

Table for PP



Foundation: 2207, 2208 DIN 16932 German association for welding

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

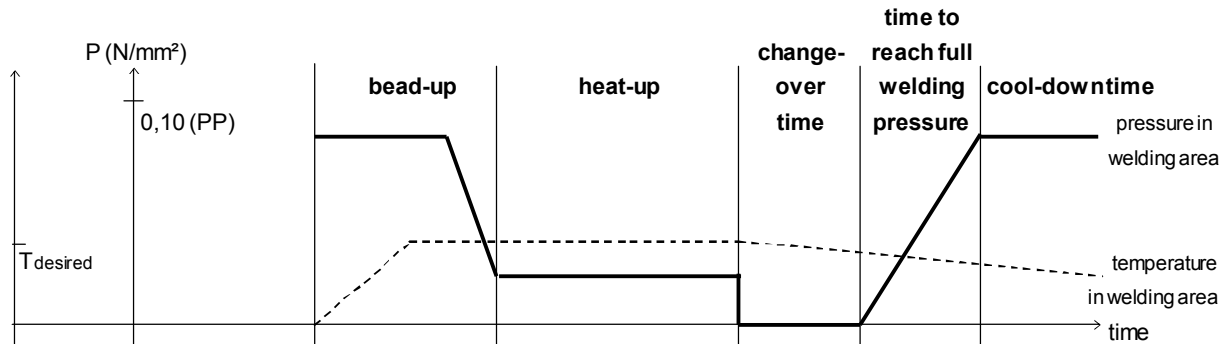
5500 OD 200 - 500

1 bar on manometer: **141 N**

The standard value for heating element temperature is 210° C +/- 10° 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]	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
200	4,9	41	3	0,5	141	5	6	3	7
	6,2	33	3	0,5	162	6	7	3	10
	7,7	26	4	1,0	185	6	8	4	13
	11,4	17,6	5	1,0	237	7	11	5	19
	18,2	11	8	1,0	320	9	16	8	29
	27,4	7,4	11	2,0	411	11	23	11	42
	33,2	6	13	2,0	456	13	29	13	50
225	5,5	41	3	0,5	151	5	6	3	8
	6,9	33	4	0,5	173	6	7	4	12
	8,6	26	5	1,0	197	6	8	5	15
	12,8	17,6	7	1,0	255	7	12	7	21
	20,5	11	10	1,5	345	9	18	10	32
	30,8	7,4	14	2,0	437	12	26	14	47
	37,4	6	16	2,5	487	14	32	16	55
250	6,2	41	4	0,5	162	6	7	4	10
	7,7	33	5	1,0	185	6	8	5	13
	9,6	26	6	1,0	211	7	9	6	16
	14,2	17,6	8	1,0	272	8	13	8	23
	22,7	11	12	1,5	367	10	20	12	35
	34,2	7,4	17	2,0	463	13	29	17	51
280	6,9	41	5	0,5	173	6	7	5	12
	8,6	33	6	1,0	197	6	8	6	15
	10,7	26	7	1,0	227	7	10	7	18
	15,9	17,6	10	1,0	292	8	14	10	26
	25,4	11	15	1,5	394	11	22	15	39
	38,3	7,4	21	2,5	493	14	33	21	57

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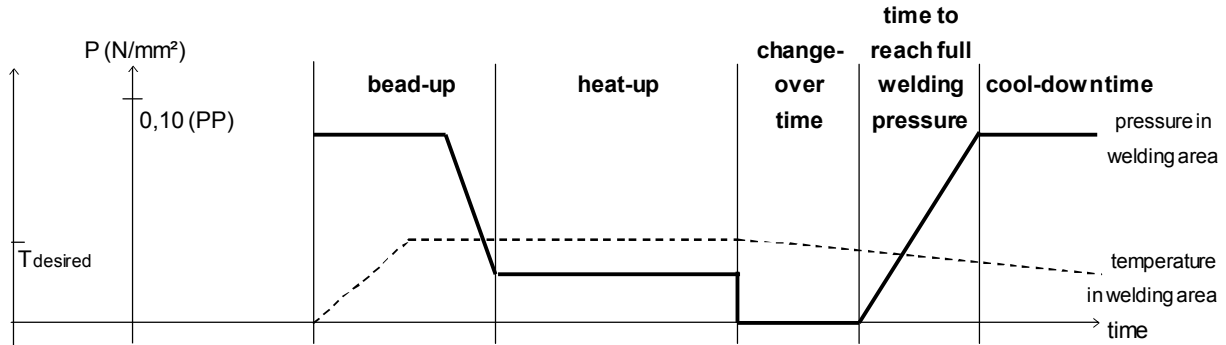
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315	7,7	41	6	1,0	185	6	8	6	13
	9,7	33	7	1,0	213	7	9	7	16
	12,1	26	9	1,0	246	7	11	9	20
	17,9	17,6	12	1,0	317	9	16	12	28
	28,6	11	19	2,0	420	12	24	19	44
355	8,7	41	7	1,0	199	6	8	7	15
	10,9	33	9	1,0	230	7	10	9	18
	13,6	26	11	1,0	264	7	12	11	22
	20,1	17,6	15	1,5	341	9	18	15	32
	32,2	11	24	2,0	448	13	28	24	48
400	9,8	41	9	1,0	214	7	9	9	16
	12,3	33	11	1,0	249	7	11	11	20
	15,3	26	14	1,0	221	7	10	14	17
	22,7	17,6	20	1,5	367	10	20	20	35
	36,3	11	30	2,0	480	14	31	30	54
450	11,0	41	11	1,0	231	7	10	11	18
	13,8	33	14	1,0	267	8	13	14	23
	17,2	26	17	1,0	308	8	15	17	27
	25,5	17,6	25	1,5	395	11	22	25	39
	40,9	11	38	2,5	508	15	35	38	59
500	12,3	41	14	1,0	249	7	11	14	20
	15,3	33	17	1,0	285	8	14	17	25
	19,1	26	21	1,5	331	9	17	21	30
	28,4	17,6	30	2,0	419	12	24	30	43

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