

# Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding  
 Use for: **8000 WM**

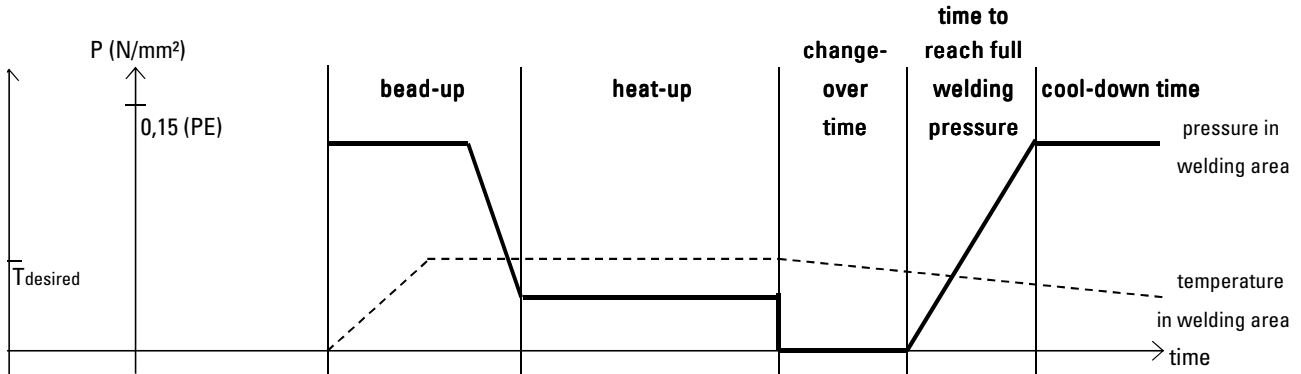
The data in the colored, labeled arrays are interpolated, no guarantee, based on DVS 2207 part 1

1 bar on manometer: **232 N**

**PE 80** The value for heating element temperature is between 200 °C - 220 °C (392 °F - 428 °F).  
 The **smaller** the pipe wall the **higher** the temperature.

**PE 100** The standard value for heating element temperature is 220 °C (428 °F).  
 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
<b>500</b>	12,3	41	13	2,0	123	8	8	13	16
	15,3	33	16	2,0	153	9	9	16	20
	19,1	26	19	2,5	191	10	11	19	24
	23,9	21	24	2,5	239	11	13	24	30
	28,4	17,6	28	3,0	284	13	15	28	35
	29,7	17	29	3,0	297	13	16	29	36
	45,4	11	42	3,5	454	19	23	42	55
	68,3	7,4	60	4,0	683	25	34	60	78
<b>560</b>	13,7	41	16	2,0	137	8	9	16	18
	17,2	33	19	2,0	172	9	10	19	22
	21,4	26	24	2,5	214	11	12	24	27
	26,7	21	29	3,0	267	12	14	29	33
	31,7	17,6	35	3,0	317	14	17	35	39
	33,2	17	36	3,0	332	15	17	36	41
	50,8	11	53	4,0	508	20	25	53	61
<b>630</b>	15,4	41	20	2,0	154	9	9	20	20
	19,3	33	24	2,5	193	10	11	24	24
	24,1	26	30	2,5	241	11	13	30	30
	30,0	21	37	3,0	300	13	16	37	37
	35,7	17,6	44	3,0	357	16	18	44	43
	37,4	17	46	3,5	374	16	19	46	45
	57,2	11	67	4,0	572	22	29	67	67

# Table for PE



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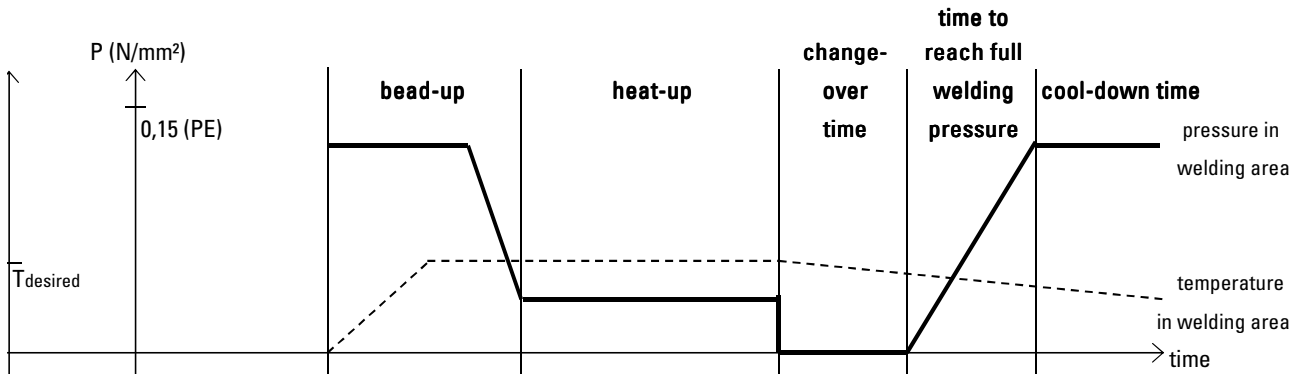
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 Increase the change-over time and the welding pressure time at PE 100 as fast as possible !

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<b>710</b>	17,4	41	25	2,0	174	10	10	25	22
	21,8	33	31	2,5	218	11	12	31	27
	27,2	26	38	3,0	272	12	15	38	33
	33,9	21	47	3,0	339	15	18	47	41
	40,2	17,6	55	3,5	402	17	20	55	49
	42,1	17	58	3,5	421	18	21	58	51
	64,5	11	85	4,0	645	24	32	85	74
<b>800</b>	19,6	41	32	2,5	196	10	11	32	25
	24,5	33	39	2,5	245	12	13	39	30
	30,6	26	48	3,0	306	14	16	48	37
	38,1	21	59	3,5	381	16	20	59	46
	45,3	17,6	70	3,5	453	19	23	70	55
	47,4	17	73	3,5	474	19	24	73	57
<b>800</b>	<b>72,7</b>	<b>11</b>	<b>108</b>	<b>4,5</b>	<b>727</b>	<b>25</b>	<b>35</b>	<b>108</b>	<b>83</b>
<b>900</b>	22,0	41	40	2,5	220	11	12	40	27
	27,6	33	49	3,0	276	13	15	49	34
	34,4	26	61	3,0	344	15	18	61	42
	42,9	21	75	3,5	429	18	22	75	52
	51,0	17,6	88	4,0	510	20	26	88	61
	53,3	17	92	4,0	533	21	27	92	63
<b>900</b>	<b>81,8</b>	<b>11</b>	<b>136</b>	<b>4,5</b>	<b>818</b>	<b>28</b>	<b>41</b>	<b>136</b>	<b>91</b>

# Table for PE



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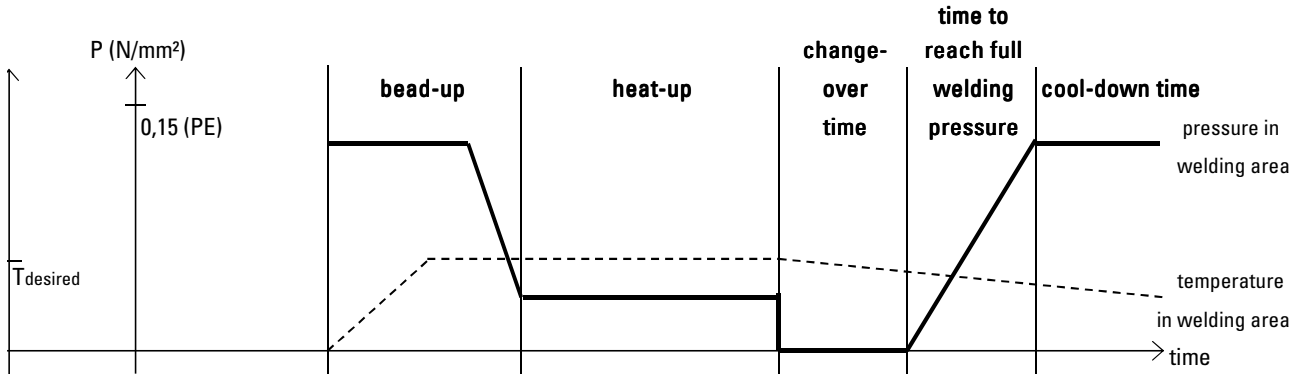
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<b>1000</b>	24,5	41	49	2,5	245	12	13	49	30
	30,6	33	61	3,0	306	14	16	61	37
	38,2	26	75	3,5	382	16	20	75	46
	47,7	21	93	3,5	477	19	24	93	57
	56,7	17,6	109	4,0	567	22	28	109	67
	59,3	17	114	4,0	593	22	30	114	69
<b>1200</b>	29,4	41	70	3,0	294	13	16	70	36
	36,7	33	87	3,0	367	16	19	87	45
	45,9	26	108	3,5	459	19	23	108	55
	57,2	21	133	4,0	572	22	29	133	67
	68,0	17,6	157	4,0	680	24	34	157	78
<b>1200</b>	<b>70,6</b>	<b>17</b>	<b>162</b>	<b>4,5</b>	<b>706</b>	<b>25</b>	<b>35</b>	<b>162</b>	<b>80</b>

**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