

Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4400**

1 bar on manometer: **25** N (Effective surface of cylinder: 250 mm² / 0,39 inch²)

The heating element temperature is 210° C ± 10° C / 410° 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%.

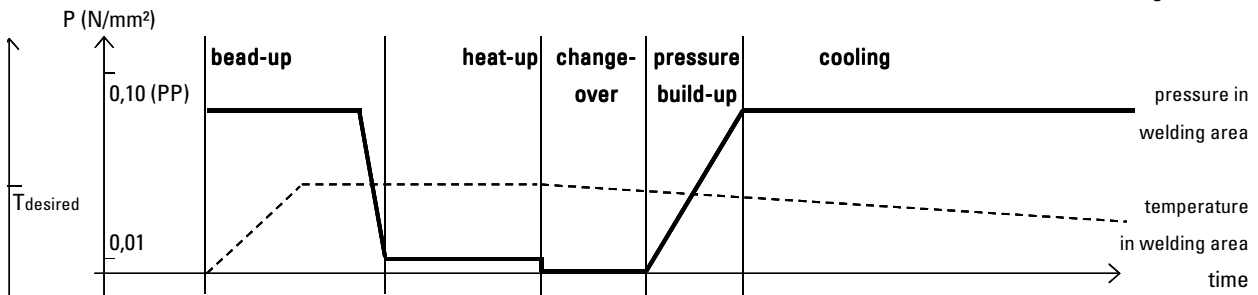
You must add the motion pressure of the welding machine to the indicated bead-up and welding pressure in each case!

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 50											
1,8	33	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
2,0	26	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
2,9	17,6	2	0,5	00:34	5	6	2	04:00	05:00	06:30	03:30
3,0	17	2	0,5	00:35	5	6	2	04:00	05:00	06:30	03:30
4,6	11,0	3	0,5	00:54	5	6	3	04:05	05:06	06:37	03:34
5,6	9	4	0,5	01:05	5	6	4	04:53	06:06	07:49	04:10
6,9	7,4	4	0,5	01:20	6	7	4	05:55	07:24	09:23	04:56
8,3	6	5	1	01:35	6	8	5	06:55	08:40	11:04	05:47
10,1	5	6	1	01:54	7	9	6	08:10	10:17	13:13	06:52
DA 63											
1,8	41	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
2,0	33	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
2,5	26	2	0,5	00:29	5	6	2	04:00	05:00	06:30	03:30
3,6	17,6	3	0,5	00:42	5	6	3	04:00	05:00	06:30	03:30
3,8	17	3	0,5	00:45	5	6	3	04:00	05:00	06:30	03:30
5,8	11	5	0,5	01:08	6	7	5	05:02	06:18	08:04	04:17
7,1	9	5	1	01:22	6	7	5	06:04	07:35	09:37	05:04
8,6	7,4	6	1	01:38	6	8	6	07:07	08:56	11:25	05:58
10,5	6	7	1	01:59	7	10	7	08:27	10:39	13:42	07:06
12,7	5	9	1	02:22	7	12	9	09:57	12:36	16:21	08:24

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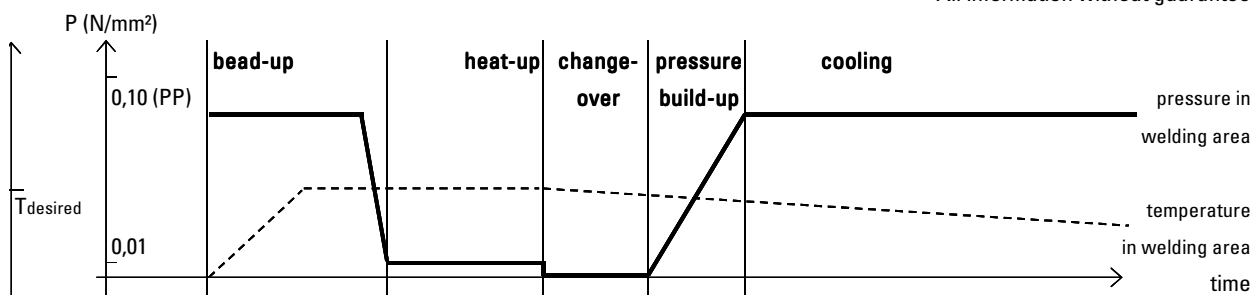
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 75											
1,9	41	2	0,5	00:24	5	6	2	04:00	05:00	06:30	03:30
2,3	33	3	0,5	00:27	5	6	3	04:00	05:00	06:30	03:30
2,9	26	3	0,5	00:34	5	6	3	04:00	05:00	06:30	03:30
4,3	17,6	4	0,5	00:51	5	6	4	04:00	05:00	06:30	03:30
4,5	17	4	0,5	00:53	5	6	4	04:00	05:00	06:30	03:30
6,8	11	6	0,5	01:19	6	7	6	05:50	07:18	09:16	04:53
8,4	9	8	1	01:36	6	8	8	06:59	08:46	11:11	05:50
10,3	7,4	9	1	01:57	7	10	9	08:19	10:28	13:28	06:59
12,5	6	10	1	02:20	7	11	10	09:49	12:26	16:06	08:17
15,1	5	12	1	02:46	8	14	12	11:30	14:39	19:16	09:46
DA 90											
2,2	41	3	0,5	00:26	5	6	3	04:00	05:00	06:30	03:30
2,8	33	4	0,5	00:33	5	6	4	04:00	05:00	06:30	03:30
3,5	26	4	0,5	00:41	5	6	4	04:00	05:00	06:30	03:30
5,1	17,6	6	0,5	01:00	5	6	6	04:29	05:36	07:13	03:52
5,4	17	6	0,5	01:03	5	6	6	04:43	05:54	07:35	04:02
8,2	11	9	1	01:34	6	8	9	06:50	08:35	10:56	05:43
10,1	9	11	1	01:54	7	9	11	08:10	10:17	13:13	06:52
12,3	7,4	13	1	02:18	7	11	13	09:42	12:15	15:52	08:10
15,0	6	15	1	02:45	8	14	15	11:26	14:34	19:09	09:43
18,1	5	17	1	03:17	9	16	17	13:25	17:14	22:54	11:29

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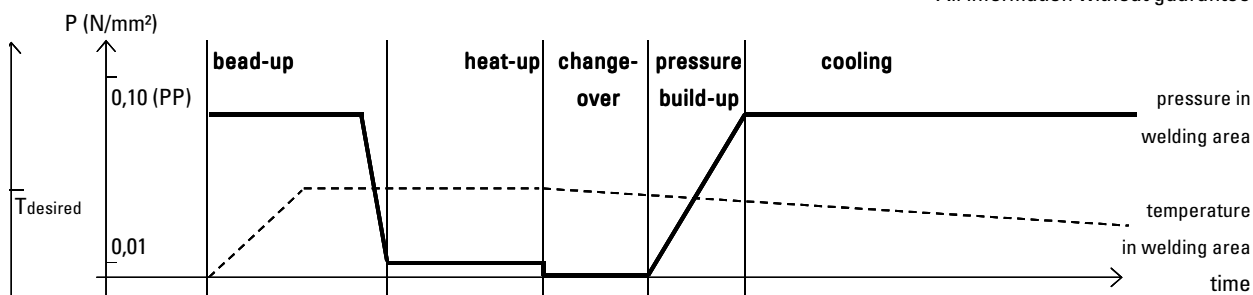
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 110											
2,7	41	4	0,5	00:32	5	6	4	04:00	05:00	06:30	03:30
3,4	33	5	0,5	00:40	5	6	5	04:00	05:00	06:30	03:30
4,2	26	6	0,5	00:49	5	6	6	04:00	05:00	06:30	03:30
6,3	17,6	9	0,5	01:13	6	7	9	05:26	06:48	08:40	04:35
6,6	17	9	0,5	01:17	6	7	9	05:41	07:06	09:01	04:46
10,0	11	13	1	01:53	7	9	13	08:06	10:12	13:06	06:48
12,3	9	16	1	02:18	7	11	16	09:42	12:15	15:52	08:10
15,1	7,4	19	1	02:46	8	14	19	11:30	14:39	19:16	09:46
18,3	6	22	1	03:19	9	16	22	13:33	17:24	23:09	11:36
22,1	5	25	1,5	03:55	10	19	25	16:13	20:39	27:33	13:46
DA 125											
3,1	41	5	0,5	00:37	5	6	5	04:00	05:00	06:30	03:30
3,9	33	6	0,5	00:46	5	6	6	04:00	05:00	06:30	03:30
4,8	26	8	0,5	00:56	5	6	8	04:14	05:18	06:52	03:41
7,1	17,6	11	1	01:22	6	7	11	06:04	07:35	09:37	05:04
7,4	17	11	1	01:25	6	7	11	06:17	07:52	09:59	05:14
11,4	11	17	1	02:09	7	11	17	09:05	11:28	14:47	07:38
14,0	9	20	1	02:35	8	13	20	10:47	13:43	17:56	09:09
17,1	7,4	24	1	03:07	8	15	24	12:47	16:22	21:42	10:55
20,8	6	28	1,5	03:43	10	18	28	15:17	19:33	26:03	13:02
25,1	5	32	1,5	04:23	11	21	32	18:21	23:14	30:58	15:29

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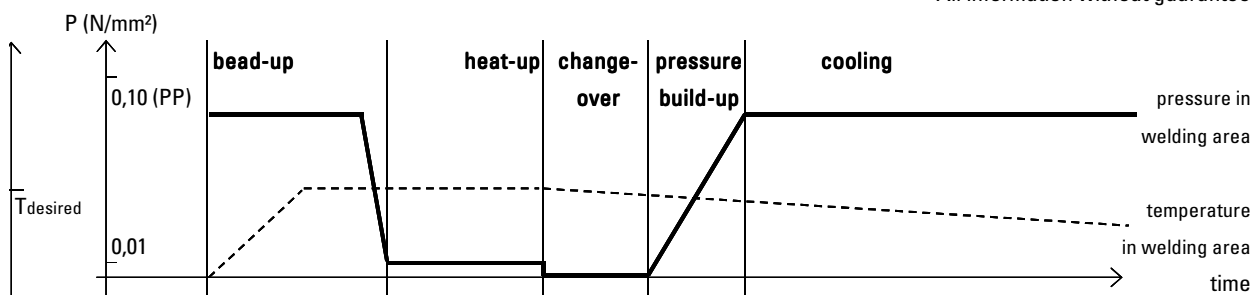
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 140											
3,5	41	7	0,5	00:41	5	6	7	04:00	05:00	06:30	03:30
4,3	33	8	0,5	00:51	5	6	8	04:00	05:00	06:30	03:30
5,4	26	10	0,5	01:03	5	6	10	04:43	05:54	07:35	04:02
8,0	17,6	14	1	01:32	6	8	14	06:42	08:24	10:42	05:36
8,3	17	14	1	01:35	6	8	14	06:55	08:40	11:04	05:47
12,7	11	21	1	02:22	7	12	21	09:57	12:36	16:21	08:24
15,7	9	25	1	02:53	8	14	25	11:53	15:10	20:00	10:07
19,2	7,4	30	1,5	03:28	9	17	30	14:09	18:10	24:14	12:07
23,3	6	35	1,5	04:06	10	20	35	17:04	21:41	28:55	14:27
28,1	5	40	2	04:48	12	24	40	20:32	25:55	34:29	17:20
DA 160											
4,0	41	8	0,5	00:47	5	6	8	04:00	05:00	06:30	03:30
4,9	33	10	0,5	00:57	5	6	10	04:19	05:24	06:59	03:44
6,2	26	12	0,5	01:12	6	7	12	05:22	06:42	08:32	04:31
9,1	17,6	18	1	01:44	6	9	18	07:28	09:23	12:01	06:16
9,5	17	18	1	01:48	6	9	18	07:45	09:45	12:30	06:30
14,6	11	27	1	02:41	8	13	27	11:10	14:14	18:39	09:29
17,9	9	32	1	03:15	9	16	32	13:18	17:03	22:40	11:22
21,9	7,4	39	1,5	03:53	10	19	39	16:04	20:29	27:19	13:39
26,6	6	45	2	04:36	11	23	45	19:26	24:33	32:43	16:23
32,1	5	52	2	05:21	13	28	52	23:26	29:33	39:13	19:53