

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

Field of application: **HRG 3, HRG4**

1 bar on pressure gauge: **98** N (Effective surface of cylinder: 980 mm² / 1,52 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%.

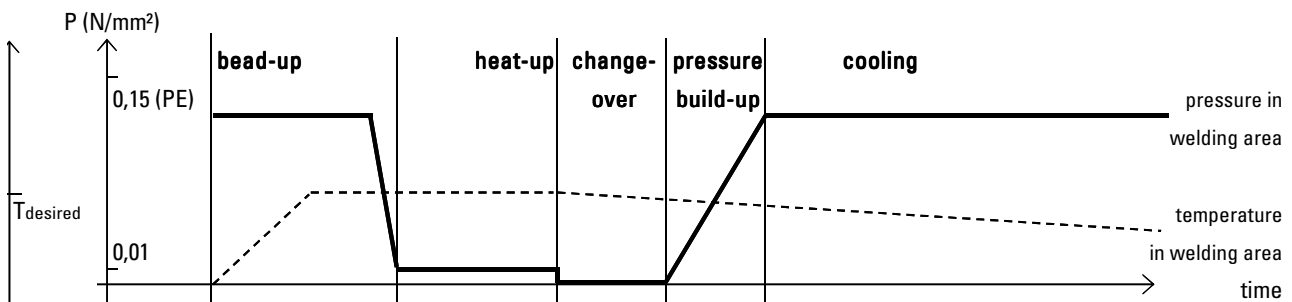
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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

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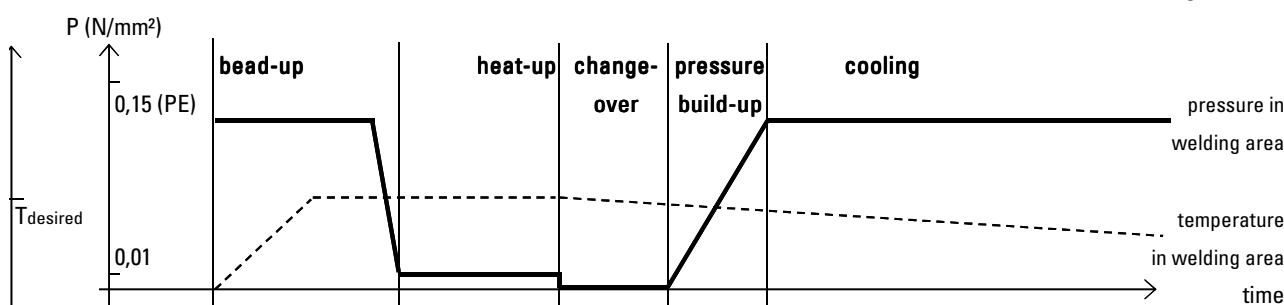
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 250											
6,2	41	8	1	01:02	6	6	8	05:22	06:42	08:32	04:31
7,7	33	9	1,5	01:17	6	6	9	06:29	08:08	10:20	05:25
9,6	26	12	1,5	01:36	7	7	12	07:49	09:50	12:37	06:34
11,9	21	14	1,5	01:59	8	8	14	09:26	11:55	15:23	07:56
14,2	17,6	17	2	02:22	9	9	17	10:55	13:53	18:10	09:15
14,8	17	17	2	02:28	9	9	17	11:18	14:24	18:54	09:36
18,4	13,6	21	2	03:04	10	11	21	13:37	17:29	23:16	11:39
22,7	11	25	2,5	03:47	11	13	25	16:39	21:10	28:14	14:07
27,9	9	30	3	04:39	13	15	30	20:23	25:44	34:15	17:13
34,2	7,4	36	3	05:42	15	18	36	24:58	31:27	41:41	21:13
DA 280											
6,9	41	10	1	01:09	6	6	10	05:55	07:24	09:23	04:56
8,6	33	12	1,5	01:26	7	7	12	07:07	08:56	11:25	05:58
10,7	26	14	1,5	01:47	7	7	14	08:35	10:50	13:56	07:13
13,4	21	18	2	02:14	8	9	18	10:24	13:12	17:12	08:48
15,9	17,6	21	2	02:39	9	10	21	12:00	15:21	20:14	10:14
16,6	17	22	2	02:46	9	10	22	12:27	15:57	21:05	10:38
20,6	13,6	26	2,5	03:26	10	12	26	15:09	19:22	25:50	12:55
25,4	11	32	2,5	04:14	12	14	32	18:34	23:29	31:19	15:39
31,3	9	38	3	05:13	14	16	38	22:51	28:49	38:16	19:22
38,3	7,4	45	3,5	06:23	16	20	45	27:54	35:12	46:36	23:48

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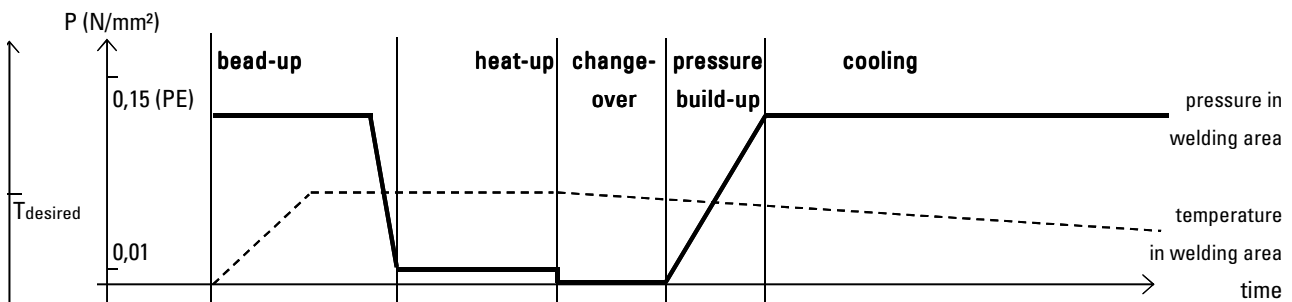
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 315											
7,7	41	12	1,5	01:17	6	6	12	06:29	08:08	10:20	05:25
9,7	33	15	1,5	01:37	7	7	15	07:53	09:56	12:44	06:37
12,1	26	18	2	02:01	8	8	18	09:34	12:05	15:37	08:03
15,0	21	22	2	02:30	9	9	22	11:26	14:34	19:09	09:43
17,9	17,6	26	2	02:59	10	11	26	13:18	17:03	22:40	11:22
18,7	17	27	2	03:07	10	11	27	13:48	17:45	23:38	11:50
23,2	13,6	33	2,5	03:52	11	13	33	17:00	21:36	28:48	14:24
28,6	11	40	3	04:46	13	15	40	20:53	26:22	35:04	17:39
35,2	9	48	3	05:52	15	18	48	25:41	32:22	42:52	21:51
43,1	7,4	57	3,5	07:11	18	22	57	31:13	39:38	52:30	26:45
DA 355											
8,7	41	15	1,5	01:27	7	7	15	07:11	09:02	11:32	06:01
10,9	33	19	1,5	01:49	8	8	19	08:44	11:01	14:11	07:20
13,6	26	23	2	02:16	8	9	23	10:32	13:22	17:27	08:55
16,9	21	28	2	02:49	9	10	28	12:39	16:12	21:27	10:48
20,1	17,6	33	2,5	03:21	10	11	33	14:47	18:57	25:15	12:38
21,1	17	34	2,5	03:31	11	12	34	15:30	19:48	26:24	13:12
26,1	13,6	42	3	04:21	12	14	42	19:04	24:05	32:07	16:04
32,2	11	50	3	05:22	14	17	50	23:31	29:38	39:20	19:57
39,7	9	61	3,5	06:37	17	20	61	28:52	36:30	48:19	24:40
48,5	7,4	72	3,5	08:05	20	24	72	34:58	44:37	59:09	30:05

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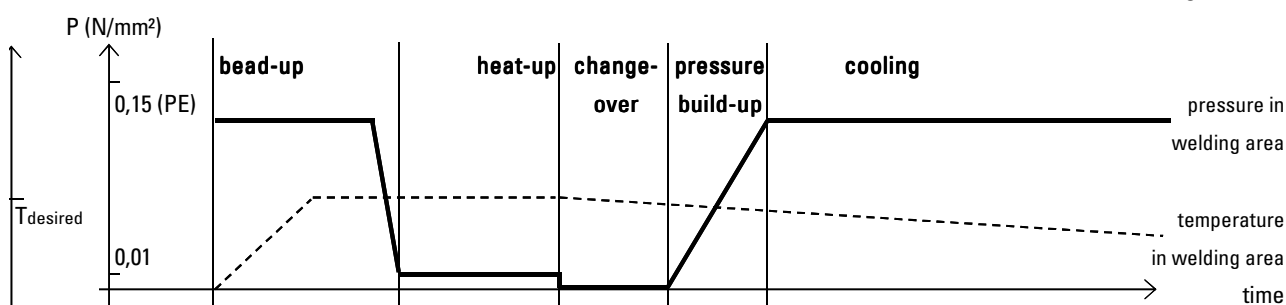
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 400											
9,8	41	19	1,5	01:38	7	7	19	07:58	10:01	12:52	06:41
12,3	33	23	2	02:03	8	8	23	09:42	12:15	15:52	08:10
15,3	26	29	2	02:33	9	9	29	11:37	14:50	19:30	09:53
19,1	21	35	2,5	03:11	10	11	35	14:04	18:05	24:07	12:03
22,7	17,6	42	2,5	03:47	11	13	42	16:39	21:10	28:14	14:07
23,7	17	43	2,5	03:57	11	13	43	17:21	22:02	29:22	14:41
29,4	13,6	53	3	04:54	13	16	53	21:28	27:05	36:01	18:10
36,3	11	64	3	06:03	16	19	64	26:29	33:22	44:10	22:33
44,7	9	77	3,5	07:27	18	23	77	32:20	41:06	54:29	27:44
54,7	7,4	91	4	09:07	21	27	91	39:17	50:14	66:38	33:49
DA 450											
11,0	41	24	1,5	01:50	8	8	24	08:48	11:06	14:18	07:24
13,8	33	29	2	02:18	9	9	29	10:39	13:33	17:41	09:02
17,2	26	36	2	02:52	9	10	36	12:51	16:27	21:49	10:58
21,5	21	45	2,5	03:35	11	12	45	15:47	20:09	26:51	13:26
25,5	17,6	53	2,5	04:15	12	14	53	18:39	23:34	31:26	15:43
26,7	17	55	3	04:27	12	14	55	19:31	24:38	32:50	16:27
33,1	13,6	67	3	05:31	15	17	67	24:10	30:27	40:23	20:31
40,9	11	81	3,5	06:49	17	21	81	29:42	37:36	49:48	25:24
50,3	9	97	4	08:23	20	25	97	36:13	46:16	61:22	31:11
61,5	7,4	115	4	10:15	23	31	115	44:03	56:21	74:48	37:54