

Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

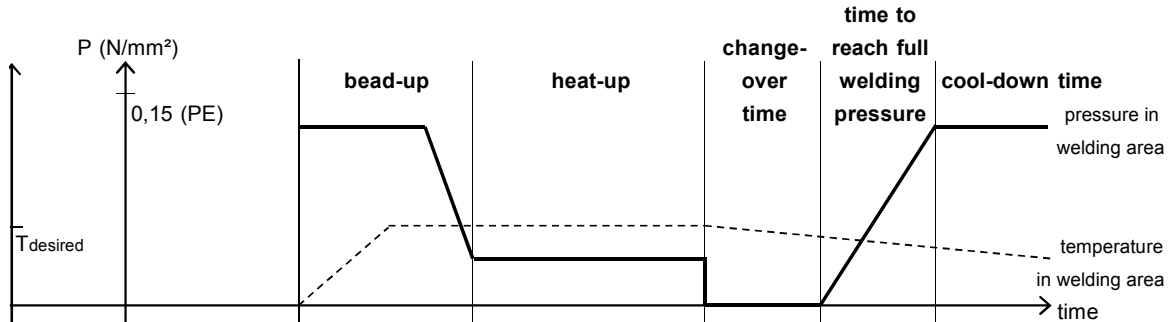
Use for: **4600 / 4502** OD 4" - 8"
4800 / 4702 OD 4" - 10"

1 bar on manometer: **52 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 |
|-----------------------|--------------------|-----|------------------------|-------------------------|------------------|---------------------------|------------------------------------|------------------------|-----------------------------------|
| 3" | 5,3 | 17 | 5 | 1,0 | 53 | 5 | 5 | 5 | 7 |
| | 8,1 | 11 | 6 | 1,5 | 81 | 6 | 6 | 6 | 11 |
| | 9,9 | 9 | 8 | 1,5 | 99 | 7 | 7 | 8 | 13 |
| 4" | 6,7 | 17 | 7 | 1,0 | 67 | 6 | 6 | 7 | 10 |
| | 11,4 | 11 | 11 | 1,5 | 114 | 8 | 8 | 11 | 15 |
| | 12,7 | 9 | 12 | 2,0 | 127 | 8 | 8 | 12 | 17 |
| 5" | 8,3 | 17 | 11 | 1,5 | 83 | 7 | 7 | 11 | 12 |
| | 12,9 | 11 | 16 | 2,0 | 129 | 8 | 8 | 16 | 17 |
| | 15,7 | 9 | 18 | 2,0 | 157 | 9 | 10 | 18 | 20 |
| 6" | 9,9 | 17 | 15 | 1,5 | 99 | 7 | 7 | 15 | 13 |
| | 16,4 | 11 | 23 | 2,0 | 164 | 9 | 10 | 23 | 21 |
| | 18,7 | 9 | 26 | 2,0 | 187 | 10 | 11 | 26 | 24 |
| 7" | 10,7 | 17 | 17 | 1,5 | 107 | 7 | 7 | 17 | 14 |
| | 16,5 | 11 | 25 | 2,0 | 165 | 9 | 10 | 25 | 21 |
| | 20,2 | 9 | 30 | 2,5 | 202 | 10 | 12 | 30 | 25 |
| 8" | 12,9 | 17 | 25 | 2,0 | 129 | 8 | 8 | 25 | 17 |
| | 20,5 | 11 | 37 | 2,5 | 205 | 10 | 12 | 37 | 26 |
| | 24,3 | 9 | 43 | 2,5 | 243 | 12 | 13 | 43 | 30 |
| 10" | 16,1 | 17 | 38 | 2,0 | 161 | 9 | 10 | 38 | 21 |
| | 25,4 | 11 | 58 | 2,5 | 254 | 12 | 14 | 58 | 31 |
| | 30,3 | 9 | 67 | 3,0 | 303 | 14 | 16 | 67 | 37 |

^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