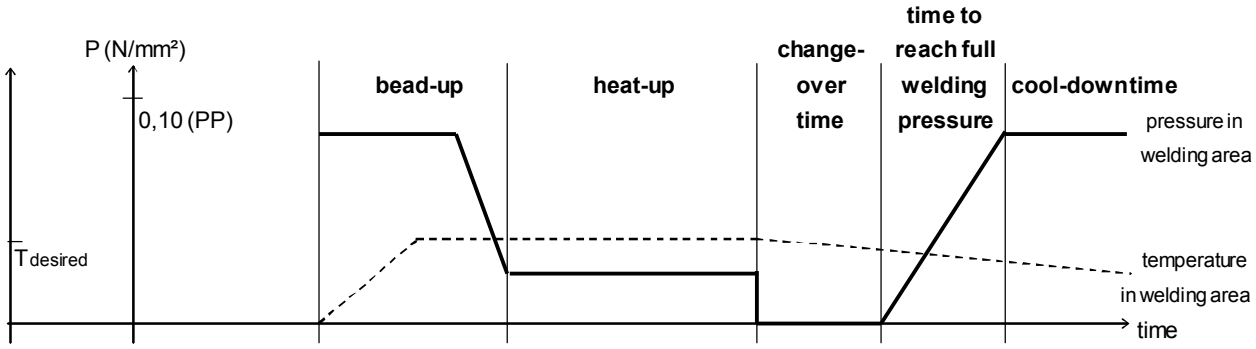
Table for PP

Foundation: 2207, 2208 DIN 16932 German association for welding
Use for: **4002 (with 2. cylinder)**

1 bar on manometer: **36** N

The standard value for heating element temperature is 210° C +/- 10° C.
The **smaller** the pipe wall the **higher** thetemperature.

Additional to the given bead-up force and to the welding force the moving force of the support must be added !



The following pressure values are only valid if the 2. cylinder is used.

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
140	3,5	41	5	0,5	117	5	6	5	4
	4,3	33	6	0,5	131	5	6	6	6
	5,4	26	7	0,5	149	5	6	7	8
	8,0	17,6	10	1,0	189	6	8	10	14
	12,7	11	15	1,0	254	7	12	15	21
	19,2	7,4	21	1,5	332	9	17	21	30
	23,3	6	24	1,5	373	10	20	24	36
160	4,0	41	6	0,5	126	5	6	6	5
	4,9	33	7	0,5	141	5	6	7	7
	6,2	26	9	0,5	162	6	7	9	10
	9,1	17,6	12	1,0	204	6	9	12	15
	14,6	11	19	1,0	277	8	13	19	24
	21,9	7,4	27	1,5	359	10	19	27	34
	26,6	6	31	2,0	405	11	23	31	41
180	4,4	41	7	0,5	133	5	6	7	6
	5,5	33	9	0,5	151	5	6	9	8
	6,9	26	11	0,5	173	6	7	11	12
	10,2	17,6	16	1,0	220	7	10	16	17
	16,4	11	24	1,0	298	8	15	24	26
	24,6	7,4	34	1,5	386	11	21	34	38
	29,0	6	39	2,0	423	12	25	39	44

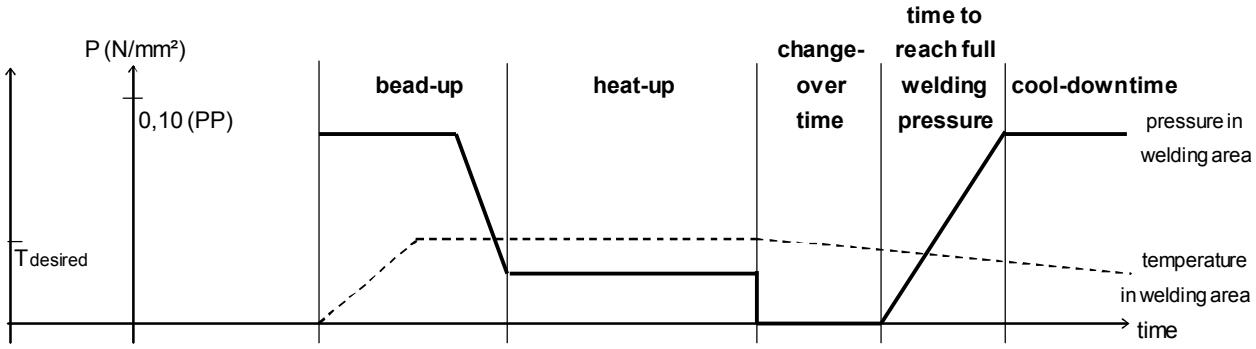
Table for PP

Foundation: 2207, 2208 DIN 16932 German association for welding
Use for: **4002 (with 2. cylinder)**

1 bar on manometer: **36** N

The standard value for heating element temperature is 210° C +/- 10° C.
The **smaller** the pipe wall the **higher** thetemperature.

Additional to the given bead-up force and to the welding force the moving force of the support must be added !



The following pressure values are only valid if the 2. cylinder is used.

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
200	4,9	41	9	0,5	141	5	6	9	7
	6,2	33	11	0,5	162	6	7	11	10
	7,7	26	13	1,0	185	6	8	13	13
	11,4	17,6	19	1,0	237	7	11	19	19
	18,2	11	29	1,0	320	9	16	29	29
	27,4	7,4	42	2,0	411	11	23	42	42
	33,2	6	49	2,0	456	13	29	49	50
225	5,5	41	11	0,5	151	5	6	11	8
	6,9	33	14	0,5	173	6	7	14	12
	8,6	26	17	1,0	197	6	8	17	15
	12,8	17,6	24	1,0	255	7	12	24	21
	20,5	11	37	1,5	345	9	18	37	32
	30,8	7,4	53	2,0	437	12	26	53	47
	37,4	6	62	2,5	487	14	32	62	55
250	6,2	41	14	0,5	162	6	7	14	10
	7,7	33	17	1,0	185	6	8	17	13
	9,6	26	21	1,0	211	7	9	21	16
	14,2	17,6	30	1,0	272	8	13	30	23
	22,7	11	46	1,5	367	10	20	46	35
	34,2	7,4	65	2,0	463	13	29	65	51
280	6,9	41	17	0,5	173	6	7	17	12
	8,6	33	21	1,0	197	6	8	21	15
	10,7	26	26	1,0	227	7	10	26	18
	15,9	17,6	37	1,0	292	8	14	37	26
	25,4	11	57	1,5	394	11	22	57	39
	38,3	7,4	81	2,5	493	14	33	81	57

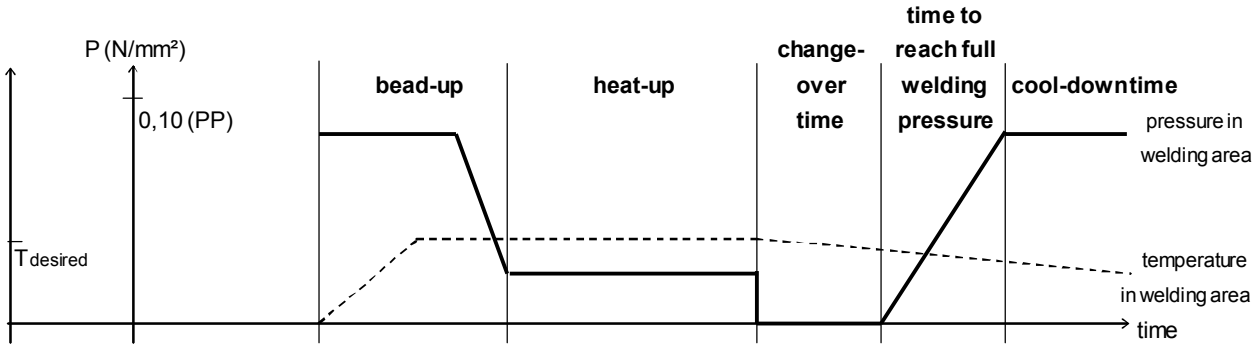
Table for PP

Foundation: 2207, 2208 DIN 16932 German association for welding
Use for: **4002 (with 2. cylinder)**

1 bar on manometer: **36** N

The standard value for heating element temperature is 210° C +/- 10° C.
The **smaller** the pipe wall the **higher** thetemperature.

Additional to the given bead-up force and to the welding force the moving force of the support must be added !



The following pressure values are only valid if the 2. cylinder is used.

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	21	1,0	185	6	8	21	13
	9,7	33	26	1,0	213	7	9	26	16
	12,1	26	32	1,0	246	7	11	32	20
	17,9	17,6	47	1,0	317	9	16	47	28
	28,6	11	72	2,0	420	12	24	72	44
355	8,7	41	27	1,0	199	6	8	27	15
	10,9	33	33	1,0	230	7	10	33	18
	13,6	26	41	1,0	264	7	12	41	22
	20,1	17,6	59	1,5	341	9	18	59	32
	32,2	11	91	2,0	448	13	28	91	48
400	9,8	41	34	1,0	214	7	9	34	16
	12,3	33	42	1,0	249	7	11	42	20
	15,3	26	52	1,0	221	7	10	52	17
	22,7	17,6	75	1,5	367	10	20	75	35
	36,3	11	116	2,0	480	14	31	116	54
450	11,0	41	43	1,0	231	7	10	43	18
	13,8	33	53	1,0	267	8	13	53	23
	17,2	26	65	1,0	308	8	15	65	27
	25,5	17,6	95	1,5	395	11	22	95	39
	40,9	11	147	2,5	508	15	35	147	59

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