



Manufacturer of  
precision pipe and shell  
alignment and forming  
clamps.

## Bear Clamp Company



7251 Garden Grove Blvd Suite A  
Garden Grove, CA 92841  
714-835-3440 [www.pres-tech.com](http://www.pres-tech.com)

Bear Clamp Company, llc, an Ohio corporation, was formed in response to an emerging trend within the heavy-industrial, chemical, power generation, oil & gas and shipbuilding industries. This trend involves a huge increase in the demand by these industries for fabricated pipe. Running simultaneously with this increase in demand is an increase in code welding requirements now strictly adhered to by all industries.

Welded pipe -to-pipe or pipe-to-fitting weld joints must pass critical inspection to protect against weld joint failure. Trade welders understand the importance of making sure the weld joint connection is near perfect prior to tacking the joint in place for a full weld. The inside diameter of the two pieces being welded must not only match within a very close tolerance but must also be aligned near-perfectly axially and radially prior to welding.



Bear Clamp Company manufactures state-of-the-art pipe forming and pipe alignment clamps for use in any fabrication facility or on any construction project site where piping is being fabricated or welded. Our clamps are designed to give the pipefitter a mechanical advantage over fitting up a pipe or vessel weld joint. Bear Clamps accomplish the once difficult tasks of forming the pipe/vessel ends into concentricity, setting the specified weld gap distance, aligning the pipe ends radially and making fine-tuning hi-low adjustments ALL IN ONE EASY SETUP!

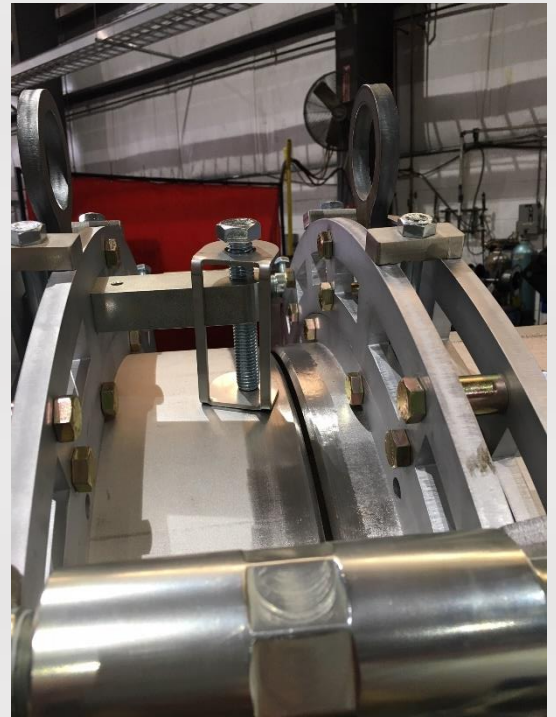


Bear Clamp Company specializes in manufacturing portable, clamshell-style, forming and alignment clamps typically utilized in the fabrication and welding of pipe, pressure vessels and shell structures. Presently we manufacture two types of clamps; Pipe alignment clamps and pipe or shell rounding rings.



Bear Alignment clamps are comprised of two (2) independent rings connected by four (4) turnbuckles. They are designed to form pipe round (SCH 40), set the desired weld gap and adjust the hi-low all IN ONE SETUP! These clamps are used to easily and accurately fit up pipe-to-pipe or pipe-to-fitting weld joints on piping and shell applications. Bear alignment clamps are available for 4" through 72" diameter pipe/shell applications. Alignment clamps are EXCELLENT when utilized strictly as a fit-up and alignment tool on HEAVY-WALL applications.

Bear "Rounder" clamps are rounding rings which are attached to the OD surface of pipe or shell structures and can produce enough mechanical force to remove ovality on piping SCH 40 and lighter, and on large diameter shells with walls up to 3/4" thick. We produce Rounders for pipe/shell diameters from 8" OD up to 72" OD (and larger upon request).



# BEAR CLAMP PRODUCT LINE

## *"Rounder"*

Bear Clamp Company manufactures a heavy duty line of rounding rings we named "Rounders". Rounders are clamshell-style forming ring clamps designed to reduce ovality in pipe, casing, shell and tank ODs. Pipefitters and welders spend much time and effort trying to fit-up pipe-to-fitting weld joints due to the ID or OD mismatch sometimes found between the pipe/vessel to fitting connection. Each Rounder clamp is manufactured with rectangular slots around the frame of the clamp ring which provide openings for "Tweaker" bars with jack bolts (see photo). A jack bolt is located at each end of the tweaker and gives the fitter/welder the ability to "fine tune" problematic "hi-low" concerns on either side of the weld joint to increase circularity.



## *Pipe and Shell Alignment Clamp*

Bear Clamp Company manufactures four (4) different models of alignment clamps designed to help fit-up a pipe-to-pipe, pipe-to-elbow or pipe-to-fitting weld joint. Bear clamps are capable of forming the pipe OD round (SCH 40 and lighter walls) while positioning the ends of pipe-to-pipe or pipe-to-fitting weld joints into near-perfect radial and axial alignment. Each Bear alignment clamp model includes the following features:

- Heavy duty clamp frame components fabricated from quality materials. Frame and accessory alloy choices include aluminum, stainless and coated carbon steel.
- Two (2) Clamshell style, dual-opposed, forming and alignment rings. Turnbuckle assemblies connect both halves of the clamp and are used to easily manipulate the weld joint and accurately set axial alignment.
- Jack-Bolts located atop turnbuckle assemblies precisely set the desired radial alignment on either side of the weld joint.
- Rectangular slot openings positioned around the circumference of each clamp ring are used to accommodate square bars of various lengths called "Tweakers". A jack bolt is located at each end of the tweaker and gives the fitter/welder the ability to "fine tune" problematic "hi-low" concerns on either side of the weld joint. Note: "Pipe Protector Pads" are attached to each tweaker jack bolt to help protect the integrity of the pipe surface area engaged by the jack bolt.





# Pipe Alignment Clamp MODELS

## ***Polar***



Bear's SUPER heavy duty "Polar" model alignment and forming clamps are manufactured from our heaviest gauge framing materials and are designed for use on large bore, above or below-ground, pipeline projects being constructed in primarily rugged field environments. The Polar's unique product features allows it to be the most versatile heavy-duty pipe alignment and forming clamp

on the market today. The Polar will fit-up pipe-to-pipe or pipe-to-fitting weld joint connections. The Polar model is offered for pipe diameters ranging from 24" OD to 72" OD.

## ***Kodiak***



Bear's "Kodiak" model alignment and forming clamps are designed for use on large bore shop or field piping, tank or vessel shell applications. Successful fit-up is achieved for pipe-to-pipe, pipe-to-fitting and/or shell-to-shell weld joint connections. The Kodiak is manufactured from heavy-gauge alloy material and covers an outside diameter range from 24" through 72" OD.

## ***Grizzly***



Bear's "Grizzly" model alignment and forming clamps are designed for use on medium bore shop or field piping, tank or vessel shell applications. The Grizzly is manufactured from heavy-gauge alloy material and covers an outside diameter range from 10" through 22" OD. Note: an "elbow" attachment must be purchased to use the Grizzly for pipe-to-elbow fit-up applications.

## ***Cub***



Bear's "Cub" model alignment and forming clamps are designed for use on small bore shop or field piping, tank or vessel shell applications. The Cub is manufactured from heavy-gauge alloy material and covers an outside diameter range from 4" through 8" OD. Note: an "elbow" attachment must be purchased to use the Cub for pipe-to-elbow fit-up applications.

*All models are offered in carbon steel (coated), stainless or aluminum alloy. Available for purchase or rent.*

# Industries & Applications for Bear Clamps

Higher demand for power generation and oil and gas production, as well as, an increase in government spending on military and infrastructure has resulted in more qualified tradesmen in the field and more construction and maintenance projects to work on. Pipe and shell fabrication and code welding work has increased so significantly that there has been a large demand increase for skilled welders and certified weld inspectors.

Bear Clamp Company supplies heavy-duty quality alignment and forming clamps to fab shop and construction personnel working within these growing industrial sectors. Some of the specific fab and weld project applications which Bear clamps are designed for includes: process piping systems, overland pipeline runs, HP & LP pressure vessel systems, power piping and headers, plant cracking ("crackers") components, power plant HRSG (heat recovery steam generator) systems, ship and sub construction, offshore rig fabrication, and many others.

Pipe alignment and forming clamps have been in use for decades by tradesmen working on commercial and industrial applications where the welding of pipe or shell components is required. Traditionally pipe clamps of various types have been used by pipefitters to help fit-up two weldable pipe or shell components into axial and radial alignment to produce a desired weld joint. Most all code welds performed on pressure piping or vessels will require a Welding Procedure Specification (WPS) to help a certified welder produce a sound weld. Unfortunately many of the pipe clamps and trades tools used throughout the years for fitting up weld joints have proven to be too cumbersome or difficult to work with resulting in BAD WELDS. Bear Clamp Company is committed to producing pipe alignment and forming clamps that will effectively and easily facilitate quality welds that pass inspection...EVERY TIME!



# Bear Pipe Alignment Clamp Model Details

Bear Clamp Series	Clamp Model #	Clamp Size (Pipe OD)	Fitting Attach	Shoe Sets
Cub	BCC-04	4"	Available	Available
Cub	BCC-06	6"	Available	Available
Cub	BCC-08	8"	Available	Available
Grizzly	BCC-10	10"	Available	Available
Grizzly	BCC-12	12"	Available	Available
Grizzly	BCC-14	14"	Available	Available
Grizzly	BCC-16	16"	Available	Available
Grizzly	BCC-18	18"	Available	Available
Grizzly	BCC-20	20"	Available	Available
Grizzly	BCC-22	22"	Available	Available
Kodiak	BCC-24	24"	N/A	Available
Kodiak	BCC-26	26"	N/A	Available
Kodiak	BCC-28	28"	N/A	Available
Kodiak	BCC-30	30"	N/A	Available
Kodiak	BCC-32	32"	N/A	Available
Kodiak	BCC-34	34"	N/A	Available
Kodiak	BCC-36	36"	N/A	Available
Kodiak	BCC-38	38"	N/A	Available
Kodiak	BCC-40	40"	N/A	Available
Kodiak	BCC-42	42"	N/A	Available
Kodiak	BCC-44	44"	N/A	Available
Kodiak	BCC-48	48"	N/A	N/A
Kodiak	BCC-52	52"	N/A	N/A
Kodiak	BCC-56	56"	N/A	N/A
Kodiak	BCC-60	60"	N/A	N/A
Kodiak	BCC-72	72"	N/A	N/A

**Note:** Please add the letters "CS" after clamp model # to choose Carbon Steel or the letters "AL" for Aluminum

**Note:** Heavy duty "Polar" Pipeline Series clamps for 24" thru 72" pipe diameters are priced upon request.



Note: Please contact Bear Clamp Company LLC for additional details and product specifications.



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