

## Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **5100** OD 8" - 18"

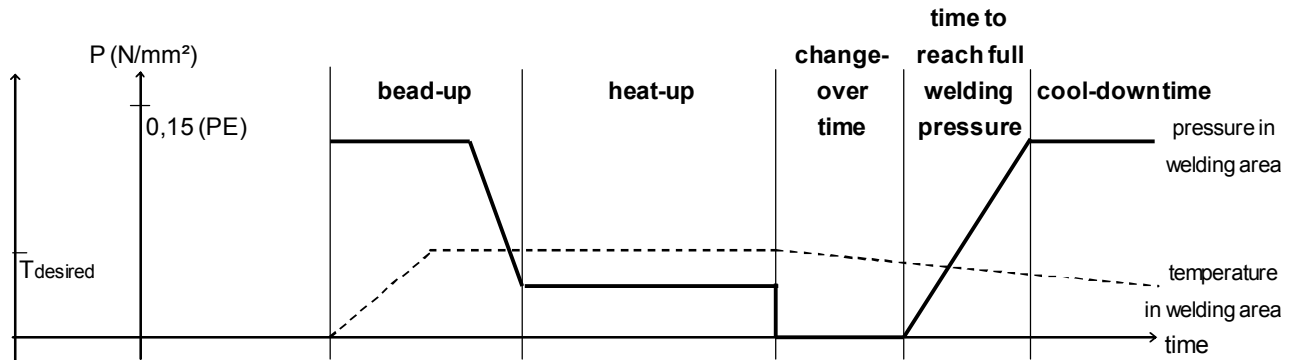
**5500** OD 8" - 18"

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] <b>①</b>
<b>8"</b>	12,8	17,0	9	2,0	128	8	8	9	17
	20,5	11,0	14	2,5	205	10	12	14	26
	24,3	9,0	16	2,5	243	12	13	16	30
<b>10"</b>	16,1	17,0	14	2,0	161	9	10	14	21
	25,4	11,0	22	2,5	254	12	14	22	31
	30,3	9,0	25	3,0	303	14	16	25	37
<b>12"</b>	19,1	17,0	20	2,5	191	10	11	20	24
	29,4	11,0	29	3,0	294	13	16	29	36
	36,0	9,0	35	3,0	360	16	19	35	44
<b>14"</b>	20,9	17,0	24	2,5	209	11	12	24	26
	32,3	11,0	35	3,0	323	14	17	35	39
	39,5	9,0	42	3,5	395	17	20	42	48
<b>16"</b>	23,9	17,0	31	2,5	239	11	13	31	30
	36,6	11,0	46	3,0	366	16	19	46	45
<b>18"</b>	26,9	17,0	39	3,0	269	12	14	39	33
	41,6	11,0	58	3,5	416	17	21	58	50
	50,8	9,0	69	4,0	508	20	25	69	61

**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