

## Table for PE



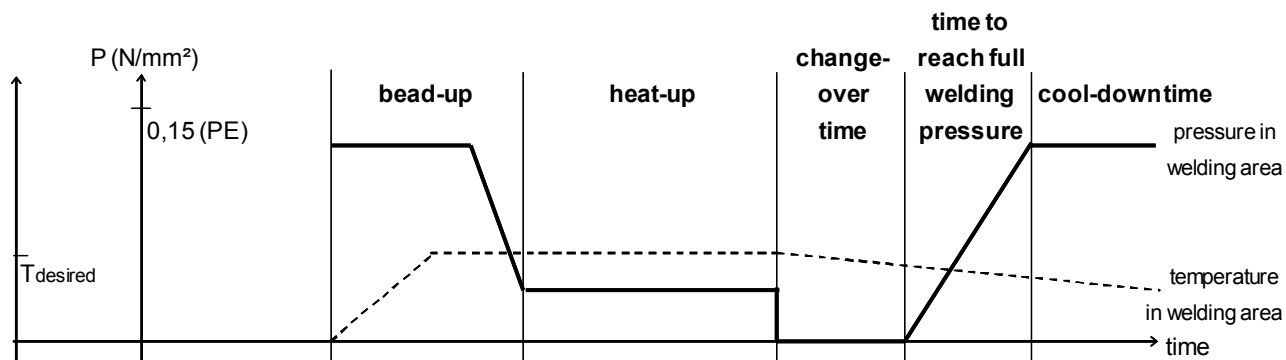
Foundation: 2207, 2208 DIN 16932 German association for welding  
 Use for: **6100 Steel / HRG 6 / 8000 (ab 06/2009)**

1 bar on manometer: **294,5 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>315</b>	7,7	41	4	1,5	77	6	6	4	11
	9,7	33	5	1,5	97	7	7	5	13
	12,1	26	6	2	121	8	8	6	16
	15,0	21,0	8	2,0	150	9	9	8	19
	17,9	17,6	9	2	179	10	11	9	23
	18,7	17	9	2	187	10	11	9	24
	23,2	13,6	11	2,5	232	11	13	11	29
	28,6	11	14	3	286	13	15	14	35
	35,2	9	16	3	352	15	18	16	43
43,1	7,4	19	3,5	431	18	22	19	52	
<b>355</b>	8,7	41	5	1,5	87	7	7	5	12
	10,9	33	7	1,5	109	8	8	7	15
	13,6	26	8	2,0	136	8	9	8	18
	16,9	21,0	10	2,0	169	9	10	10	22
	20,1	17,6	11	2,5	201	10	11	11	25
	21,1	17	12	2,5	211	11	12	12	26
	26,1	13,6	14	3,0	261	12	14	14	32
	32,2	11	17	3,0	322	14	17	17	39
	39,7	9	21	3,5	397	17	20	21	48
48,5	7,4	24	3,5	485	20	24	24	58	

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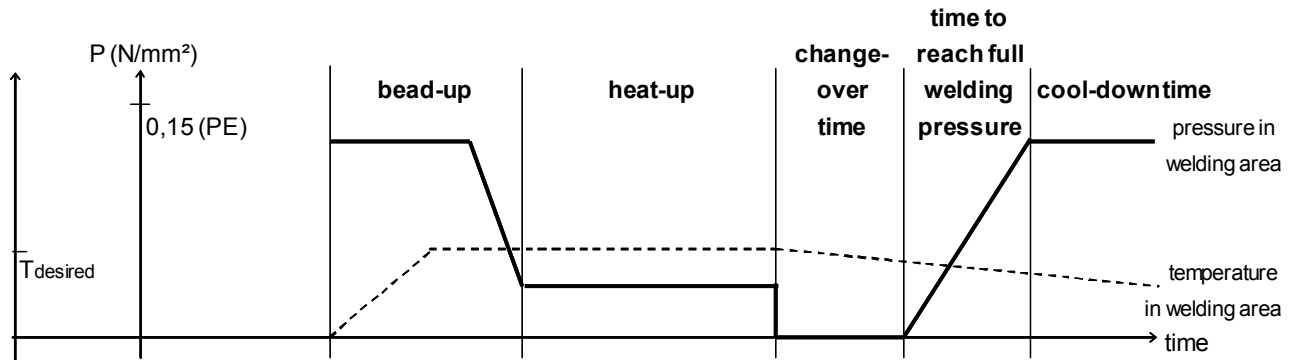
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<b>400</b>	9,8	41	7	1,5	98	7	7	7	13
	12,3	33	8	2,0	123	8	8	8	16
	15,3	26	10	2,0	153	9	9	10	20
	19,1	21,0	12	2,5	191	10	11	12	24
	22,7	17,6	14	2,5	227	11	13	14	28
	23,7	17	15	2,5	237	11	13	15	29
	29,4	13,6	18	3,0	294	13	16	18	36
	36,3	11	22	3,0	363	16	19	22	44
	44,7	9	26	3,5	447	18	23	26	54
54,7	7,4	31	4,0	547	21	27	31	65	
<b>450</b>	11,0	41	8	1,5	110	8	8	8	15
	13,8	33	10	2,0	138	9	9	10	18
	17,2	26	12	2,0	172	9	10	12	22
	21,5	21,0	15	2,5	215	11	12	15	27
	25,5	17,6	18	2,5	255	12	14	18	31
	26,7	17	19	3,0	267	12	14	19	33
	33,1	13,6	23	3,0	331	15	17	23	40
	40,9	11	27	3,5	409	17	21	27	49
	50,3	9	33	4,0	503	20	25	33	60
61,5	7,4	39	4,0	615	23	31	39	71	

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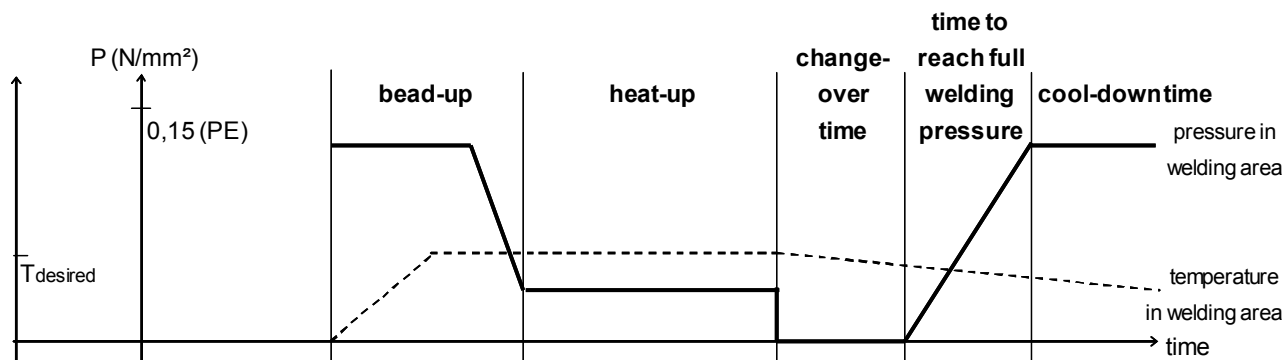
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<b>500</b>	12,3	41	10	2,0	123	8	8	10	16
	15,3	33	12	2,0	153	9	9	12	20
	19,1	26	15	2,5	191	10	11	15	24
	23,9	21,0	19	2,5	239	11	13	19	30
	28,4	17,6	22	3,0	284	13	15	22	35
	29,7	17	23	3,0	297	13	16	23	36
	36,8	13,6	28	3,0	369	16	19	28	45
	45,4	11	34	3,5	454	19	23	34	55
	55,8	9	40	4,0	558	21	28	40	66
68,3	7,4	48	4,0	683	25	34	48	78	
<b>560</b>	13,7	41	12	2,0	137	8	9	12	18
	17,2	33	15	2,0	172	9	10	15	22
	21,4	26	19	2,5	214	11	12	19	27
	26,7	21	23	3,0	267	12	14	23	33
	31,7	17,6	27	3,0	317	14	17	27	39
	33,2	17	28	3,0	332	15	17	28	41
	41,2	13,6	35	3,5	412	17	21	35	50
	50,8	11	42	4,0	508	20	25	42	61
	62,5	9	50	4,0	625	23	31	50	72

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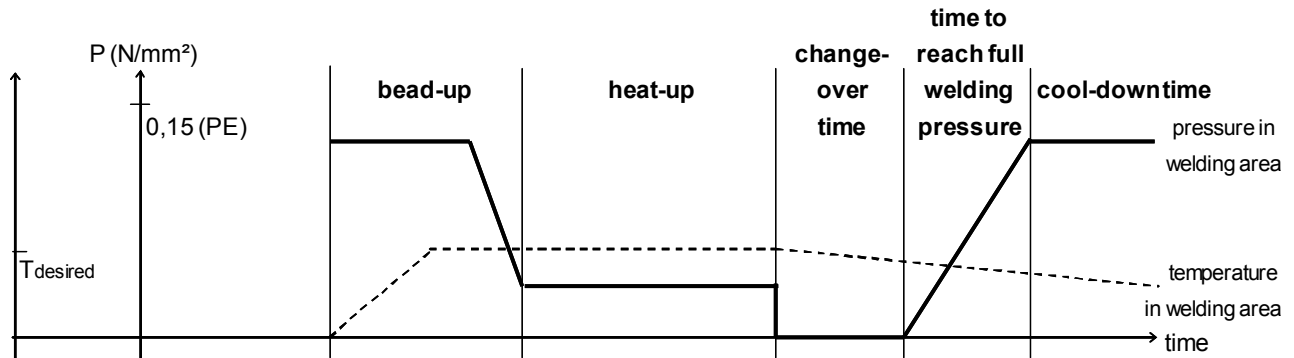
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach full welding pressure [s]	welding pressure [bar]	cool-down time [min] <b>①</b>
<b>630</b>	15,4	41	16	2,0	154	9	9	16	20
	19,3	33	19	2,5	193	10	11	19	24
	24,1	26	24	2,5	241	11	13	24	30
	30,0	21	29	3,0	300	16	16	29	37
	35,7	17,6	34	3,0	357	13	18	34	43
	37,4	17	36	3,5	374	16	23	36	45
	46,3	13,6	44	3,5	463	19	19	44	56
	57,2	11	53	4,0	572	22	29	53	67
70	9	63	4,0	700	25	35	63	80	
<b>710</b>	17,4	41	20	2,0	174	10	10	20	22
	21,8	33	25	2,5	218	11	12	25	27
	27,2	26	30	3,0	272	12	15	30	33
	33,9	21	37	3,0	339	15	18	37	41
	40,2	17,6	44	3,5	402	17	20	44	49
	42,1	17	45	3,5	421	18	21	45	51
	52,2	13,6	55	4,0	522	21	26	55	62
	64,5	11	67	4,0	645	24	32	67	74

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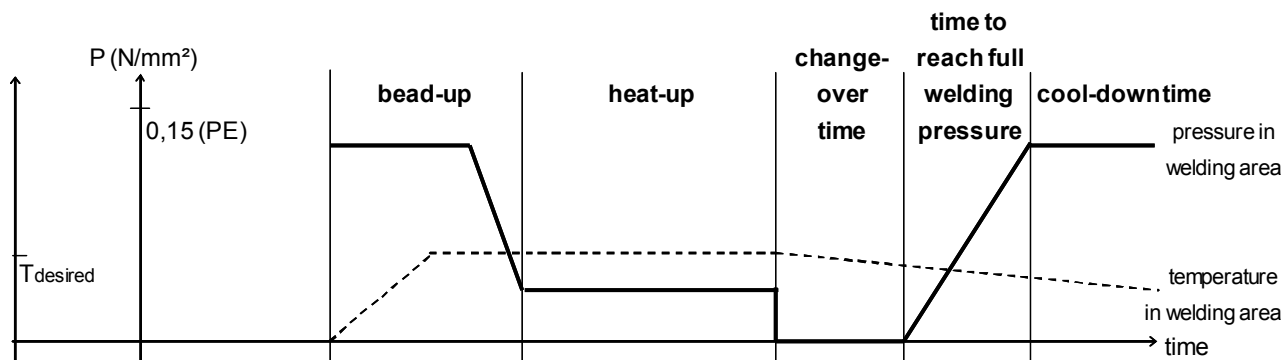
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<b>800</b>	19,6	41	25	2,0	145	9	9	25	19
	24,5	33	31	2,5	245	12	13	31	30
	30,6	26	38	3,0	306	14	16	38	37
	38,1	21	47	3,5	381	16	20	47	46
	45,3	17,6	55	3,5	453	19	23	55	55
	47,4	17	58	58	3,5	474	19	24	58

**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