

Table for PE

Basis: DVS data sheets 2207, 2208 - State 2016

Field of application: **4900 / 4911 / 4955 / 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%.

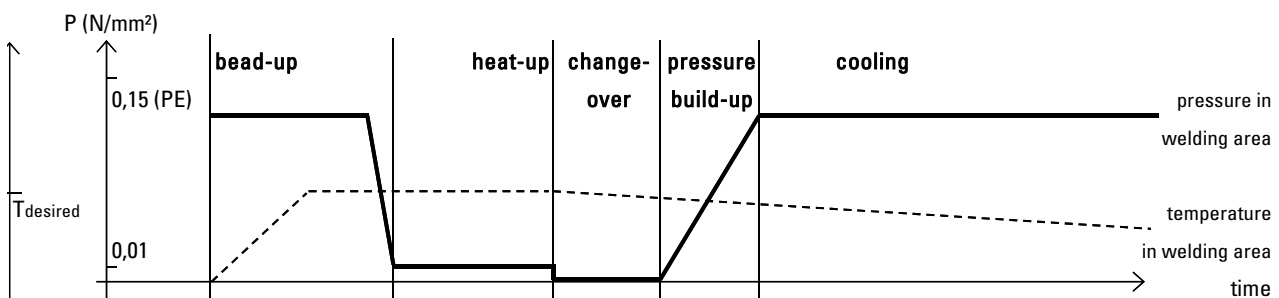
You must add the motion pressure of the welding machine to the indicated bead-up and cooling pressure in each case!

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

1 These cooling times are only valid under the following conditions:

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- 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 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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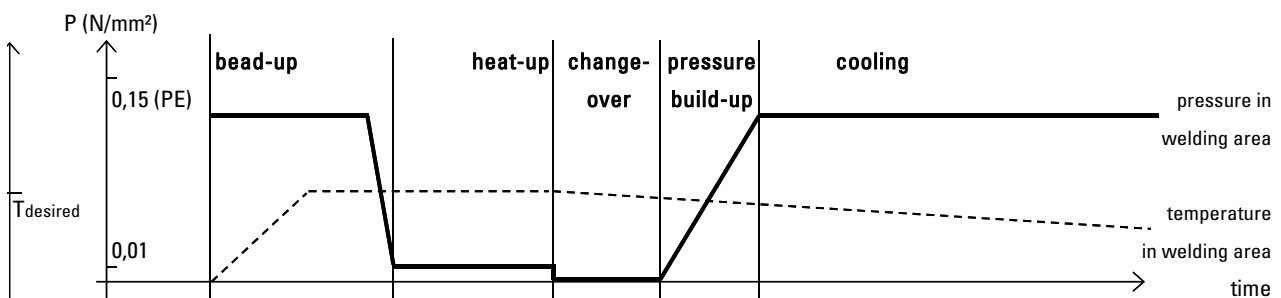
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 125											
3,1	41	4	0,5	00:31	5	5	4	04:00	05:00	06:30	03:30
3,9	33	4	0,5	00:39	5	5	4	04:00	05:00	06:30	03:30
4,8	26	5	1	00:48	5	5	5	04:14	05:18	06:52	03:41
6,0	21	6	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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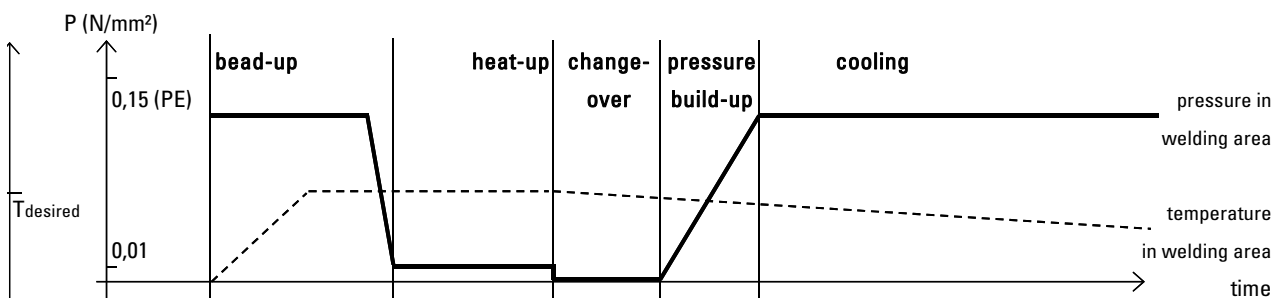
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 160											
4,0	41	5	0,5	00:40	5	5	5	04:00	05:00	06:30	03:30
4,9	33	7	1	00:49	5	5	7	04:19	05:24	06:59	03:44
6,2	26	8	1	01:02	6	6	8	05:22	06:42	08:32	04:31
7,7	21	10	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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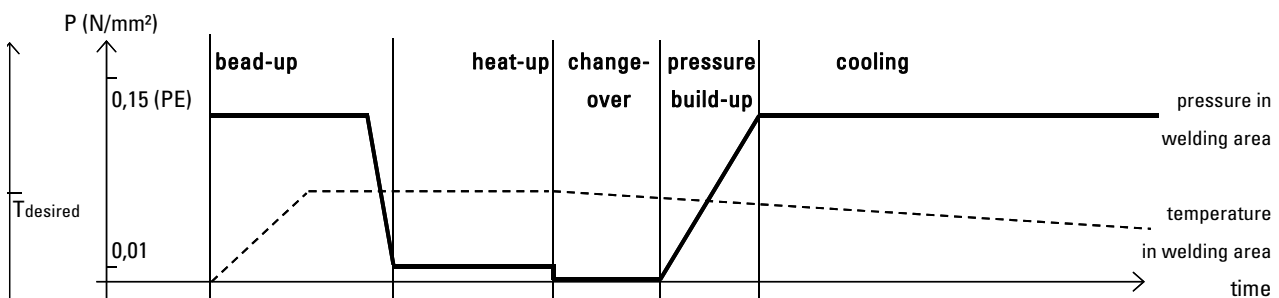
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 200											
4,9	41	8	1	00:49	5	5	8	04:19	05:24	06:59	03:44
6,2	33	10	1	01:02	6	6	10	05:22	06:42	08:32	04:31
7,7	26	12	1,5	01:17	6	6	12	06:29	08:08	10:20	05:25
9,6	21	15	1,5	01:36	7	7	15	07:49	09:50	12:37	06:34
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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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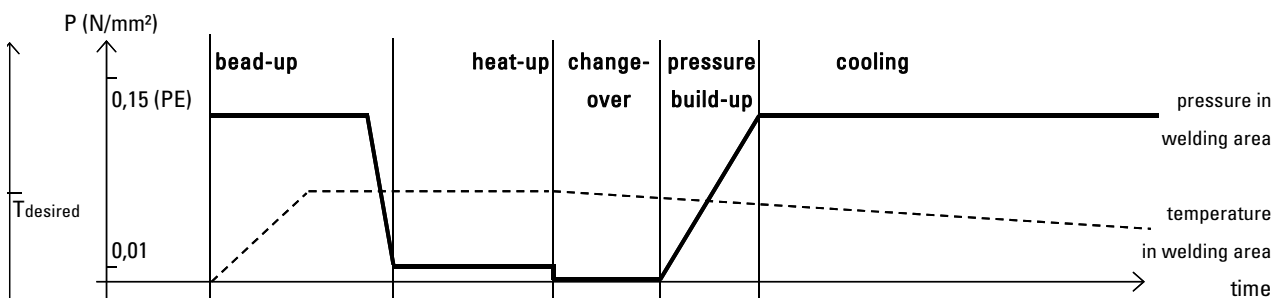
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 250											
6,2	41	13	1	01:02	6	6	13	05:22	06:42	08:32	04:31
7,7	33	15	1,5	01:17	6	6	15	06:29	08:08	10:20	05:25
9,6	26	19	1,5	01:36	7	7	19	07:49	09:50	12:37	06:34
11,9	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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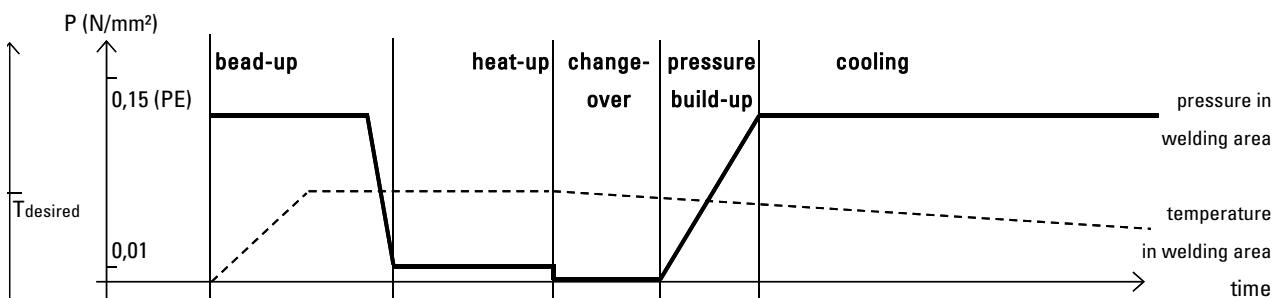
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 315											
7,7	41	19	1,5	01:17	6	6	19	06:29	08:08	10:20	05:25
9,7	33	24	1,5	01:37	7	7	24	07:53	09:56	12:44	06:37
12,1	26	30	2	02:01	8	8	30	09:34	12:05	15:37	08:03
15,0	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