

## Table for PE



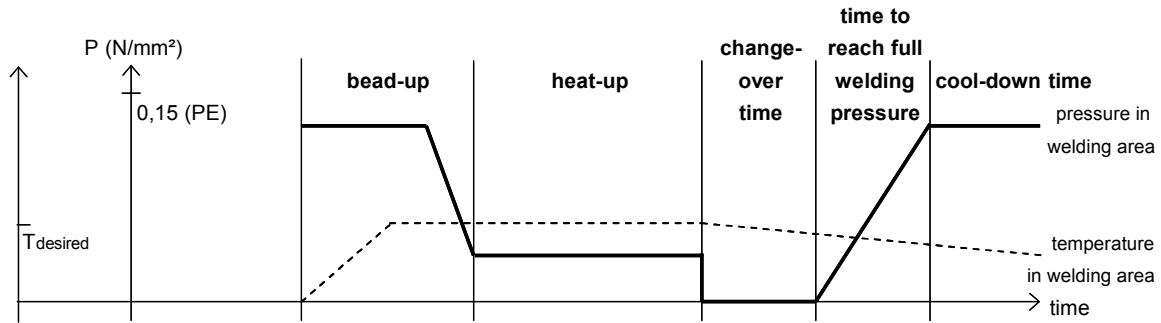
Foundation: 2207, 2208 DIN 16932 German association for welding  
Use for: **6100**

1 bar on manometer: **173 N**

**PE 80** The value for heating element temperature is between 200° C - 220° C.  
The **smaller** the pipe wall the **higher** the temperature.

**PE 100** The standard value for heating element temperature is 220° C.  
Increase the change-over time and the welding pressure time at PE 100 as fast as possible !

Additional to the given bead-up force and to the welding force the moving force of the support must be added !



pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] <sup>①</sup>
<b>315</b>	7,7	41	7	1,5	77	6	6	7	11
	9,7	33	9	1,5	97	7	7	9	13
	12,1	26	10	2	121	8	8	10	16
	15,0	21,0	13	2,0	150	9	9	13	19
	17,9	17,6	15	2	179	10	11	15	23
	18,7	17	16	2	187	10	11	16	24
	23,2	13,6	19	2,5	232	11	13	19	29
	28,6	11	23	3	286	13	15	23	35
	35,2	9	27	3	352	15	18	27	43
43,1	7,4	32	3,5	431	18	22	32	52	
<b>355</b>	8,7	41	9	1,5	87	7	7	9	12
	10,9	33	11	1,5	109	8	8	11	15
	13,6	26	13	2,0	136	8	9	13	18
	16,9	21,0	16	2,0	169	9	10	16	22
	20,1	17,6	19	2,5	201	10	11	19	25
	21,1	17	20	2,5	211	11	12	20	26
	26,1	13,6	24	3,0	261	12	14	24	32
	32,2	11	29	3,0	322	14	17	29	39
	39,7	9	35	3,5	397	17	20	35	48
48,5	7,4	41	3,5	485	20	24	41	58	
<b>400</b>	9,8	41	11	1,5	98	7	7	11	13
	12,3	33	13	2,0	123	8	8	13	16
	15,3	26	17	2,0	153	9	9	17	20
	19,1	21,0	20	2,5	191	10	11	20	24
	22,7	17,6	24	2,5	227	11	13	24	28
	23,7	17	25	2,5	237	11	13	25	29
	29,4	13,6	30	3,0	294	13	16	30	36
	36,3	11	36	3,0	363	16	19	36	44
	44,7	9	44	3,5	447	18	23	44	54
54,7	7,4	52	4,0	547	21	27	52	65	

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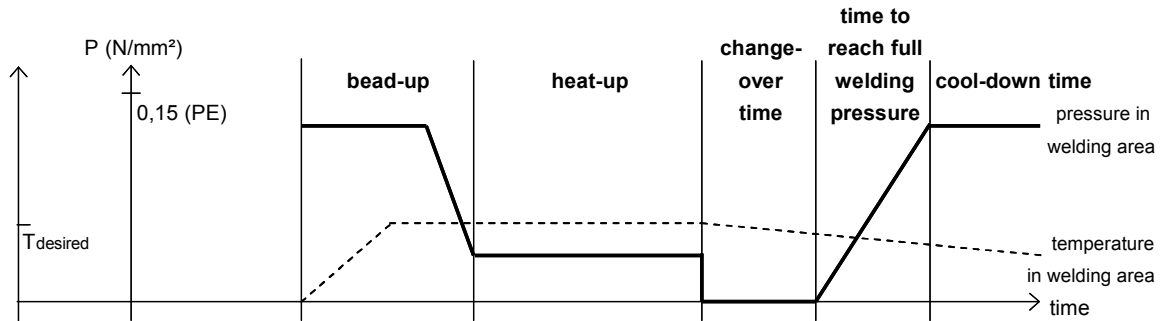
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<b>450</b>	11,0	41	14	1,5	110	8	8	14	15
	13,8	33	17	2,0	138	9	9	17	18
	17,2	26	21	2,0	172	9	10	21	22
	21,5	21,0	26	2,5	215	11	12	26	27
	25,5	17,6	30	2,5	255	12	14	30	31
	26,7	17	31	3,0	267	12	14	31	33
	33,1	13,6	38	3,0	331	15	17	38	40
	40,9	11	46	3,5	409	17	21	46	49
	50,3	9	55	4,0	503	20	25	55	60
<b>500</b>	61,5	7,4	66	4,0	615	23	31	66	71
	12,3	41	17	2,0	123	8	8	17	16
	15,3	33	21	2,0	153	9	9	21	20
	19,1	26	26	2,5	191	10	11	26	24
	23,9	21,0	31	2,5	239	11	13	31	30
	28,4	17,6	37	3,0	284	13	15	37	35
	29,7	17	39	3,0	297	13	16	39	36
	36,8	13,6	47	3,0	369	16	19	47	45
	45,4	11	57	3,5	454	19	23	57	55
<b>560</b>	55,8	9	68	4,0	558	21	28	68	66
	68,3	7,4	81	4,0	683	25	34	81	78
	13,7	41	21	2,0	137	8	9	21	18
	17,2	33	26	2,0	172	9	10	26	22
	21,4	26	32	2,5	214	11	12	32	27
	26,7	21	39	3,0	267	12	14	39	33
	31,7	17,6	46	3,0	317	14	17	46	39
	33,2	17	48	3,0	332	15	17	48	41
	41,2	13,6	59	3,5	412	17	21	59	50
50,8	11	71	4,0	508	20	25	71	61	
62,5	9	85	4,0	625	23	31	85	72	

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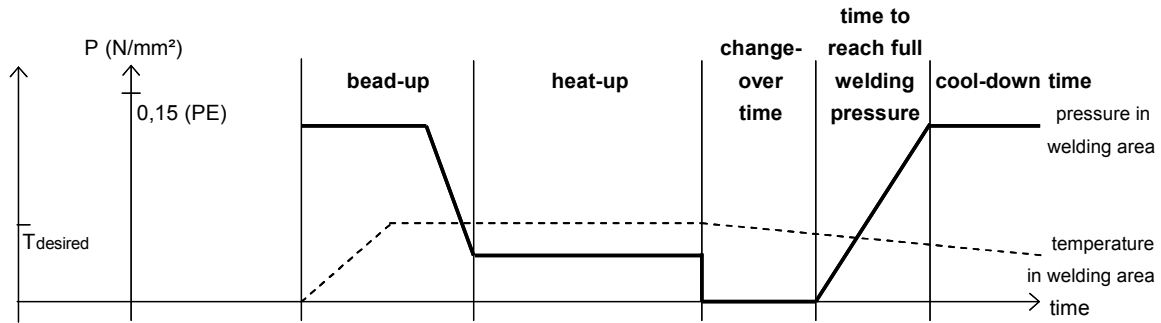
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<b>630</b>	15,4	41	26	2,0	154	9	9	26	20
	19,3	33	33	2,5	193	10	11	33	24
	24,1	26	40	2,5	241	11	13	40	30
	30,0	21	50	3,0	300	16	16	50	37
	35,7	17,6	58	3,0	357	13	18	58	43
	37,4	17	61	3,5	374	16	23	61	45
	46,3	13,6	74	3,5	463	19	19	74	56
	57,2	11	90	4,0	572	22	29	90	67
70	9	107	4,0	700	25	35	107	80	

<sup>①</sup> Remaining under the cool-down time for up to 50% is allowed under the following conditions:

- prefabrication under workshop conditions
- low additional pressure at unclamping
- no additional pressure during further cooling down
- load onto the workpieces only after being completely cooled down