

## Table for PVDF



Foundation: 2208, 2207 Part 15 German association for welding

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

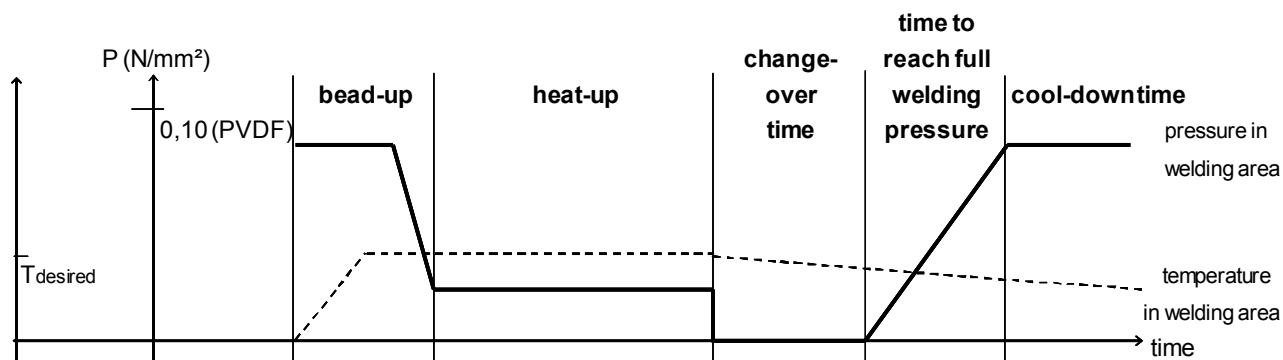
**5500** OD 200 - 500

1 bar on manometer: **141 N**

The standard value for heating element temperature is 240° C +/- 8° C.

The **smaller** the pipe wall the **higher** the temperature.

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]	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>200</b>	6,2	3	0,6	102	4	5	3	9,5
	9,6	5	1,0	136	4	7	5	13,5
<b>225</b>	6,9	4	0,7	109	4	6	4	10,5
	10,8	6	1,0	148	4	7	6	15,0
<b>250</b>	7,7	5	0,7	117	4	6	5	11,0
	11,9	7	1,1	159	4	8	7	16,5
<b>280</b>	8,6	6	0,8	126	4	6	6	12,5
<b>315</b>	9,7	7	1,0	137	4	7	7	13,5