

Table for PE



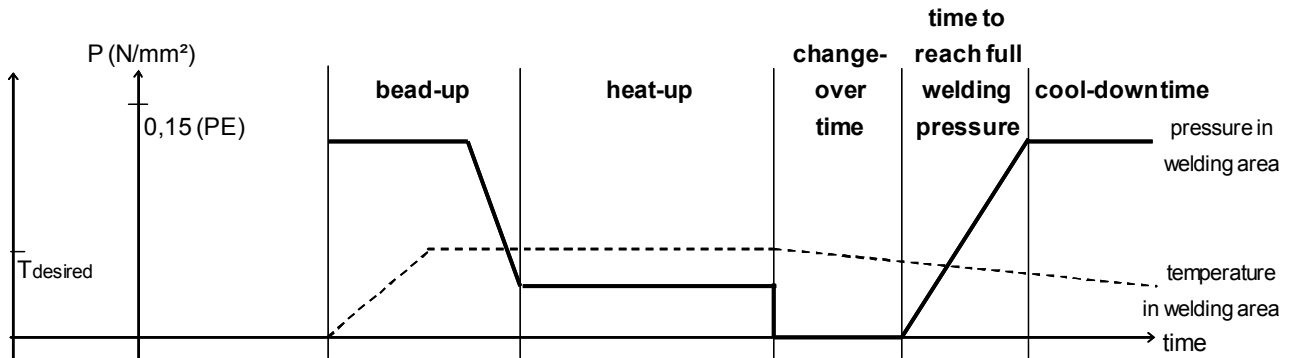
Foundation: 2207, 2208 DIN 16932 German association for welding
Use for: **6100**

1 bar on manometer: **173 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
12"	19,1	17	16	2,5	191	10	11	16	24
	28,6	11	24	3	286	13	15	24	35
	36	9	29	3	360	16	19	29	44
14"	20,9	17	20	2,5	209	11	12	20	26
	32,3	11	29	3,0	323	14	17	29	39
	39,5	9	35	3,5	395	17	20	35	48
16"	23,9	17	25	2,5	239	11	13	25	30
	36,6	11	37	3,0	366	16	19	37	45
	45,1	9	45	3,5	451	18	23	45	54
18"	26,9	17	32	3,0	269	12	14	32	33
	8,7	11	11	3,5	416	17	21	11	50
	36,8	9	43	4,0	508	20	25	43	61
20"	29,9	17	39	3,0	299	13	16	39	37
	46,2	11	59	3,5	462	19	23	59	56
	56,4	9	70	4,0	564	22	28	70	66
24"	35,9	17	57	3,0	359	16	19	57	44
	55,4	11	84	4,0	554	21	28	84	65
	67,7	9	100	4,0	677	24	34	100	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