

WS Plus Cylinder

The WS Plus Cylinder is constructed to keep the purge time at a constant less than 2.5 minutes, subject to a gas flow rate of minimum 10% of the pipe diameter, and to the welding seams being covered by tape.



Example: A 16" WS Plus Cylinder has to be purged with a gas flow rate of 40 L/min. After 2,5 minutes the ppm level will be below 25 ppm O₂.

Walter Schnorrer ApS is testing every single WS Plus and WS Purge Cylinder. The backpressure is also controlled, and the result is written on the cylinder (e.g. 6-E). The backpressure must be between 6-10 mill bar (and always slightly higher when the final welding seam is being welded.)

NOTE: These are flow rates for Stainless Steel only. By duplex or titan the flow is 100% more.

Number	Type	ID mm	Purgeflow	Purgetime
1815008	WS Plus Purge cylinder 8" (340°C)	180-215	20 l/min	2,5 min
1815009	WS Plus Purge cylinder 9" (340°C)	215-240	23 l/min	2,5 min
1820010	WS Plus Purge cylinder 10" (340°C)	240-265	25 l/min	2,5 min
1820011	WS Plus Purge cylinder 11" (340°C)	265-290	28 l/min	2,5 min
1825012	WS Plus Purge cylinder 12" (340°C)	290-315	30 l/min	2,5 min
1825013	WS Plus Purge cylinder 13" (340°C)	315-330	33 l/min	2,5 min
1830014	WS Plus Purge cylinder 14" (340°C)	330-360	35 l/min	2,5 min
1835016	WS Plus Purge cylinder 16" (340°C)	370-400	40 l/min	2,5 min
1840018	WS Plus Purge cylinder 18" (340°C)	420-450	45 l/min	2,5 min
1845020	WS Plus Purge cylinder 20" (340°C)	470-500	20 l/min	2,5 min
1855024	WS Plus Purge cylinder 24" (340°C)	570-600	60 l/min	2,5 min
1855026	WS Plus Purge cylinder 26" (340°C)	625-655	65 l/min	2,5 min
1855028	WS Plus Purge cylinder 28" (340°C)	675-705	70 l/min	2,5 min
1871030	WS Plus Purge cylinder 30" (340°C)	725-755	75 l/min	2,5 min
1875032	WS Plus Purge cylinder 32" (340°C)	770-805	80 l/min	2,5 min
1875034	WS Plus Purge cylinder 34" (340°C)	825-860	85 l/min	2,5 min
1886036	WS Plus Purge cylinder 36" (340°C)	870-905	90 l/min	2,5 min