

Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **5100** OD 200 - 450

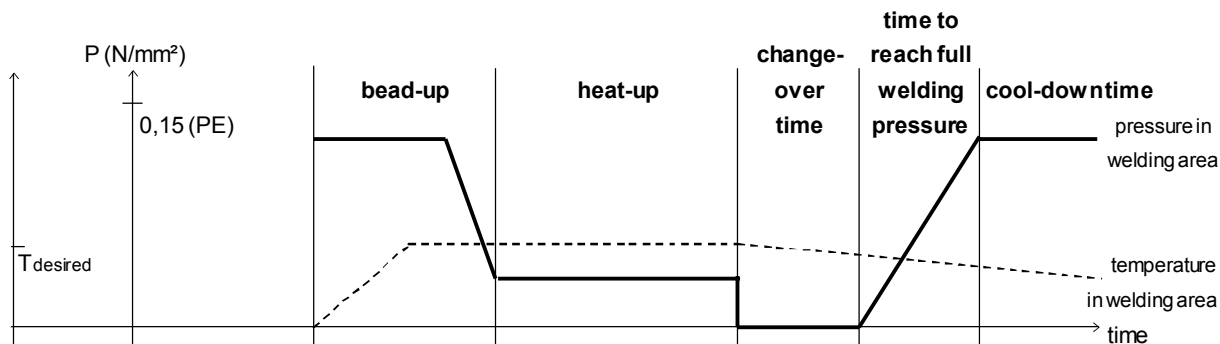
5500 OD 200 - 500

1 bar on manometer: **141 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
200	4,9	41,0	4	1,0	49	5	5	4	7
	6,2	33,0	5	1,0	62	6	6	5	9
	7,7	26,0	5	1,5	77	6	6	5	11
	9,6	21,0	7	1,5	96	7	7	7	13
	11,4	17,6	8	1,5	114	8	8	8	15
	11,9	17,0	8	1,5	119	8	8	8	16
	14,7	13,6	10	2,0	147	9	9	10	19
	18,2	11,0	12	2,0	182	10	11	12	23
	22,4	9,0	14	2,5	224	11	12	14	28
27,4	7,4	16	3,0	274	13	15	16	34	
225	5,5	41	5	1,0	55	5	5	5	8
	6,9	33	6	1,0	69	6	6	6	10
	8,6	26,0	7	1,5	86	7	7	7	12
	10,8	21,0	8	1,5	108	8	8	8	15
	12,8	17,6	10	2,0	128	8	8	10	17
	13,4	17	10	2,0	134	8	9	10	18
	16,6	13,6	12	2,0	166	9	10	12	21
	20,5	11,0	15	2,5	205	10	12	15	26
	25,2	9,0	17	2,5	252	12	14	17	31
30,8	7,4	20	3,0	308	14	16	20	38	

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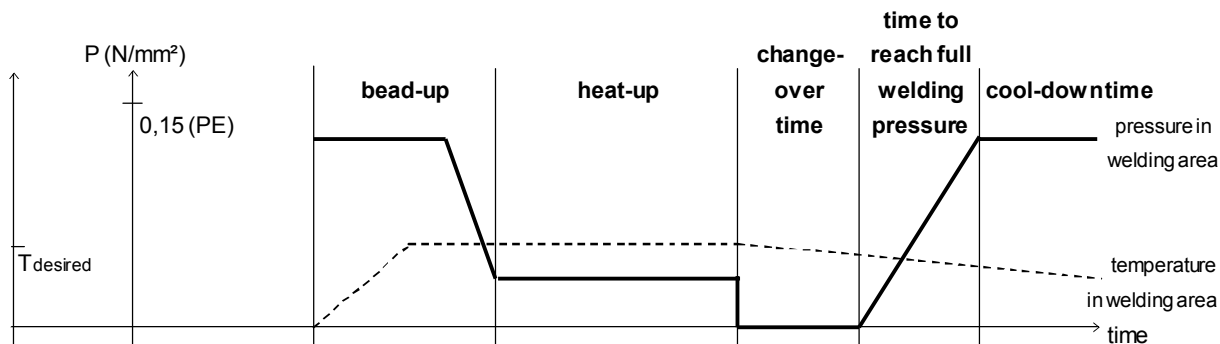
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250	6,2	41	6	1,0	62	6	6	6	9
	7,7	33	7	1,5	77	6	6	7	11
	9,6	26	8	1,5	96	7	7	8	13
	11,9	21,0	10	1,5	119	8	8	10	16
	14,2	17,6	12	2,0	142	9	9	12	19
	14,8	17,0	12	2,0	148	9	9	12	19
	18,4	13,6	15	2,0	184	10	11	15	23
	22,7	11,0	18	2,5	227	11	13	18	28
	27,9	9,0	21	3,0	279	13	15	21	34
34,2	7,4	25	3,0	342	15	18	25	42	
280	6,9	41	7	1,0	69	6	6	7	10
	8,6	33	8	1,5	86	7	7	8	12
	10,7	26,0	10	1,5	107	7	7	10	14
	13,4	21,0	12	2,0	134	8	9	12	18
	15,9	17,6	15	2,0	159	9	10	15	20
	16,6	17	15	2,0	166	9	10	15	21
	20,6	13,6	18	2,5	206	10	12	18	26
	25,4	11,0	22	2,5	254	12	14	22	31
	31,3	9,0	27	3,0	313	14	16	27	38
38,3	7,4	31	3,5	383	16	20	31	47	

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Use for: **5100** OD 200 - 450

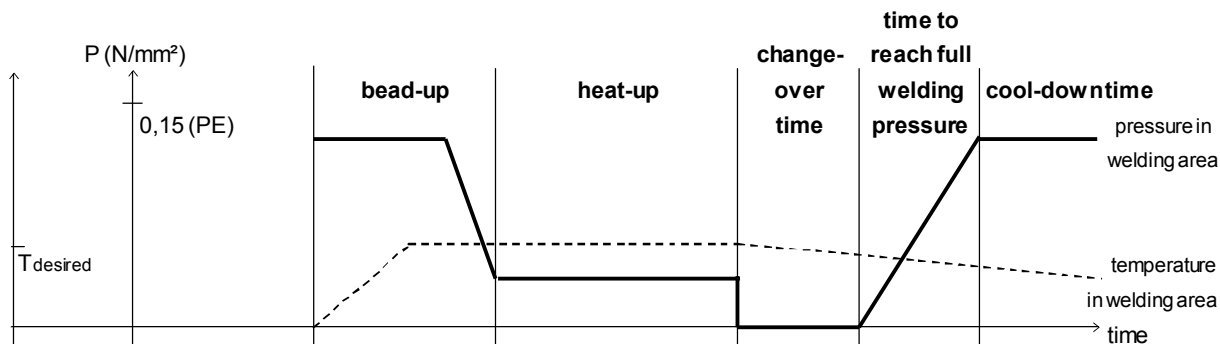
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] 1
315	7,7	41	8	1,5	77	6	6	8	11
	9,7	33	10	1,5	97	7	7	10	13
	12,1	26	13	2,0	121	8	8	13	16
	15,0	21,0	16	2,0	150	9	9	16	19
	17,9	17,6	18	2,0	179	10	11	18	23
	18,7	17,0	19	2,0	187	10	11	19	24
	23,2	13,6	23	2,5	232	11	13	23	29
	28,6	11,0	28	3,0	286	13	15	28	35
	35,2	9,0	33	3,0	352	15	18	33	43
43,1	7,4	40	3,5	431	18	22	40	52	
355	8,7	41	11	1,5	87	7	7	11	12
	10,9	33	13	1,5	109	8	8	13	15
	13,6	26,0	16	2,0	136	8	9	16	18
	16,9	21,0	20	2,0	169	9	10	20	22
	20,1	17,6	23	2,5	201	10	11	23	25
	21,1	17	24	2,5	211	11	12	24	26
	26,1	13,6	29	3,0	261	12	14	29	32
	32,2	11,0	35	3,0	322	14	17	35	39
	39,7	9,0	42	3,5	397	17	20	42	48
48,5	7,4	50	3,5	485	20	24	50	58	

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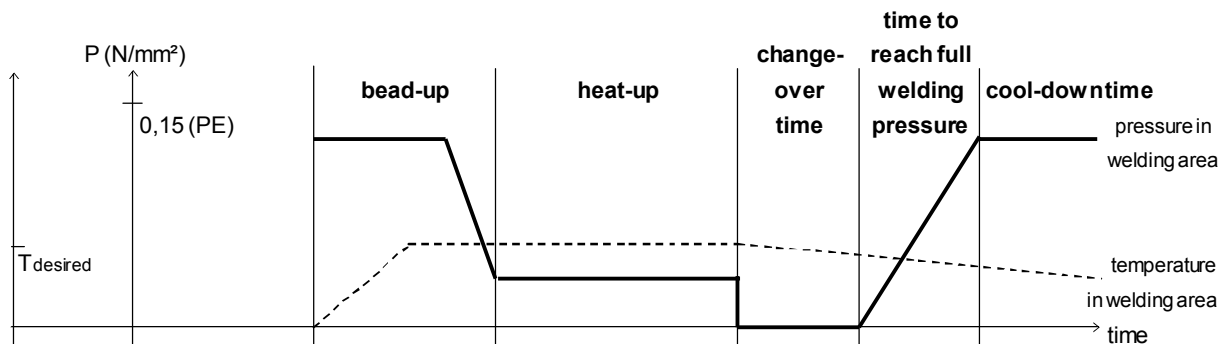
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400	9,8	41	13	1,5	98	7	7	13	13
	12,3	33	16	2,0	123	8	8	16	16
	15,3	26,0	20	2,0	153	9	9	20	20
	19,1	21,0	25	2,5	191	10	11	25	24
	22,7	17,6	29	2,5	227	11	13	29	28
	23,7	17,0	30	2,5	237	11	13	30	29
	29,4	13,6	37	3,0	294	13	16	37	36
	36,3	11,0	45	3,0	363	16	19	45	44
	44,7	9,0	54	3,5	447	18	23	54	54
54,7	7,4	64	4,0	547	21	27	64	65	
450	11,0	41	17	1,5	110	8	8	17	15
	13,8	33	21	2,0	138	9	9	21	18
	17,2	26,0	25	2,0	172	9	10	25	22
	21,5	21,0	31	2,5	215	11	12	31	27
	25,5	17,6	37	2,5	255	12	14	37	31
	26,7	17,0	38	3,0	267	12	14	38	33
	33,1	13,6	47	3,0	331	15	17	47	40
	40,9	11,0	56	3,5	409	17	21	56	49
	50,3	9,0	68	4,0	503	20	25	68	60
61,5	7,4	80	4,0	615	23	31	80	71	

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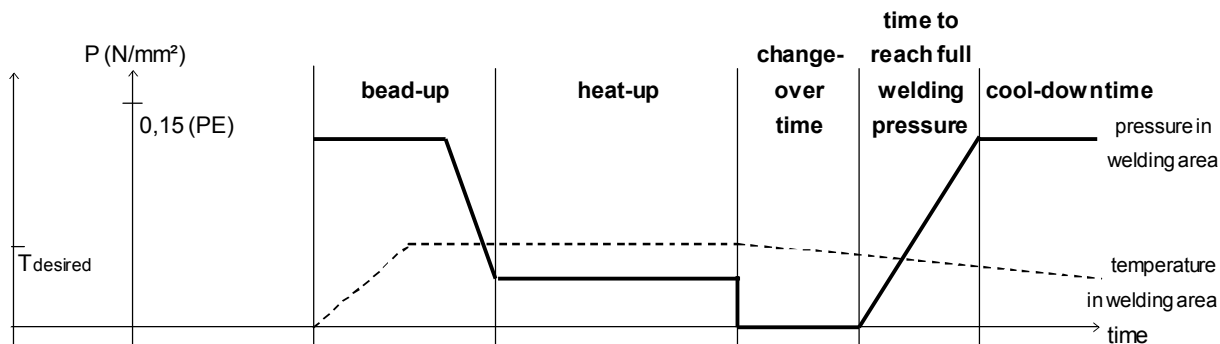
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500	12,3	41	21	2,0	123	8	8	21	16
	15,3	33	25	2,0	153	9	9	25	20
	19,1	26,0	31	2,5	191	10	11	31	24
	23,9	21,0	39	2,5	239	11	13	39	30
	28,4	17,6	45	3,0	284	13	15	45	35
	29,7	17,0	47	3,0	297	13	16	47	36
	36,8	13,6	57	3,0	369	16	19	57	45
	45,4	11,0	69	3,5	454	19	23	69	55
	55,8	9,0	83	4,0	558	21	28	83	66
68,3	7,4	99	4,0	683	25	34	99	78	

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