

Table for PE

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **6100 steel / 5100 steel / HRG 6 / 8000 (from 06.2009)**

1 bar on pressure gauge: **294,5 N** (Effective surface of cylinder: 2954 mm² / 4,57 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%.

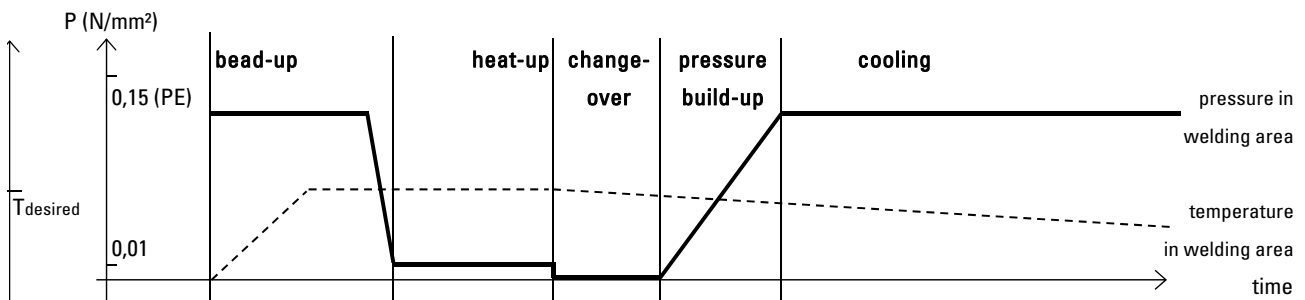
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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 wall (s)	SDR degree	bead-up pressure	circular bead height min.	heat-up time	max. change-over time	pressure build-up time	welding pressure	cooling time for ambient temperature			special cooling time 1
								< 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 315											
7,7	41	4	1,5	01:17	6	6	4	06:29	08:08	10:20	05:25
9,7	33	5	1,5	01:37	7	7	5	07:53	09:56	12:44	06:37
12,1	26	6	2	02:01	8	8	6	09:34	12:05	15:37	08:03
15,0	21	8	2	02:30	9	9	8	11:26	14:34	19:09	09:43
17,9	17,6	9	2	02:59	10	11	9	13:18	17:03	22:40	11:22
18,7	17	9	2	03:07	10	11	9	13:48	17:45	23:38	11:50
23,2	13,6	11	2,5	03:52	11	13	11	17:00	21:36	28:48	14:24
28,6	11	14	3	04:46	13	15	14	20:53	26:22	35:04	17:39
35,2	9	16	3	05:52	15	18	16	25:41	32:22	42:52	21:51
43,1	7,4	19	3,5	07:11	18	22	19	31:13	39:38	52:30	26:45
DA 355											
8,7	41	5	1,5	01:27	7	7	5	07:11	09:02	11:32	06:01
10,9	33	7	1,5	01:49	8	8	7	08:44	11:01	14:11	07:20
13,6	26	8	2	02:16	8	9	8	10:32	13:22	17:27	08:55
16,9	21	10	2	02:49	9	10	10	12:39	16:12	21:27	10:48
20,1	17,6	11	2,5	03:21	10	11	11	14:47	18:57	25:15	12:38
21,1	17	12	2,5	03:31	11	12	12	15:30	19:48	26:24	13:12
26,1	13,6	14	3	04:21	12	14	14	19:04	24:05	32:07	16:04
32,2	11	17	3	05:22	14	17	17	23:31	29:38	39:20	19:57
39,7	9	21	3,5	06:37	17	20	21	28:52	36:30	48:19	24:40
48,5	7,4	24	3,5	08:05	20	24	24	34:58	44:37	59:09	30:05

Table for PE

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **6100 steel / 5100 steel / HRG 6 / 8000 (from 06.2009)**

1 bar on pressure gauge: **294,5 N** (Effective surface of cylinder: 2954 mm² / 4,57 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%.

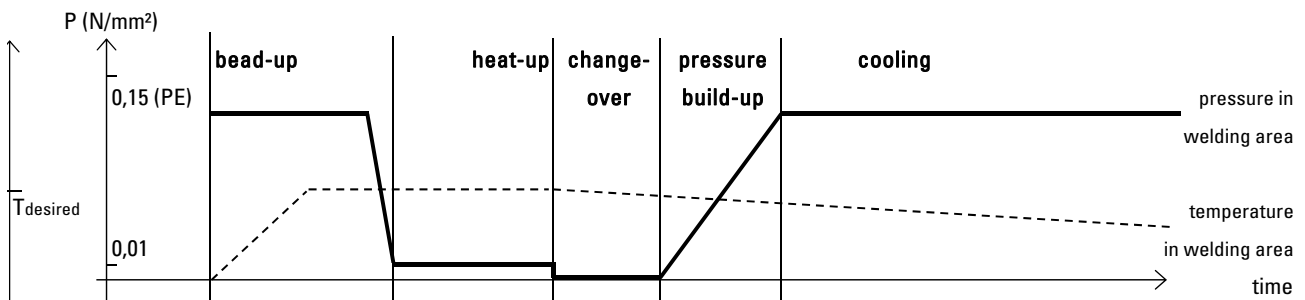
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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

Table for PE

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **6100 steel / 5100 steel / HRG 6 / 8000 (from 06.2009)**

1 bar on pressure gauge: **294,5 N** (Effective surface of cylinder: 2954 mm² / 4,57 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%.

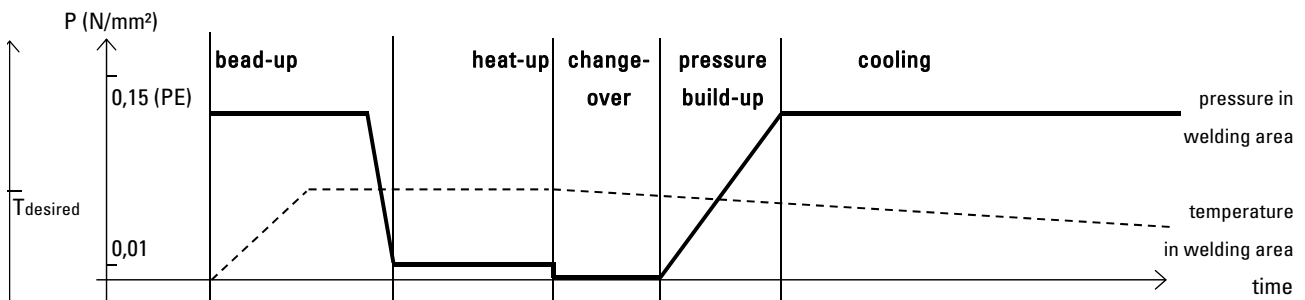
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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 wall (s)	SDR degree	bead-up pressure	circular bead height min.	heat-up time	max. change-over time	pressure build-up time	welding pressure	cooling time for ambient temperature			special cooling time 1
								< 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 500											
12,3	41	10	2	02:03	8	8	10	09:42	12:15	15:52	08:10
15,3	33	12	2	02:33	9	9	12	11:37	14:50	19:30	09:53
19,1	26	15	2,5	03:11	10	11	15	14:04	18:05	24:07	12:03
23,9	21	19	2,5	03:59	11	13	19	17:30	22:12	29:36	14:48
28,4	17,6	22	3	04:44	13	15	22	20:45	26:11	34:50	17:32
29,7	17	23	3	04:57	13	16	23	21:41	27:22	36:22	18:21
36,8	13,6	28	3	06:08	16	19	28	26:51	33:49	44:46	22:52
45,4	11	34	3,5	07:34	19	23	34	32:49	41:45	55:20	28:10
55,8	9	40	4	09:18	21	28	40	40:04	51:13	67:58	34:29
68,3	7,4	48	4	11:23	25	34	48	48:49	62:28	82:58	41:59
DA 560											
13,7	41	12	2	02:17	8	9	12	10:36	13:27	17:34	08:58
17,2	33	15	2	02:52	9	10	15	12:51	16:27	21:49	10:58
21,4	26	19	2,5	03:34	11	12	19	15:43	20:03	26:45	13:22
26,7	21	23	3	04:27	12	14	23	19:31	24:38	32:50	16:27
31,7	17,6	27	3	05:17	14	17	27	23:09	29:11	38:44	19:38
33,2	17	28	3	05:32	15	17	28	24:14	30:33	40:31	20:35
41,2	13,6	35	3,5	06:52	17	21	35	29:54	37:53	50:10	25:35
50,8	11	42	4	08:28	20	25	42	36:34	46:43	61:58	31:29
62,5	9	50	4	10:25	23	31	50	44:45	57:15	76:00	38:30
75,8	7,4	59	4,5	12:38	26	35	59	54:04	69:13	91:58	46:29

Table for PE

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **6100 steel / 5100 steel / HRG 6 / 8000 (from 06.2009)**

1 bar on pressure gauge: **294,5 N** (Effective surface of cylinder: 2954 mm² / 4,57 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%.

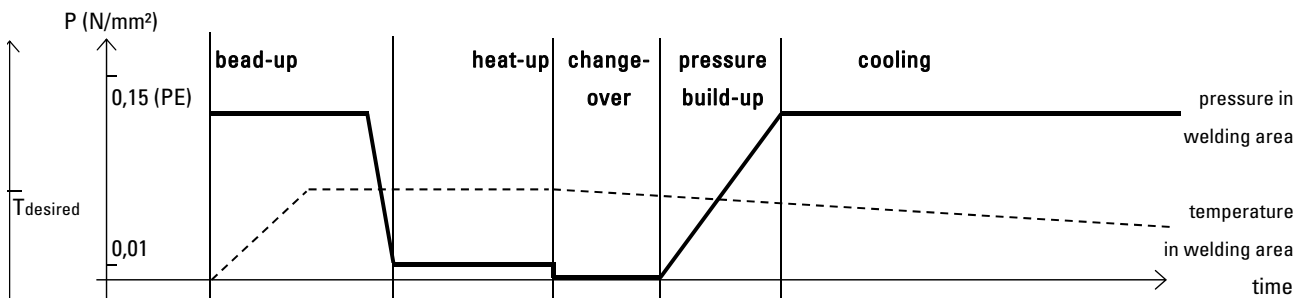
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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 wall (s)	SDR degree	bead-up pressure	circular bead height min.	heat-up time	max. change-over time	pressure build-up time	welding pressure	cooling time for ambient temperature			special cooling time 1
								< 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 630											
15,4	41	16	2	02:34	9	9	16	11:41	14:55	19:38	09:57
19,3	33	19	2,5	03:13	10	11	19	14:13	18:15	24:21	12:10
24,1	26	24	2,5	04:01	11	13	24	17:39	22:22	29:50	14:55
30,0	21	29	3	05:00	13	16	29	21:55	27:38	36:44	18:33
35,7	17,6	34	3	05:57	16	18	34	26:03	32:49	43:28	22:10
37,4	17	36	3,5	06:14	16	19	36	27:17	34:22	45:30	23:15
46,3	13,6	44	3,5	07:43	19	23	44	33:26	42:35	56:27	28:43
57,2	11	53	4	09:32	22	29	53	41:02	52:29	69:38	35:19
70,0	9	63	4,5	11:40	25	35	63	50:00	64:00	85:00	43:00
85,1	7,4	75	4,5	14:11	29	35	75	60:34	77:35	103:07	52:04
DA 710											
17,4	41	20	2	02:54	10	10	20	12:58	16:38	22:03	11:05
21,8	33	25	2,5	03:38	11	12	25	16:00	20:24	27:12	13:36
27,2	26	30	3	04:32	12	15	30	19:52	25:05	33:25	16:46
33,9	21	37	3	05:39	15	18	37	24:45	31:11	41:20	21:02
40,2	17,6	44	3,5	06:42	17	20	44	29:13	36:57	48:56	24:58
42,1	17	45	3,5	07:01	18	21	45	30:32	38:42	51:17	26:08
52,2	13,6	55	4	08:42	21	26	55	37:32	47:59	63:38	32:19
64,5	11	67	4	10:45	24	32	67	46:09	59:03	78:24	39:42

Table for PE

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **6100 steel / 5100 steel / HRG 6 / 8000 (from 06.2009)**

1 bar on pressure gauge: **294,5** N (Effective surface of cylinder: 2954 mm² / 4,57 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%.

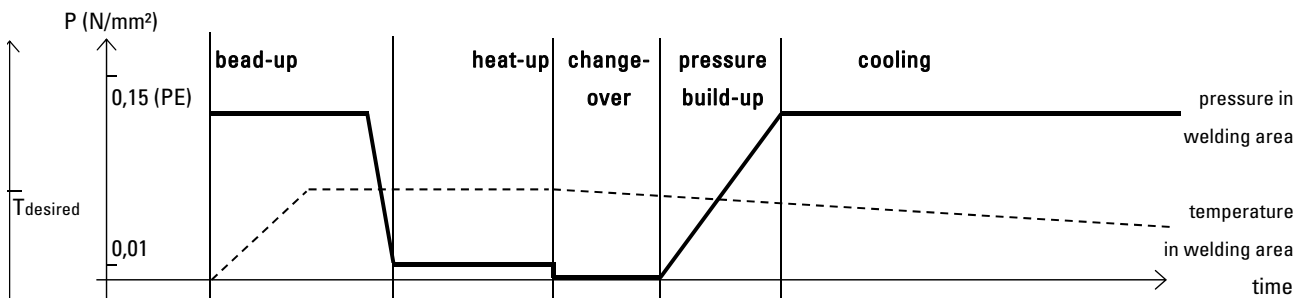
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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 wall (s)	SDR degree	bead-up pressure	circular bead height min.	heat-up time	max. change-over time	pressure build-up time	welding pressure	cooling time for ambient temperature			special cooling time 1
								< 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 800											
19,6	41	25	2,5	03:16	10	11	25	14:26	18:31	24:41	12:21
24,5	33	31	2,5	04:05	12	13	31	17:56	22:43	30:17	15:09
30,6	26	38	3	05:06	14	16	38	22:21	28:11	37:26	18:56
38,1	21	47	3,5	06:21	16	20	47	27:46	35:01	46:21	23:41
45,3	17,6	55	3,5	07:33	19	23	55	32:45	41:40	55:13	28:06
47,4	17	58	3,5	07:54	19	24	58	34:12	43:36	57:48	29:24
58,8	13,6	70	4	09:48	22	29	70	42:10	53:55	71:34	36:17
72,7	11	85	4,5	12:07	26	35	85	51:53	66:26	88:14	44:37
88,9	9	102	4,5	14:49	30	35	102	63:14	81:01	107:41	54:20
108,1	7,4	120	5	18:01	35	35	120	76:40	98:17	130:43	65:52