

Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

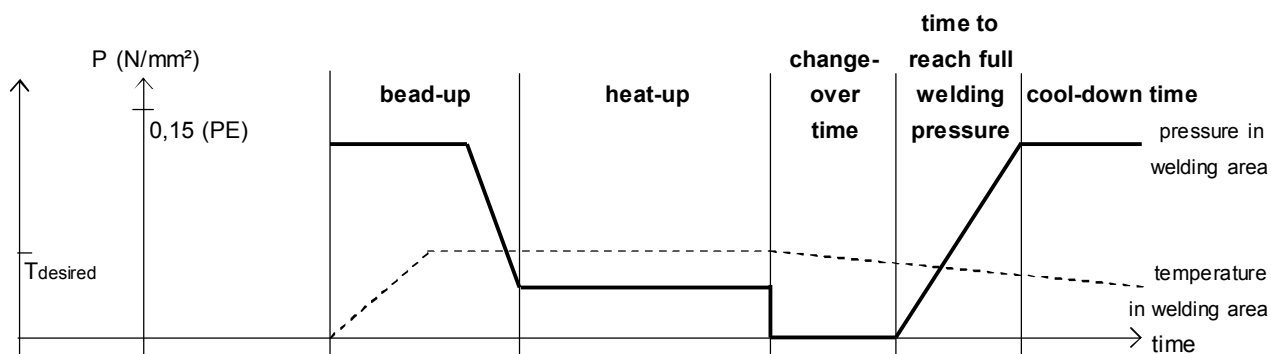
Use for: **4400**

1 bar on manometer: **25 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
50	1,8	33,0	2	0,5	20	4	4	2	2
	2,0	26,0	2	0,5	20	4	4	2	2
	2,4	21,0	3	0,5	24	4	4	3	3
	2,9	17,6	3	0,5	29	4	4	3	3
	3,0	17,0	3	0,5	30	4	4	3	4
	3,7	13,6	4	0,5	37	5	5	4	5
	4,6	11,0	4	1,0	46	5	5	4	6
	5,6	9,0	5	1,0	56	5	5	5	8
63	6,9	7,4	6	1,0	69	6	6	6	10
	1,8	41,0	3	0,5	20	4	4	3	2
	2,0	33,0	3	0,5	20	4	4	3	2
	2,5	26,0	3	0,5	25	4	4	3	3
	3,0	21,0	4	0,5	30	4	4	4	4
	3,6	17,6	5	0,5	36	5	5	5	5
	3,8	17,0	5	0,5	38	5	5	5	5
	4,7	13,6	6	1,0	47	5	5	6	6
	5,8	11,0	7	1,0	58	6	6	7	8
	7,1	9,0	8	1,5	71	6	6	8	10
8,6	7,4	9	1,5	86	7	7	9	12	

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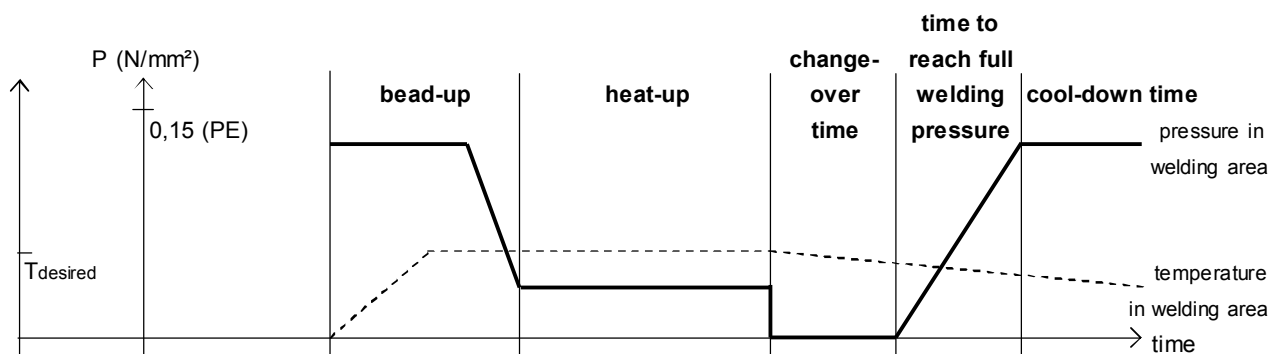
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75	1,9	41,0	3	0,5	20	4	4	3	2
	2,3	33,0	4	0,5	23	4	4	4	2
	2,9	26,0	4	0,5	29	4	4	4	3
	3,6	21,0	5	0,5	36	5	5	5	5
	4,3	17,6	6	0,5	43	5	5	6	6
	4,5	17,0	6	1,0	45	5	5	6	6
	5,6	13,6	8	1,0	56	5	5	8	8
	6,8	11,0	9	1,0	68	6	6	9	10
	8,4	9,0	11	1,5	84	7	7	11	12
10,3	7,4	13	1,5	103	7	7	13	14	
90	2,2	41,0	4	0,5	22	4	4	4	2
	2,8	33,0	5	0,5	28	4	4	5	3
	3,5	26,0	6	0,5	35	5	5	6	4
	4,3	21,0	7	0,5	43	5	5	7	6
	5,1	17,6	9	1,0	51	5	5	9	7
	5,4	17,0	9	1,0	54	5	5	9	7
	6,7	13,6	11	1,0	67	6	6	11	10
	8,2	11,0	13	1,5	82	6	6	13	11
	10,1	9,0	16	1,5	101	7	7	16	14
12,3	7,4	19	2,0	123	8	8	19	16	

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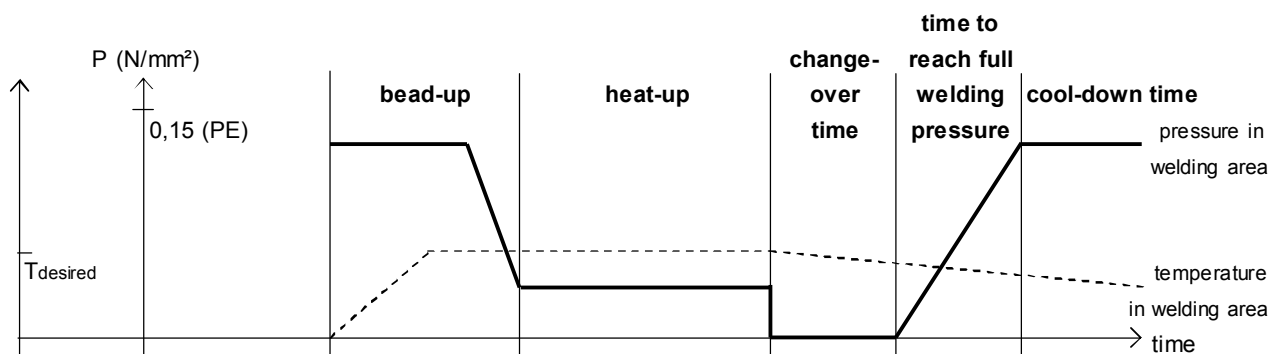
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110	2,7	41,0	6	0,5	27	4	4	6	3
	3,4	33,0	7	0,5	34	5	5	7	4
	4,2	26,0	9	0,5	42	5	5	9	6
	5,3	21,0	11	1,0	53	5	5	11	7
	6,3	17,6	13	1,0	63	6	6	13	9
	6,6	17,0	13	1,0	66	6	6	13	9
	8,1	13,6	16	1,5	81	6	6	16	11
	10,0	11,0	19	1,5	100	7	7	19	14
	12,3	9,0	23	2,0	123	8	8	23	16
15,1	7,4	28	2,0	151	9	9	28	20	
125	3,1	41,0	8	0,5	31	4	4	8	4
	3,9	33,0	9	0,5	39	5	5	9	5
	4,8	26,0	11	1,0	48	5	5	11	6
	6,0	21,0	14	1,0	60	6	6	14	8
	7,1	17,6	16	1,5	71	6	6	16	10
	7,4	17,0	17	1,5	74	6	6	17	10
	9,2	13,6	21	1,5	92	7	7	21	13
	11,4	11,0	25	1,5	114	8	8	25	15
	14,0	9,0	30	2,0	140	9	9	30	18
	17,1	7,4	35	2,0	171	9	10	35	22

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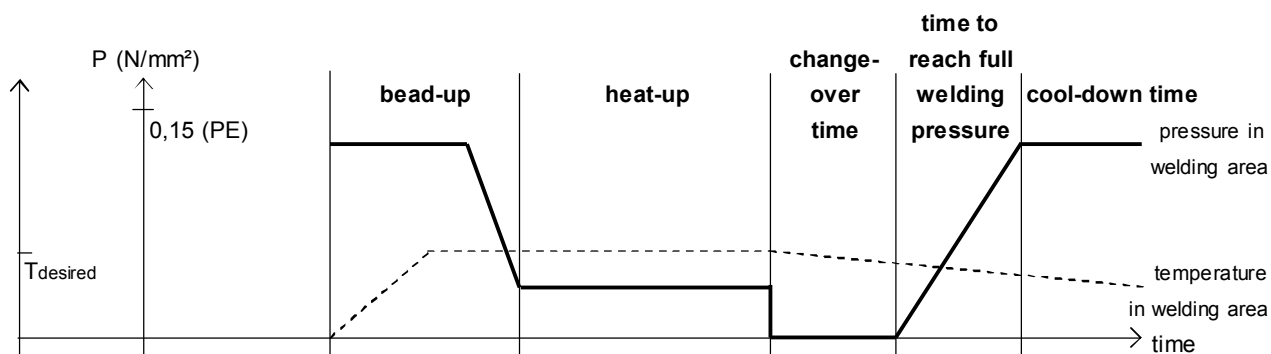
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140	3,5	41,0	10	0,5	35	5	5	10	4
	4,3	33,0	11	0,5	43	5	5	11	6
	5,4	26,0	14	1,0	54	5	5	14	7
	6,7	21,0	17	1,0	67	6	6	17	10
	8,0	17,6	20	1,5	80	6	6	20	11
	8,3	17,0	21	1,5	83	7	7	21	12
	10,3	13,6	26	1,5	103	7	7	26	14
	12,7	11,0	31	2,0	127	8	8	31	17
	15,7	9,0	37	2,0	157	9	10	37	20
160	4,0	41,0	12	0,5	40	5	5	12	5
	4,9	33,0	15	1,0	49	5	5	15	7
	6,2	26,0	18	1,0	62	6	6	18	9
	7,7	21,0	23	1,5	77	6	6	23	11
	9,1	17,6	26	1,5	91	7	7	26	13
	9,5	17,0	27	1,5	95	7	7	27	13
	11,8	13,6	33	1,5	118	8	8	33	16
	14,6	11,0	41	2,0	146	9	9	41	19
	17,9	9,0	48	2,0	179	10	11	48	23
	21,9	7,4	58	2,5	219	11	12	58	27

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