

Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding
 Use for: **8000** DA 450 - 800 (valid from 2000-07 to 2009-05)
10000 DA 500 - 1000 (valid from 2000-07)
12000 DA 800 - 1200 (valid from 2000-07)

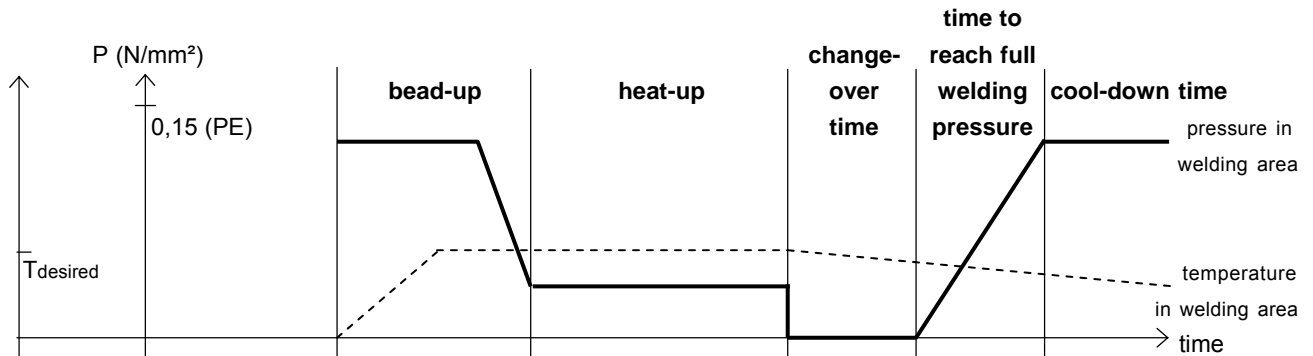
The data in the colored, labeled arrays are interpolated, no guarantee, based on DVS 2207 part 1

1 bar on manometer: **463 N**

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 [mm]	pipe wall (s) [mm]	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
450	11,0	41	5	1,5	110	8	8	5	15
	13,8	33	7	2,0	138	9	9	7	18
	17,2	26	8	2,0	172	9	10	8	22
	21,5	21,0	10	2,5	215	11	12	10	27
	25,5	17,6	12	2,5	255	12	14	12	31
	26,7	17	12	3,0	267	12	14	12	33
	33,1	13,6	15	3,0	331	15	17	15	40
	40,9	11	18	3,5	409	17	21	18	49
	50,3	9,0	21	4,0	503	20	25	21	60
61,5	7,4	25	4,0	615	23	31	25	71	
500	12,3	41	7	2,0	123	8	8	7	16
	15,3	33	8	2,0	153	9	9	8	20
	19,1	26	10	2,5	191	10	11	10	24
	23,9	21,0	12	2,5	239	11	13	12	30
	28,4	17,6	14	3,0	284	13	15	14	35
	29,7	17	15	3,0	297	13	16	15	36
	36,8	13,6	18	3,0	369	16	19	18	45
	45,4	11	22	3,5	454	19	23	22	55
	56	9	26	4,0	560	21	28	26	66
68,3	7,4	31	4,0	683	25	34	31	78	

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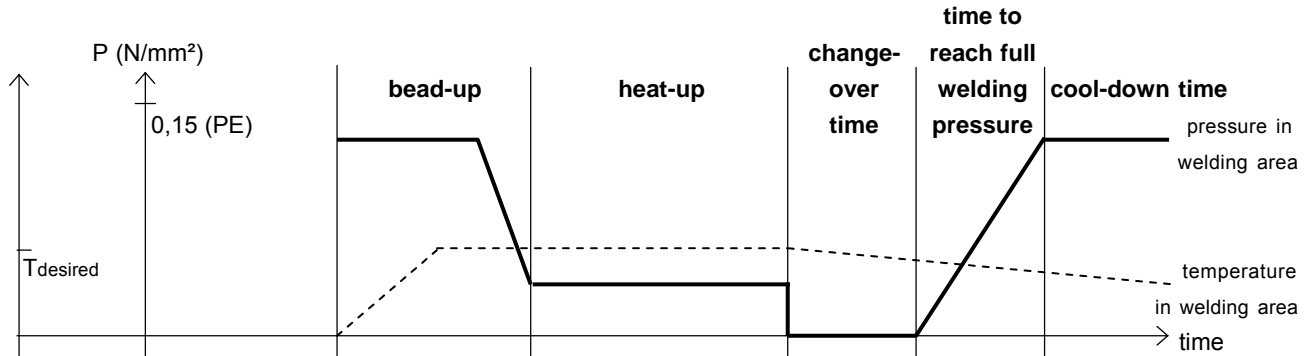
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560	13,7	41	8	2,0	137	8	9	8	18
	17,2	33	10	2,0	172	9	10	10	22
	21,4	26	12	2,5	214	11	12	12	27
	26,7	21	15	3,0	267	12	14	15	33
	31,7	17,6	18	3,0	317	14	17	18	39
	33,2	17	18	3,0	332	15	17	18	41
	41,2	13,6	22	3,5	412	17	21	22	50
	50,8	11	27	4,0	508	20	25	27	61
62,5	9	32	4,0	625	23	31	32	72	
630	15,4	41	10	2,0	154	9	9	10	20
	19,3	33	12	2,5	193	10	11	12	24
	24,1	26	15	2,5	241	11	13	15	30
	30,0	21	19	3,0	300	16	16	19	37
	35,7	17,6	22	3,0	357	16	18	22	43
	37,4	17	23	3,5	374	16	19	23	45
	46,3	13,6	28	3,5	463	19	19	28	56
	57,2	11	34	4,0	572	22	29	34	67
62,5	9	32	4,0	625	23	31	32	72	

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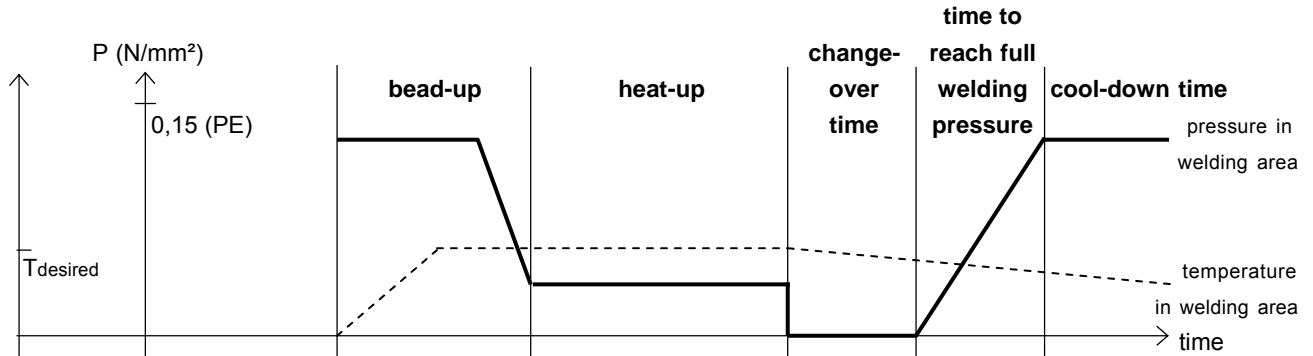
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710	17,4	41	13	2,0	174	10	10	13	22
	21,8	33	16	2,5	218	11	12	16	27
	27,2	26	19	3,0	272	12	15	19	33
	33,9	21	24	3,0	339	15	18	24	41
	40,2	17,6	28	3,5	402	17	20	28	49
	42,1	17	29	3,5	421	18	21	29	51
	52,2	13,6	35	4,0	522	21	26	35	62
800	64,5	11	43	4,0	645	24	32	43	74
	19,6	41	16	2,0	145	9	9	16	19
	24,5	33	20	2,5	245	12	13	20	30
	30,6	26	24	3,0	306	14	16	24	37
	38,1	21	30	3,5	381	16	20	30	46
	45,3	17,6	35	3,5	453	19	23	35	55
800	47,4	17	37	3,5	474	19	24	37	57
800	72,7	11	54	4,5	727	25	35	54	83
900	22,0	41	20	2,5	220	11	12	20	27
	27,6	33	25	3,0	276	13	15	25	34
	34,4	26	31	3,0	344	15	18	31	42
	42,9	21	38	3,5	429	18	22	38	52
	51,0	17,6	45	4,0	510	20	26	45	61
	53,3	17	46	4,0	533	21	27	46	63
900	81,8	11	69	4,5	818	28	41	69	91

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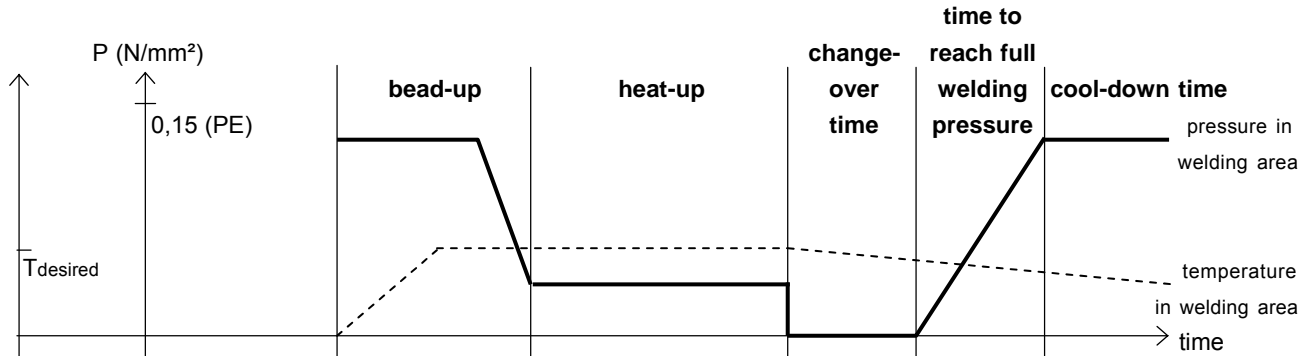
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1000	24,5	41	25	2,5	245	12	13	25	30
	30,6	33	31	3,0	306	14	16	31	37
	38,2	26	38	3,5	382	16	20	38	46
	47,7	21	47	3,5	426	18	22	47	51
	56,7	17,6	55	4,0	567	22	28	55	67
	59,3	17	57	4,0	593	22	30	57	69
1200	29,4	41	36	3,0	294	13	16	36	36
	36,7	33	44	3,0	367	16	19	44	45
	45,9	26	54	3,5	459	19	23	54	55
	57,2	21	67	4,0	572	22	29	67	67
	68,0	17,6	79	4,0	680	24	34	79	78

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 ≥ 15 mm