

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

Field of application: **4900 / 4911 / WELD IT 315 / WELD IT 315 Stahl / HRG 0315
250 Compact S / 315 Compact S / 355 Compact A**

1 bar on pressure gauge: **59** N (Effective surface of cylinder: 589 mm² / 0,91 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%.

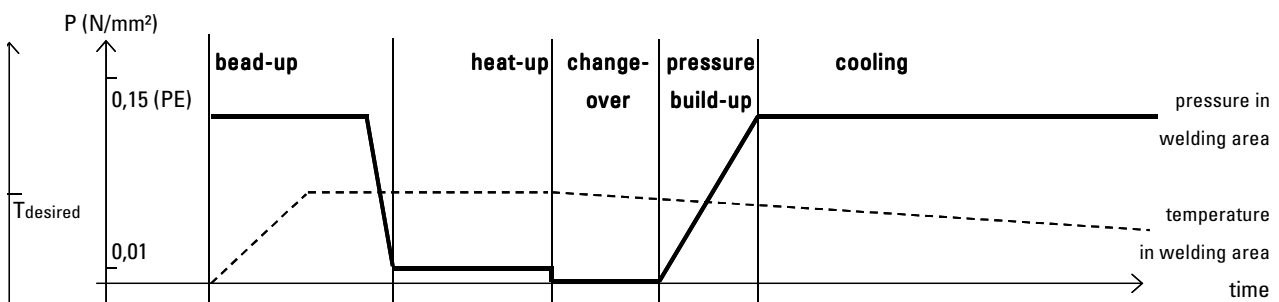
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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

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All information without guarantee



pipe wall (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]	
DA 90											
2,2	41	2	0,5	00:22	5	5	2	04:00	05:00	06:30	03:30
2,8	33	2	0,5	00:28	5	5	2	04:00	05:00	06:30	03:30
3,5	26	3	0,5	00:35	5	5	3	04:00	05:00	06:30	03:30
4,3	21	3	0,5	00:43	5	5	3	04:00	05:00	06:30	03:30
5,1	17,6	4	1	00:51	5	5	4	04:29	05:36	07:13	03:52
5,4	17	4	1	00:54	5	5	4	04:43	05:54	07:35	04:02
6,7	13,6	5	1	01:07	6	6	5	05:46	07:12	09:08	04:49
8,2	11	6	1,5	01:22	6	6	6	06:50	08:35	10:56	05:43
10,1	9	7	1,5	01:41	7	7	7	08:10	10:17	13:13	06:52
12,3	7,4	8	2	02:03	8	8	8	09:42	12:15	15:52	08:10
DA 110											
2,7	41	3	0,5	00:27	5	5	3	04:00	05:00	06:30	03:30
3,4	33	3	0,5	00:34	5	5	3	04:00	05:00	06:30	03:30
4,2	26	4	0,5	00:42	5	5	4	04:00	05:00	06:30	03:30
5,3	21	5	1	00:53	5	5	5	04:38	05:48	07:28	03:59
6,3	17,6	6	1	01:03	6	6	6	05:26	06:48	08:40	04:35
6,6	17	6	1	01:06	6	6	6	05:41	07:06	09:01	04:46
8,1	13,6	7	1,5	01:21	6	6	7	06:46	08:29	10:49	05:40
10,0	11	8	1,5	01:40	7	7	8	08:06	10:12	13:06	06:48
12,3	9	10	2	02:03	8	8	10	09:42	12:15	15:52	08:10
15,1	7,4	12	2	02:31	9	9	12	11:30	14:39	19:16	09:46

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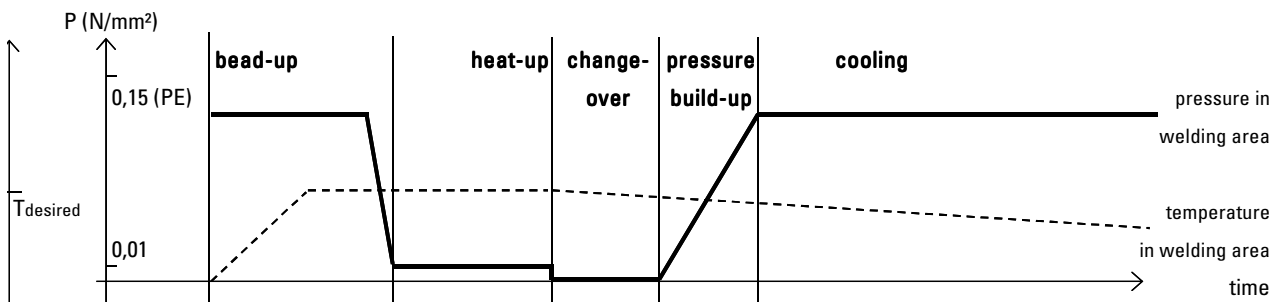
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 125											
3,1	41	4	0,5	00:31	5	5	4	04:00	05:00	06:30	03:30
3,9	33	4	0,5	00:39	5	5	4	04:00	05:00	06:30	03:30
4,8	26	5	1	00:48	5	5	5	04:14	05:18	06:52	03:41
6,0	21	6	1	01:00	6	6	6	05:12	06:30	08:18	04:24
7,1	17,6	7	1,5	01:11	6	6	7	06:04	07:35	09:37	05:04
7,4	17	7	1,5	01:14	6	6	7	06:17	07:52	09:59	05:14
9,2	13,6	9	1,5	01:32	7	7	9	07:32	09:29	12:08	06:19
11,4	11	11	1,5	01:54	8	8	11	09:05	11:28	14:47	07:38
14,0	9	13	2	02:20	9	9	13	10:47	13:43	17:56	09:09
17,1	7,4	15	2	02:51	9	10	15	12:47	16:22	21:42	10:55
DA 140											
3,5	41	4	0,5	00:35	5	5	4	04:00	05:00	06:30	03:30
4,3	33	5	0,5	00:43	5	5	5	04:00	05:00	06:30	03:30
5,4	26	6	1	00:54	5	5	6	04:43	05:54	07:35	04:02
6,7	21	8	1	01:07	6	6	8	05:46	07:12	09:08	04:49
8,0	17,6	9	1,5	01:20	6	6	9	06:42	08:24	10:42	05:36
8,3	17	9	1,5	01:23	7	7	9	06:55	08:40	11:04	05:47
10,3	13,6	11	1,5	01:43	7	7	11	08:19	10:28	13:28	06:59
12,7	11	13	2	02:07	8	8	13	09:57	12:36	16:21	08:24
15,7	9	16	2	02:37	9	10	16	11:53	15:10	20:00	10:07
19,2	7,4	19	2,5	03:12	10	11	19	14:09	18:10	24:14	12:07

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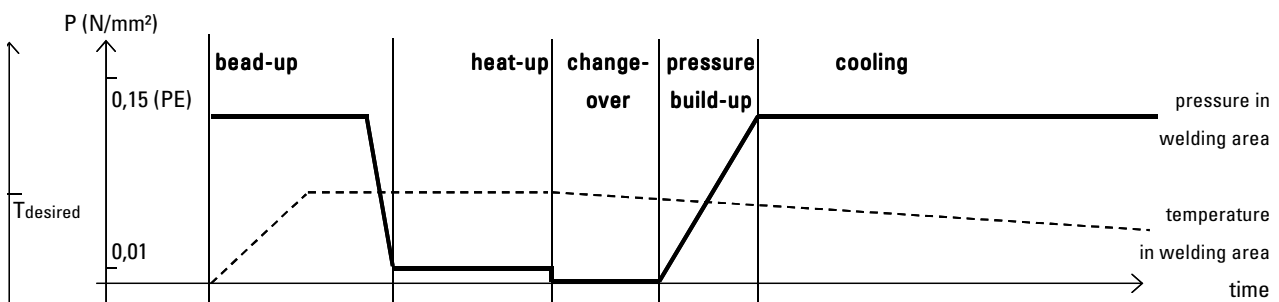
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 160											
4,0	41	5	0,5	00:40	5	5	5	04:00	05:00	06:30	03:30
4,9	33	7	1	00:49	5	5	7	04:19	05:24	06:59	03:44
6,2	26	8	1	01:02	6	6	8	05:22	06:42	08:32	04:31
7,7	21	10	1,5	01:17	6	6	10	06:29	08:08	10:20	05:25
9,1	17,6	11	1,5	01:31	7	7	11	07:28	09:23	12:01	06:16
9,5	17	12	1,5	01:35	7	7	12	07:45	09:45	12:30	06:30
11,8	13,6	14	1,5	01:58	8	8	14	09:22	11:49	15:16	07:53
14,6	11	17	2	02:26	9	9	17	11:10	14:14	18:39	09:29
17,9	9	21	2	02:59	10	11	21	13:18	17:03	22:40	11:22
21,9	7,4	25	2,5	03:39	11	12	25	16:04	20:29	27:19	13:39
DA 180											
4,4	41	7	0,5	00:44	5	5	7	04:00	05:00	06:30	03:30
5,5	33	8	1	00:55	5	5	8	04:48	06:00	07:42	04:06
6,9	26	10	1	01:09	6	6	10	05:55	07:24	09:23	04:56
8,6	21	12	1,5	01:26	7	7	12	07:07	08:56	11:25	05:58
10,2	17,6	14	1,5	01:42	7	7	14	08:14	10:23	13:20	06:55
10,7	17	15	1,5	01:47	7	7	15	08:35	10:50	13:56	07:13
13,3	13,6	18	2	02:13	8	9	18	10:20	13:07	17:05	08:45
16,4	11	22	2	02:44	9	10	22	12:20	15:46	20:51	10:31
20,1	9	26	2,5	03:21	10	11	26	14:47	18:57	25:15	12:38
24,6	7,4	31	2,5	04:06	12	13	31	18:00	22:48	30:24	15:12

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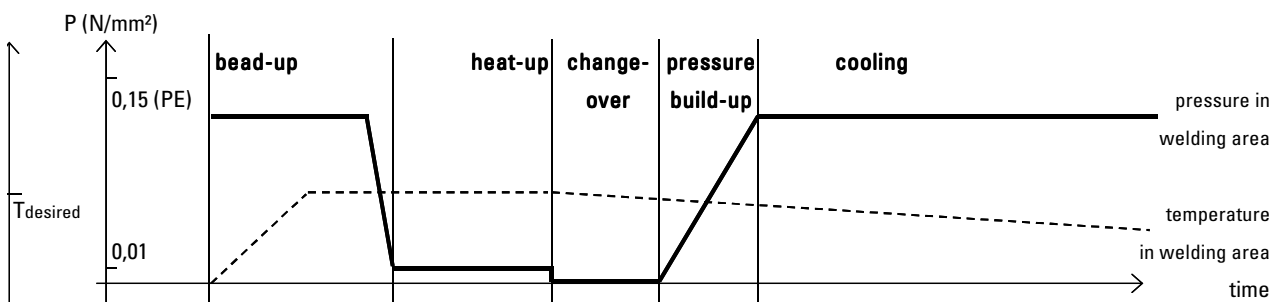
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 200											
4,9	41	8	1	00:49	5	5	8	04:19	05:24	06:59	03:44
6,2	33	10	1	01:02	6	6	10	05:22	06:42	08:32	04:31
7,7	26	12	1,5	01:17	6	6	12	06:29	08:08	10:20	05:25
9,6	21	15	1,5	01:36	7	7	15	07:49	09:50	12:37	06:34
11,4	17,6	18	1,5	01:54	8	8	18	09:05	11:28	14:47	07:38
11,9	17	18	1,5	01:59	8	8	18	09:26	11:55	15:23	07:56
14,7	13,6	22	2	02:27	9	9	22	11:14	14:19	18:47	09:33
18,2	11	27	2	03:02	10	11	27	13:29	17:19	23:02	11:33
22,4	9	32	2,5	03:44	11	12	32	16:26	20:55	27:53	13:57
27,4	7,4	38	3	04:34	13	15	38	20:01	25:16	33:39	16:53
DA 225											
5,5	41	10	1	00:55	5	5	10	04:48	06:00	07:42	04:06
6,9	33	13	1	01:09	6	6	13	05:55	07:24	09:23	04:56
8,6	26	15	1,5	01:26	7	7	15	07:07	08:56	11:25	05:58
10,8	21	19	1,5	01:48	8	8	19	08:40	10:55	14:04	07:17
12,8	17,6	22	2	02:08	8	8	22	10:01	12:41	16:28	08:27
13,4	17	23	2	02:14	8	9	23	10:24	13:12	17:12	08:48
16,6	13,6	28	2	02:46	9	10	28	12:27	15:57	21:05	10:38
20,5	11	34	2,5	03:25	10	12	34	15:04	19:17	25:43	12:51
25,2	9	41	2,5	04:12	12	14	41	18:26	23:19	31:05	15:33
30,8	7,4	48	3	05:08	14	16	48	22:29	28:22	37:40	19:03

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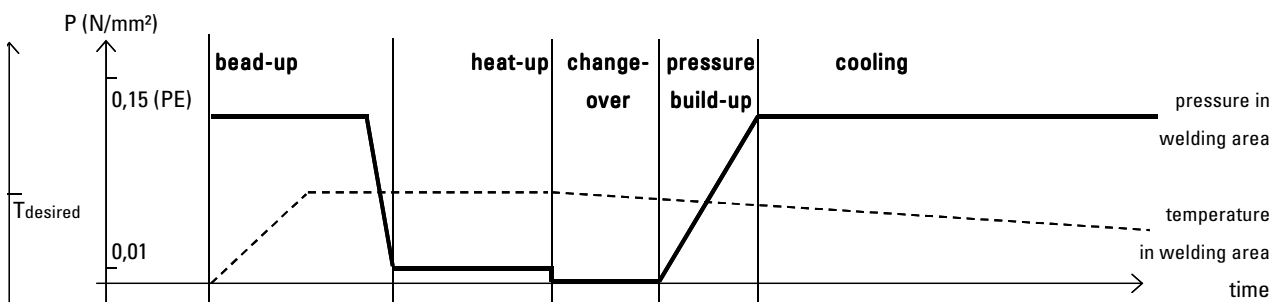
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 250											
6,2	41	13	1	01:02	6	6	13	05:22	06:42	08:32	04:31
7,7	33	15	1,5	01:17	6	6	15	06:29	08:08	10:20	05:25
9,6	26	19	1,5	01:36	7	7	19	07:49	09:50	12:37	06:34
11,9	21	23	1,5	01:59	8	8	23	09:26	11:55	15:23	07:56
14,2	17,6	27	2	02:22	9	9	27	10:55	13:53	18:10	09:15
14,8	17	28	2	02:28	9	9	28	11:18	14:24	18:54	09:36
18,4	13,6	35	2	03:04	10	11	35	13:37	17:29	23:16	11:39
22,7	11	42	2,5	03:47	11	13	42	16:39	21:10	28:14	14:07
27,9	9	50	3	04:39	13	15	50	20:23	25:44	34:15	17:13
34,2	7,4	59	3	05:42	15	18	59	24:58	31:27	41:41	21:13
DA 280											
6,9	41	16	1	01:09	6	6	16	05:55	07:24	09:23	04:56
8,6	33	19	1,5	01:26	7	7	19	07:07	08:56	11:25	05:58
10,7	26	24	1,5	01:47	7	7	24	08:35	10:50	13:56	07:13
13,4	21	29	2	02:14	8	9	29	10:24	13:12	17:12	08:48
15,9	17,6	34	2	02:39	9	10	34	12:00	15:21	20:14	10:14
16,6	17	35	2	02:46	9	10	35	12:27	15:57	21:05	10:38
20,6	13,6	43	2,5	03:26	10	12	43	15:09	19:22	25:50	12:55
25,4	11	52	2,5	04:14	12	14	52	18:34	23:29	31:19	15:39
31,3	9	63	3	05:13	14	16	63	22:51	28:49	38:16	19:22
38,3	7,4	74	3,5	06:23	16	20	74	27:54	35:12	46:36	23:48

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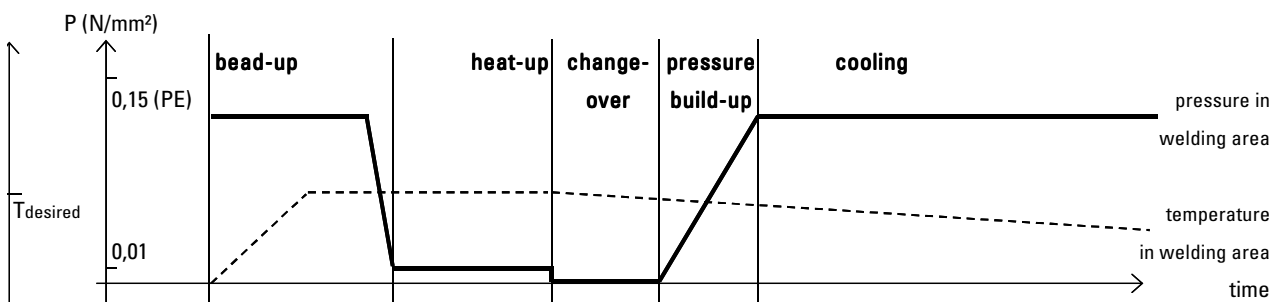
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 315											
7,7	41	19	1,5	01:17	6	6	19	06:29	08:08	10:20	05:25
9,7	33	24	1,5	01:37	7	7	24	07:53	09:56	12:44	06:37
12,1	26	30	2	02:01	8	8	30	09:34	12:05	15:37	08:03
15,0	21	36	2	02:30	9	9	36	11:26	14:34	19:09	09:43
17,9	17,6	43	2	02:59	10	11	43	13:18	17:03	22:40	11:22
18,7	17	45	2	03:07	10	11	45	13:48	17:45	23:38	11:50
23,2	13,6	55	2,5	03:52	11	13	55	17:00	21:36	28:48	14:24
28,6	11	66	3	04:46	13	15	66	20:53	26:22	35:04	17:39
35,2	9	79	3	05:52	15	18	79	25:41	32:22	42:52	21:51
43,1	7,4	94	3,5	07:11	18	22	94	31:13	39:38	52:30	26:45
DA 355											
8,7	41	25	1,5	01:27	7	7	25	07:11	09:02	11:32	06:01
10,9	33	30	1,5	01:49	8	8	30	08:44	11:01	14:11	07:20
13,6	26	38	2	02:16	8	9	38	10:32	13:22	17:27	08:55
16,9	21	46	2	02:49	9	10	46	12:39	16:12	21:27	10:48
20,1	17,6	54	2,5	03:21	10	11	54	14:47	18:57	25:15	12:38
21,1	17	57	2,5	03:31	11	12	57	15:30	19:48	26:24	13:12
26,1	13,6	69	3	04:21	12	14	69	19:04	24:05	32:07	16:04
32,2	11	84	3	05:22	14	17	84	23:31	29:38	39:20	19:57
39,7	9	100	3,5	06:37	17	20	100	28:52	36:30	48:19	24:40
48,5	7,4	119	3,5	08:05	20	24	119	34:58	44:37	59:09	30:05