

Table for PE



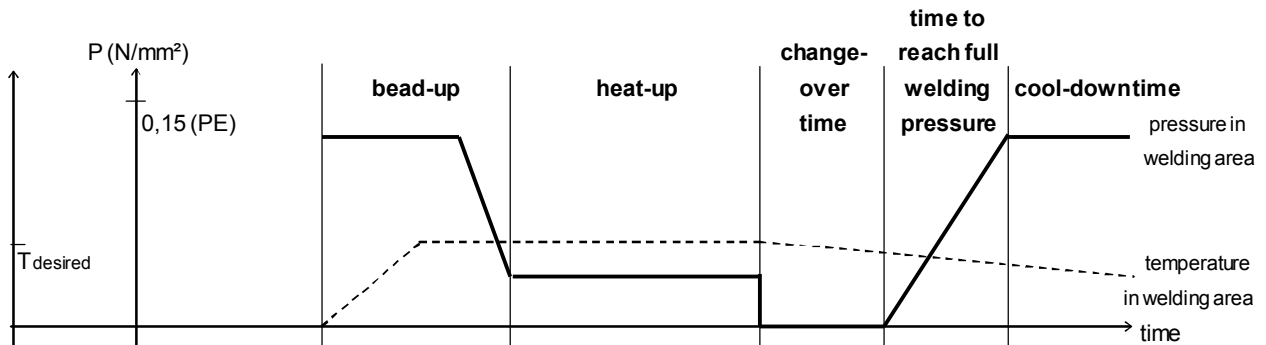
Foundation: 2207, 2208 DIN 16932 German association for welding
Use for: **4000 / 4001 / 4002**

1 bar on manometer: **23 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] ^①
90	2,2	41	4	0,5	22	4	4	4	2
	2,8	33	6	0,5	28	4	4	6	3
	3,5	26	7	0,5	35	5	5	7	4
	4,3	21,0	8	0,5	43	5	5	8	6
	5,1	17,6	9	1,0	51	5	5	9	7
	5,4	17	10	1,0	54	5	5	10	7
	6,7	13,6	12	1,0	67	6	6	12	10
	8,2	11	14	1,5	82	6	6	14	11
	10,1	9,0	17	1,5	101	7	7	17	14
	12,3	7,4	20	2,0	123	8	8	20	16
110	2,7	41	6	0,5	27	4	4	6	3
	3,4	33	8	0,5	34	5	5	8	4
	4,2	26	10	0,5	42	5	5	10	6
	5,3	21,0	12	1,0	53	5	5	12	7
	6,3	17,6	14	1,0	63	6	6	14	9
	6,6	17	14	1,0	66	6	6	14	9
	8,1	13,6	17	1,5	81	6	6	17	11
	10,0	11	21	1,5	100	7	7	21	14
	12,3	9,0	25	2,0	123	8	8	25	16
	15,1	7,4	30	2,0	151	9	9	30	20

Table for PE



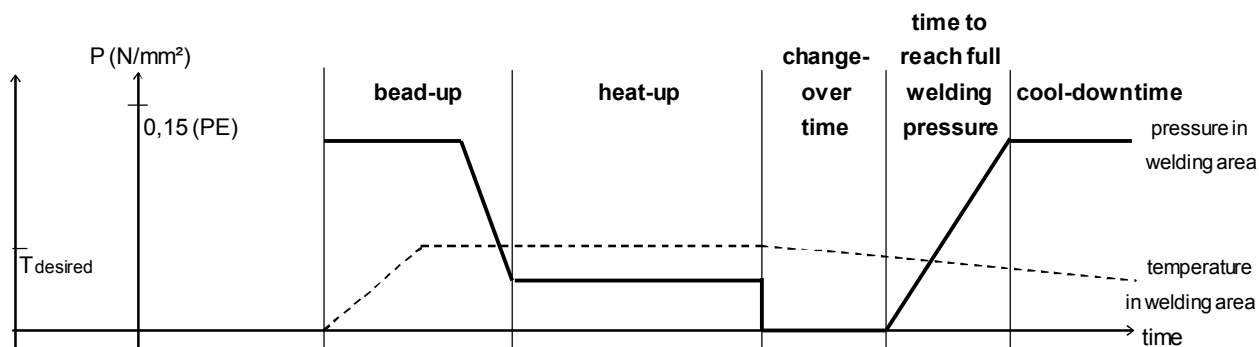
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125	3,1	41	8	0,5	31	4	4	8	4
	3,9	33	10	0,5	39	5	5	10	5
	4,8	26	12	1,0	48	5	5	12	6
	6,0	21,0	15	1,0	60	6	6	15	8
	7,1	17,6	18	1,5	71	6	6	18	10
	7,4	17	18	1,5	74	6	6	18	10
	9,2	13,6	22	1,5	92	7	7	22	13
	11,4	11	27	1,5	114	8	8	27	15
	14,0	9,0	32	2,0	140	9	9	32	18
17,1	7,4	38	2,0	171	9	10	38	22	
140	3,5	41	10	0,5	35	5	5	10	4
	4,3	33	12	0,5	43	5	5	12	6
	5,4	26	15	1,0	54	5	5	15	7
	6,7	21,0	19	1,0	67	6	6	19	10
	8,0	17,6	22	1,5	80	6	6	22	11
	8,3	17	23	1,5	83	7	7	23	12
	10,3	13,6	28	1,5	103	7	7	28	14
	12,7	11	34	2,0	127	8	8	34	17
	15,7	9,0	40	2,0	157	9	10	40	20
19,2	7,4	48	2,5	192	10	11	48	24	

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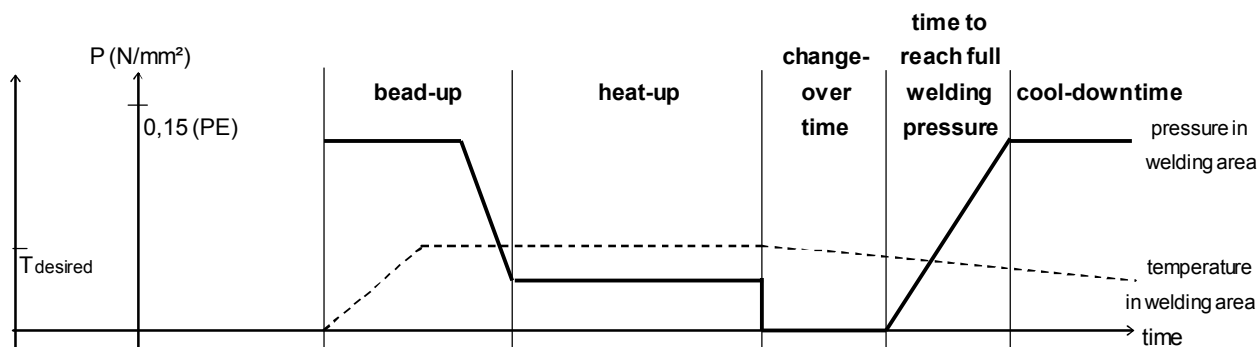
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] ①
160	4,0	41	13	0,5	40	5	5	13	5
	4,9	33	16	1,0	49	5	5	16	7
	6,2	26	20	1,0	62	6	6	20	9
	7,7	21,0	25	1,5	77	6	6	25	11
	9,1	17,6	29	1,5	91	7	7	29	13
	9,5	17	30	1,5	95	7	7	30	13
	11,8	13,6	36	2,0	169	9	10	36	22
	14,6	11	44	2,0	146	9	9	44	19
	17,9	9,0	53	2,0	179	10	11	53	23
21,9	7,4	62	2,5	219	11	12	62	27	
180	4,4	41	16	0,5	44	5	5	16	6
	5,5	33	20	1,0	55	5	5	20	8
	6,9	26	25	1,0	69	6	6	25	10
	8,6	21,0	31	1,5	86	7	7	31	12
	10,2	17,6	36	1,5	102	7	7	36	14
	10,7	17	38	1,5	107	7	7	38	14
	13,3	13,6	46	2,0	136	8	9	46	18
	16,4	11	55	2,0	164	9	10	55	21
	20,1	9,0	66	2,5	201	10	11	66	25
24,6	7,4	79	2,5	246	12	13	79	30	

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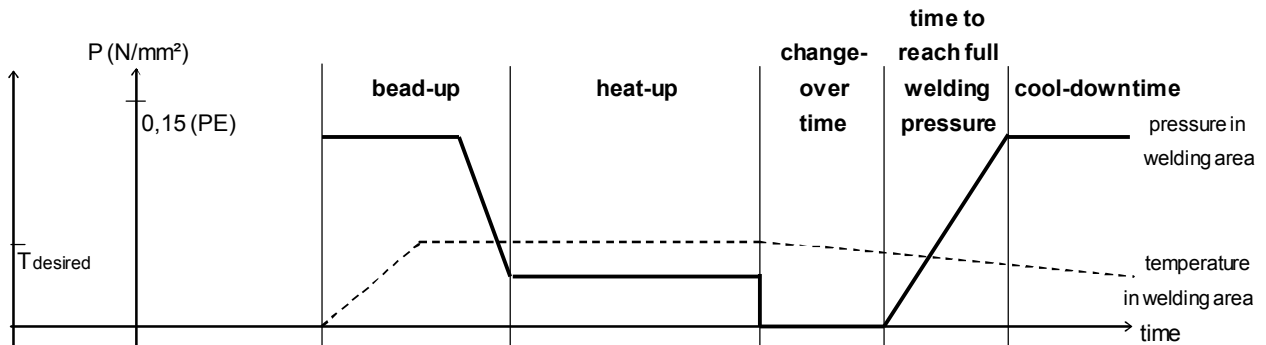
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200	4,9	41	20	1,0	49	5	5	20	7
	6,2	33	25	1,0	62	6	6	25	9
	7,7	26	31	1,5	77	6	6	31	11
	9,6	21,0	38	1,5	96	7	7	38	13
	11,4	17,6	45	1,5	114	8	8	45	15
	11,9	17	46	1,5	119	8	8	46	16
	14,7	13,6	56	2,0	147	9	9	56	19
	18,2	11	68	2,0	182	10	11	68	23
	22,4	9,0	82	2,5	224	11	12	82	28
27,4	7,4	97	3,0	274	13	15	97	34	
225	5,5	41	25	1,0	55	5	5	25	8
	6,9	33	31	1,0	69	6	6	31	10
	8,6	26	39	1,5	86	7	7	39	12
	10,8	21,0	48	1,5	108	8	8	48	15
	12,8	17,6	56	2,0	128	8	8	56	17
	13,4	17	59	2,0	134	8	9	59	18
	16,6	13,6	71	2,0	166	9	10	71	21
	20,5	11	86	2,5	205	10	12	86	26
	25,2	9,0	104	2,5	252	12	14	104	31
30,8	7,4	123	3,0	308	14	16	123	38	

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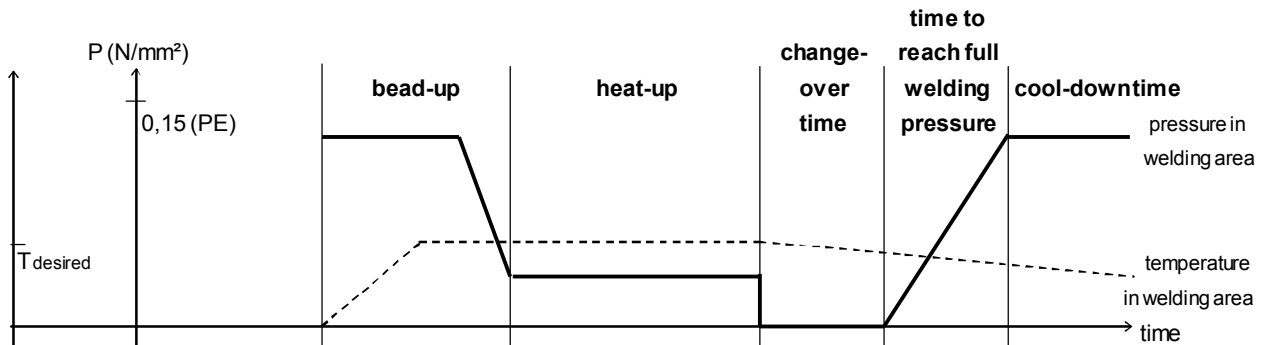
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] 1
250	6,2	41	31	1,0	62	6	6	31	9
	7,7	33	39	1,5	77	6	6	39	11
	9,6	26	48	1,5	96	7	7	48	13
	11,9	21,0	59	1,5	119	8	8	59	16
	14,2	17,6	69	2,0	142	9	9	69	19
	14,8	17	72	2,0	148	9	9	72	19
	18,4	13,6	88	2,0	184	10	11	88	23
	22,7	11	106	2,5	227	11	13	106	28
	27,9	9,0	127	3,0	279	13	15	127	34
	34,2	7,4	152	3,0	342	15	18	152	42
280	6,9	41	39	1,0	69	6	6	39	10
	8,6	33	48	1,5	86	7	7	48	12
	10,7	26	60	1,5	107	7	7	60	14
	13,4	21,0	74	2,0	134	8	9	74	18
	15,9	17,6	87	2,0	159	9	10	87	20
	16,6	17	90	2,0	166	9	10	90	21
	20,6	13,6	110	2,5	206	10	12	110	26
	25,4	11	133	2,5	254	12	14	133	31
	31,3	9,0	160	3,0	313	14	16	160	38
	38,3	7,4	190	3,5	383	16	20	190	47

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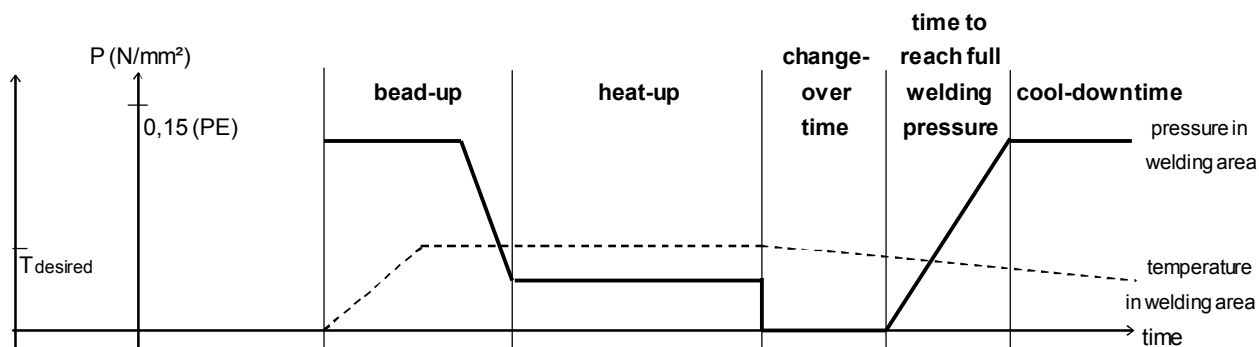
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315	7,7	41	49	1,5	77	6	6	49	11
	9,7	33	61	1,5	97	7	7	61	13
	12,1	26	76	2,0	121	8	8	76	16
	15,0	21,0	93	2,0	150	9	9	93	19
	17,9	17,6	109	2,0	179	10	11	109	23
	18,7	17	114	2,0	187	10	11	114	24
	23,2	13,6	139	2,5	232	11	13	139	29
	28,6	11	168	3,0	286	13	15	168	35
	35,2	9,0	202	3,0	352	15	18	202	43
	43,1	7,4	241	3,5	431	18	22	241	52
355	8,7	41	62	1,5	87	7	7	62	12
	10,9	33	77	1,5	109	8	8	77	15
	13,6	26,0	96	2,0	136	8	9	96	18
	16,9	21,0	118	2,0	169	9	10	118	22
	20,1	17,6	138	2,5	201	10	11	138	25
	21,1	17	145	2,5	211	11	12	145	26
	26,1	13,6	176	3,0	261	12	14	176	32
	32,2	11,0	213	3,0	322	14	17	213	39
	39,7	9,0	257	3,5	397	17	20	257	48
	48,5	7,4	305	3,5	485	20	24	305	58

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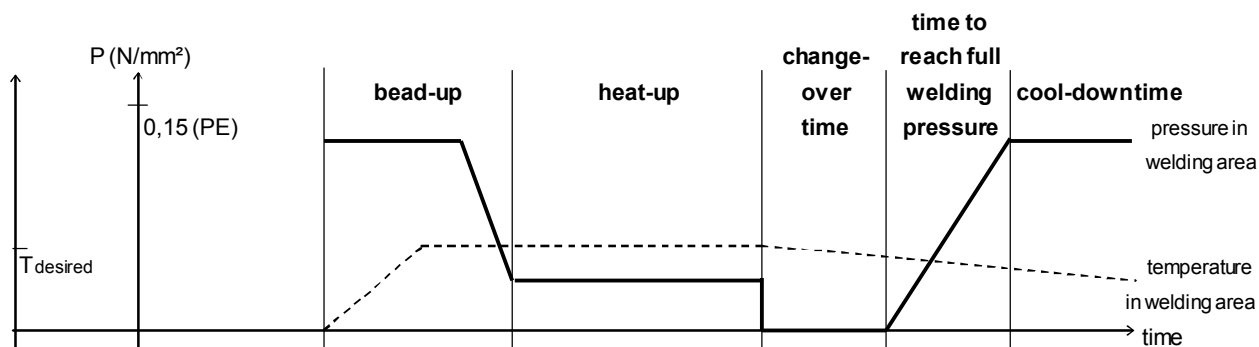
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400	9,8	41	79	1,5	98	7	7	79	13
	12,3	33	98	2,0	123	8	8	98	16
	15,3	26,0	121	2,0	153	9	9	121	20
	19,1	21,0	150	2,5	191	10	11	150	24
	22,7	17,6	176	2,5	227	11	13	176	28
	23,7	17,0	183	2,5	237	11	13	183	29
	29,4	13,6	224	3,0	294	13	16	224	36
	36,3	11,0	271	3,0	363	16	19	271	44
	44,7	9,0	326	3,5	447	18	23	326	54
54,7	7,4	387	4,0	547	21	27	387	65	
450	11,0	41	99	1,5	110	8	8	99	15
	13,8	33	124	2,0	138	9	9	124	18
	17,2	26,0	153	2,0	172	9	10	153	22
	21,5	21,0	189	2,5	215	11	12	189	27
	25,5	17,6	222	2,5	255	12	14	222	31
	26,7	17,0	232	3,0	267	12	14	232	33
	33,1	13,6	283	3,0	331	15	17	283	40
	40,9	11,0	343	3,5	409	17	21	343	49
	50,3	9,0	412	4,0	503	20	25	412	60
61,5	7,4	490	4,0	615	23	31	490	71	

① 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