

## Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **4600 / 4502** OD 75 - 250

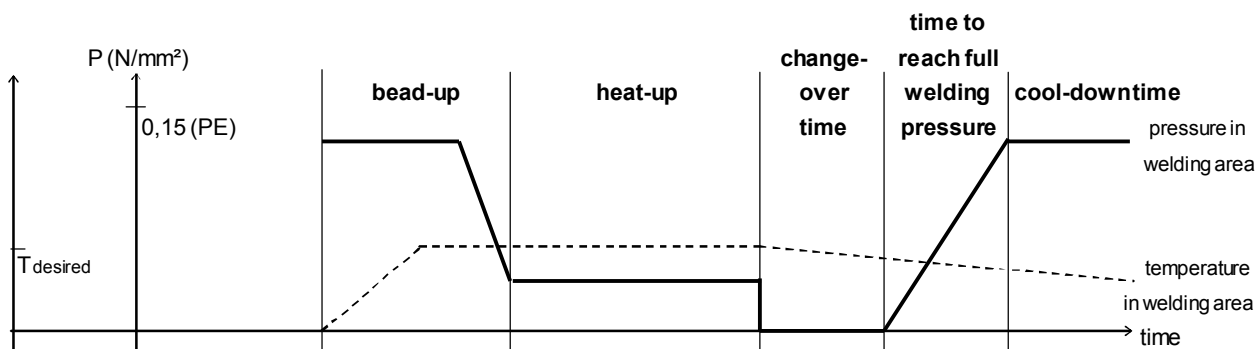
**4800 / 4702 / 12"** OD 90 - 315

1 bar on manometer: **52 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] <b>①</b>
<b>75</b>	1,9	41	2	0,5	20	4	4	2	2
	2,3	33	2	0,5	23	4	4	2	2
	2,9	26	2	0,5	29	4	4	2	3
	3,6	21,0	3	0,5	36	5	5	3	5
	4,3	17,6	3	0,5	43	5	5	3	6
	4,5	17	3	1,0	45	5	5	3	6
	5,6	13,6	4	1,0	56	5	5	4	8
	6,8	11	5	1,0	68	6	6	5	10
	8,4	9,0	6	1,5	84	7	7	6	12
	10,3	7,4	7	1,5	103	7	7	7	14
<b>90</b>	2,2	41	2	0,5	22	4	4	2	2
	2,8	33	3	0,5	28	4	4	3	3
	3,5	26	3	0,5	35	5	5	3	4
	4,3	21,0	4	0,5	43	5	5	4	6
	5,1	17,6	4	1,0	51	5	5	4	7
	5,4	17	5	1,0	54	5	5	5	7
	6,7	13,6	6	1,0	67	6	6	6	10
	8,2	11	7	1,5	82	6	6	7	11
	10,1	9,0	8	1,5	101	7	7	8	14
	12,3	7,4	9	2,0	123	8	8	9	16

## Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **4600 / 4502** OD 75 - 250

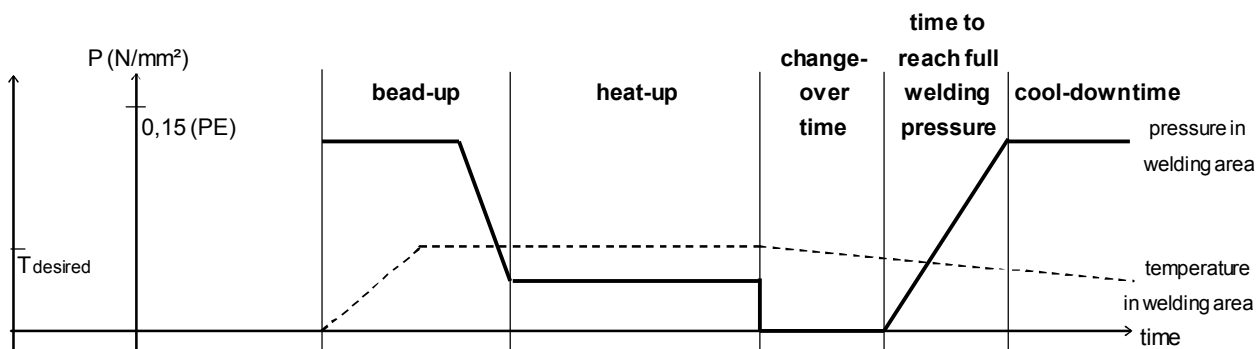
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] <b>①</b>
<b>110</b>	2,7	41	3	0,5	27	4	4	3	3
	3,4	33	4	0,5	34	5	5	4	4
	4,2	26	5	0,5	42	5	5	5	6
	5,3	21,0	6	1,0	53	5	5	6	7
	6,3	17,6	6	1,0	63	6	6	6	9
	6,6	17	7	1,0	66	6	6	7	9
	7,4	15	5	1,5	74	6	6	5	10
	8,1	13,6	8	1,5	81	6	6	8	11
	10,0	11	10	1,5	100	7	7	10	14
	12,3	9,0	11	2,0	123	8	8	11	16
15,1	7,4	13	2,0	151	9	9	13	20	
<b>125</b>	3,1	41	4	0,5	31	4	4	4	4
	3,9	33	5	0,5	39	5	5	5	5
	4,8	26	6	1,0	48	5	5	6	6
	6,0	21,0	7	1,0	60	6	6	7	8
	7,1	17,6	8	1,5	71	6	6	8	10
	7,4	17	8	1,5	74	6	6	8	10
	9,2	13,6	10	1,5	92	7	7	10	13
	11,4	11	12	1,5	114	8	8	12	15
	14,0	9,0	15	2,0	140	9	9	15	18
17,1	7,4	17	2,0	171	9	10	17	22	

## Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

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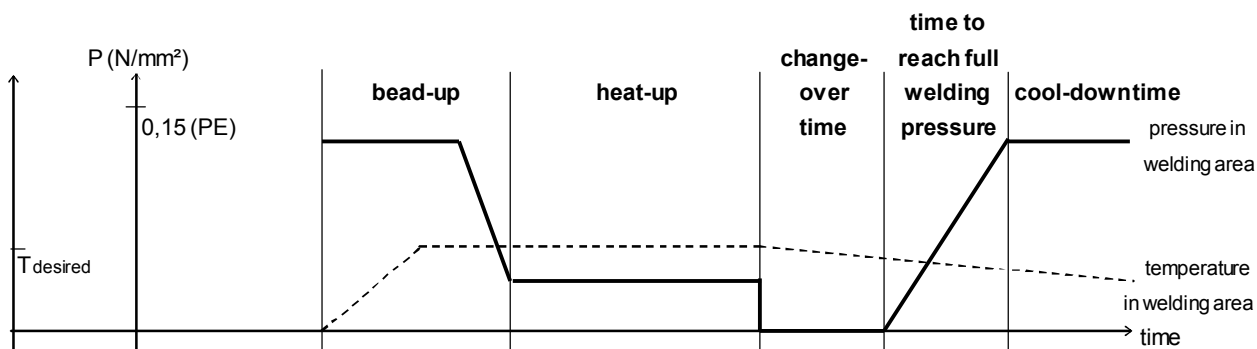
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] <b>①</b>
<b>140</b>	3,5	41	5	0,5	35	5	5	5	4
	4,3	33	6	0,5	43	5	5	6	6
	5,4	26	7	1,0	54	5	5	7	7
	6,7	21,0	9	1,0	67	6	6	9	10
	8,0	17,6	10	1,5	80	6	6	10	11
	8,3	17	10	1,5	83	7	7	10	12
	10,3	13,6	13	1,5	103	7	7	13	14
	12,7	11	15	2,0	127	8	8	15	17
	15,7	9,0	18	2,0	157	9	10	18	20
<b>160</b>	4,0	41	6	0,5	40	5	5	6	5
	4,9	33	7	1,0	49	5	5	7	7
	6,2	26	9	1,0	62	6	6	9	9
	7,7	21,0	11	1,5	77	6	6	11	11
	9,1	17,6	13	1,5	91	7	7	13	13
	9,5	17	13	1,5	95	7	7	13	13
	11,8	13,6	16	2,0	118	8	8	16	16
	14,6	11	20	2,0	146	9	9	20	19
	17,9	9,0	24	2,0	179	10	11	24	23
21,9	7,4	28	2,5	219	11	12	28	27	

## Table for PE



Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **4600 / 4502** OD 75 - 250

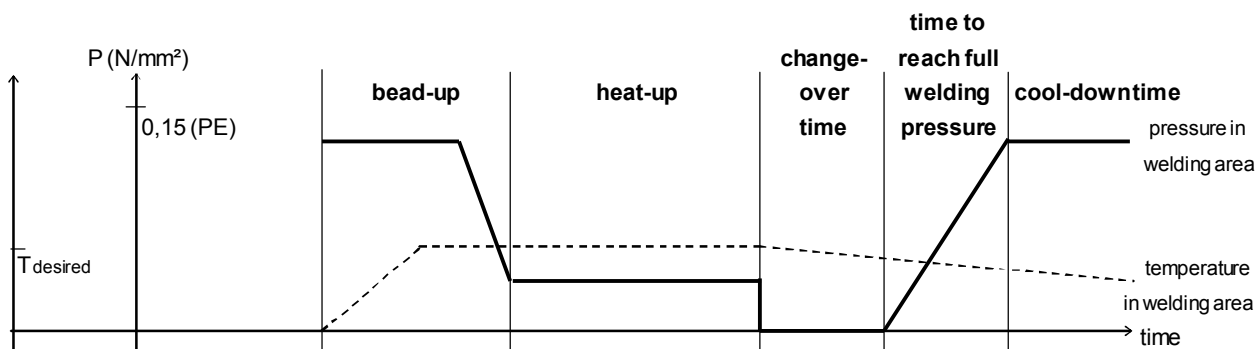
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] <b>①</b>
<b>180</b>	4,4	41	8	0,5	44	5	5	8	6
	5,5	33	9	1,0	55	5	5	9	8
	6,9	26	11	1,0	69	6	6	11	10
	8,6	21,0	14	1,5	86	7	7	14	12
	10,2	17,6	16	1,5	102	7	7	16	14
	10,7	17	17	1,5	107	7	7	17	14
	13,3	13,6	21	2,0	133	8	9	21	17
	16,4	11	25	2,0	164	9	10	25	21
	20,1	9,0	30	2,5	201	10	11	30	25
24,6	7,4	35	2,5	246	12	13	35	30	
<b>200</b>	4,9	41	9	1,0	49	5	5	9	7
	6,2	33	11	1,0	62	6	6	11	9
	7,7	26	14	1,5	77	6	6	14	11
	9,6	21,0	17	1,5	96	7	7	17	13
	11,4	17,6	20	1,5	114	8	8	20	15
	11,9	17	21	1,5	119	8	8	21	16
	14,7	13,6	25	2,0	147	9	9	25	19
	18,2	11	30	2,0	182	10	11	30	23
	22,4	9,0	37	2,5	224	11	12	37	28
27,4	7,4	43	3,0	274	13	15	43	34	

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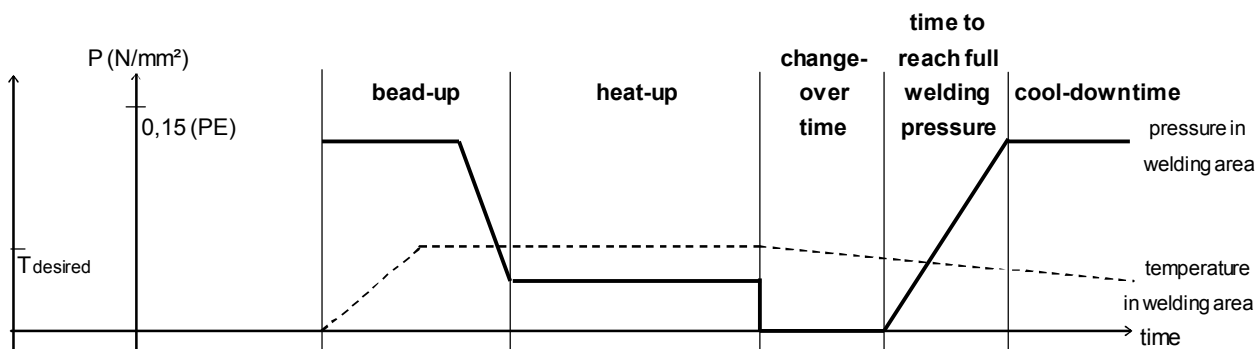
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] <b>①</b>
<b>225</b>	5,5	41	11	1,0	55	5	5	11	8
	6,9	33	14	1,0	69	6	6	14	10
	8,6	26	17	1,5	86	7	7	17	12
	10,8	21,0	21	1,5	108	8	8	21	15
	12,8	17,6	25	2,0	128	8	8	25	17
	13,4	17	26	2,0	134	8	9	26	18
	16,6	13,6	32	2,0	166	9	10	32	21
	20,5	11	38	2,5	205	10	12	38	26
	25,2	9,0	46	2,5	252	12	14	46	31
	30,8	7,4	55	3,0	308	14	16	55	38
<b>250</b>	6,2	41	14	1,0	62	6	6	14	9
	7,7	33	17	1,5	77	6	6	17	11
	9,6	26	21	1,5	96	7	7	21	13
	11,9	21,0	26	1,5	119	8	8	26	16
	14,2	17,6	31	2,0	142	9	9	31	19
	14,8	17	32	2,0	148	9	9	32	19
	18,4	13,6	39	2,0	184	10	11	39	23
	22,7	11	47	2,5	227	11	13	47	28
	27,9	9,0	57	3,0	279	13	15	57	34
	34,2	7,4	67	3,0	342	15	18	67	42

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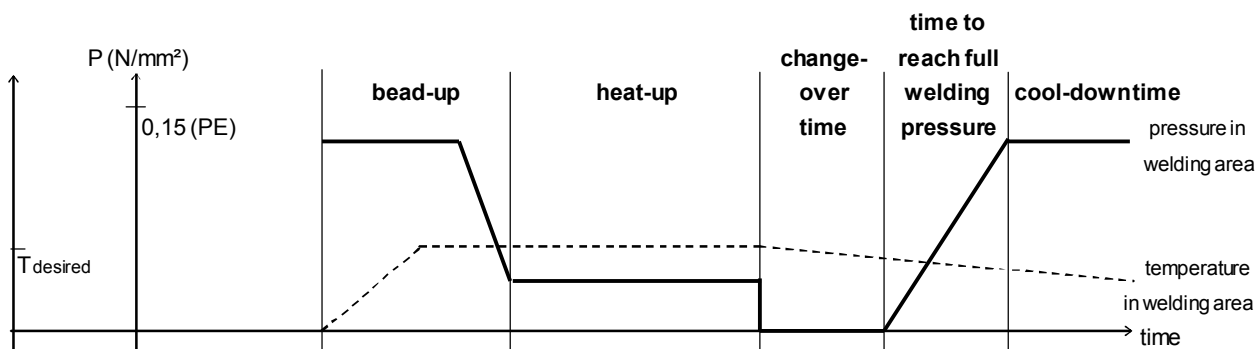
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<b>280</b>	6,9	41	18	1,0	69	6	6	18	10
	8,6	33	22	1,5	86	7	7	22	12
	10,7	26	27	1,5	107	7	7	27	14
	13,4	21,0	33	2,0	134	8	9	33	18
	15,9	17,6	39	2,0	159	9	10	39	20
	16,6	17	40	2,0	166	9	10	40	21
	20,6	13,6	49	2,5	206	10	12	49	26
	25,4	11	59	2,5	254	12	14	59	31
	31,3	9,0	71	3,0	313	14	16	71	38
<b>315</b>	7,7	41	22	1,5	77	6	6	22	11
	9,7	33	27	1,5	97	7	7	27	13
	12,1	26	34	2,0	121	8	8	34	16
	15,0	21,0	41	2,0	150	9	9	41	19
	17,9	17,6	49	2,0	179	10	11	49	23
	18,7	17	51	2,0	187	10	11	51	24
	23,2	13,6	62	2,5	232	11	13	62	29
	28,6	11	75	3,0	286	13	15	75	35
	35,2	9,0	90	3,0	352	15	18	90	43
43,1	7,4	107	3,5	431	18	22	107	52	

**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