access and freedom when welding.

The hydraulic cylinder is equipped with a locking device and is secured against the housing with a ring on the trapezoidal threaded piston stand after pressing on. The cylinder should be used in the vertical position.



## Mechanical external cage clamp

Light version  
DN 80 up to DN 450

The mechanical external cage clamps in light design are suitable for the range DN 80 - DN 450 and only for tacking. The pipe ends are clamped via the eccentric by means of bars.



Part No.	Pipe size	OD Inch	OD mm	Weight kg
11 003 0088	DN 80	3	88	5,3
11 003 0114	DN 100	4	114	6,0
11 003 0125	DN 125	5	141	6,3
11 003 0168	DN 150	6	168	8,5
11 003 0219	DN 200	8	219	11,0
11 003 0273	DN 250	10	273	15,0
11 003 0323	DN 300	12	323	17,0
11 003 0355	DN 350	14	355	20,5
11 003 0406	DN 400	16	406	22,0
11 003 0457	DN 450	18	457	24,5

Other sizes on request.



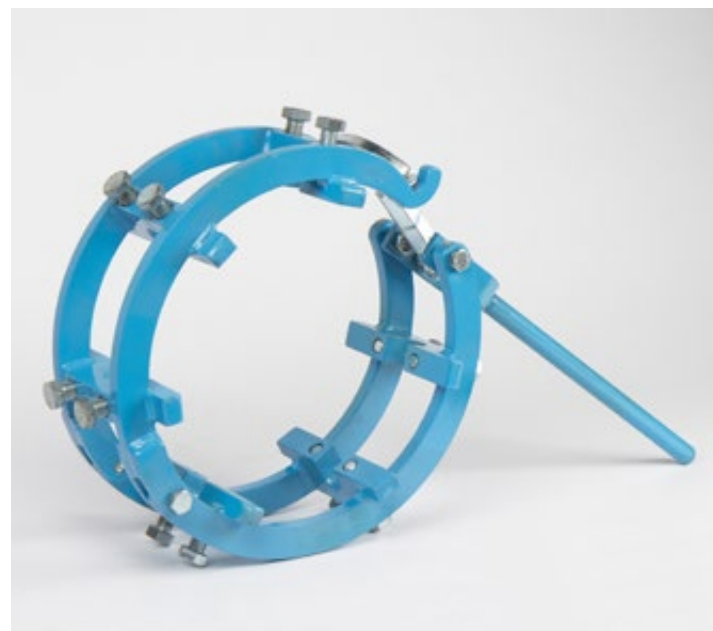
## Mechanical external cage clamp

Medium-duty version  
DN 100 up to DN 1.200

The widely recessed bridges allow up to 80% of the root pass to be achieved without loosening the centering. The pressure screws allow deformed pipes to be aligned so that flush tacking is possible.

Part No.	Pipe size	OD Inch	OD mm	Weight kg
11 004 0114	DN 100	4	114	9,0
11 004 0139	DN 125	5	141	9,5
11 004 0168	DN 150	6	168	10,0
11 004 0219	DN 200	8	219	13,0
11 004 0273	DN 250	10	273	17,0
11 004 0323	DN 300	12	323	23,0
11 004 0355	DN 350	14	355	27,0
11 004 0406	DN 400	16	406	31,0
11 004 0457	DN 450	18	457	36,0
11 004 0508	DN 500	20	508	38,0

Other sizes on request.

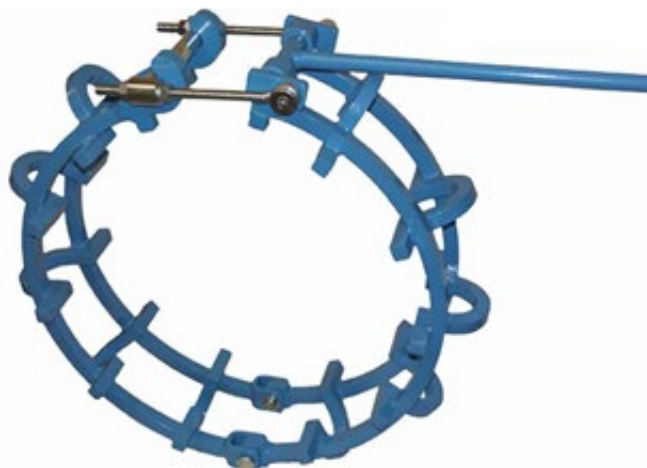


## Mechanical external cage clamp

Medium-duty version  
DN 400 up to DN 1.200

Part No.	Pipe size	OD Inch	OD mm	Weight kg
11 N04 0406	DN 400	16	406	33,0
11 N04 0457	DN 450	18	457	38,0
11 N04 0508	DN 500	20	508	42,0
11 N04 0559	DN 550	22	559	49,0
11 N04 0610	DN 600	24	610	52,0
11 N04 0711	DN 700	28	711	58,0
11 N04 0762	DN 750	30	762	60,0
11 N04 0813	DN 800	32	813	62,0
11 N04 0914	DN 900	36	914	70,0
11 N04 1016	DN 1.000	40	1.016	72,0
11 N04 1067	DN 1.050	42	1.067	78,0
11 N04 1118	DN 1.100	44	1.118	85,0
11 N04 1220	DN 1.200	48	1.219	100,0

Other sizes on request.







## PIPE PURGING

Systems and accessories

BT  
BUTTING 155584  
DHW 05-F101  
ID 768.4 X 22  
MUP 458 X 22  
TEST PRESSURE  
200 PSI  
HEAT TREATING

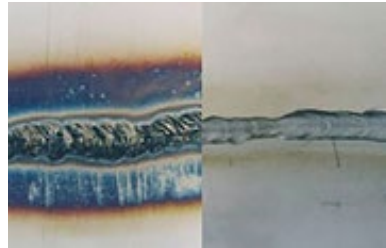
CE  
GmbH  
CAPACITY 1500 KG

CE

## PIPE PURGE SYSTEMS for pipe welding

When welding stainless steel pipes, the pipe should be purged or shielded beforehand to ensure the corrosion resistance of the materials. The purpose of forming is to create or maintain a high-quality surface condition of the root with regard to oxidation and root shaping.

Without pipe  
purge systems



With pipe purge  
systems

### QUALITY OF THE WELD SEAM

Inert, reducing or inert gases are used for root protection. Gases are used for root protection such as pure nitrogen, mixtures (purging gases) of hydrogen and nitrogen, argon-hydrogen mixtures or pure argon.



### OCCUPATIONAL SAFETY

Measures must be taken when welding complex materials to prevent the risk of ignitable gas mixtures and the uncontrolled ingress of unwanted air.

### WE HAVE THE SOLUTIONS!

With our pipe purge systems, aluminium pipe stopper, oxygen monitors, weld backing tape and water soluble purge films, you can purge stainless steel pipes quickly and easily and thus protect the weld seam from oxidation and sparks.







## I-PURGE-X PIPE PURGE SYSTEM

### Modular pipe purge system

Available for internal pipe diameter ID 2 - 48"

A system for purging the pipes. Unique modular design for a customised solution

- Highly resilient inflatable inner cover
- Components can be replaced quickly and easily thanks to corrosion-resistant quick-release fasteners
- Made in the USA with the highest quality materials
- Spark retardant outer shell
- High heat resistance (optional extended length at higher temperatures)
- Flexible, kink-resistant connection for pipes, bends and T-pieces



- Preset pressure relief valves allow for precise flow rates, and reduce the risk of overloading the forming systems.
- Equipped with shielding gas diffuser to avoid turbulence of the gas flow during pipe welding (Diffuser not available for 2" and 3" types)
- 3-fold hose connection (1 filling of the bubbles; 2 rinsing of the welding zone; 3 connection of the oxygen monitors), accelerates the rinsing process
- Improves the efficiency of the gas flow in the purging area
- Carrying bag to protect the reed bubbles

Part No.	Description	Range Inch	Range mm
RG350220	Inflatable bladder system	2 - 3	51 - 76
RG350221	Inflatable bladder system	4 - 6	102 - 152
RG350222	Inflatable bladder system	8 - 12	203 - 305
RG350223	Inflatable bladder system	14 - 18	356 - 457
RG350224	Inflatable bladder system	20 - 26	509 - 660
RG350225	Inflatable bladder system	28 - 36	711 - 914
RG350226	Inflatable bladder system	38 - 48	965 - 1.219

Other hose lengths on request.



Oxygen monitor available on page 25-26



## DWT Pipe purge system

For internal pipe diameters from 25 mm to 320 mm

The pipe purge system consists of a 200 mm long base unit and two sealing discs, which have a temperature resistance of up to 320 °C. The sealing discs can be used to seal the forming gas.

It can be easily pushed into the pipe without the system tilting or bending. The design ensures that one of the respective sealing lips seals, thus reducing gas consumption and forming time.



## Complete systems

Each forming gas system includes 2 pcs. Sealing washers, 1 pcs. Base unit (200 mm), 10 m stainless steel pull cord, 10 m hose incl. coupling.

Part No.	Description	Diameter mm	Range ID mm
RG350116	Pipe purge system	32	25 - 31
RG350117	Pipe purge system	43	32 - 40
RG350118	Pipe purge system	54	41 - 50
RG350119	Pipe purge system	64	52 - 61
RG350120	Pipe purge system	78	62 - 74
RG350121	Pipe purge system	90	75 - 86
RG350122	Pipe purge system	110	85 - 101
RG350123	Pipe purge system	120	100 - 110
RG350124	Pipe purge system	142	120 - 135
RG350125	Pipe purge system	160	140 - 155
RG350126	Pipe purge system	175	150 - 165
RG350127	Pipe purge system	210	175 - 200
RG350128	Pipe purge system	230	195 - 215
RG350129	Pipe purge system	270	235 - 260
RG350130	Pipe purge system	290	255 - 280
RG350131	Pipe purge system	310	275 - 300
RG350132	Pipe purge system	330	290 - 320

## Replacement seals

Always required 2 per system

Part No.	Description	Diameter mm	Range ID mm
RG350099	Pipe purge sealing disc	32	25 - 31
RG350100	Pipe purge sealing disc	43	32 - 40
RG350101	Pipe purge sealing disc	54	41 - 50
RG350102	Pipe purge sealing disc	64	52 - 61
RG350103	Pipe purge sealing disc	78	62 - 74
RG350104	Pipe purge sealing disc	90	75 - 86
RG350105	Pipe purge sealing disc	110	85 - 101
RG350106	Pipe purge sealing disc	120	100 - 110
RG350107	Pipe purge sealing disc	142	120 - 135
RG350108	Pipe purge sealing disc	160	140 - 155
RG350109	Pipe purge sealing disc	175	150 - 165
RG350110	Pipe purge sealing disc	210	175 - 200
RG350111	Pipe purge sealing disc	230	195 - 215
RG350112	Pipe purge sealing disc	270	235 - 260
RG350113	Pipe purge sealing disc	290	255 - 280
RG350114	Pipe purge sealing disc	310	275 - 300
RG350115	Pipe purge sealing disc	330	290 - 320



Pipe purge sealing disc





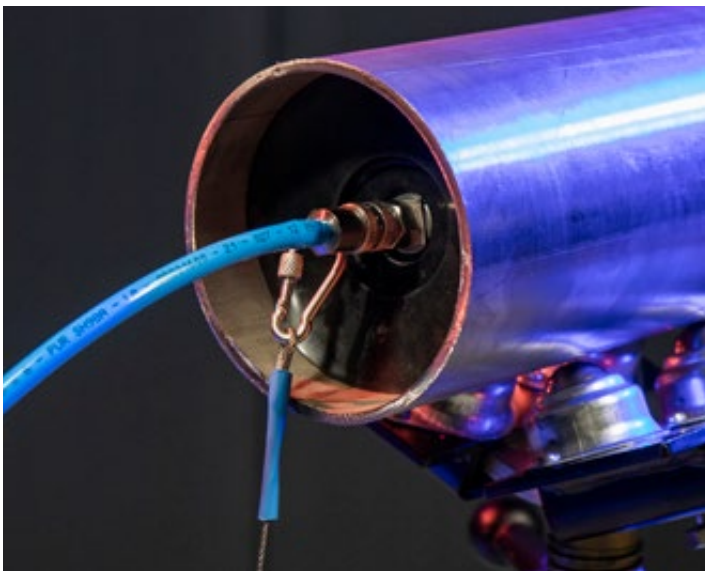
## Suitcase set

Suitable for internal pipe diameter 25 mm - 165 mm

- Handy complete set with pipe purge sealing discs and base unit (200 mm)
- Replaceable sealing discs
- Incl. 10 m stainless steel cable, 10 m hose, coupling and accessories
- High-quality and durable case made from a sustainable mix of materials



Part No.	Description	Internal pipe diameter mm
RG350139	Pipe purge system suitcase set	25 - 165 mm



# PIPE STOPPER



## ALUMINIUM PIPE STOPPER

Available for internal pipe diameters from 1,5"

The test stopper are made of cast aluminium. The expandable natural rubber ring ensures optimum sealing of the pipe. They are suitable for closing and sealing pipes during the forming process and for sealing in low-pressure applications.

- Extra long wing nuts for easy handling
- Hollow spindle for gas connection in forming applications
- Plastic cap closes the spindle for pipe seal measurements
- Cost effective solution
- Temperature resistant from -30 °C to +90 °C

Part No.	ID mm	OD Stopper		Outer thread Inch	Max. counter- pressure bar	Weight kg
		Inch	mm			
RG350150	38 - 50	1 1/2	40	1/2	2,0	0,17
RG350151	49 - 62	2	50	1/2	2,0	0,22
RG350152	62 - 77	2 1/2	65	1/2	2,0	0,27
RG350153	73 - 89	3	75	1/2	1,3	0,31
RG350154	84 - 103	3 1/2	90	1/2	1,0	0,36
RG350155	94 - 110	4	100	1/2	0,6	0,36

Part No.	ID mm	OD Stopper		Outer thread Inch	Max. counter- pressure bar	Weight kg
		Inch	mm			
RG350156	112 - 130	4 1/2	115	1/2	0,69	0,47
RG350157	125 - 142	5	125	1/2	0,69	0,79
RG350158	146 - 168	6	150	1/2	0,69	0,70
RG350159	175 - 200	7	175	1	0,48	1,92
RG350160	193 - 220	8	200	1	0,48	1,59
RG350161	220 - 240	9	225	1	0,48	2,06
RG350162	245 - 270	10	250	1	0,48	2,52
RG350163	274 - 328	11	275	1	0,48	3,45
RG350164	295 - 325	12	300	1	0,48	3,42
RG350165	325 - 360	13	325	1	0,34	4,75
RG350166	350 - 385	14	350	1	0,34	6,95
RG350167	370 - 410	15	375	1	0,34	5,35
RG350168	390 - 435	16	400	1	0,34	5,90
RG350169	445 - 495	18	450	2	0,34	8,75
RG350170	495 - 550	20	500	2	0,34	11,30
RG350171	515 - 555	21	525	2	0,21	11,30
RG350172	595 - 650	24	600	2	0,21	15,85







## WATER SOLUBLE PURGE FILM

Extremely stable and tear-resistant

- Dissolves completely after successful flushing (with water) and leaves no residue in the pipe
- Provides optimal conditions for a strong dam during the flushing process
- Suitable for welding stainless steel, duplex, chrome-molybdenum and titanium

Step 1: Clean the pipe.

Step 2: Apply water soluble film adhesive to the pipe.

Step 3: Cut out the water soluble film in a circular shape.  
Circle should be 76 mm larger than the pipe circumference.

Step 4: Press the smooth surface of the water soluble film onto the adhesive in the pipe.

Part No.	Description	Unit
RG350215	Water soluble purge film (with 2x 250 ml adhesive)	1 x 20 m
RG350216	Water soluble purge film (without adhesive)	1 x 20 m
RG350214	Adhesive	250 ml

## WELD BACKING TAPE

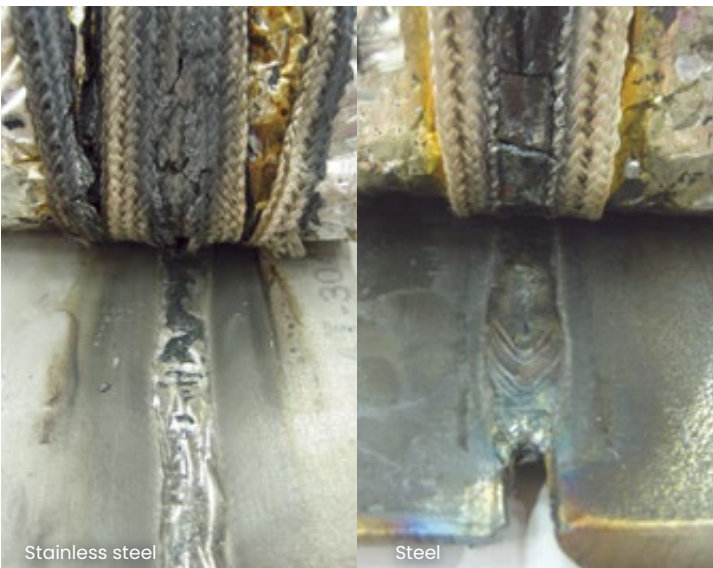
Alternative for conventional backwash methods

The weld backing tape is an innovative replacement for traditional back-flush methods that protect the back of the welding spot and ensure a high quality finish.

The weld backing tape reduces set-up, cleaning and welding time; eliminates grinding after welding and increases work efficiency while minimising costs.

- Reduces the set-up time
- Minimises the grinding effort after welding
- Increases welding performance, reduces costs
- Heat resistant
- Use for welding carbon or stainless steel
- Available in 64 mm x 12,5 m and 102 mm x 12,5 m

Part No.	Size	
RG350218	64 mm x 12,5 m	2" x 39"
RG350219	101,6 mm x 12,5 m	4" x 39"



Step 1: Carefully pull back the corners of the adhesive strips and remove the carrier film cover on both sides.

Step 2: The fiberglass fabric strips must be adjusted and attached to the back of the pipe joint.

Step 3: The aluminium adhesive tape must be applied slowly from the inside to the outside of the area around the pipe joint, this is the only way to ensure a tight seal.

The weld backing tape can be used with steel or stainless steel for welding pipe sheet and pipe sheet or pipe and pipe. The 1/4 gap between the sheet was welded with a 11 mm flux core. It is important to note that the glass fibres were not burnt and that no oxidation took place.



## Water soluble paper

Purge gas dam with low air permeability for all pipe diameters

It is made from sodium carboxymethyl cellulose and wood fibres and dissolves immediately and completely in water and most liquids. It is 100% biodegradable and leaves no residue in the pipe.

- Forms an excellent insulation for noble gases
- Cost savings due to lower gas consumption, as the paper is placed in close proximity to the welding zone, which means that less shielding gas is required to replace the oxygen from the purge chamber.
- Can be easily attached to the inner wall of the pipe with the water soluble Aquasol adhesive tape, thus forming an airtight barrier

Part No.	Description	Unit	Size
RG350204	Water soluble paper	Roll	230 mm x 50 m
RG350205	Water soluble paper	Roll	390 mm x 50 m
RG350206	Water soluble paper	Roll	520 mm x 50 m
RG350202	Water soluble paper	Pack (500 sheets)	430 x 560 mm
RG350203	Water soluble paper	Pack (250 sheets)	390 x 560 mm
RG350209	Water soluble tape	Roll	25,4 mm x 91 m

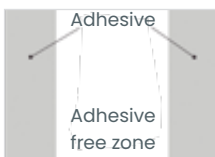
## EZ Zone tape

Clean welding without impurities

EZ Zone Tape is a purge gas masking tape that seals the weld gap between pipes, minimising gas loss during the purge process.

Due to the adhesive-free middle area, welding without contamination is possible.

- Halogen and fluorocarbon free
- Heat resistant
- Reduces pipe cleaning time and the amount of gas used
- Improves safety at your workplace
- Heat resistance up to 260 °C
- Minimum temperature application: -12.5 °C



Part No.	Size	Adhesive free zone
RG350211	63 mm x 22 m 2.5" x 75'	25 mm
RG350212	101 mm x 22 m 4.0" x 75'	50 mm



## EZ Tape aluminum tape

Heat-resistant aluminium adhesive tape

EZ Tape is a traditional aluminium tape used for sealing c- measures during purging, as well as for sealing pipe ends for transport. It is coated with a heat resistant acrylic adhesive system against high shear forces.

The tape can be used in many other traditional applications, such as sealing pipes for heating or air conditioning systems. It is also an excellent vapour barrier.

- Halogen-free and fully coated with acrylic adhesive
- Soft film adapts well to irregular surfaces
- Suitable e.g. as a vapour barrier for sealing pipes

Part No.	Description	Size
RG350213	EZ Tape aluminum tape	50 mm x 20 m





## Oxygen monitor Oxy-Pro

Measuring range 5 - 999 ppm O<sub>2</sub>

- Suitable for inert gases and gases with a hydrogen content of max. 10 %
- Temperature controlled zirconium sensor
- USB interface for storing parameter sets
- Documentation of residual oxygen value, date, time value and name of the project
- Illuminated LED display with simple menu navigation
- Parameter input via keyboard
- Maintenance-free measuring cell made of zirconium oxide
- Long service life through intelligent cell management
- Freely adjustable working range
- Reminder of the validation process
- Robust plastic housing with protective rubber frame



Part No.	Description
RG350520	Oxygen monitor Oxy-Pro

### Technical specifications

Measuring range	5 - 999 ppm O <sub>2</sub>
Power	110 V - 240 V
Interfaces	USB, 0 - 5 VDC, digital
Dimensions (LxWxH)	185 x 93 x 36 mm
Weight	600 g
System language	English and German
Power duration	Up to 8 hours
Sensor type	Zirconium oxide

#### Scope of delivery:

- Hose set 1 m, including filter and stainless steel probe
- Test certificate (validation)
- Transport case
- Power supply unit



## Oxygen monitor PRO OX 100

Measuring range 0,01 – 21,00 % O<sub>2</sub>

- Very fast response time <15 seconds
- Operating temperature 0° – 50°C
- Battery life up to 2 hours in trial mode
- Electrochemical oxygen sensor
- Calibration and test certificate
- Measuring accuracy 0,01%(100 ppm)
- Integrated automatic pump
- Automatic calibration
- Data storage, up to 50 data sets
- USB interface for data transmission and storage
- Audio-visual alarm signal at the end of the flushing time
- Rechargeable 9V battery
- Backlight
- Windows-based software
- One year warranty on the sensor



Part No.	Description	Weight kg
RG350140	Oxygen monitor PRO OX 100	1,8

### Technical specifications

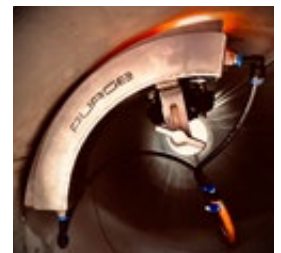
Measuring range	0,01 - 21,00 % O <sub>2</sub>
Calibration	20,9 %
Gas for calibration	Environmental air
Response time	<15 seconds
Warm-up time	Insignificant
Substantial Humidity	0 - 95 % non-condensing
Operating temperature	0 ° - 50 °C
Storage temperature	3 ° - 20 °C
Sample flow	1.0 LPM max.
Proof pressure	10 PSI
Power	9V NiMH Battery
Power duration	Up to 2 hours in trial mode
Sensor type	Electrochemical oxygen sensor
Sensor life	12 months
Recommended calibration interval	weekly, depending on use-frequency
PC interface	USB Type B

### Scope of delivery:

- Oxygen monitor PRO OX 100 with Sensor
- Polycarbonate carrying case
- 1,5 m hose with quick coupling
- Rechargeable battery with charger
- Holding frame
- Stainless steel measuring probe, 2 mm diameter
- USB cable
- Screwdriver
- Instructions for use

## Purge Gas Saver

One of the time consuming and expensive operations when welding pipes, is the purging. To ensure that no oxidation occurs on the inside of the pipes mostly a purging with gas is made. This fills the pipe with gas and the pipe is continuously flushed during welding. Imagine that you could just apply gas where the welding takes place, and that the gas inside the pipe follows the torch on the outside of the pipe.



- For pipes and tanks
- Works on all non-magnetic metals
- Diameter from 300 mm
- Wall thickness up to 8 mm
- Quick change of diameter
- Saves up to 80% gas
- Saves time & easy to use



Part No.	Description
RG350230	Purge Gas Saver



The inserts for different pipe diameters are not part of the scope of delivery and are made available via a download link

## Features & benefits

### Easy of use

- Through the utilization of strong magnets, the Purge Gas Saver always follows the torch
- Due to the 360° wheels the Purge Gas Saver can be slid sideways and through elbows
- No need for attaching wires or similar tools to the Purge Gas Saver. Simply slide it out when you are finished welding

### Efficiency

- The gas consumption can be reduced by up to 80% depending on diameter and length of pipe
- Avoid long flush times and uncertainty of the ppm level during the weld.
- We offers a complete package ready to use for pipe applications.

### Tank welding

- When welding tanks (horizontal welding) reduce the staff involved to only the welder
- No need for trailing with a manually operated gas cup on the inside





## PIPE HANDLING

Pipe stands and pipe carts



## Pipe stand foldable

Foldable, for mobile use

All pipe stands are supplied as standard with a V-head and safety ring to prevent unexpected collapse and injury. The foldable version with carrying handle makes it easy to put down and transport. The load capacity of the pipe stand is 1.500 kg. In addition, the heads are interchangeable and different sets of rollers are available.

- Quick lock washer for fast height positioning
- Safety adjusting screw
- Adjusting screw for locking the V-head
- Delivery incl. V-head

Part No.	Description	Weight kg	Height Inch	Height mm	Load capacity kg
RG350300	Pipe stand foldable and height adjustable	12	33.5 - 49.2	850 - 1.250	1.500



Stainless steel balls



Polyethylene roller

Steel rollers

## Ball & Roller Attachments

Steel rollers, stainless steel balls and polyethylene rollers for foldable pipe stand

Please note that the above-mentioned attachments are always 2 required for 1 stand

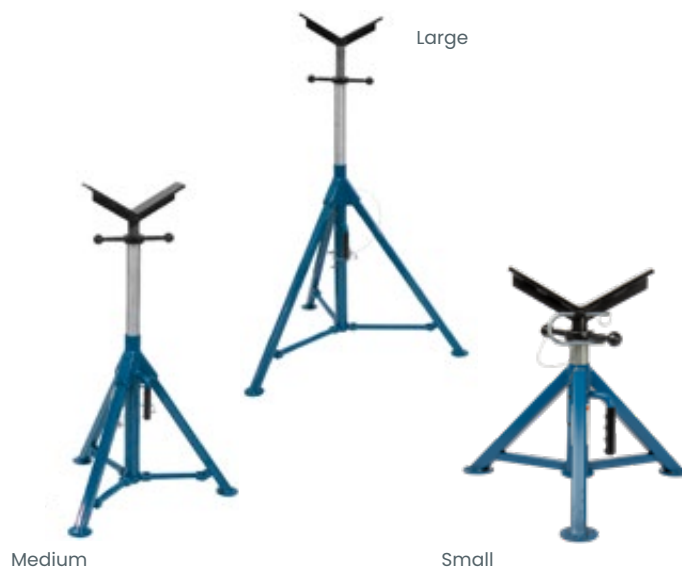
Part No.	Description	Load capacity (2 pieces) kg	OD Inch	OD mm	Weight (per piece) kg
RG350001	Stainless steel ball	925	1 - 20	25 - 500	1,8
RG350002	Polyethylene roller	450	1/2 - 16	12 - 355	1,1
RG350003	Steel rollers	450	1/2 - 16	12 - 355	1,3

## Pipe stand Heavy Duty

For pipes up to 900 mm outer diameter

- 2.725 kg Load capacity
- Version „Medium“ and „Large“ foldable
- Height adjustable
- Additional securing of the V-head
- Delivery complete, incl. V-head

Part No.	Description	Height mm	Load capacity kg	Weight kg
RG350082	Pipe stand HD small with V-head	406 - 724	2.725	11,4
RG350083	Pipe stand HD medium with V-head	673 - 1.130	2.725	16,8
RG350084	Pipe stand HD large with V-head	914 - 1.549	2.725	21,4







## Pipe stand Twin Stand

Outer pipe diameter from 108 - 900 mm

- Height adjustable from 80 cm to 130 cm
- Up to 2.000 kg load capacity
- Levelling on both sides of the support
- Use of quick change housings

\*Quick change rolls not included in delivery. Please order separately!

Part No.	Description	OD mm	Weight kg
RG350185	Pipe stand Twin stand, foldable and height adjustable	108 - 900	16,4



Stainless steel



Nylon

Steel

## Quick change roll sets

Quick-release housing for Twin Stand pipe stand  
Load capacity: 900 kg (steel & stainless steel rolls) 550 kg (nylon rolls)

- Up to 900 kg load capacity (per set)
- No additional tools required for assembly, thanks to snap-in mechanism
- Rollers are already mounted in the quick change housings

Part No.	Description	Load capacity kg	Weight (per set) kg
RG350187	Quick change nylon rolls for Twin stand	550	3,2
RG350188	Quick change steel rolls for Twin stand	900	3,6
RG350189	Quick change stainless steel rolls for Twin stand	900	3,6

## Mobile pipe stand MAXI FLEX

Suitable for pipe storage and pipe transport

The versatile Maxi Flex is the ideal fabrication stand. The large 300 mm V-head and heavy-duty 5-leg design provide the welders maximum safety margin for pipes up to 900 mm in diameter. With any accessories, such as the heavy-duty rollers, pipes weighing up to 2,000 kg per Maxi Flex can be easily moved from the storage rack... to the welding cabin... and on to the shipping area. Thus, loads only have to be lifted once and handling costs are reduced accordingly by 50 % or more.

The Maxi Flex is excellent for levelling loads when aligning or for use together with a pipe turning device.

- Sturdy tubular construction
- Fine-tuning
- Quick-acting parking brake
- Delivery incl. V-head (Steel)

Part No.	Description	Max. Height mm	Weight kg
RG350090	Mobile pipe stand MAXI FLEX incl. casters / steel roller head	1.080	55,0
RG350146	V-head with PU rolls (set)	-	16,0
RG350147	V-head with stainless steel rolls	-	20,0



## Pipe cart

Transports pipes up to 450 kg

Transport of up to 6,1 m long and up to 450 kg heavy pipes with a diameter of up to 300 mm possible

- Quick-release handle for compact storage
- Ideal for transporting materials on construction sites
- Total weight only 36 kg



Attach the pipe to the upturned cart with the ratchet strap.



Turn the cart & pipe over using the handle on the side.



Move handle

Part No.	Description	Weight kg
RG350247	Pipe cart	36,0



## OTHER ACCESSORIES

Useful products and tools





## Centering head for pipes

Solutions for pipe diameters 1/2 - 24"

The DWT centering head is the easiest way to determine the angle of inclination for pipe slopes. It can also be used to find any given point at an angle from the head of the pipe. The centering head can be used on all pipes with a diameter from 1/2" to 5".

- With graduation and protractor bubble for marking out
- Adjustable protractor bubble with graduation
- Hardened centering pin

Part No.	Description	Range	Weight
RG350032	Centering head DWT	1/2 - 5"	0,3
RG350190	Centering head XL DWT	1 - 24"	0,6

## Marking tape

Suitable for pipe diameter 3 - 12"

Ideal tool for marking out the outer surface of pipes. Thanks to the imprint and the stable edges, angle markings and straight lines are easy to set.

The asbestos-free material can withstand temperatures of up to 288 °C to approx.

Part No.	Description	Dimensions	Range OD Inch	Range OD mm
RG350280	Marking tape M	10 cm x 1,2 m	3 - 6"	75 - 150
RG350281	Marking tape L	10 cm x 1,8 m	3 - 10"	75 - 250
RG350282	Marking tape XL	12,5 cm x 2,1 m	4 - 12"	100 - 300







### DWT Flange leveler

Bolt spacing from 60 to 260 mm

The flange leveler level is suitable for flanges with bolt diameters from 16 mm to 32 mm. With this tool, incorrect positions of parts are prevented and no further adjustment tools are required. The bolt spacing can be varied continuously from 60 mm to 260 mm so that the bolt holes are kept in balance.

#### Specification

Dimensions	400 x 50 x 23 mm
Bolt length	75 mm
Bolt distance	60 - 260 mm

Part No.	Description
RG350030	DWT Flange leveler



### DWT Digital flange leveler

with digital protractor

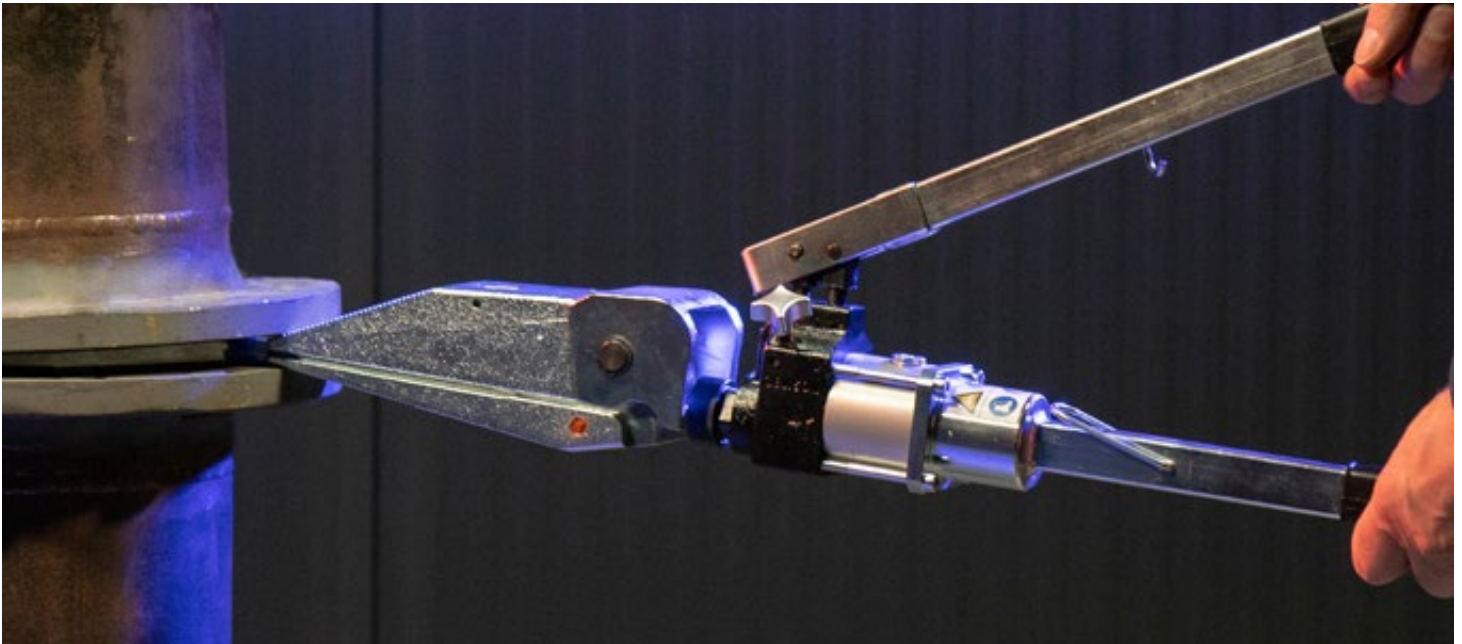
- Automatic rotation of the display
- Measuring range +/- 90 °
- Measurable inclination in °, %, inch and mm
- Automatically rotatable display indicator



#### Specification

Dimensions	400 x 50 x 23 mm
Bolt length	75 mm
Bolt distance	60 - 260 mm
Measurable inclination	+/- 90 °

Part No.	Description
RG350031	DWT Digital flange leveler



## Hydraulic flange spreader

with built-in pressure cylinder

- Ideal for spreading flanges during maintenance work
- Hardened materials
- Built-in impression cylinder
- Simple operation
- Corrosion protected

Part No.	Description	Max. spreading force t	Max. Operating pressure bar	Weight kg
RG350277	Hydr. flange spreader - 2 t spreading force	2	800	8,8



## Hydraulic flange spreaders

Spreading force up to 15 t

- Ideal for spreading flanges during maintenance work
- Interchangeable spreader plates (ribbed and stepped)
- Hardened materials
- Simple operation
- Corrosion protected
- Min. gap distance 5 mm

Part No.	Description	Max. spreading force t	Max. Operating pressure bar	Weight kg
RG350270	Hydr. flange spreader - serrated	15	700	3,2
RG350271	Hydr. flange spreader - stepped	15	700	3,2
RG350273	Hand pump - two-stage	-	700	2,6



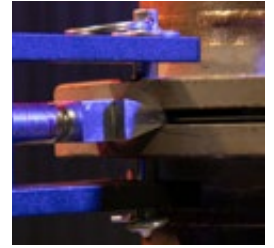


## Mechanical flange spreader

Bolt diameter: 16 - 25 mm

With the flange spreaders, pipe flanges can be separated or lifted quickly, safely and easily within seconds in order to carry out maintenance.

- 4 Various models to cover all flange sizes
- Hardened wedge for safe cutting
- Spindle can be turned with conventional spanner or 12 mm round bar
- Large feed spindle



Part No.	Description	Spreading diameter mm	Bolt diameter mm	Weight kg
RG350175	Flange spreader FS-76	76	16	5,2
RG350176	Flange spreader FS-101	101	19	5,4
RG350177	Flange spreader FS-127	127	22	6,0
RG350178	Flange spreader FS-162	162	25	6,6

## Flange alignment pins

Effortless flange alignment in seconds! Our flange pins, forged from hardened steel, are the key to precise alignment. Robust, durable, and dependable – they are an indispensable tool for every professional.

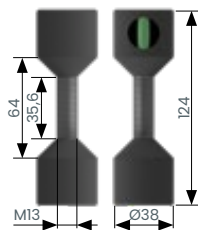
- Crafted from hardened steel: Ensuring maximum stability and longevity
- Lead and quick threads: Secure flanges swiftly and securely
- Equipped with a bubble level for vertical alignment: Ensuring accurate positioning for every job
- Suitable for flanges ranging from 2" to 3": Universally adaptable for diverse projects



Part No.	Description
RG350278	Two hole Pin - Medium
RG350279	Two hole Pin - Large

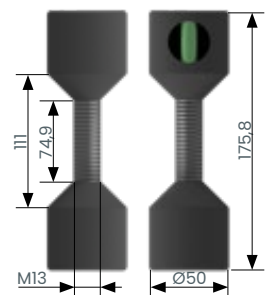
### Two hole Pin - Medium

Self-centring alignment pins, threaded, for flanges with holes 1/2 to 1-7/16" in diameter x 2-1/2" thick.



### Two hole Pin - Large

Self-centring alignment pins, threaded, for flanges with holes 1/2 to 1-15/16" in diameter x 4" thick.



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Distributed by:

**Normaco International OÜ**  
Kuma tee 6, 75312, Peetri, Estonia  
+372 56 922 370  
[sales@normaco-tools.com](mailto:sales@normaco-tools.com)

## **DWT GmbH**

Wilhelm-Tenhagen-Str. 5  
46240 Bottrop - Germany

T +49 (0) 2041-77144-0  
F +49 (0) 2041-77144-99

[info@dwt-gmbh.de](mailto:info@dwt-gmbh.de)

[www.dwt-pipetools.com](http://www.dwt-pipetools.com)

