

# Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding  
 Use for: WIDOS 24000 DA 1600 mm - 2400 mm

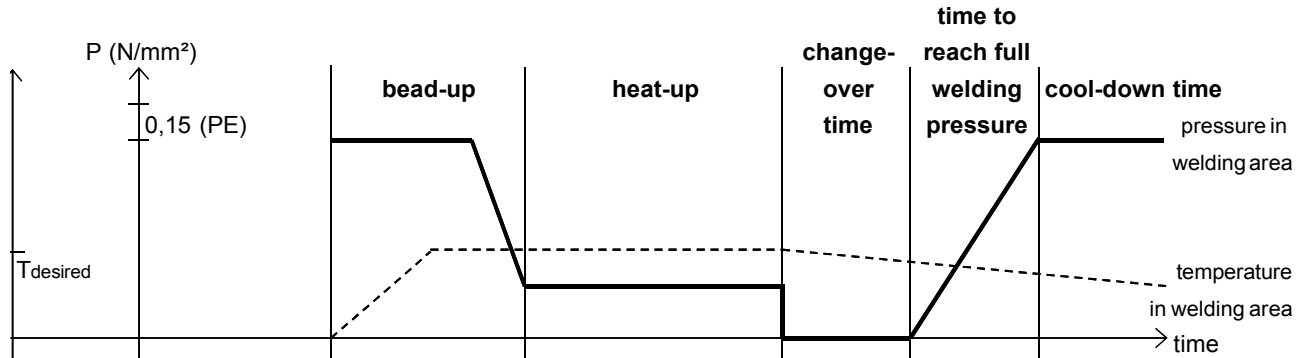
The data in the colored, labeled arrays are interpolated, no guarantee, based on DVS 2207 part 1

1 bar on manometer: **2010 N** with **4 welding cylinders (option)**

**PE 80** The value for heating element temperature is between 200° C - 220° C.  
 The **smaller** the pipe wall the **higher** the temperature.

**PE 100** The standard value for heating element temperature is 220° C.  
 Increase the change-over time and the welding pressure time at PE 100 as fast as possible !

Additional to the given bead-up force and to the welding force the moving force of the support must be added !



pipe diameter OD	pipe wall (s) [mm] ②	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] ①
1600	39,2	41	15	3,5	392	17	20	15	48
	49,0	33	18	3,5	490	20	25	18	59
	61,2	26	23	4,0	612	23	31	23	71
	90,9	17,6	33	4,5	909	26	35	33	101
	94,1	17	34	5,0	941	25	35	34	104
	145,5	11	50	6,0	1455	25	35	50	156
1800	43,9	41	19	3,5	439	18	22	19	53
	54,6	33	23	4,0	546	21	27	23	65
	69,2	26	29	4,0	692	25	35	29	79
	102,3	17,6	41	5,0	1023	25	35	41	112
	105,9	17	43	5,0	1059	25	35	43	116
	163,6	11	63	7,0	1636	25	35	63	175
2000	48,8	41	23	3,5	488	20	24	23	59
	66,6	33	31	4,0	666	24	33	31	77
	76,9	26	35	4,5	769	25	35	35	87
	113,6	17,6	51	5,0	1136	25	35	51	124
	117,6	17	52	5,0	1176	25	35	52	128
	181,8	11	78	7,0	1818	25	35	78	182
2200	53,7	41	28	4,0	537	21	27	28	64
	66,7	33	34	4,0	667	24	33	34	77
	84,6	26	42	4,5	846	25	35	42	95
	125,0	17,6	61	6,0	1250	25	35	61	135
	129,4	17	63	6,0	1294	25	35	63	139
	200,0	11	94	8,0	2000	25	35	94	200

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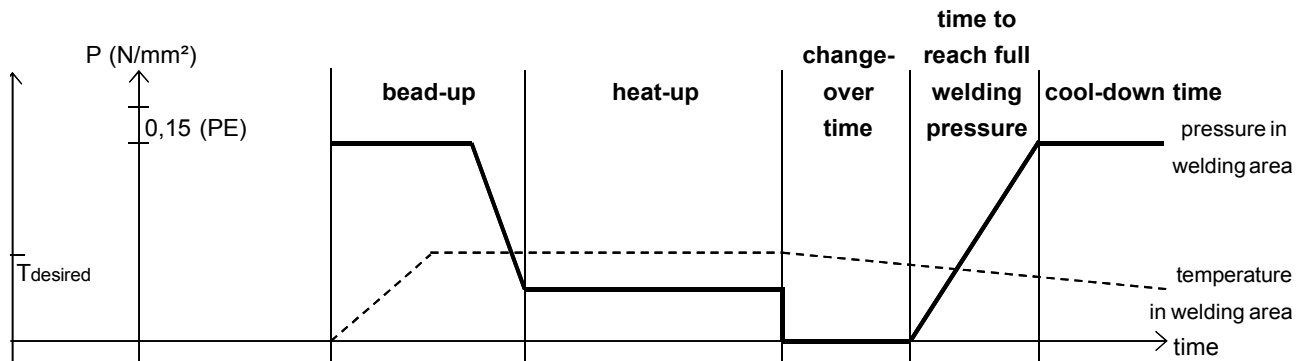
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2250	68,9	33	36	4,0	689	25	34	36	79
	75,0	30	39	4,5	750	25	35	39	85
	86,0	26	44	4,5	860	25	35	44	96
	107,2	21	54	5,0	1072	25	35	54	117
	133,2	17	67	6,0	1332	25	35	67	143
2400	58,8	41	33	4,0	588	22	29	33	69
	72,7	33	40	4,5	727	25	35	40	83
	92,3	26	50	4,5	923	26	35	50	102
	136,4	17,6	73	6,0	1364	25	35	73	146
	141,2	17	75	6,0	1412	25	35	75	152
	218,2	11	112	8,0	2182	25	35	112	218

**①** Remaining under the cool-down time for up to 50% is allowed under the following conditions:

- prefabrication under workshop conditions
- low additional pressure at unclamping
- no additional pressure during further cooling down
- load onto the workpieces only after being completely cooled down
- Join parts with wall thickness  $\geq 15$  mm