



INSTALLATION, OPERATION, AND MAINTENANCE MANUAL  
FOR WELKER® COMPOSITE GAS SAMPLER

**MODEL**

GSS-4PM

**DRAWING NUMBERS**

AD617BS

AD617CL

**MANUAL NUMBER**

IOM-022

**REVISION**

Rev. G, 11/19/2024

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# SAFETY

## IMPORTANT SAFETY INFORMATION READ ALL INSTRUCTIONS



NOTES emphasize information and/or provide additional information to assist the user.



CAUTION messages appear before procedures that could result in damage to equipment if not observed.



WARNING messages appear before procedures that could result in personal injury if not observed.

*This manual is intended to be used as a basic installation, operation, and maintenance guide for the Welker® Composite Gas Sampler, Model GSS-4PM. For further information and instructions, please refer to the Installation, Operation, and Maintenance (IOM) Manuals for each individual component. A list of relevant component IOM Manuals is provided in the Appendix to this manual.*

*The information in this manual has been carefully checked for accuracy and is intended to be used as a guide for the installation, operation, and maintenance of the Welker® equipment described in this manual. Correct installation and operation, however, are the responsibility of the end user. Welker® reserves the right to make changes to this manual and all products in order to improve performance and reliability.*

### BEFORE YOU BEGIN

Read these instructions completely and carefully.

**IMPORTANT** – Save these instructions for local inspectors' use.

**IMPORTANT** – Observe all governing codes and ordinances.

**Note to Installer** – Leave these instructions with the end user.

**Note to End User** – Keep these instructions for future reference.

Installation of this Composite Gas Sampler is of a mechanical and electrical nature.

Proper installation is the responsibility of the installer. Product failure due to improper installation is not covered under the warranty.

If you received a damaged Composite Gas Sampler, please contact a Welker® representative immediately.

**Phone:** 281.491.2331

**Address:** 13839 West Bellfort Street  
Sugar Land, TX 77498

# SECTION 1: PRODUCT INFORMATION

## 1.1 Introduction

We appreciate your business and your choice of Welker® products. The installation, operation, and maintenance liability for this equipment becomes that of the purchaser at the time of receipt. Reading the applicable *Installation, Operation, and Maintenance (IOM) Manuals* prior to installation and operation of this equipment is required for a full understanding of its application and performance prior to use.\*

If you have any questions, please call Welker® at 1.281.491.2331.

*\*The following procedures have been written for use with standard Welker® parts and equipment. Assemblies that have been modified might have additional requirements and specifications that are not listed in this manual.*

## 1.2 Product Description

The Welker® GSS-4PM Composite Gas Sampler is a self-purging positive displacement pump designed to extract samples from the center one-third ( $\frac{1}{3}$ ) of a pressurized gas pipeline and collect them in a connected sample cylinder.

The compact design of this probe-mounted sampler eliminates long tubing runs and sample lag time. By minimizing the distance between the product source and the collection head, the GSS-4PM ensures quality sample grabs. With every actuation, pressure is applied to the Vanishing Chamber™ collection cup, collapsing the cup and fully displacing the trapped sample into the sample cylinder.

The GSS-4PM can be connected to a customer-provided Programmable Logic Controller (PLC) or other signal control system to operate the solenoid. Alternatively, the GSS-4PM can be supplied with a Welker® 4P Sample Frequency Controller or a Welker® 6Tc Timer/Controller, both of which are capable of operating the solenoid for timed or proportional-to-flow sampling.

In locations where the process gas is not clean and dry, the GSS-4PM can be configured for operation by an auxiliary instrument air supply. For such locations, the Welker® LE-2SSKO Probe-Mounted Liquid Eliminator is recommended in place of the standard probe, because it removes free liquids, condensed hydrocarbons, glycol, and amines from gas samples, which ensures the collection of representative samples and also protects the sampler.



For this manual, the term "Programmable Logic Controller" (PLC) will refer to the PLC, DCS, or other signal control used by the customer.

*Welker® might custom design the GSS-4PM to suit the particular application and specifications of each customer.*

## 1.3 Specifications



The specifications listed in this section are generalized for this equipment. Welker® can modify the equipment according to your company's needs. **Please note that the specifications may vary depending on the customization of your equipment.**

### Welker® GSS-4PM Composite Gas Sampler Specifications

Products Sampled	Natural Gas and Other Gases Compatible With the Materials of Construction
Materials of Construction	316/316L Stainless Steel, PTFE, and Viton® Others Available
Maximum Allowable Operating Pressure	<b>With LE-2SSKO:</b> 1440 psig @ -20 °F to 120 °F ( <i>99 barg @ -28 °C to 48 °C</i> ) <b>Standard:</b> 2160 psig @ -20 °F to 120 °F ( <i>148 barg @ -28 °C to 48 °C</i> )
Pipeline Connection	½" MNPT ¾" MNPT (Standard) 1" MNPT
Electrical Connection	AC 110 V DC 6 V DC 12 V (Standard) DC 24 V (Standard)
Sample Volume	0.065 cc Vanishing Chamber™ Collection Cup 0.22 cc Vanishing Chamber™ Collection Cup (Standard) 0.5 cc Vanishing Chamber™ Collection Cup 1.0 cc Vanishing Chamber™ Collection Cup 1.5 cc Vanishing Chamber™ Collection Cup
Operation	Diaphragm-Operated Motor
Features	Inline Relief Integrated Bypass Manifold With Valve Outlet Pressure Gauge Regulator With Relief and Pressure Gauge
Options	4-Way Solenoid Valve (Standard) Manifold for Welker® SC Single Cavity Cylinder (Standard) Welker® 4P Sample Frequency Controller Welker® 6Tc Timer/Controller Welker® LE-2SSKO Probe-Mounted Liquid Eliminator (Standard)

## 1.4 Equipment Diagrams

Figure 1: Welker® GSS-4PM Connections Diagram

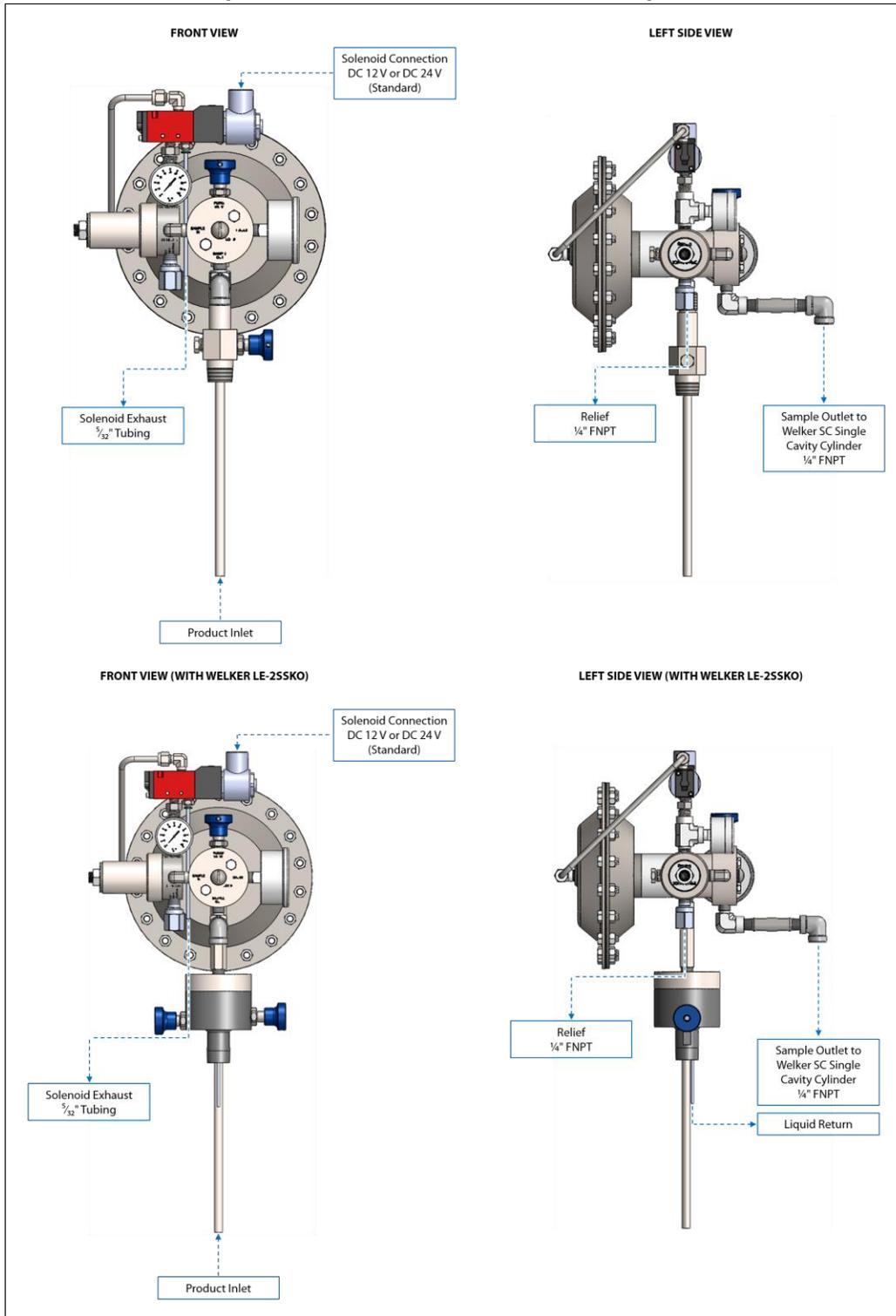


Figure 2: Welker® GSS-4PM With Standard Probe

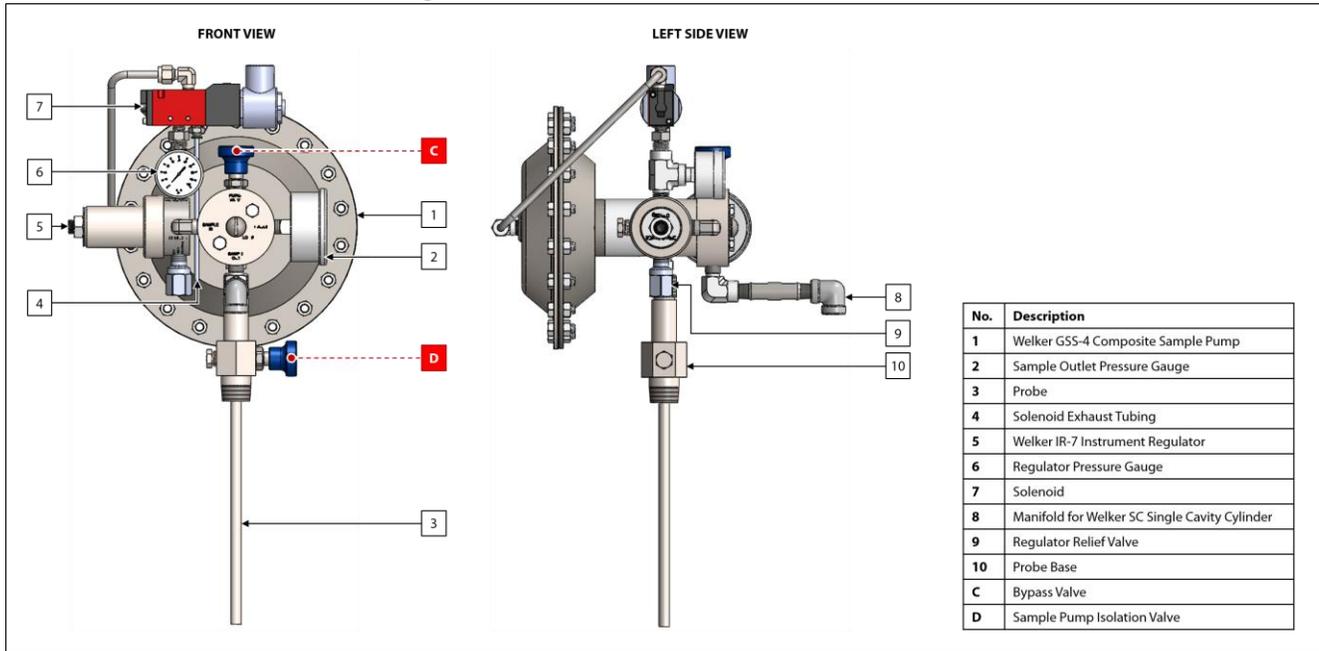


Figure 3: Welker® GSS-4PM With LE-2SSKO Probe-Mounted Liquid Eliminator

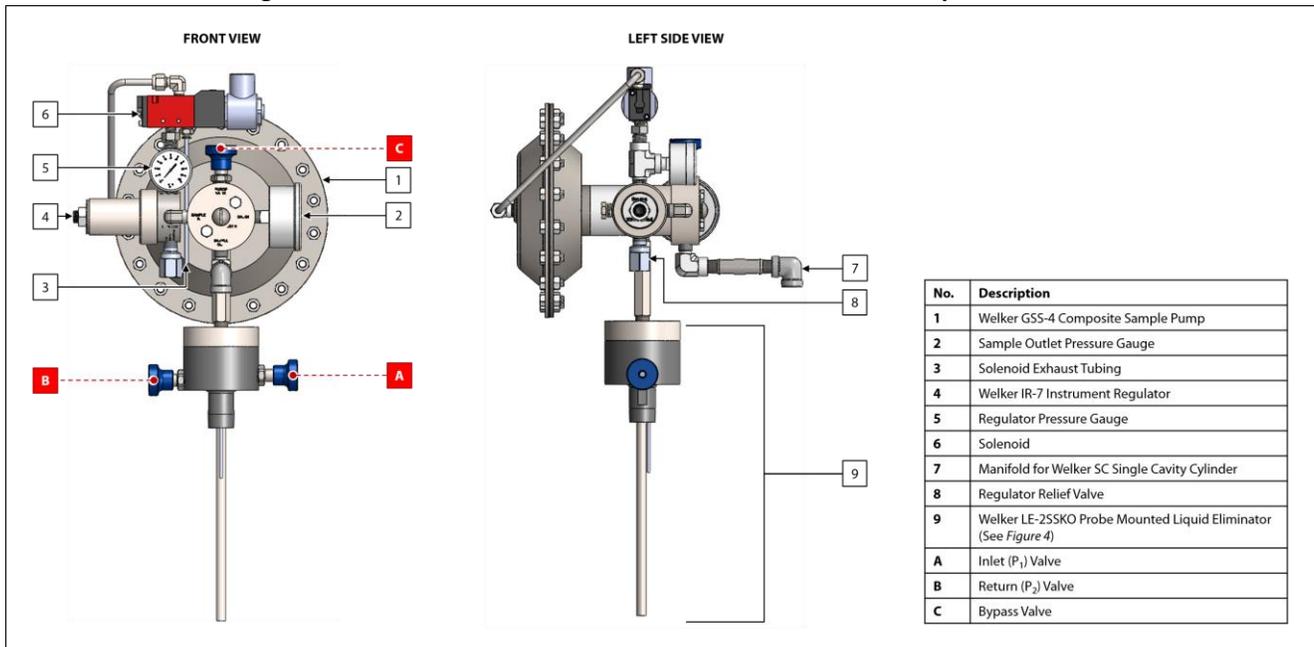
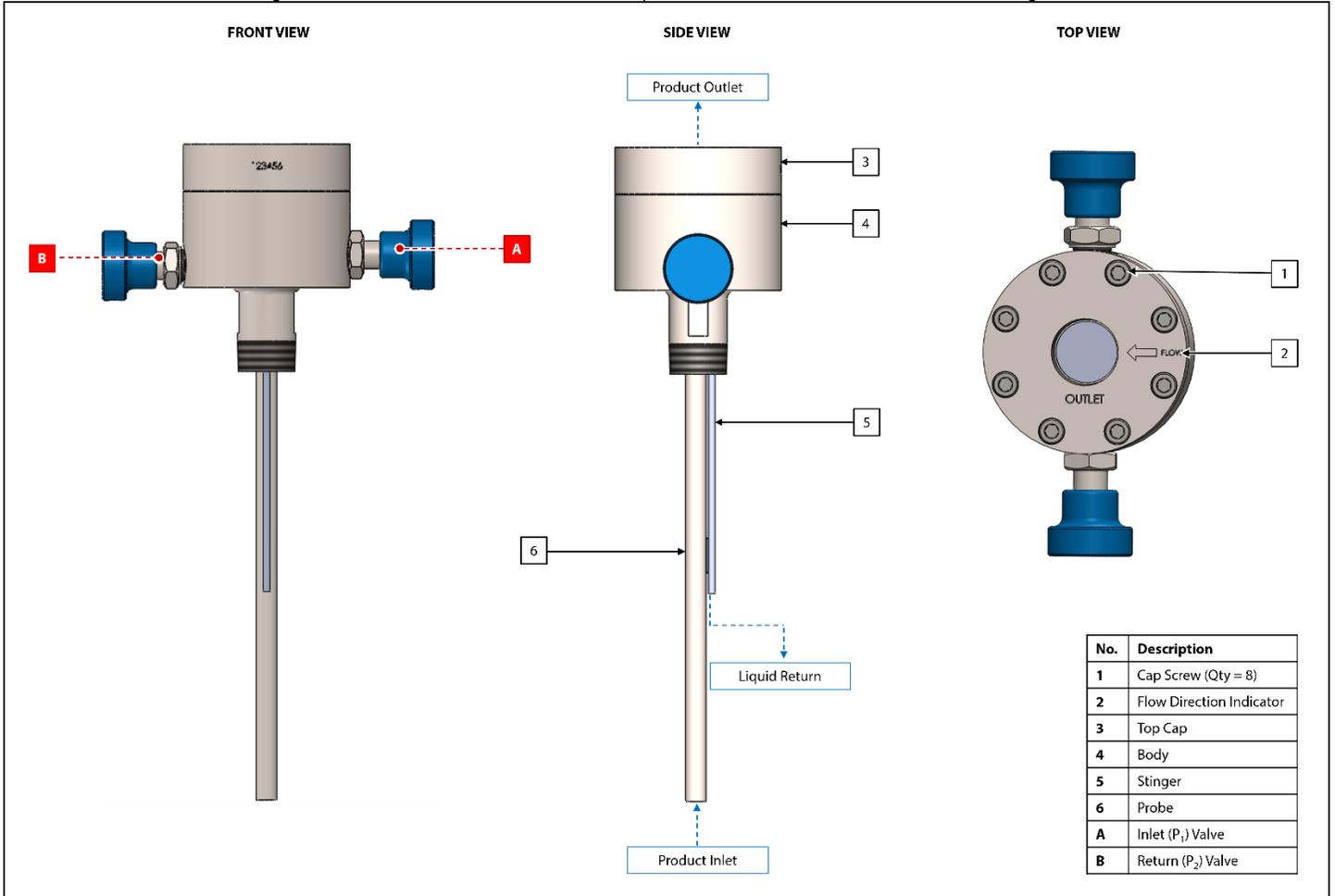


Figure 4: Welker® Probe-Mounted Liquid Eliminator, Model LE-2SSKO Diagram



## SECTION 2: INSTALLATION & OPERATION

### 2.1 Before You Begin



After unpacking the Welker® GSS-4PM, check it for compliance and any damage that might have occurred during shipment. Immediately contact a Welker® representative if you received a damaged unit.



When sealing fittings with PTFE tape, refer to the proper sealing instructions for the brand used.



All electrical connections must meet local and national electric codes, and excessive weight added to the conduit run must be supported.

1. The installation instructions are written with the assumption that the sampler has been purchased as part of a complete sampling system. If the sampler has been purchased individually, a sampling system should be constructed in a fashion compatible with the instructions in this *Installation, Operation, and Maintenance (IOM) Manual*.
2. The sample probe should be located in the least turbulent area of the flowing stream available (i.e., not in a header or blow-down stack and away from obstructions, elbows, and partially closed valves).
3. Typically, the Welker® GSS-4PM is installed with a single probe. The unique self-purging design of the GSS-4PM uses process gas to supply the solenoid, thus purging the sample line prior to each sample grab. If auxiliary instrument air is used to supply the solenoid, the customer must have a return port downstream of a moderate pressure drop (e.g., an orifice plate or control valve) to create a bypass for the sampler, which will allow for a "real-time" sample to be taken with each actuation of the sampler.
4. The SP probe, LE-2SSKO, and manifold are shipped unattached to the GSS-4PM. These parts might be shipped with PTFE tape applied to threaded connections. However, if PTFE tape was not applied, first apply PTFE tape to threaded connections.
5. Carefully hand-torque when attaching the SP probe to the LE-2SSKO (*Figure 4*).
6. Carefully hand-torque when attaching the manifold to the GSS-4PM (*Figure 3*).
7. Carefully hand-torque when attaching the LE-2SSKO to the GSS-4PM (*Figure 3*).
8. Check the GSS-4PM system for leaks and repair as necessary.
9. The unit is now ready to be installed. Proceed to *Section 2.2, Installation*.

## 2.2 Installation

1. Turn off all electrical power.
2. Depressurize the pipeline.



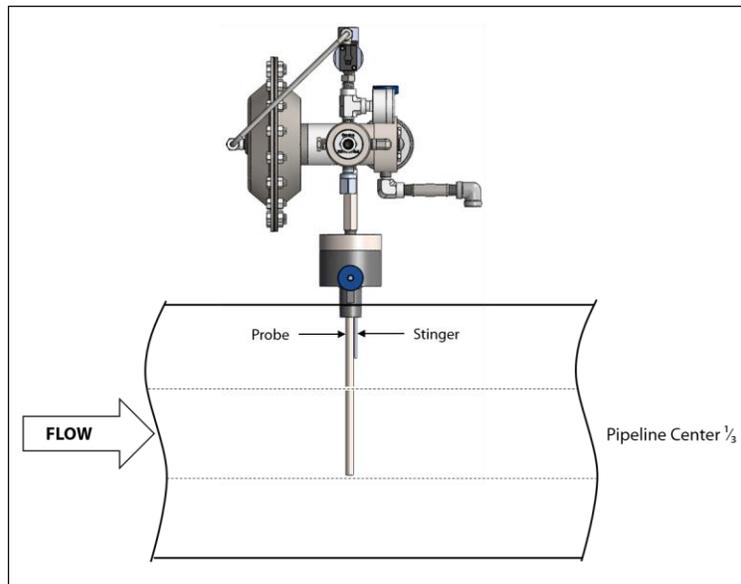
Be certain to turn off ALL electrical power before accomplishing installation.



The pipeline MUST BE depressurized prior to installing and removing the Welker® GSS-4PM unit.

3. Ensure that all valves on the GSS-4PM are closed.
4. Wrap the threads of the threaded pipeline connection with PTFE tape.
5. Install the GSS-4PM to the pipeline. If the GSS-4PM is equipped with the optional Welker® LE-2SSKO Probe-Mounted Liquid Eliminator, ensure that it is installed so that the stinger is downstream of the direction of product flow (*Figure 5*).

Figure 5: Correct Installation of the Welker® GSS-4PM With the Welker® LE-2SSKO



6. As necessary, connect from the solenoid exhaust tubing to a flare (*Figure 1*).



If the process gas used to actuate the sample cannot be safely vented to the atmosphere, Welker® recommends connecting from the solenoid exhaust tubing to a flare.

7. If the GSS-4PM is equipped with a Welker® 4P Sample Frequency Controller, refer to the *Installation, Operation, and Maintenance (IOM) Manual* for the 4P for wiring instructions.
8. If the GSS-4PM is equipped with a solenoid, connect from the PLC to the solenoid (*Figure 1*).
9. If process gas will be used to actuate the sampler, the sample cylinder may now be installed.



If a Welker® Single Cavity Cylinder will be used for sample collection, proceed to step 16.  
If a Welker® Constant Pressure Cylinder will be used for sample collection, proceed to step 19.

10. If an auxiliary instrument air supply will be used to actuate the sample, continue to step 11.



The GSS-4PM is designed to use process gas as the instrument supply and does not require an auxiliary instrument air supply. However, if process gas is not clean and dry and/or cannot be safely vented to the atmosphere, Welker® recommends the use of an auxiliary instrument air supply.

### Using an Auxiliary Instrument Air Supply (Optional)

11. Remove the elbow connecting the regulator to the base, and then tube from the instrument supply port in the base to the **required downstream return**. This creates a bypass for the sampler, which will allow for a “real-time” sample to be taken with each actuation of the sampler.
12. Connect the customer-supplied clean, dry auxiliary instrument air supply to the open port of the regulator.
13. Regulate the auxiliary instrument air supply to the pressure appropriate for the application. The auxiliary instrument air supply should be between 40 and 60 psig.



In applications where pipeline pressure is greater than 1500 psig, additional instrument air may be required to take a sample. Increase the instrument air supply and adjust the regulator relief valve as necessary. To protect the diaphragm motor, the instrument air supply should not exceed 100 psig.

14. Set the regulator relief valve to approximately 85 psig. Refer to the *Installation, Operation, and Maintenance (IOM) Manual* for the regulator relief valve for instructions on setting the relief.
15. The sample cylinder may now be installed.



If a Welker® Single Cavity Cylinder will be used for sample collection, proceed to step 16.  
If a Welker® Constant Pressure Cylinder will be used for sample collection, proceed to step 19.

## Installing the Sample Cylinder

### Single Cavity (SC) Cylinder

16. Ensure that the inlet and outlet valves on the SC are closed.
17. Install the inlet valve of the SC to the cylinder hanger on the manifold (*Figure 1, Figure 2, and Figure 3*).
18. Installation is now complete.

### Constant Pressure Cylinder

19. Ensure that the pre-charge and product inlet valves on the constant pressure cylinder are closed.
20. Tube from the pre-charge pressure supply to the pre-charge inlet valve on the constant pressure cylinder.



If the GSS-4PM is equipped with the standard probe and process gas will be used to pre-charge the constant pressure cylinder, remove the plug from the probe base, and then tube from the port to the pre-charge valve on the constant pressure cylinder. Welker® recommends first installing a valve to the port on the probe base.



If the GSS-4PM is equipped with the optional LE-2SSKO and process gas will be used to pre-charge the constant pressure cylinder, remove the plug from the back of the regulator. Then tube from the port to the pre-charge valve on the constant pressure cylinder.



If the optional auxiliary instrument air supply will be used to pre-charge the constant pressure cylinder, remove the plug from the back of the regulator. Then tube from the port to the pre-charge valve on the constant pressure cylinder.

21. Tube from the sample outlet on the base of the GSS-4 to the product inlet valve on the constant pressure cylinder.
22. Pre-charge the constant pressure cylinder. Refer to the *Installation, Operation, and Maintenance (IOM) Manual* for the constant pressure cylinder for instructions on pre-charging the constant pressure cylinder.

## 2.3 Start-Up Procedures

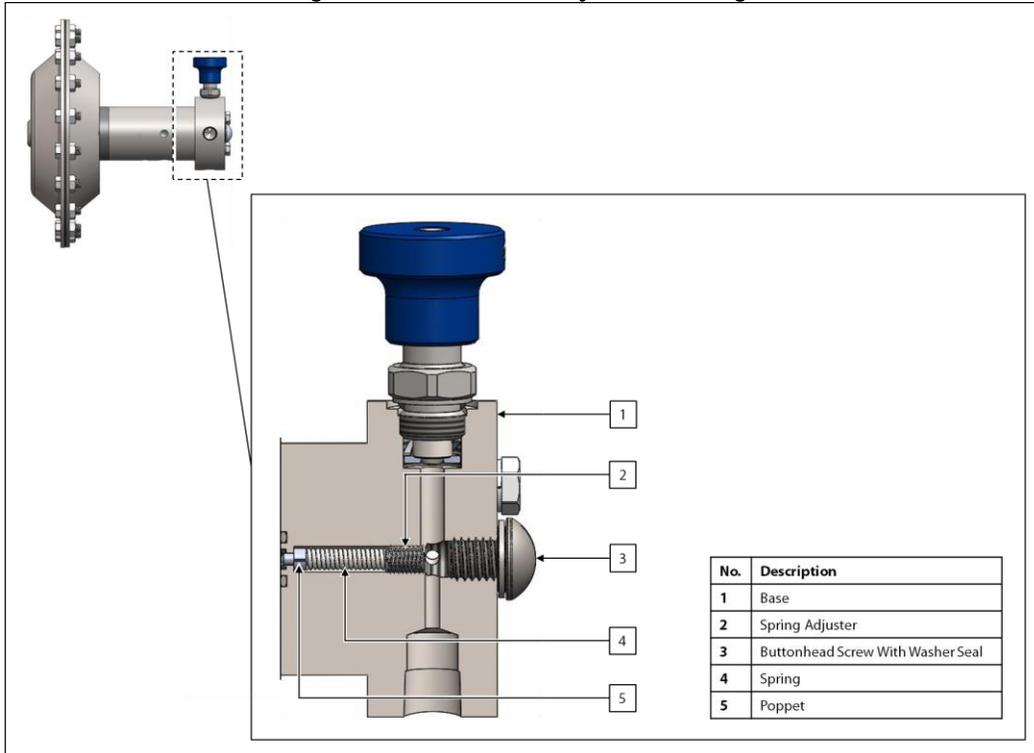
1. Ensure that all valves on the GSS-4PM are closed.
2. Pressurize the pipeline.
3. As necessary, adjust the inline relief. If the inline relief does not need to be adjusted, proceed to step 22.

### Setting the Inline Relief



If a Welker® Single Cavity Cylinder will be used for sample collection, continue to step 4.  
If a Welker® Constant Pressure Cylinder will be used for sample collection, proceed to step 11.

Figure 6: Inline Relief Adjustment Diagram



## Single Cavity Cylinder

4. Remove the buttonhead screw and washer seal from the end of the base.
5. Insert a hex key through the base to the spring adjuster.
6. Allow full pipeline pressure to reach the GSS-4M. Check for leaks and repair or replace as necessary.



If the GSS-4PM is equipped with a standard probe, slowly open sample pump isolation valve D (*Figure 2*).  
If the GSS-4PM is equipped with the optional LE-2SSKO, slowly open inlet (P<sub>1</sub>) valve A and return (P<sub>2</sub>) valve B (*Figure 3*).

7. Turn the spring adjuster to adjust the spring tension until no gas bleeds through. Then turn the spring adjuster clockwise another full turn.



When sampling into a Welker® SC Single Cavity Cylinder, the inline relief must be set to approximately 100 psig above pipeline pressure.



To increase spring tension and raise the relief set point, turn the spring adjuster clockwise.  
To decrease spring tension and lower the relief set point, turn the spring adjuster counterclockwise.



Each full clockwise turn of the spring adjuster increases spring tension approximately 100 psig.

8. Replace the washer seal. Then return the buttonhead screw to the base.
9. Verify that the sample outlet pressure gauge reads the pressure appropriate for the sample cylinder (*Figure 2* or *Figure 3*). This reading indicates that the inline relief is holding and that sample cannot flow back to the pipeline.



When sampling into a Welker® Single Cavity (SC) Cylinder, the pressure gauge should read 0 psig at start-up.

10. Proceed to step 22.

## Constant Pressure Cylinder

11. Allow full pipeline pressure to reach the GSS-4PM. Check for leaks and repair or replace as necessary.



If the GSS-4PM is equipped with a standard probe, slowly open sample pump isolation valve D (*Figure 2*).  
If the GSS-4PM is equipped with the optional LE-2SSKO, slowly open inlet (P<sub>1</sub>) valve A and return (P<sub>2</sub>) valve B (*Figure 3*).

12. Read the pressure on the sample outlet pressure gauge (*Figure 2* or *Figure 3*). To determine the current inline relief setting, subtract the pressure reading from the pipeline pressure.



When sampling into a Welker® Single Cavity (SC) Cylinder, the pressure gauge should read approximately 200 psig below pipeline pressure at start-up.

13. If the current inline relief setting is approximately 200 psig, the inline relief does not need to be adjusted. Proceed to step 22. However, if the current inline relief setting is anything other than approximately 200 psig, the inline relief must be adjusted. Continue to step 14.
14. Isolate the GSS-4PM from pipeline pressure.



If the GSS-4PM is equipped with a standard probe, close sample pump isolation valve D (*Figure 2*).  
If the GSS-4PM is equipped with the optional LE-2SSKO, close inlet (P<sub>1</sub>) valve A and return (P<sub>2</sub>) valve B (*Figure 3*).

15. Remove the buttonhead screw and washer seal from the end of the base.
16. Insert a hex key through the base to the spring adjuster.
17. Turn the spring adjuster to adjust the spring tension.



When sampling into a Welker® Single Cavity (SC) Cylinder, the pressure gauge should read approximately 200 psig below pipeline pressure at start-up.



To increase spring tension and raise the relief set point, turn the spring adjuster clockwise.  
To decrease spring tension and lower the relief set point, turn the spring adjuster counterclockwise.



Each full clockwise turn of the spring adjuster increases spring tension approximately 100 psig.

18. Replace the washer seal. Then return the buttonhead screw to the base.
19. Allow full pipeline pressure to reach the GSS-4PM.



If the GSS-4PM is equipped with a standard probe, slowly open sample pump isolation valve D (*Figure 2*).  
If the GSS-4PM is equipped with the optional LE-2SSKO, slowly open inlet (P<sub>1</sub>) valve A and return (P<sub>2</sub>) valve B (*Figure 3*).

20. Read the pressure on the sample outlet pressure gauge (*Figure 2* or *Figure 3*). To determine the current inline relief setting, subtract this pressure reading from the pipeline pressure.



When sampling into a Welker® Single Cavity (SC) Cylinder, the pressure gauge should read approximately 200 psig below pipeline pressure at start-up.

21. If the current inline relief setting is approximately 200 psig, the inline relief does not need to be adjusted. Continue to step 22. If the current inline relief setting is anything other than approximately 200 psig, the inline relief must be adjusted. Repeat steps 14–21 until the inline relief is set to approximately 200 psig.

## Purging the Sample Cylinder



Refer to Gas Processors Association (GPA) Standard 2166-86, *Obtaining Natural Gas Samples for Analysis by Gas Chromatography*, for further instructions on GPA-recommended purge methods.



The following methods are only advisable if the sample cylinder will be used in the same location to sample the same type of product.

22. Purge the sample cylinder.



To purge the Welker® SC Single Cavity Cylinder, continue to step 23.  
To purge the Welker® Constant Pressure Cylinder, proceed to step 30.

### Single Cavity (SC) Cylinder

23. Slowly open bypass valve C (*Figure 2* or *Figure 3*). Check for leaks and replace or repair as necessary.
24. Close bypass valve C.
25. Open the Outlet valve on the SC.
26. Open bypass valve C.
27. Open the inlet valve on the SC.
28. Close bypass valve C.
29. Proceed to step 35.

### Constant Pressure Cylinder

30. Open the pre-charge supply to the constant pressure cylinder. Check for leaks and replace or repair as necessary.



If process gas will be used to pre-charge the constant pressure cylinder, slowly open sample pump isolation valve D (*Figure 2*).  
If the optional auxiliary instrument air supply will be used to pre-charge the constant pressure cylinder, slowly open the supply to the constant pressure cylinder.

31. Slowly open the pre-charge valve on the constant pressure cylinder. This supplies pre-charge pressure to the constant pressure cylinder and forces the constant pressure cylinder piston to the product side of the cylinder.
32. Open the product inlet valve on the constant pressure cylinder.
33. Open the process connection to the constant pressure cylinder. Check for leaks between the pipeline and the constant pressure cylinder and repair or replace as necessary.



If the GSS-4PM is equipped with a standard probe, slowly open sample pump isolation valve D (*Figure 2*).  
If the GSS-4PM is equipped with the optional LE-2SSKO, slowly open inlet (P<sub>1</sub>) valve A and return (P<sub>2</sub>) valve B (*Figure 3*).

34. Purge the tubing between the GSS-4PM and the constant pressure cylinder.



If the constant pressure cylinder is equipped with a purge valve, open the purge valve for approximately three to five (3–5) seconds to purge the tubing, and then close the purge valve. Welker® recommends plugging the purge valve when not in use..  
If the constant pressure cylinder is not equipped with a purge valve, the tube fitting at the product inlet of the constant pressure cylinder might be cracked. However, Welker® recommends installing a tee with a valve between the sample outlet on the GSS-4PM and the product inlet on the constant pressure cylinder to enable the tubing to be purged.

## Testing the GSS-4PM

35. Ensure that bypass valve C is closed (*Figure 2* or *Figure 3*).
36. Close the product inlet valve on the sample cylinder.
37. Actuate the GSS-4PM.
38. Observe the sample outlet pressure gauge (*Figure 2* or *Figure 3*). Allow pressure to build above line pressure, and then let the GSS-4PM sit for several minutes.
39. After several minutes, read the pressure on the sample outlet pressure gauge. If the pressure has dropped, check the GSS-4PM for leaks and repair or replace as necessary. If the pressure has not dropped, the unit is ready to be placed into operation.
40. Bleed off the test pressure from the sample cylinder.
41. Open the product inlet valve on the sample cylinder.

## Preparing for Sampling

42. Set the signal control system to the desired sampling frequency based on the sampling actuation equations provided (*Figure 7*). If the GSS-4PM is equipped with a 4P, refer to the *Installation, Operation, and Maintenance (IOM) Manual* for the 4P for instructions on setting the sampling frequency. If the GSS-4PM is equipped for a 6Tc, refer to the *Installation, Operation, and Maintenance (IOM) Manual* for the 6Tc for instructions on setting the sampling frequency.

Figure 7: Gas Sampling Equations

Gas Sampling, Proportional-to-Flow Collection	
<b>Equation 1: Number of Samples Needed</b>	$\text{Number of Samples Needed to Fill to 100\%} = \frac{\text{Container Size (cc)}}{\text{Bite Size (cc)}}$
<b>Equation 2: Proportional-to-Flow</b>	$\text{Volume of Flow Between Sample Grabs} = \frac{\text{Batch Size (Total Volume to Be Sampled)}}{\text{Number of Samples Needed (Eq. 1)}}$
Use <b>Equation 1</b> to determine the number of actuations needed. Use <b>Equation 2</b> to determine how often (after what volume of flow) to take each sample.	
Gas Sampling, Timed Collection	
<b>Equation 1: Number of Samples Needed</b>	$\text{Number of Samples Needed to Fill to 100\%} = \frac{\text{Container Size (cc)}}{\text{Bite Size (cc)}}$
<b>Equation 2: Timed Sampling</b>	$\text{Time Between Sample Grabs} = \frac{\text{Total Time in Sample Period}}{\text{Number of Samples Needed (Eq. 1)}}$
Use <b>Equation 1</b> to determine the number of actuations needed. Use <b>Equation 2</b> to determine how often (after what amount of time) to take each sample.	



Note that the sample volume of the Vanishing Chamber™ collection cup could be 0.065 cc, 0.22 cc, 0.5 cc, 1.0 cc, or 1.5 cc.

43. The GSS-4PM is now operational.

## SECTION 3: MAINTENANCE

### 3.1 Before You Begin

1. **Welker® recommends that the unit have standard maintenance every six (6) months under normal operating conditions.** In cases of severe service, dirty conditions, excessive usage, or other unique applications that might lead to excess wear on the unit, a more frequent maintenance schedule might be appropriate.
2. Prior to maintenance or disassembly of the unit, it is advisable to have a repair kit available for repairs to the system in case of unexpected wear or faulty seals.



New seals supplied in spare parts kits should be lightly lubricated before being installed to ease the installation of the seals and reduce the risk of damage when positioning them on parts. Wipe excess lubricant from the seals, because it might adversely affect analytical instrument results.



For sample-exposed seals, Welker® recommends non-hydrocarbon-based lubricants, such as Krytox®. For non-sample-exposed seals, Welker® recommends either non-hydrocarbon-based lubricants or silicone-based lubricants, such as Molykote® 111.



After the seals are installed, the outer diameter of shafts and inner diameter of cylinders may be lubricated to allow smooth transition of parts.

2. All maintenance and cleaning of the unit should be performed on a smooth, clean surface.
3. Welker® recommends having the following tools available for maintenance. Please note that the exact tools required might vary by model.
  - a. ½" Wrench
  - b. 6" Adjustable Wrench
  - c. Adjustable Pliers
  - d. Anti-Galling Compound
  - e. Hex Key Set
  - f. Seal Pick
  - g. Snap Ring Pliers
  - h. Threadlocker

## 3.2 Maintenance

1. Isolate the GSS-4PM from pipeline pressure.



During maintenance, check valves for leaks and repair or replace as necessary.



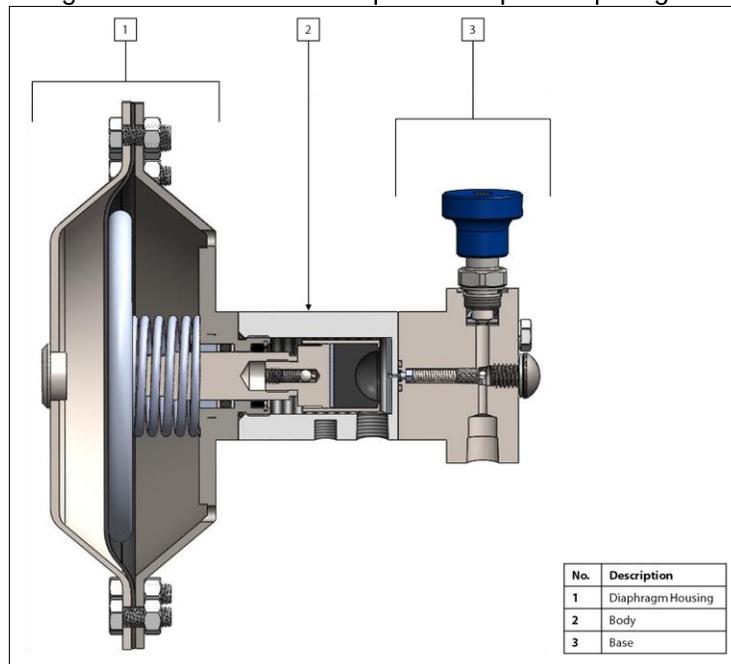
If maintenance on the valves is required, the GSS-4PM **MUST BE** isolated from pipeline pressure **and removed from the pipeline** before maintenance can safely be performed. The pipeline **MUST BE** depressurized prior to installing and removing the Welker® GSS-4PM.



If the GSS-4PM is equipped with a standard probe, close sample pump isolation valve D (*Figure 2*).  
If the GSS-4PM is equipped with the optional LE-2SSKO, close inlet (P<sub>1</sub>) valve A and return (P<sub>2</sub>) valve B (*Figure 3*).

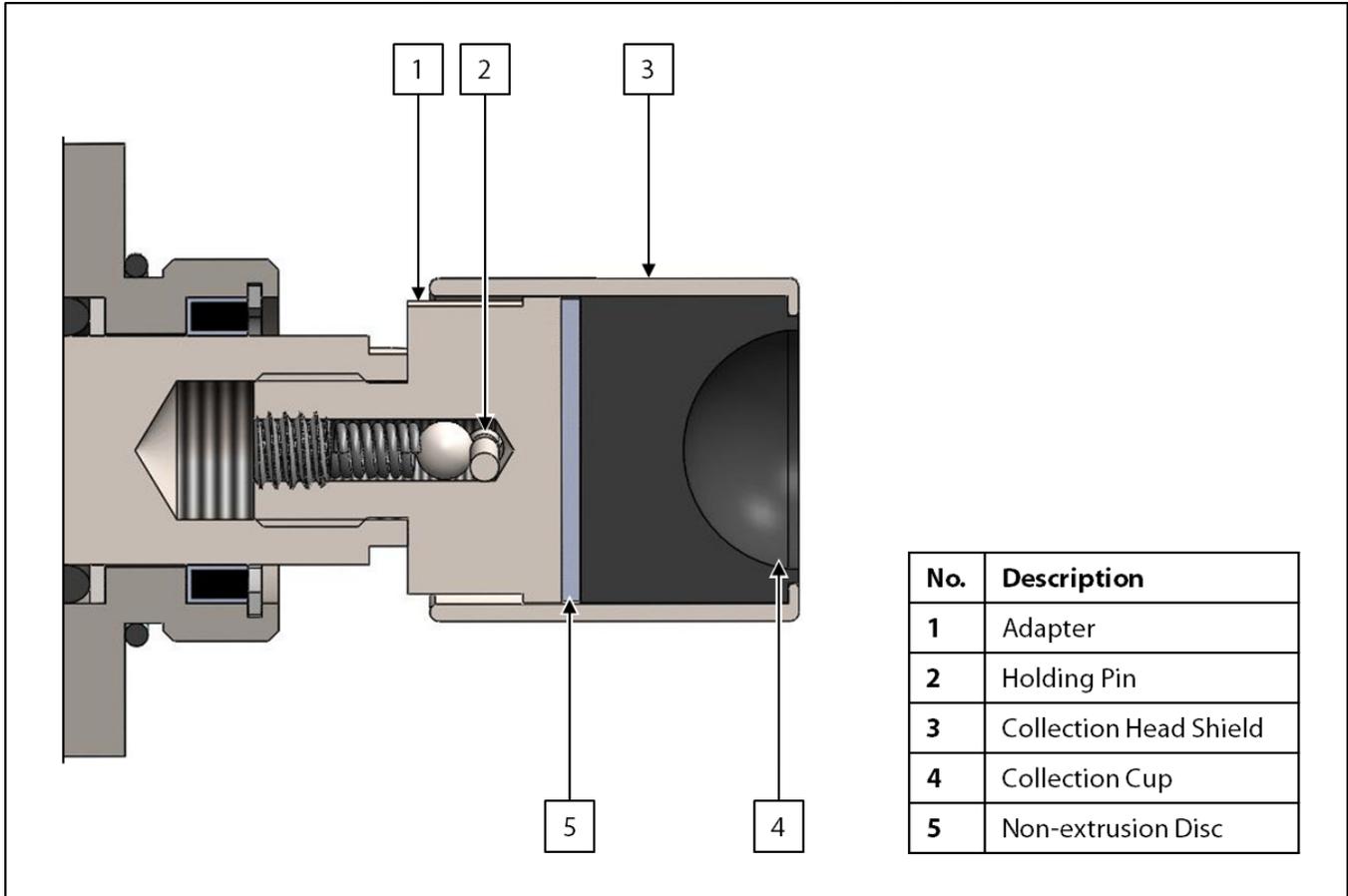
2. Turn OFF electrical power to the system and carefully remove all electrical connections.
3. As necessary, disconnect the tubing between the solenoid exhaust and flare.
4. As necessary, disconnect the auxiliary instrument air supply.
5. As necessary, relieve pressure from the tubing connecting the GSS-4PM to the sample cylinder.
6. Remove the GSS-4PM body from the standard probe or from the optional LE-2SSKO.
7. As necessary, maintain the optional LE-2SSKO. Refer to the *Operation, Installation, and Maintenance (IOM) Manual* for the LE-2SSKO for maintenance instructions.
8. Unscrew the diaphragm housing from the body, taking care not to misplace the stainless steel Vacuum Breaker™ disc or clear spider seal, which separate from the body with the removal of the diaphragm housing (*Figure 8* or *Figure 11*). The collection head assembly should now be exposed.

Figure 8: Welker® GSS-4 Composite Sample Pump Diagram



## Collection Head Maintenance

Figure 9: Collection Head Maintenance Diagram



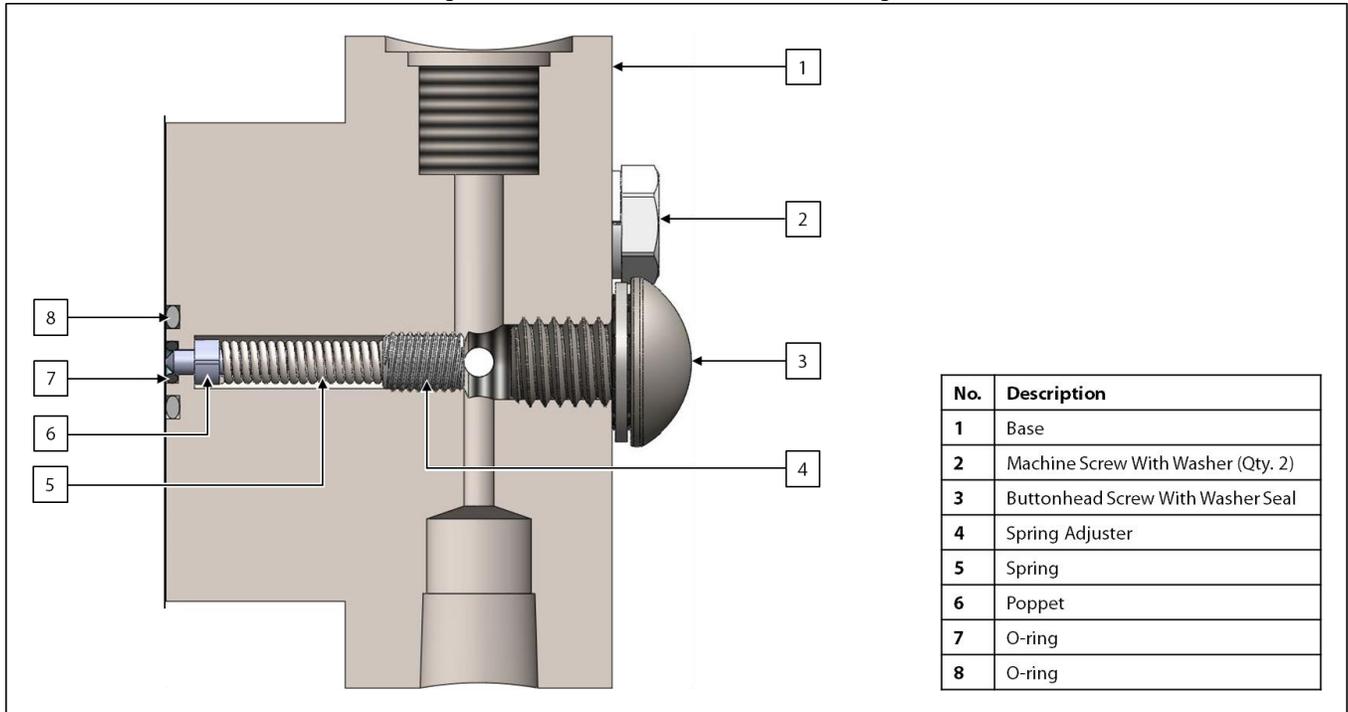
9. Remove the holding pin from the collection head shield. Then separate the collection head shield from the adapter.
10. Push the collection cup and non-extrusion disc out of the collection head shield.
11. Lubricate the inside of the collection head shield. Then install the replacement collection cup and non-extrusion disc.



Welker® recommends a non-hydrocarbon-based lubricant, such as Krytox®, for use with this unit.

12. Return the collection head shield to the adapter. Then install the holding pin to secure the collection head shield to the adapter.
13. Unscrew the adapter from the shaft.

Figure 10: Inline Relief Maintenance Diagram



14. Unscrew the machine screws and washers from the base. Then remove the base from the body.
15. Remove the buttonhead screw and washer seal from the end of the base.
16. Insert a hex key through the base to the spring adjuster. Turn the hex key counterclockwise to unscrew and remove the spring adjuster from the base.
17. Remove the spring and poppet from the base.
18. Inspect the seating face of the poppet for scratches or other damage. Replace as necessary.

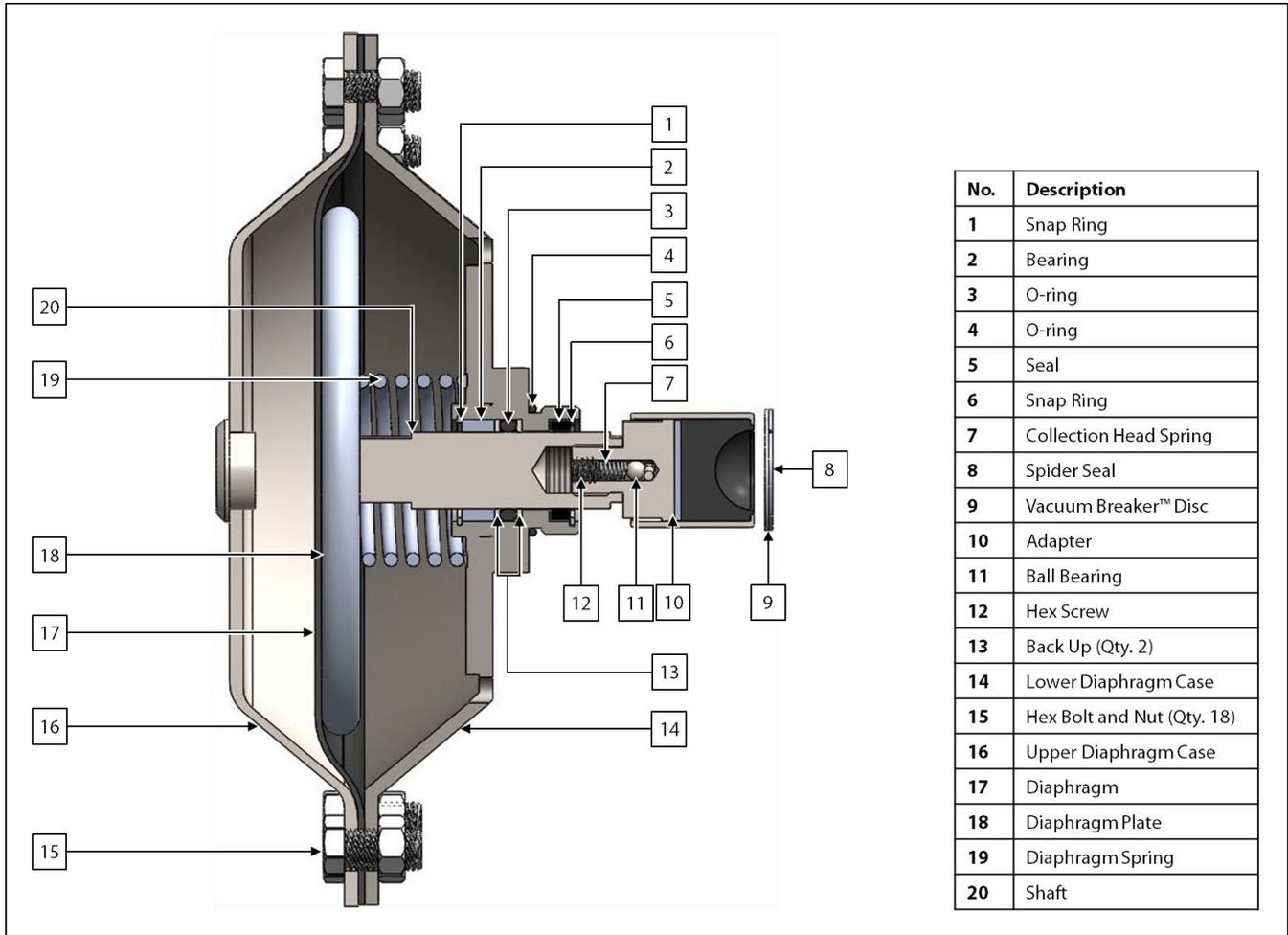


Debris or scratches on the poppet will prevent positive shutoff of the relief.

19. Return the poppet and spring to the base.
20. Using a hex key, screw the spring adjuster into the base.
21. Return the buttonhead screw and washer seal to the end of the base.
22. Replace the O-rings on the sealing face of the base.
23. Set the base aside.

## Diaphragm Housing Maintenance

Figure 11: Diaphragm Housing Maintenance Diagram



24. Unscrew and remove the hex nuts and bolts holding the upper and lower diaphragm cases together.
25. Remove the upper diaphragm case to expose the diaphragm.
26. Remove the diaphragm and inspect it for cracks or other damage. Replace as necessary.
27. Carefully push the shaft until the diaphragm plate clears the lower diaphragm case. Then carefully pull the diaphragm plate, diaphragm spring, and shaft out from the lower diaphragm case.
28. Remove the diaphragm spring from the shaft.
29. Closely inspect the polished outer diameter of the shaft. Scratches or pits might cause the seals to leak. If scratches or pits are present, the unit might need to be repaired or replaced. Contact Welker® for service options.
30. Remove the snap ring and seal from the body side of the lower diaphragm case.
31. Replace the seal. Then return the snap ring to the body side of the lower diaphragm case.
32. Remove the snap ring, bearing, backups, and O-ring from the diaphragm plate side of the lower diaphragm case.
33. Replace the backups, O-ring, and bearing. Then return the snap ring to the lower diaphragm case.
34. Lightly lubricate the shaft. Then carefully slide the diaphragm spring back onto the shaft.

## Reassembly

35. Carefully push the diaphragm plate assembly through the seals of the lower diaphragm case.
36. Apply an appropriate threadlocker to the adapter threads. Then screw the adapter into the shaft.
37. Attach the diaphragm to the diaphragm case.
38. Set the upper diaphragm case in place against the lower diaphragm case.
39. Following a cross-bolting sequence, bolt the upper and lower diaphragm cases together and tighten by hand.
40. Return the spider seal to the body.
41. Return the Vacuum Breaker™ disc to the body. It should rest on top of the spider seal in the body.
42. Using the machine screws and washers, install the base to the body (*Figure 10*). Tighten the machine screws by hand.
43. Apply anti-galling compound to the threads on the lower diaphragm case.



Welker® recommends Never-Seez® or an equivalent anti-galling compound for use with this unit.

44. Install the body to the diaphragm assembly.
45. Screw the sampler onto the standard probe or optional LE-2SSKO.
46. Maintenance is now complete. See *Section 2.2, Installation*, and *Section 2.3, Start-Up Procedures*, for instructions on returning the GSS-4PM to operation.



During reinstallation, check valves for leaks and repair or replace as necessary.

### 3.3 Troubleshooting Guidelines

Table 2: Welker® GSS-4PM Troubleshooting Guidelines		
Issues	Possible Causes	Solutions
The GSS-4PM is not actuating properly.	The pneumatic supply might be too low or not operating.	Inspect the pneumatic supply and regulator to ensure that air is supplied at the appropriate pressure (i.e., approximately 40–60 psig).
	The solenoid might not be operating properly.	Use the manual override button to check the solenoid and ensure proper operation. If the solenoid is operating improperly, refer to the <i>Installation, Operation, and Maintenance (IOM) Manual</i> for the solenoid.
	The stroke and exhaust times are too short.	Ensure that the pump cycle is no faster than every four (4) seconds.
The sample cylinder or constant pressure cylinder is not filling.	The inlet valve on the sample cylinder is closed.	Ensure that the inlet valve on the sample cylinder is open.
	There is a leak between the sample outlet and the sample cylinder.	Check all fittings from the sample outlet to the inlet valve on the sample cylinder for leaks. Repair or replace as necessary.
	The inline relief setting is too high.	See <i>Section 2.3, Start-Up Procedures</i> , for instructions on setting the inline relief. As necessary, see <i>Section 3.2, Maintenance</i> , for instructions on maintaining the inline relief.
	The GSS-4PM is unable to build pressure.	See <i>Section 2.3, Start-Up Procedures</i> , for instructions on testing the GSS-4PM and ensuring that the sampler will build pressure.
	The Vacuum Breaker™ disc is installed incorrectly.	See <i>Section 3.2, Maintenance</i> , for instructions on correct installation of the Vacuum Breaker™ disc.

Table 2: Welker® GSS-4PM Troubleshooting Guidelines, *Continued*

Issues	Possible Causes	Solutions
<p>The single cavity cylinder is filling too quickly.</p>	<p>The inline relief is not adequate.</p> <p>The sampler might be set at a faster sampling frequency than desired.</p>	<p>See <i>Section 2.3, Start-Up Procedures</i>, for instructions on setting the inline relief. As necessary, see <i>Section 3.2, Maintenance</i>, for instructions on maintaining the inline relief.</p> <p>Adjust the 4P, 6Tc, or PLC to sample at the desired rate. Ensure that the calculations used to determine the sample frequency are correct (<i>Figure 7</i>).</p>
<p>The constant pressure cylinder is filling too quickly.</p>	<p>The inline relief setting is not adequate.</p> <p>The constant pressure cylinder is not pre-charged.</p> <p>The GSS-4PM might be set at a faster sampling frequency than desired.</p> <p>The purge valve on the constant pressure cylinder is open.</p> <p>Pressure is leaking past the cylinder piston.</p>	<p>See <i>Section 2.3, Start-Up Procedures</i>, for instructions on setting the inline relief. As necessary, see <i>Section 3.2, Maintenance</i>, for instructions on maintaining the inline relief.</p> <p>Pre-charge the constant pressure cylinder. Refer to the <i>Installation, Operation, and Maintenance (IOM) Manual</i> for the constant pressure cylinder for instructions.</p> <p>Adjust the 4P, 6Tc, or PLC to sample at the desired rate. Ensure that the calculations used to determine the sample frequency are correct (<i>Figure 7</i>).</p> <p>Ensure that the purge valve on the constant pressure cylinder is closed.</p> <p>Check the piston seals to ensure they are not leaking. As necessary, replace the piston seals. Refer to the <i>Installation, Operation, and Maintenance (IOM) Manual</i> for the constant pressure cylinder for instructions.</p>

### 3.4 Purging and Cleaning the Sample Cylinder



Regular cleaning of the sample cylinders is essential for proper functioning of the unit. For cylinders used for sample containment, any debris or residue left in the sample cylinders could contaminate the results of later samples collected in the sample cylinders.



Welker® recommends routinely inspecting the sample cylinders for any dents, damage, and/or signs of misuse, because these might affect proper functioning of the unit. If any dents, damage, and/or signs of misuse are present, please contact Welker® for service options.

**Regular cleaning of the cylinder is essential for the device's proper functioning. Solvent cleaning is normally done during scheduled maintenance.** However, some companies require such cleaning before each cylinder is put into service. Any debris or residue that is not removed from the cylinder will contaminate the results of the next sample extracted from the cylinder. Welker® recommends cleaning and leak testing the cylinder after each use.



Welker® recommends cleaning and leak testing the cylinder after each use.

#### Cleaning a Constant Pressure Cylinder can be accomplished one of the following four ways:

##### 1. Purging (i.e., flushing) with new product:

- Purge (i.e., flush) the cylinder using the product to be sampled. This can be accomplished each time the cylinder is put into service.
- Pressure up the cylinder at one end with an inert gas supply and test for leaks. Repeat the process from the opposite end. Pressurize slowly to avoid slamming the piston from one end to the other.

##### 2. Cleaning with solvent:

- Fill and empty the cylinder repeatedly with solvent.
- Use an inert gas to dry and purge the cylinder.
- Use method 3.6.1 to verify the system is free of contaminants.
- Pressure up the cylinder at one end with an inert gas supply and test for leaks. Repeat the process from the opposite end. Pressurize slowly to avoid slamming the piston from one end to the other.

##### 3. Using a very clean rag:

- Remove the six (6) crown nuts.
- Remove the product end cap.
- Using a very clean rag, wipe the product end cap and what can be seen of the piston assembly.
- Replace the product end cap, the six (6) crown nuts, and the cylinder feet.
- Pressure up the cylinder at one end with an inert gas supply and test for leaks. Repeat the process from the opposite end. Pressurize slowly to avoid slamming the piston from one end to the other.

##### 4. Using a steam cleaner:

1. Ensure that the temperature rating of the steam cleaner will not exceed that of the seals and the tracker tube. When the steam cleaning is complete, ensure that no moisture from the steam remains within the Constant Pressure Cylinder. Also, keep the valves open sufficient time for the steam heat to dissipate and the temperature of the Constant Pressure Cylinder to normalize. When the steam cleaning is finished, pressure up the cylinder at one end with an inert gas supply and test for leaks. Repeat the process from the opposite end. Pressurize slowly to avoid slamming the piston from one end to the other.

### 3.5 Leak Testing the Constant Pressure Cylinder

Welker® recommends leak testing the cylinder after each time it is put into service.

- Slowly pressure up the product end with helium and leak check all the external fittings and reliefs on the product end.
- Slowly open the pre-charge end valves and ensure there are no leaks across the piston.
- Slowly pressure up the pre-charge end with helium, which will push the piston back to the product end.
- Leak check all the external fittings and reliefs on the pre-charge end.
- Slowly open the product end valves and ensure there are no leaks across the piston in that direction.
- Relieve all pressure and shut off all valves.
- The cylinder is now ready to go back into service, starting with the pre-charging procedure.

## APPENDIX: REFERENCED OR ATTACHED DOCUMENTS

Welker® *Installation, Operation, and Maintenance (IOM) Manuals* suggested for reference or for use with this unit:

- IOM-001: Welker® 4P Sample Frequency Controller
- IOM-002: Welker® 6Tc Timer/Controller
- IOM-011: Welker® CP-2G, CP-5G, CP-35G, and CP-2G With Premium Purge Constant Pressure Cylinders With Tracker Tube
- IOM-044: Welker® IR-7 Instrument Regulator
- IOM-048: Welker® FIR-1 Filter / Instrument Regulator
- IOM-069: Welker® LE-2SSKO Probe-Mounted Liquid Eliminator
- IOM-105: Welker® NV-1 and NV-2 Instrument Valves
- IOM-128: Welker® CSVC Cylinder Steam & Vacuum Cleaner
- IOM-146: Welker® SC Single Cavity Cylinder

Other *Installation, Operation, and Maintenance (IOM) Manuals* suggested for reference or for use with this unit:

- Circle Seal Controls 500 Series Adjustable Popoff & Inline Relief Valves (Welker® IOM-V178)
- McDaniel Controls, Inc. Series 7 Stainless Steel Case Utility Gauges (Welker® IOM-V274)
- Norgren R83 Cylinder Gas Pressure Regulator For Industrial Gas Systems (Welker® IOM-V014)
- Versa Products Company, Inc. C-Series Valves (Welker® IOM-V041)
- Versa Products Company, Inc. C-316 Series Stainless Steel 3-Way and 4-Way Manual, Latching and Key Valves (Welker® IOM-V070)
- Versa Products Company, Inc. CSG-4222-LA-XX-D012 4-Way Solenoid Valve (Welker® IOM-V071)
- WIKA Instrument Corporation Bourdon Tube Pressure Gauges Type 232.53 and Type 233.53 (Welker® IOM-V171)

Welker® drawings and schematics suggested for reference or for use with this unit:

- Assembly Drawing: AD617BS (GSS-4PM With Standard Probe)
- Assembly Drawing: AD617CL (GSS-4PM With Welker® LE-2SSKO Probe Mounted Liquid Eliminator)

