

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

Field of application: **8000 (from 07/2000 until 05/2009)**
10000 (from 07/2000) / 12000 (from 07/2000)

1 bar on pressure gauge: **463** N (Effective surface of cylinder: 4626 mm² / 7,17 inch²)

The heating element temperature is 220° C ± 10° C / 428° F ± 18° F.

The change-over time should be kept as low as possible.

The joining pressure build-up time should be recognized as maximum value and may be underrun by up to 50%.

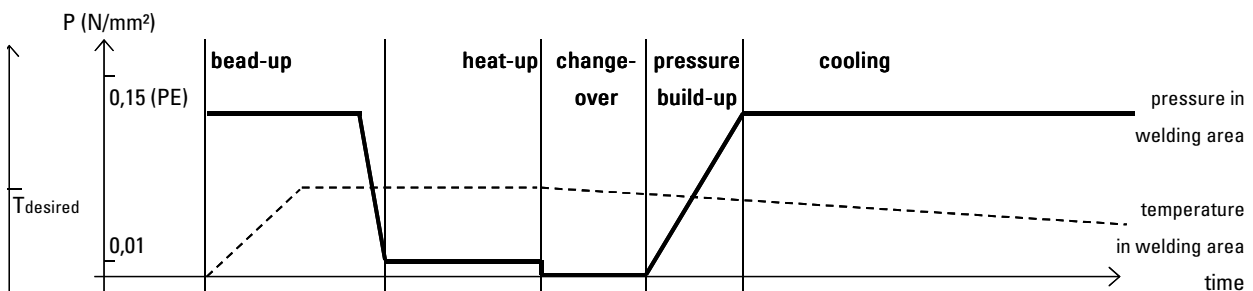
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

The maximum pressure of the welding machine is to be observed.

1 These cooling times are only valid under the following conditions:

- Welding connection is produced under workshop conditions
- Removal from the welding machine and temporary storage until complete cooling time elapses only cause minor strain for the welding connection

All information without guarantee



pipe (s) (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change- over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature			special cooling time 1 [min:s]
								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
DA 450											
11,0	41	5	1,5	01:50	8	8	5	08:48	11:06	14:18	07:24
13,8	33	7	2	02:18	9	9	7	10:39	13:33	17:41	09:02
17,2	26	8	2	02:52	9	10	8	12:51	16:27	21:49	10:58
21,5	21	10	2,5	03:35	11	12	10	15:47	20:09	26:51	13:26
25,5	17,6	12	2,5	04:15	12	14	12	18:39	23:34	31:26	15:43
26,7	17	12	3	04:27	12	14	12	19:31	24:38	32:50	16:27
33,1	13,6	15	3	05:31	15	17	15	24:10	30:27	40:23	20:31
40,9	11	18	3,5	06:49	17	21	18	29:42	37:36	49:48	25:24
50,3	9	21	4	08:23	20	25	21	36:13	46:16	61:22	31:11
61,5	7,4	25	4	10:15	23	31	25	44:03	56:21	74:48	37:54
DA 500											
12,3	41	7	2	02:03	8	8	7	09:42	12:15	15:52	08:10
15,3	33	8	2	02:33	9	9	8	11:37	14:50	19:30	09:53
19,1	26	10	2,5	03:11	10	11	10	14:04	18:05	24:07	12:03
23,9	21	12	2,5	03:59	11	13	12	17:30	22:12	29:36	14:48
28,4	17,6	14	3	04:44	13	15	14	20:45	26:11	34:50	17:32
29,7	17	15	3	04:57	13	16	15	21:41	27:22	36:22	18:21
36,8	13,6	18	3	06:08	16	19	18	26:51	33:49	44:46	22:52
45,4	11	22	3,5	07:34	19	23	22	32:49	41:45	55:20	28:10
56,0	9	26	4	09:20	21	28	26	40:12	51:24	68:12	34:36
68,3	7,4	31	4	11:23	25	34	31	48:49	62:28	82:58	41:59

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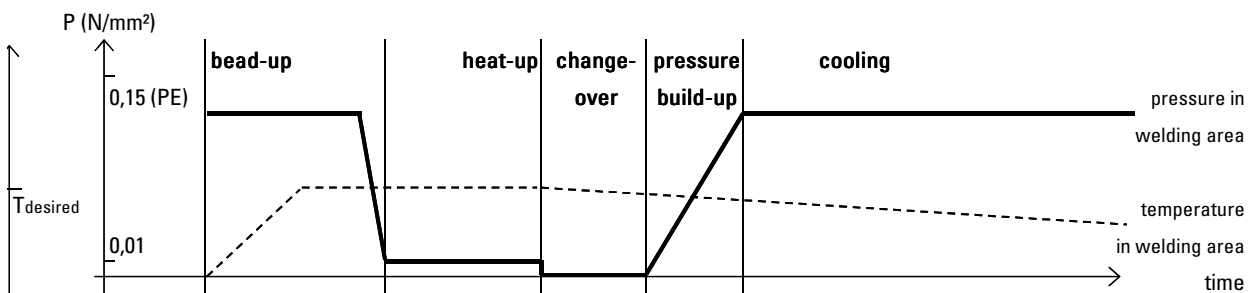
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
DA 560											
13,7	41	8	2	02:17	8	9	8	10:36	13:27	17:34	08:58
17,2	33	10	2	02:52	9	10	10	12:51	16:27	21:49	10:58
21,4	26	12	2,5	03:34	11	12	12	15:43	20:03	26:45	13:22
26,7	21	15	3	04:27	12	14	15	19:31	24:38	32:50	16:27
31,7	17,6	18	3	05:17	14	17	18	23:09	29:11	38:44	19:38
33,2	17	18	3	05:32	15	17	18	24:14	30:33	40:31	20:35
41,2	13,6	22	3,5	06:52	17	21	22	29:54	37:53	50:10	25:35
50,8	11	27	4	08:28	20	25	27	36:34	46:43	61:58	31:29
62,5	9	32	4	10:25	23	31	32	44:45	57:15	76:00	38:30
DA 630											
15,4	41	10	2	02:34	9	9	10	11:41	14:55	19:38	09:57
19,3	33	12	2,5	03:13	10	11	12	14:13	18:15	24:21	12:10
24,1	26	15	2,5	2,5	11	13	15	17:39	22:22	29:50	14:55
30,0	21	19	3	3	13	16	19	21:55	27:38	36:44	18:33
35,7	17,6	22	3	05:57	16	18	22	26:03	32:49	43:28	22:10
37,4	17	23	3,5	06:14	16	19	23	27:17	34:22	45:30	23:15
46,3	13,6	28	3,5	07:43	19	23	28	33:26	42:35	56:27	28:43
57,2	11	34	4	09:32	22	29	34	41:02	52:29	69:38	35:19

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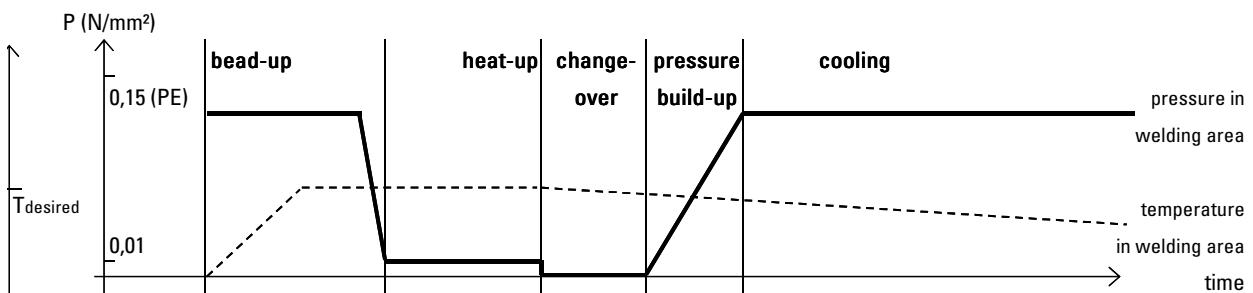
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
DA 710											
17,4	41	13	2	02:54	10	10	13	12:58	16:38	22:03	11:05
21,8	33	16	2,5	03:38	11	12	16	16:00	20:24	27:12	13:36
27,2	26	19	3	04:32	12	15	19	19:52	25:05	33:25	16:46
33,9	21	24	3	05:39	15	18	24	24:45	31:11	41:20	21:02
40,2	17,6	28	3,5	06:42	17	20	28	29:13	36:57	48:56	24:58
42,1	17	29	3,5	07:01	18	21	29	30:32	38:42	51:17	26:08
52,2	13,6	35	4	08:42	21	26	35	37:32	47:59	63:38	32:19
64,5	11	43	4	10:45	24	32	43	46:09	59:03	78:24	39:42
DA 800											
19,6	41	16	2,5	03:16	10	11	16	14:26	18:31	24:41	12:21
24,5	33	20	2,5	04:05	12	13	20	17:56	22:43	30:17	15:09
30,6	26	24	3	05:06	14	16	24	22:21	28:11	37:26	18:56
38,1	21	30	3,5	06:21	16	20	30	27:46	35:01	46:21	23:41
45,3	17,6	35	3,5	07:33	19	23	35	32:45	41:40	55:13	28:06
47,4	17	37	3,5	07:54	19	24	37	34:12	43:36	57:48	29:24
58,8	13,6	45	4	09:48	22	29	45	42:10	53:55	71:34	36:17

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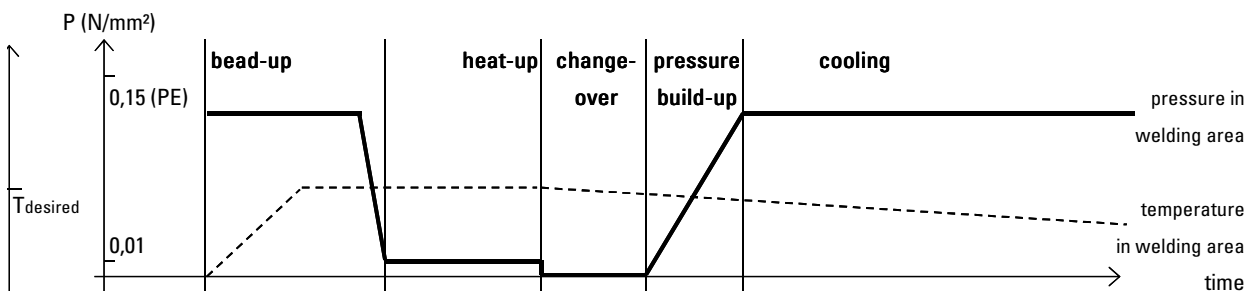
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
DA 900											
22,0	41	20	2,5	03:40	11	12	20	16:09	20:34	27:26	13:43
27,6	33	25	3	04:36	13	15	25	20:10	25:27	33:53	17:01
34,4	26	31	3	05:44	15	18	31	25:07	31:38	41:56	21:21
42,9	21	38	3,5	07:09	18	22	38	31:05	39:27	52:16	26:38
51,0	17,6	45	4	08:30	20	26	45	36:42	46:54	62:12	31:36
53,3	17	46	4	08:53	21	27	46	38:19	48:58	64:58	32:59
66,2	13,6	57	4	11:02	24	33	57	47:20	60:35	80:26	40:43
DA 1000											
24,5	41	25	2,5	04:05	12	13	25	17:56	22:43	30:17	15:09
30,6	33	31	3	05:06	14	16	31	22:21	28:11	37:26	18:56
38,2	26	38	3,5	06:22	16	20	38	27:50	35:06	46:29	23:44
47,7	21	47	3,5	07:57	19	24	47	34:24	43:53	58:10	29:35
56,7	17,6	55	4	09:27	22	28	55	40:41	52:02	69:02	35:01
59,3	17	57	4	09:53	22	30	57	42:31	54:22	72:10	36:35
DA 1200											
29,4	41	36	3	04:54	13	16	36	21:28	27:05	36:01	18:10
36,7	33	44	3	06:07	16	19	44	26:47	33:44	44:39	22:49
45,9	26	54	3,5	07:39	19	23	54	33:10	42:13	55:57	28:29
57,2	21	67	4	09:32	22	29	67	41:02	52:29	69:38	35:19
68,0	17,6	79	4	11:20	24	34	79	48:36	62:12	82:36	41:48