Table for PE

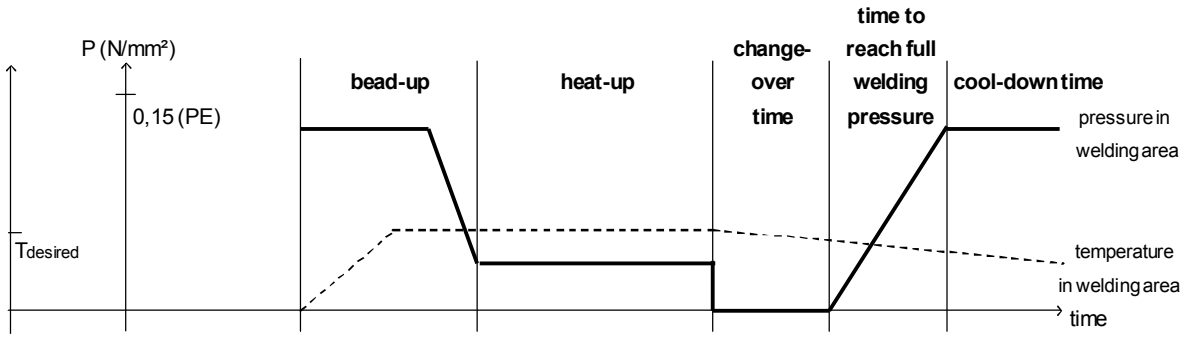
Foundation: 2207, 2208 DIN 16932 German association for welding
Use for: **4900**

1 bar on manometer: **59** 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] ❶
90	2,2	41,0	2	0,5	22	4	4	2	2
	2,8	33,0	2	0,5	28	4	4	2	3
	3,5	26,0	3	0,5	35	5	5	3	4
	4,3	21,0	3	0,5	43	5	5	3	6
	5,1	17,6	4	1,0	51	5	5	4	7
	5,4	17,0	4	1,0	54	5	5	4	7
	6,7	13,6	5	1,0	67	6	6	5	10
	8,2	11,0	6	1,5	82	6	6	6	11
	10,1	9,0	7	1,5	101	7	7	7	14
	12,3	7,4	8	2,0	123	8	8	8	16
110	2,7	41,0	3	0,5	27	4	4	3	3
	3,4	33,0	3	0,5	34	5	5	3	4
	4,2	26,0	4	0,5	42	5	5	4	6
	5,3	21,0	5	1,0	53	5	5	5	7
	6,3	17,6	6	1,0	63	6	6	6	9
	6,6	17,0	6	1,0	66	6	6	6	9
	8,1	13,6	7	1,5	81	6	6	7	11
	10,0	11,0	8	1,5	100	7	7	8	14
	12,3	9,0	10	2,0	123	8	8	10	16
	15,1	7,4	12	2,0	151	9	9	12	20

Table for PE

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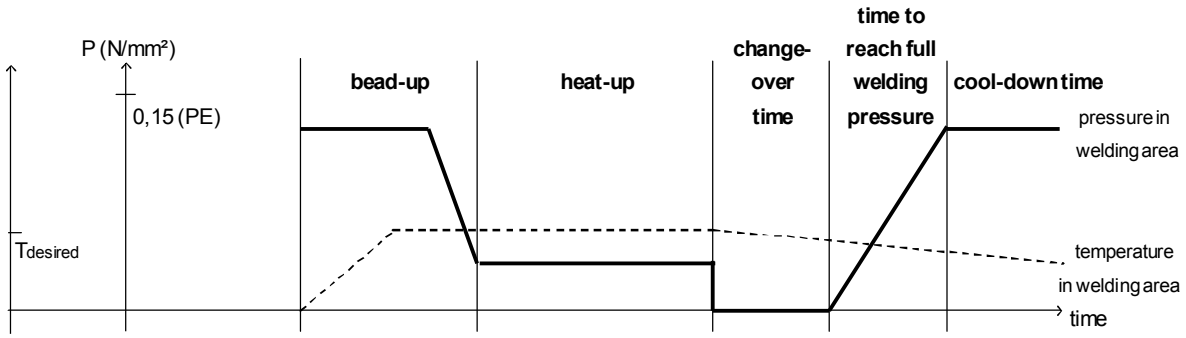

pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] ❶
125	3,1	41,0	4	0,5	31	4	4	4	4
	3,9	33,0	4	0,5	39	5	5	4	5
	4,8	26,0	5	1,0	48	5	5	5	6
	6,0	21,0	6	1,0	60	6	6	6	8
	7,1	17,6	7	1,5	71	6	6	7	10
	7,4	17,0	7	1,5	74	6	6	7	10
	9,2	13,6	9	1,5	92	7	7	9	13
	11,4	11,0	11	1,5	114	8	8	11	15
	14,0	9,0	13	2,0	140	9	9	13	18
	17,1	7,4	15	2,0	171	9	10	15	22
140	3,5	41,0	4	0,5	35	5	5	4	4
	4,3	33,0	5	0,5	43	5	5	5	6
	5,4	26,0	6	1,0	54	5	5	6	7
	6,7	21,0	8	1,0	67	6	6	8	10
	8,0	17,6	9	1,5	80	6	6	9	11
	8,3	17,0	9	1,5	83	7	7	9	12
	10,3	13,6	11	1,5	103	7	7	11	14
	12,7	11,0	13	2,0	127	8	8	13	17
	15,7	9,0	16	2,0	157	9	10	16	20
	19,2	7,4	19	2,5	192	10	11	19	24
160	4,0	41,0	5	0,5	40	5	5	5	5
	4,9	33,0	7	1,0	49	5	5	7	7
	6,2	26,0	8	1,0	62	6	6	8	9
	7,7	21,0	10	1,5	77	6	6	10	11
	9,1	17,6	11	1,5	91	7	7	11	13
	9,5	17,0	12	1,5	95	7	7	12	13
	11,8	13,6	14	1,5	118	8	8	14	16
	14,6	11,0	17	2,0	146	9	9	17	19
	17,9	9,0	21	2,0	179	10	11	21	23
	21,9	7,4	25	2,5	219	11	12	25	27

Table for PE

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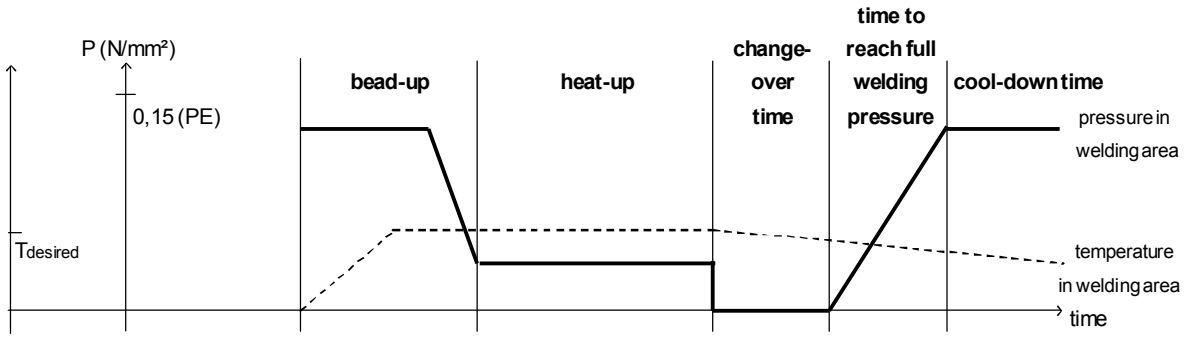

pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] ❶
180	4,4	41,0	7	0,5	44	5	5	7	6
	5,5	33,0	8	1,0	55	5	5	8	8
	6,9	26,0	10	1,0	69	6	6	10	10
	8,6	21,0	12	1,5	86	7	7	12	12
	10,2	17,6	14	1,5	102	7	7	14	14
	10,7	17,0	15	1,5	107	7	7	15	14
	13,3	13,6	18	2,0	133	8	9	18	17
	16,4	11,0	22	2,0	164	9	10	22	21
	20,1	9,0	26	2,5	201	10	11	26	25
	24,6	7,4	31	2,5	246	12	13	31	30
200	4,9	41,0	8	1,0	49	5	5	8	7
	6,2	33,0	10	1,0	62	6	6	10	9
	7,7	26,0	12	1,5	77	6	6	12	11
	9,6	21,0	15	1,5	96	7	7	15	13
	11,4	17,6	18	1,5	114	8	8	18	15
	11,9	17,0	18	1,5	119	8	8	18	16
	14,7	13,6	22	2,0	147	9	9	22	19
	18,2	11,0	27	2,0	182	10	11	27	23
	22,4	9,0	32	2,5	224	11	12	32	28
	27,4	7,4	38	3,0	274	13	15	38	34
225	5,5	41,0	10	1,0	55	5	5	10	8
	6,9	33,0	13	1,0	69	6	6	13	10
	8,6	26,0	15	1,5	86	7	7	15	12
	10,8	21,0	19	1,5	108	8	8	19	15
	12,8	17,6	22	2,0	128	8	8	22	17
	13,4	17,0	23	2,0	134	8	9	23	18
	16,6	13,6	28	2,0	166	9	10	28	21
	20,5	11,0	34	2,5	205	10	12	34	26
	25,2	9,0	41	2,5	252	12	14	41	31
	30,8	7,4	48	3,0	308	14	16	48	38

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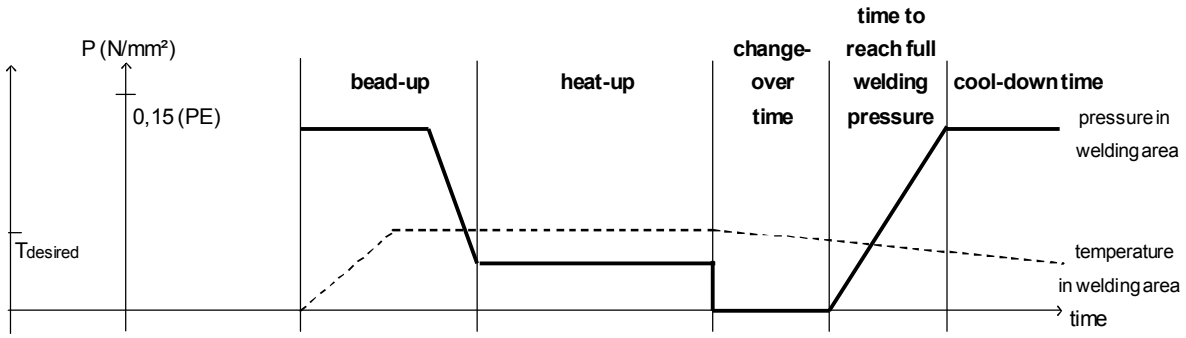

pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] ❶
250	6,2	41,0	13	1,0	62	6	6	13	9
	7,7	33,0	15	1,5	77	6	6	15	11
	9,6	26,0	19	1,5	96	7	7	19	13
	11,9	21,0	23	1,5	119	8	8	23	16
	14,2	17,6	27	2,0	142	9	9	27	19
	14,8	17,0	28	2,0	148	9	9	28	19
	18,4	13,6	35	2,0	184	10	11	35	23
	22,7	11,0	42	2,5	227	11	13	42	28
	27,9	9,0	50	3,0	279	13	15	50	34
	34,2	7,4	59	3,0	342	15	18	59	42
280	6,9	41,0	16	1,0	69	6	6	16	10
	8,6	33,0	19	1,5	86	7	7	19	12
	10,7	26,0	24	1,5	107	7	7	24	14
	13,4	21,0	29	2,0	134	8	9	29	18
	15,9	17,6	34	2,0	159	9	10	34	20
	16,6	17,0	35	2,0	166	9	10	35	21
	20,6	13,6	43	2,5	206	10	12	43	26
	25,4	11,0	52	2,5	254	12	14	52	31
	31,3	9,0	63	3,0	313	14	16	63	38
	38,3	7,4	74	3,5	383	16	20	74	47

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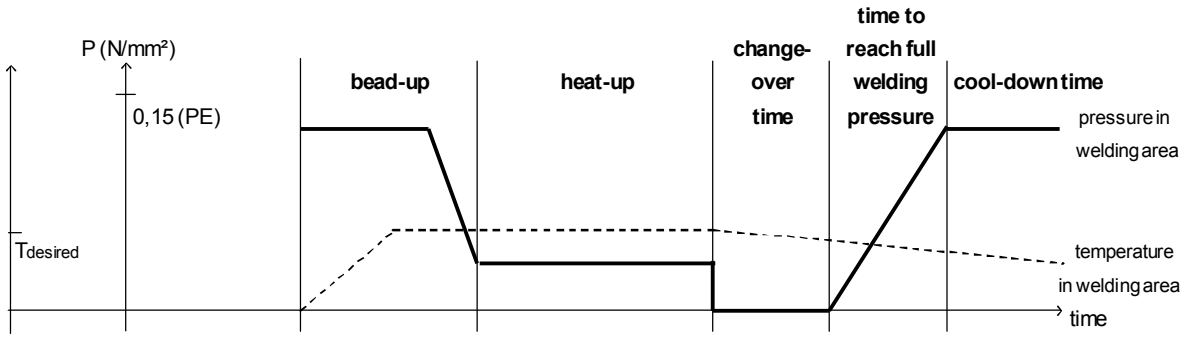

pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] ❶
315	7,7	41,0	19	1,5	77	6	6	19	11
	9,7	33,0	24	1,5	97	7	7	24	13
	12,1	26,0	30	2,0	121	8	8	30	16
	15,0	21,0	36	2,0	150	9	9	36	19
	17,9	17,6	43	2,0	179	10	11	43	23
	18,7	17,0	45	2,0	187	10	11	45	24
	23,2	13,6	55	2,5	232	11	13	55	29
	28,6	11,0	66	3,0	286	13	15	66	35
	35,2	9,0	79	3,0	352	15	18	79	43
	43,1	7,4	94	3,5	431	18	22	94	52

❶ **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