

Table for PE

Heating up time = 10 x wall thickness [sec]

Cooling down time under joining pressure = 1,333 * wall thickness [min]

PE 80 The standard value for the heating element temperature is between 200° C - 220° C.
For **smaller** wall thickness higher temperatures should be realized.

PE 100 The standard value for the heating element temperature is 220° C.
The change-over and pressure building up time should be realized with PE 100 as fast as possible!

1 kp = 23 N; For the given adjusting and welding pressure the movement pressure of the welding slide has to be added!

Tickness	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Bead height	0,5	0,5	0,5	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5	2	2	2	2	2	2	2	2
Lenght	Joining pressure [bar]																			
100	1	2	2	3	4	4	5	6	6	7	8	8	9	10	10	11	12	12	13	14
120	1	2	3	4	4	5	6	7	8	8	9	10	11	11	12	13	14	15	15	16
140	1	2	3	4	5	6	7	8	9	10	11	11	12	13	14	15	16	17	18	19
160	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21
180	2	3	4	5	6	8	9	10	11	12	13	15	16	17	18	19	20	22	23	24
200	2	3	4	6	7	8	10	11	12	14	15	16	17	19	20	21	23	24	25	27
220	2	3	5	6	8	9	11	12	13	15	16	18	19	21	22	23	25	26	28	29
240	2	4	5	7	8	10	11	13	15	16	18	19	21	22	24	26	27	29	30	32
260	2	4	6	7	9	11	12	14	16	17	19	21	23	24	26	28	29	31	33	34
280	2	4	6	8	10	11	13	15	17	19	21	22	24	26	28	30	32	33	35	37
300	2	4	6	8	10	12	14	16	18	20	22	24	26	28	30	32	34	36	38	40
320	3	5	7	9	11	13	15	17	19	21	23	26	28	30	32	34	36	38	40	42
340	3	5	7	9	12	14	16	18	20	23	25	27	29	32	34	36	38	40	43	45
360	3	5	8	10	12	15	17	19	22	24	26	29	31	33	36	38	40	43	45	47
380	3	5	8	10	13	15	18	20	23	25	28	30	33	35	38	40	43	45	48	50
400	3	6	8	11	14	16	19	21	24	27	29	32	34	37	40	42	45	47	50	53

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1 kp = 23 N; For the given adjusting and welding pressure the movement pressure of the welding slide has to be added!

Tickness	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Bead height	0,5	0,5	0,5	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5	2	2	2	2	2	2	2	2
Lenght	Joining pressure [bar]																			
420	3	6	9	11	14	17	20	22	25	28	31	33	36	39	42	44	47	50	53	55
440	3	6	9	12	15	18	21	23	26	29	32	35	38	41	44	46	49	52	55	58
460	4	7	10	13	16	19	22	25	28	31	34	37	40	43	46	49	52	55	58	61
480	4	7	10	13	16	19	22	26	29	32	35	38	41	44	47	51	54	57	60	63
500	4	7	10	14	17	20	23	27	30	33	36	40	43	46	49	53	56	59	62	66
520	4	7	11	14	17	21	24	28	31	34	38	41	45	48	51	55	58	62	65	68
540	4	8	11	15	18	22	25	29	32	36	39	43	46	50	53	57	60	64	67	71
560	4	8	11	15	19	22	26	30	33	37	41	44	48	52	55	59	63	66	70	74
580	4	8	12	16	19	23	27	31	35	38	42	46	50	53	57	61	65	69	72	76
600	4	8	12	16	20	24	28	32	36	40	44	47	51	55	59	63	67	71	75	79
620	5	9	13	17	21	25	29	33	37	41	45	49	53	57	61	65	69	73	77	81
640	5	9	13	17	21	26	30	34	38	42	46	51	55	59	63	67	71	76	80	84
660	5	9	13	18	22	26	31	35	39	44	48	52	56	61	65	69	74	78	82	87
680	5	9	14	18	23	27	32	36	40	45	49	54	58	63	67	71	76	80	85	89
700	5	10	14	19	23	28	32	37	42	46	51	55	60	64	69	74	78	83	87	92
720	5	10	15	19	24	29	33	38	43	47	52	57	62	66	71	76	80	85	90	94
740	5	10	15	20	25	29	34	39	44	49	54	58	63	68	73	78	83	87	92	97

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Tickness	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
Bead height	0,5	0,5	0,5	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5	2	2	2	2	2	2	2	2
Lenght	Joining pressure [bar]																			
760	5	10	15	20	25	30	35	40	45	50	55	60	65	70	75	80	85	90	95	100
780	6	11	16	21	26	31	36	41	46	51	56	62	67	72	77	82	87	92	97	102
800	6	11	16	21	27	32	37	42	47	53	58	63	68	74	79	84	89	94	100	105
820	6	11	17	22	27	33	38	43	49	54	59	65	70	75	81	86	91	97	102	107
840	6	11	17	22	28	33	39	44	50	55	61	66	72	77	83	88	94	99	105	110
860	6	12	17	23	29	34	40	45	51	57	62	68	73	79	85	90	96	101	107	113
880	6	12	18	23	29	35	41	46	52	58	64	69	75	81	87	92	98	104	110	115
900	6	12	18	24	30	36	42	47	53	59	65	71	77	83	89	94	100	106	112	118
920	7	13	19	25	31	37	43	49	55	61	67	73	79	85	91	97	103	109	115	121
940	7	13	19	25	31	37	43	50	56	62	68	74	80	86	92	99	105	111	117	123
960	7	13	19	26	32	38	44	51	57	63	69	76	82	88	94	101	107	113	119	126
980	7	13	20	26	32	39	45	52	58	64	71	77	84	90	96	103	109	116	122	128
1000	7	14	20	27	33	40	46	53	59	66	72	79	85	92	98	105	111	118	124	131
1020	7	14	20	27	34	40	47	54	60	67	74	80	87	94	100	107	114	120	127	134
1040	7	14	21	28	34	41	48	55	62	68	75	82	89	95	102	109	116	123	129	136
1060	7	14	21	28	35	42	49	56	63	70	77	83	90	97	104	111	118	125	132	139
1080	8	15	22	29	36	43	50	57	64	71	78	85	92	99	106	113	120	127	134	141

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Bead height	0,5	0,5	0,5	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5	2	2	2	2	2	2	2	2
Lenght	Joining pressure [bar]																			
1100	8	15	22	29	36	44	51	58	65	72	79	87	94	101	108	115	122	130	137	144
1120	8	15	22	30	37	44	52	59	66	74	81	88	95	103	110	117	125	132	139	147
1140	8	15	23	30	38	45	53	60	67	75	82	90	97	105	112	119	127	134	142	149
1160	8	16	23	31	38	46	53	61	69	76	84	91	99	106	114	122	129	137	144	152
1180	8	16	24	31	39	47	54	62	70	77	85	93	101	108	116	124	131	139	147	154
1200	8	16	24	32	40	47	55	63	71	79	87	94	102	110	118	126	134	141	149	157
1220	8	16	24	32	40	48	56	64	72	80	88	96	104	112	120	128	136	144	152	160
1240	9	17	25	33	41	49	57	65	73	81	89	98	106	114	122	130	138	146	154	162
1260	9	17	25	33	42	50	58	66	74	83	91	99	107	116	124	132	140	148	157	165
1280	9	17	26	34	42	51	59	67	76	84	92	101	109	117	126	134	142	151	159	167
1300	9	17	26	34	43	51	60	68	77	85	94	102	111	119	128	136	145	153	162	170
1320	9	18	26	35	44	52	61	69	78	87	95	104	112	121	130	138	147	155	164	173
1340	9	18	27	35	44	53	62	70	79	88	97	105	114	123	132	140	149	158	167	175
1360	9	18	27	36	45	54	63	71	80	89	98	107	116	125	134	142	151	160	169	178
1380	10	19	28	37	46	55	64	73	82	91	100	109	118	127	136	145	154	163	172	181
1400	10	19	28	37	46	55	64	74	83	92	101	110	119	128	137	147	156	165	174	183
1420	10	19	28	38	47	56	65	75	84	93	102	112	121	130	139	149	158	167	176	186

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Bead height	0,5	0,5	0,5	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5	2	2	2	2	2	2	2	2
Lenght	Joining pressure [bar]																			
1440	10	19	29	38	47	57	66	76	85	94	104	113	123	132	141	151	160	170	179	188
1460	10	20	29	39	48	58	67	77	86	96	105	115	124	134	143	153	162	172	181	191
1480	10	20	29	39	49	58	68	78	87	97	107	116	126	136	145	155	165	174	184	194
1500	10	20	30	40	49	59	69	79	89	98	108	118	128	137	147	157	167	177	186	196
1520	10	20	30	40	50	60	70	80	90	100	110	119	129	139	149	159	169	179	189	199
1540	11	21	31	41	51	61	71	81	91	101	111	121	131	141	151	161	171	181	191	201
1560	11	21	31	41	51	62	72	82	92	102	112	123	133	143	153	163	173	184	194	204
1580	11	21	31	42	52	62	73	83	93	104	114	124	134	145	155	165	176	186	196	207
1600	11	21	32	42	53	63	74	84	94	105	115	126	136	147	157	167	178	188	199	209
1620	11	22	32	43	53	64	74	85	96	106	117	127	138	148	159	170	180	191	201	212
1640	11	22	33	43	54	65	75	86	97	107	118	129	140	150	161	172	182	193	204	214
1660	11	22	33	44	55	65	76	87	98	109	120	130	141	152	163	174	185	195	206	217
1680	11	22	33	44	55	66	77	88	99	110	121	132	143	154	165	176	187	198	209	220
1700	12	23	34	45	56	67	78	89	100	111	122	134	145	156	167	178	189	200	211	222
1720	12	23	34	45	57	68	79	90	101	113	124	135	146	158	169	180	191	202	214	225

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Bead height	0,5	0,5	0,5	1	1	1	1,5	1,5	1,5	1,5	1,5	1,5	2	2	2	2	2	2	2	2
Lenght	Joining pressure [bar]																			
1740	12	23	35	46	57	69	80	91	103	114	125	137	148	159	171	182	193	205	216	227
1760	12	23	35	46	58	69	81	92	104	115	127	138	150	161	173	184	196	207	219	230
1780	12	24	35	47	59	70	82	93	105	117	128	140	151	163	175	186	198	209	221	233
1800	12	24	36	47	59	71	83	94	106	118	130	141	153	165	177	188	200	212	224	235
1820	12	24	36	48	60	72	84	95	107	119	131	143	155	167	179	190	202	214	226	238
1840	13	25	37	49	61	73	85	97	109	121	133	145	157	169	181	193	205	217	229	241
1860	13	25	37	49	61	73	85	98	110	122	134	146	158	170	182	195	207	219	231	243
1880	13	25	37	50	62	74	86	99	111	123	135	148	160	172	184	197	209	221	233	246
1900	13	25	38	50	62	75	87	100	112	124	137	149	162	174	186	199	211	224	236	248
1920	13	26	38	51	63	76	88	101	113	126	138	151	163	176	188	201	213	226	238	251
1940	13	26	38	51	64	76	89	102	114	127	140	152	165	178	190	203	216	228	241	254
1960	13	26	39	52	64	77	90	103	116	128	141	154	167	179	192	205	218	231	243	256
1980	13	26	39	52	65	78	91	104	117	130	143	155	168	181	194	207	220	233	246	259
2000	14	27	40	53	66	79	92	105	118	131	144	157	170	183	196	209	222	235	248	261