

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

Field of application: **20000**

1 bar on pressure gauge: **613** N (Effective surface of cylinder: 6126 mm² / 9,50 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%.

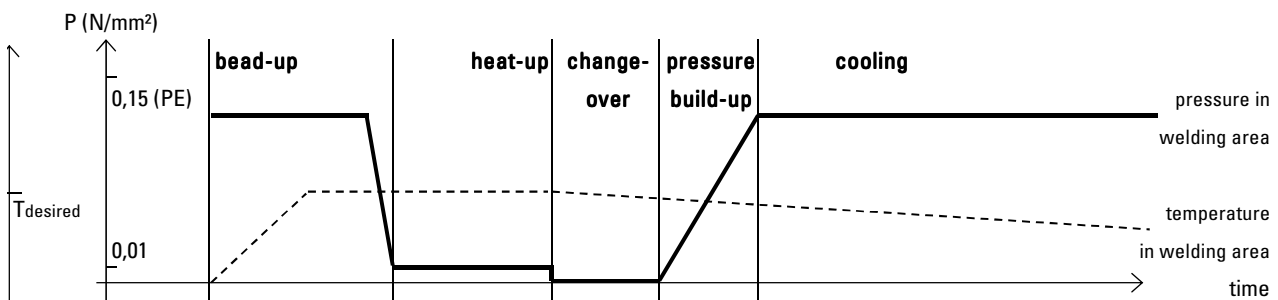
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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)	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 [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
[mm]											
DA 1000											
24,5	41	19	2,5	04:05	12	13	19	17:56	22:43	30:17	15:09
30,6	33	23	3	05:06	14	16	23	22:21	28:11	37:26	18:56
38,2	26	29	3,5	06:22	16	20	29	27:50	35:06	46:29	23:44
47,7	21	35	3,5	07:57	19	24	35	34:24	43:53	58:10	29:35
56,7	17,6	42	4	09:27	22	28	42	40:41	52:02	69:02	35:01
59,3	17	43	4	09:53	22	30	43	42:31	54:22	72:10	36:35
73,5	13,6	53	4,5	12:15	26	35	53	52:27	67:09	89:12	45:06
DA 1200											
29,4	41	27	3	04:54	13	16	27	21:28	27:05	36:01	18:10
36,7	33	33	3	06:07	16	19	33	26:47	33:44	44:39	22:49
45,9	26	41	3,5	07:39	19	23	41	33:10	42:13	55:57	28:29
57,2	21	51	4	09:32	22	29	51	41:02	52:29	69:38	35:19
68,0	17,6	60	4	11:20	24	34	60	48:36	62:12	82:36	41:48
70,6	17	62	4,5	11:46	25	35	62	50:25	64:32	85:43	43:22
88,2	13,6	76	4,5	14:42	30	35	76	62:44	80:23	106:50	53:55

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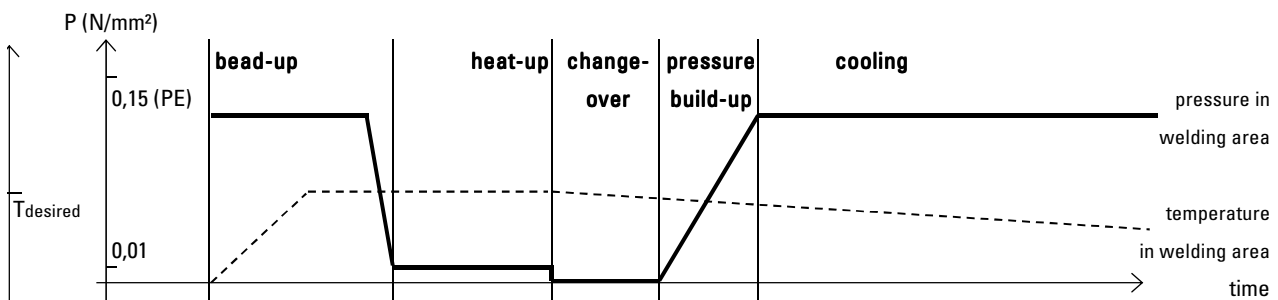
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
[mm]											
DA 1400											
34,3	41	37	3	05:43	15	18	37	25:02	31:33	41:49	21:17
42,9	33	45	3,5	07:09	18	22	45	31:05	39:27	52:16	26:38
53,5	26	56	4	08:55	21	27	56	38:27	49:09	65:12	33:06
66,7	21	69	4	11:07	24	33	69	47:41	61:02	81:02	41:01
79,5	17,6	81	4,5	13:15	27	35	81	56:39	72:33	96:24	48:42
82,4	17	84	4,5	13:44	28	35	84	58:41	75:10	99:53	50:26
102,8	13,6	103	5	17:08	33	35	103	72:58	93:31	124:22	62:41
DA 1600											
39,2	41	48	3,5	06:32	17	20	48	28:31	36:02	47:42	24:21
49,0	33	59	3,5	08:10	20	25	59	35:18	45:05	59:46	30:23
61,2	26	73	4	10:12	23	31	73	43:50	56:05	74:26	37:43
76,1	21	90	4,5	12:41	27	35	90	54:16	69:29	92:19	46:40
90,9	17,6	106	5	15:09	30	35	106	64:38	82:49	110:05	55:32
94,0	17	109	5	15:40	31	35	109	66:48	85:36	113:48	57:24
117,5	13,6	134	5,5	19:35	35	35	134	83:15	106:45	142:00	71:30

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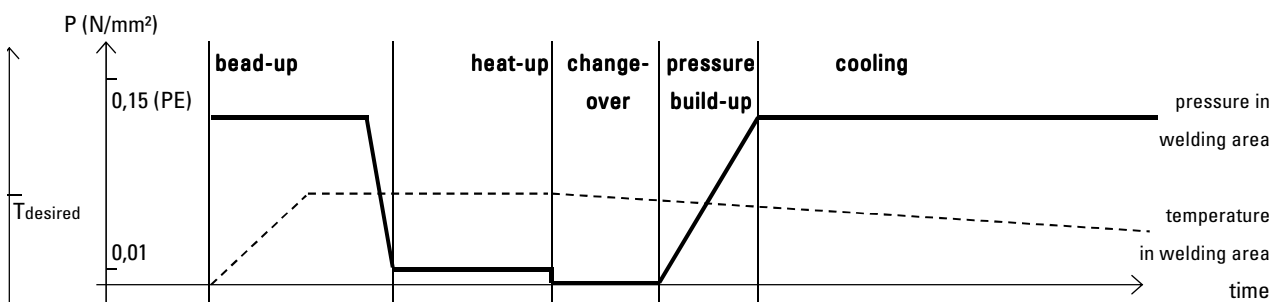
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								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 1800											
43,8	41	60	3,5	07:18	18	22	60	31:42	40:17	53:22	27:11
54,5	33	74	4	09:05	21	27	74	39:09	50:03	66:24	33:42
69,1	26	92	4	11:31	25	35	92	49:22	63:11	83:55	42:28
85,6	21	113	4,5	14:16	29	35	113	60:55	78:02	103:43	52:22
102,3	17,6	134	5	17:03	33	35	134	72:37	93:04	123:46	62:23
105,8	17	138	5	17:38	34	35	138	75:04	96:13	127:58	64:29
DA 2000											
48,7	41	74	3,5	08:07	20	24	74	35:06	44:48	59:24	30:12
54,4	33	82	4	09:04	21	27	82	39:05	49:58	66:17	33:38
76,8	26	114	4,5	12:48	27	35	114	54:46	70:07	93:10	47:05
95,1	21	140	5	15:51	31	35	140	67:34	86:35	115:07	58:04
113,6	17,6	165	5,5	18:56	35	35	165	80:31	103:14	137:19	69:10
117,5	17	171	5,5	19:35	35	35	171	83:15	106:45	142:00	71:30