



Tackless Internal Clamp

Weld flanges without tacking

The Sawyer Value

- Available in 2" - 6" with custom wall thickness for pipe and tube
- Each clamp is machined for a specific wall thickness
- Gap is unobstructed to permit welding without tacking
- Automatically aligns inner bore between pipe and flange
- Copper Backing for anti-spatter is replaceable
- Quick release for fast application
- Requires no outside power unit
- Precision manufactured alloy steel for strength and durability
- 1 year warranty



2" Sch. XXH (247-2-XXH) 3" Sch. XXH (247-3-XXH) 4" Sch. XXH (247-4-XXH) 6" Sch. XXH (247-6-XXH)

**Works with any
flange to pipe
application**

**Stringer with no
tack for better
quality welds**

Standard sizes:

(Contact us for custom sizes and wall thicknesses)

| | | | |
|-------------|-------------|-------------|-------------|
| 2" Sch. 160 | 3" Sch. 160 | 4" Sch. 160 | 6" Sch. 160 |
| 2" Sch. 80 | 3" Sch. 80 | 4" Sch. 80 | 6" Sch. 80 |
| 2" Sch. 40 | 3" Sch. 40 | 4" Sch. 40 | 6" Sch. 40 |
| 2" Sch. XXH | 3" Sch. XXH | 4" Sch. XXH | 6" Sch. XXH |

30 Seconds (or less!) Sales Statement:

Sawyer Mfg.'s Tackless Internal Welding Clamps are custom built to accommodate 2" to 6" pipe and tube with custom wall thickness. These clamps provide the ability to weld without tacking, which keeps the integrity of the weld and give an enormous advantage compared to other clamping methods. The Tackless Internal Clamp is designed for automatic welding but can be used with most flange-to-pipe or pup-to-pup applications. For ultimate efficiency and speed, a Quick Release Nut allows the clamp to be easily released from its position once the weld is complete. The replaceable Copper Backing prevents weld spatter and the need to feather or grind out tacks for a focus on quality welds.



Parts Diagrams

- A. Aluminum Alloy Handle
- B. All Thread Post
- C. Quick Release Nut
- D. Copper Backing
- E. Replacement Screws
- F. Alignment Segments
- G. Retracting (Tension) Spring

**Expanded 4"
Sch. 160
(247-4-160)**



| Model No. | Description | Est. Shipping Wgt. |
|-----------|--|--------------------|
| 227-2-160 | Tackless Int. Welding Clamp 2" Sch 160 | 5 lbs. 2.26 kg. |
| 247-2-80 | Tackless Int. Welding Clamp 2" Sch 80 | 7 lbs. 3.17 kg. |
| 227-2-40 | Tackless Int. Welding Clamp 2" Sch 40 | 10 lbs. 4.53 kg. |
| 247-2-XXH | Tackless Int. Welding Clamp 2" Sch XXH | 3 lbs. 1.36 kg. |
| 227-3-160 | Tackless Int. Welding Clamp 3" Sch 160 | 13 lbs. 5.89 kg. |
| 247-3-80 | Tackless Int. Welding Clamp 3" Sch 80 | 16 lbs. 7.25 kg. |
| 227-3-40 | Tackless Int. Welding Clamp 3" Sch 40 | 20 lbs. 9.07 kg. |
| 247-3-XXH | Tackless Int. Welding Clamp 3" Sch XXH | 11 lbs. 4.98 kg. |
| 227-4-160 | Tackless Int. Welding Clamp 4" Sch 160 | 14 lbs. 6.35 kg. |
| 247-4-80 | Tackless Int. Welding Clamp 4" Sch 80 | 18 lbs. 8.16 kg. |
| 227-4-40 | Tackless Int. Welding Clamp 4" Sch 40 | 22 lbs. 9.97 kg. |
| 247-4-XXH | Tackless Int. Welding Clamp 4" Sch XXH | 12 lbs. 5.44 kg. |
| 227-6-160 | Tackless Int. Welding Clamp 6" Sch 160 | 38 lbs. 17.23 kg. |
| 247-6-80 | Tackless Int. Welding Clamp 6" Sch 80 | 42 lbs. 19.05 kg. |
| 227-6-40 | Tackless Int. Welding Clamp 6" Sch 40 | 48 lbs. 21.77 kg. |
| 247-6-XXH | Tackless Int. Welding Clamp 6" Sch XXH | 32 lbs. 14.51 kg. |

* Available for custom wall thickness pipes and tubes, contact us for details.

For Additional Resources:



Contact Sawyer Mfg. Co for more information about the Tackless Internal Clamp

<http://www.sawyerimg.com>



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