

Table for PE



Basis: DVS data sheets 2207, 2208 - State 2016

Field of application: **5100 / 5500**

1 bar on pressure gauge: **141** N (Effective surface of cylinder: 1414 mm² / 2,19 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 overrun by up to 50%.

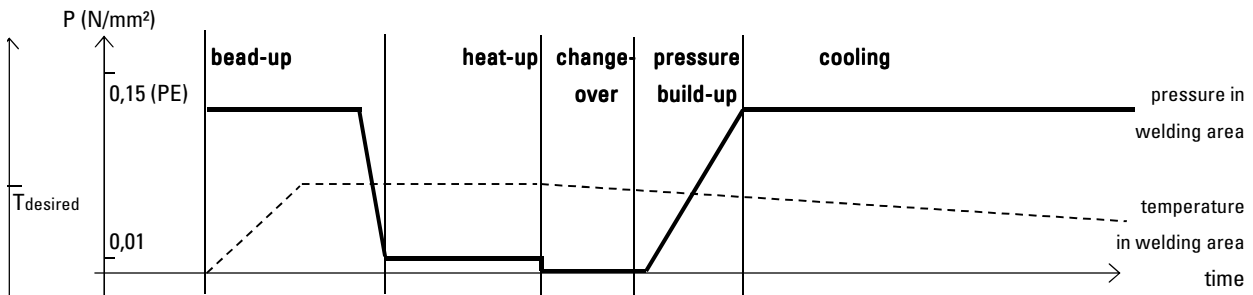
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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

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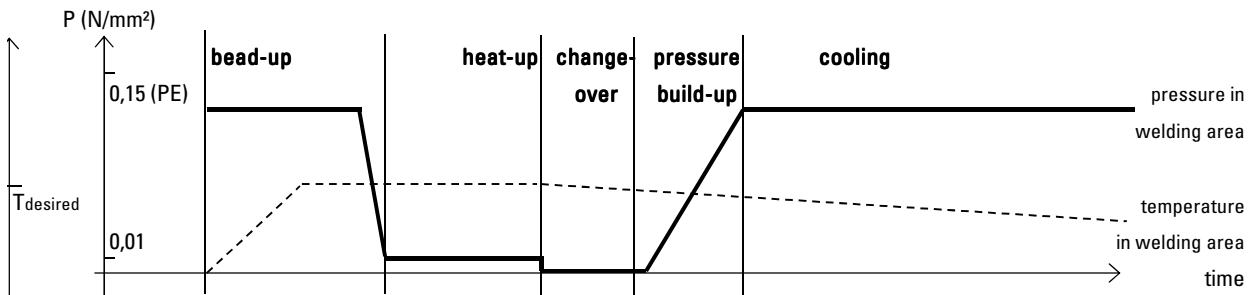
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 250											
6,2	41	6	1	01:02	6	6	6	05:22	06:42	08:32	04:31
7,7	33	7	1,5	01:17	6	6	7	06:29	08:08	10:20	05:25
9,6	26	8	1,5	01:36	7	7	8	07:49	09:50	12:37	06:34
11,9	21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

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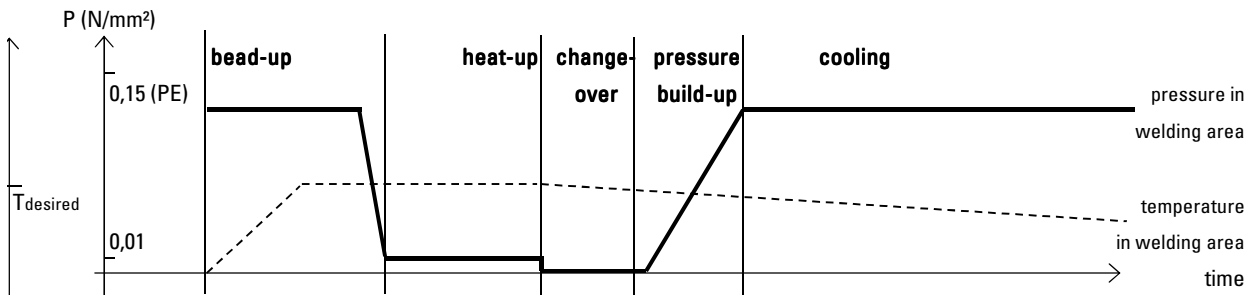
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 315											
7,7	41	8	1,5	01:17	6	6	8	06:29	08:08	10:20	05:25
9,7	33	10	1,5	01:37	7	7	10	07:53	09:56	12:44	06:37
12,1	26	13	2	02:01	8	8	13	09:34	12:05	15:37	08:03
15,0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

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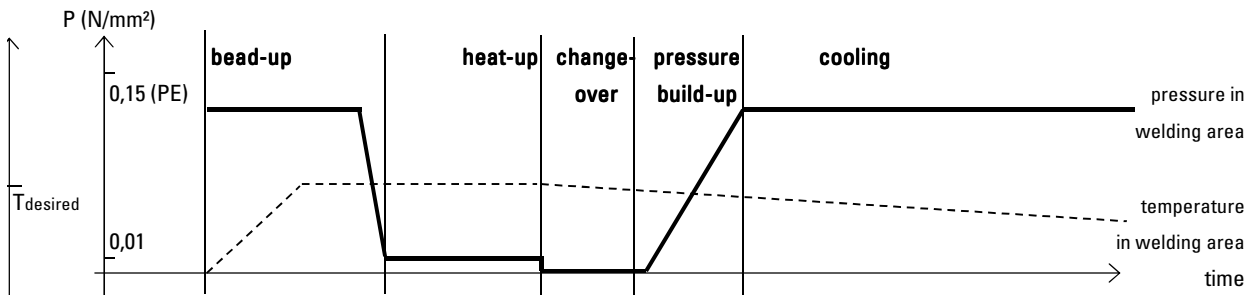
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 400											
9,8	41	13	1,5	01:38	7	7	13	07:58	10:01	12:52	06:41
12,3	33	16	2	02:03	8	8	16	09:42	12:15	15:52	08:10
15,3	26	20	2	02:33	9	9	20	11:37	14:50	19:30	09:53
19,1	21	25	2,5	03:11	10	11	25	14:04	18:05	24:07	12:03
22,7	17,6	29	2,5	03:47	11	13	29	16:39	21:10	28:14	14:07
23,7	17	30	2,5	03:57	11	13	30	17:21	22:02	29:22	14:41
29,4	13,6	37	3	04:54	13	16	37	21:28	27:05	36:01	18:10
36,3	11	45	3	06:03	16	19	45	26:29	33:22	44:10	22:33
44,7	9	54	3,5	07:27	18	23	54	32:20	41:06	54:29	27:44
54,7	7,4	64	4	09:07	21	27	64	39:17	50:14	66:38	33:49
DA 450											
11,0	41	17	1,5	01:50	8	8	17	08:48	11:06	14:18	07:24
13,8	33	21	2	02:18	9	9	21	10:39	13:33	17:41	09:02
17,2	26	25	2	02:52	9	10	25	12:51	16:27	21:49	10:58
21,5	21	31	2,5	03:35	11	12	31	15:47	20:09	26:51	13:26
25,5	17,6	37	2,5	04:15	12	14	37	18:39	23:34	31:26	15:43
26,7	17	38	3	04:27	12	14	38	19:31	24:38	32:50	16:27
33,1	13,6	47	3	05:31	15	17	47	24:10	30:27	40:23	20:31
40,9	11	56	3,5	06:49	17	21	56	29:42	37:36	49:48	25:24
50,3	9	68	4	08:23	20	25	68	36:13	46:16	61:22	31:11
61,5	7,4	80	4	10:15	23	31	80	44:03	56:21	74:48	37:54

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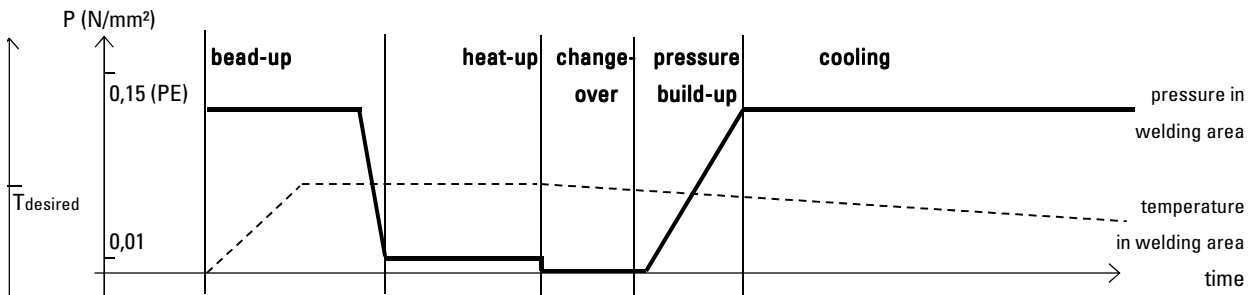
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 500											
12,3	41	21	2	02:03	8	8	21	09:42	12:15	15:52	08:10
15,3	33	25	2	02:33	9	9	25	11:37	14:50	19:30	09:53
19,1	26	31	2,5	03:11	10	11	31	14:04	18:05	24:07	12:03
23,9	21	39	2,5	03:59	11	13	39	17:30	22:12	29:36	14:48
28,4	17,6	45	3	04:44	13	15	45	20:45	26:11	34:50	17:32
29,7	17	47	3	04:57	13	16	47	21:41	27:22	36:22	18:21
36,8	13,6	57	3	06:08	16	19	57	26:51	33:49	44:46	22:52
45,4	11	69	3,5	07:34	19	23	69	32:49	41:45	55:20	28:10
55,8	9	83	4	09:18	21	28	83	40:04	51:13	67:58	34:29
68,3	7,4	99	4	11:23	25	34	99	48:49	62:28	82:58	41:59