Table for PP

Basis: DVS data sheets 2207, 2208 - State 2017

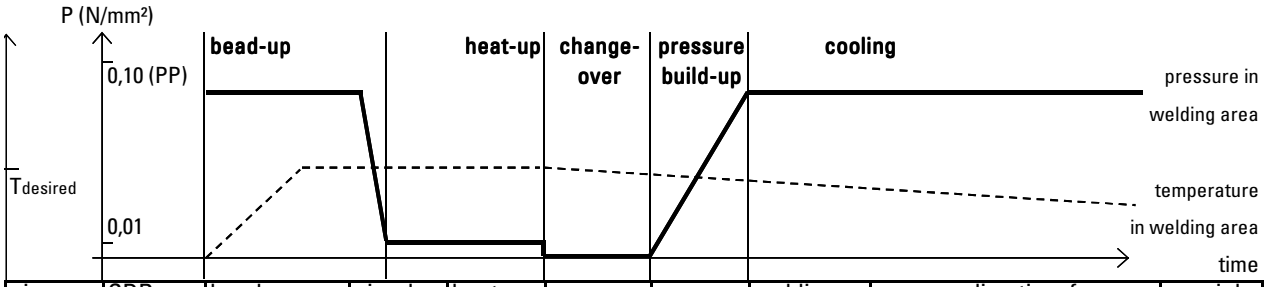
Field of application: **4900 / 4911 / WELD IT 315 / WELD IT 315 Stahl / HRG 0315 250 Compact S /315 Compact S / 355 Compact A**

1 bar on manometer: **59** N (Effective surface of cylinder: 589m² / 0,91 inch²)

The heating element temperature is 210° C ± 10° C / 410° F ± 18° F.
The change-over time should be kept as low as possible.
The joining pressure build-up time should be recognized as maximum value and may be underrun by up to 50%.
You must add the motion pressure of the welding machine to the indicated bead-up and welding pressure in each case!
The maximum pressure of the welding machine is to be observed.

❶ **These cooling times are only valid under the following conditions:**

- Welding connection is produced under workshop conditions
- Removal from the welding machine and temporary storage until complete cooling time elapses only cause minor strain for the welding connection



pipe wall (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature < 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	special cooling time ❶ [min:s]
DA	**90**										
2,2	41	2	0,5	00:26	5	6	2	04:00	05:00	06:30	03:30
2,8	33	2	0,5	00:33	5	6	2	04:00	05:00	06:30	03:30
3,5	26	2	0,5	00:41	5	6	2	04:00	05:00	06:30	03:30
5,1	17,6	3	0,5	01:00	5	6	3	04:29	05:36	07:13	03:52
5,4	17	3	0,5	01:03	5	6	3	04:43	05:54	07:35	04:02
8,2	11	4	1	01:34	6	8	4	06:50	08:35	10:56	05:43
10,1	9	5	1	01:54	7	9	5	08:10	10:17	13:13	06:52
12,3	7,4	6	1	02:18	7	11	6	09:42	12:15	15:52	08:10
15,0	6	6	1	02:45	8	14	6	11:26	14:34	19:09	09:43
18,1	5	7	1	03:17	9	16	7	13:25	17:14	22:54	11:29
DA	**110**										
2,7	41	2	0,5	00:32	5	6	2	04:00	05:00	06:30	03:30
3,4	33	2	0,5	00:40	5	6	2	04:00	05:00	06:30	03:30
4,2	26	3	0,5	00:49	5	6	3	04:00	05:00	06:30	03:30
6,3	17,6	4	0,5	01:13	6	7	4	05:26	06:48	08:40	04:35
6,6	17	4	0,5	01:17	6	7	4	05:41	07:06	09:01	04:46
10,0	11	6	1	01:53	7	9	6	08:06	10:12	13:06	06:48
12,3	9	7	1	02:18	7	11	7	09:42	12:15	15:52	08:10
15,1	7,4	8	1	02:46	8	14	8	11:30	14:39	19:16	09:46
18,3	6	9	1	03:19	9	16	9	13:33	17:24	23:09	11:36
22,1	5	11	1,5	03:55	10	19	11	16:13	20:39	27:33	13:46

Table for PP

Basis: DVS data sheets 2207, 2208 - State 2017

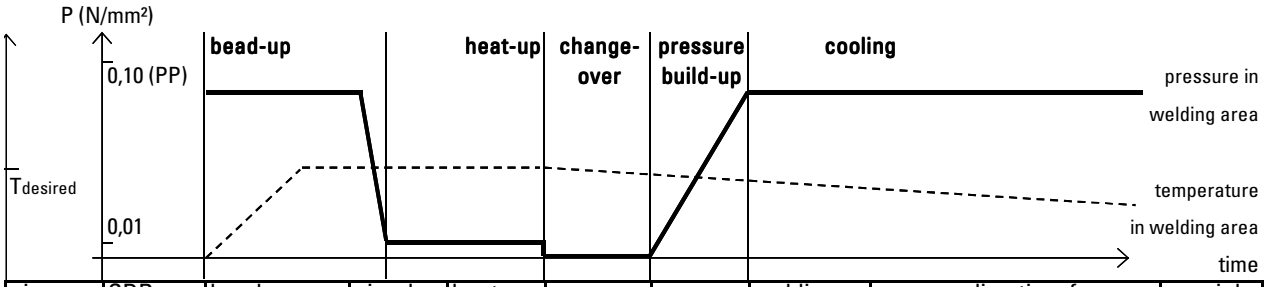
Field of application: **4900 / 4911 / WELD IT 315 / WELD IT 315 Stahl / HRG 0315 250 Compact S /315 Compact S / 355 Compact A**

1 bar on manometer: **59** N (Effective surface of cylinder: 589m² / 0,91 inch²)

The heating element temperature is 210° C ± 10° C / 410° F ± 18° F.
The change-over time should be kept as low as possible.
The joining pressure build-up time should be recognized as maximum value and may be underrun by up to 50%.
You must add the motion pressure of the welding machine to the indicated bead-up and welding pressure in each case!
The maximum pressure of the welding machine is to be observed.

❶ **These cooling times are only valid under the following conditions:**

- Welding connection is produced under workshop conditions
- Removal from the welding machine and temporary storage until complete cooling time elapses only cause minor strain for the welding connection



pipe wall (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature < 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	special cooling time ❶ [min:s]
DA	**125**										
3,1	41	3	0,5	00:37	5	6	3	04:00	05:00	06:30	03:30
3,9	33	3	0,5	00:46	5	6	3	04:00	05:00	06:30	03:30
4,8	26	4	0,5	00:56	5	6	4	04:14	05:18	06:52	03:41
7,1	17,6	5	1	01:22	6	7	5	06:04	07:35	09:37	05:04
7,4	17	5	1	01:25	6	7	5	06:17	07:52	09:59	05:14
11,4	11	7	1	02:09	7	11	7	09:05	11:28	14:47	07:38
14,0	9	9	1	02:35	8	13	9	10:47	13:43	17:56	09:09
17,1	7,4	10	1	03:07	8	15	10	12:47	16:22	21:42	10:55
20,8	6	12	1,5	03:43	10	18	12	15:17	19:33	26:03	13:02
25,1	5	14	1,5	04:23	11	21	14	18:21	23:14	30:58	15:29
DA	**140**										
3,5	41	3	0,5	00:41	5	6	3	04:00	05:00	06:30	03:30
4,3	33	4	0,5	00:51	5	6	4	04:00	05:00	06:30	03:30
5,4	26	4	0,5	01:03	5	6	4	04:43	05:54	07:35	04:02
8,0	17,6	6	1	01:32	6	8	6	06:42	08:24	10:42	05:36
8,3	17	6	1	01:35	6	8	6	06:55	08:40	11:04	05:47
12,7	11	9	1	02:22	7	12	9	09:57	12:36	16:21	08:24
15,7	9	11	1	02:53	8	14	11	11:53	15:10	20:00	10:07
19,2	7,4	13	1,5	03:28	9	17	13	14:09	18:10	24:14	12:07
23,3	6	15	1,5	04:06	10	20	15	17:04	21:41	28:55	14:27
28,1	5	17	2	04:48	12	24	17	20:32	25:55	34:29	17:20

Table for PP

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4900 / 4911 / WELD IT 315 / WELD IT 315 Stahl / HRG 0315 250 Compact S /315 Compact S / 355 Compact A**

1 bar on manometer: **59** N (Effective surface of cylinder: 589m² / 0,91 inch²)

The heating element temperature is 210° C ± 10° C / 410° F ± 18° F.
The change-over time should be kept as low as possible.
The joining pressure build-up time should be recognized as maximum value and may be underrun by up to 50%.
You must add the motion pressure of the welding machine to the indicated bead-up and welding pressure in each case!
The maximum pressure of the welding machine is to be observed.

❶ **These cooling times are only valid under the following conditions:**

- Welding connection is produced under workshop conditions
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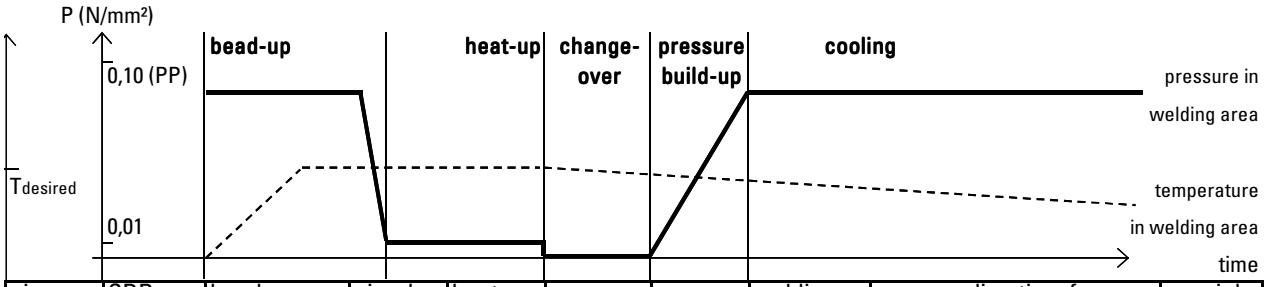

pipe wall (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature < 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	special cooling time ❶ [min:s]
DA	**160**										
4,0	41	4	0,5	00:47	5	6	4	04:00	05:00	06:30	03:30
4,9	33	5	0,5	00:57	5	6	5	04:19	05:24	06:59	03:44
6,2	26	6	0,5	01:12	6	7	6	05:22	06:42	08:32	04:31
9,1	17,6	8	1	01:44	6	9	8	07:28	09:23	12:01	06:16
9,5	17	8	1	01:48	6	9	8	07:45	09:45	12:30	06:30
14,6	11	12	1	02:41	8	13	12	11:10	14:14	18:39	09:29
17,9	9	14	1	03:15	9	16	14	13:18	17:03	22:40	11:22
21,9	7,4	17	1,5	03:53	10	19	17	16:04	20:29	27:19	13:39
26,6	6	19	2	04:36	11	23	19	19:26	24:33	32:43	16:23
32,1	5	22	2	05:21	13	28	22	23:26	29:33	39:13	19:53
DA	**180**										
4,4	41	5	0,5	00:52	5	6	5	04:00	05:00	06:30	03:30
5,5	33	6	0,5	01:04	5	6	6	04:48	06:00	07:42	04:06
6,9	26	7	0,5	01:20	6	7	7	05:55	07:24	09:23	04:56
10,2	17,6	10	1	01:56	7	10	10	08:14	10:23	13:20	06:55
10,7	17	10	1	02:01	7	10	10	08:35	10:50	13:56	07:13
16,4	11	15	1	03:00	8	15	15	12:20	15:46	20:51	10:31
20,1	9	18	1,5	03:36	9	18	18	14:47	18:57	25:15	12:38
24,6	7,4	21	1,5	04:18	11	21	21	18:00	22:48	30:24	15:12
29,0	6	24	2	04:56	12	25	24	21:11	26:44	35:33	17:55
36,1	5	28	2	05:55	14	31	28	26:21	33:11	43:56	22:26

Table for PP

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4900 / 4911 / WELD IT 315 / WELD IT 315 Stahl / HRG 0315 250 Compact S /315 Compact S / 355 Compact A**

1 bar on manometer: **59** N (Effective surface of cylinder: 589m² / 0,91 inch²)

The heating element temperature is 210° C ± 10° C / 410° F ± 18° F.
The change-over time should be kept as low as possible.
The joining pressure build-up time should be recognized as maximum value and may be underrun by up to 50%.
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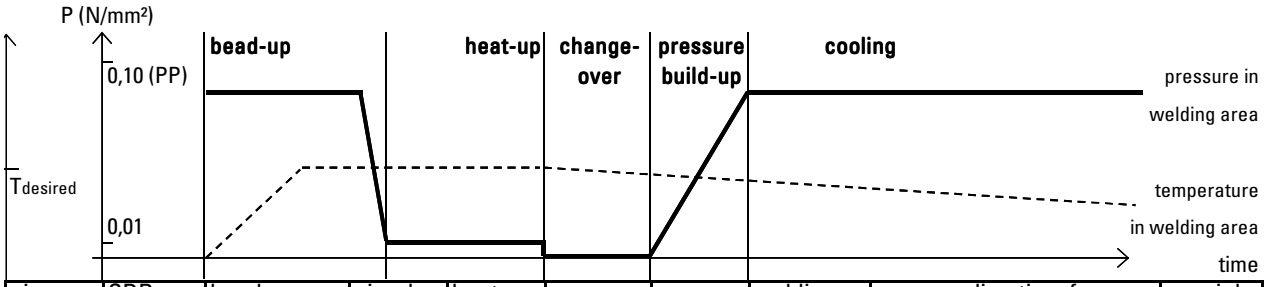

pipe wall (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature < 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	special cooling time ❶ [min:s]
DA	**200**										
4,9	41	6	0,5	00:57	5	6	6	04:19	05:24	06:59	03:44
6,2	33	7	0,5	01:12	6	7	7	05:22	06:42	08:32	04:31
7,7	26	8	1	01:29	6	8	8	06:29	08:08	10:20	05:25
11,4	17,6	12	1	02:09	7	11	12	09:05	11:28	14:47	07:38
11,9	17	12	1	02:14	7	11	12	09:26	11:55	15:23	07:56
18,2	11	18	1	03:18	9	16	18	13:29	17:19	23:02	11:33
22,4	9	22	1,5	03:58	10	19	22	16:26	20:55	27:53	13:57
27,4	7,4	26	2	04:43	11	23	26	20:01	25:16	33:39	16:53
33,2	6	30	2	05:31	13	29	30	24:14	30:33	40:31	20:35
DA	**225**										
5,5	41	7	0,5	01:04	5	6	7	04:48	06:00	07:42	04:06
6,9	33	9	0,5	01:20	6	7	9	05:55	07:24	09:23	04:56
8,6	26	10	1	01:38	6	8	10	07:07	08:56	11:25	05:58
12,8	17,6	15	1	02:23	7	12	15	10:01	12:41	16:28	08:27
13,4	17	16	1	02:29	7	12	16	10:24	13:12	17:12	08:48
20,5	11	23	1,5	03:40	9	18	23	15:04	19:17	25:43	12:51
25,2	9	27	1,5	04:24	11	21	27	18:26	23:19	31:05	15:33
30,8	7,4	32	2	05:11	12	26	32	22:29	28:22	37:40	19:03
37,4	6	38	2,5	06:05	14	32	38	27:17	34:22	45:30	23:15

Table for PP

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4900 / 4911 / WELD IT 315 / WELD IT 315 Stahl / HRG 0315 250 Compact S /315 Compact S / 355 Compact A**

1 bar on manometer: **59** N (Effective surface of cylinder: 589m² / 0,91 inch²)

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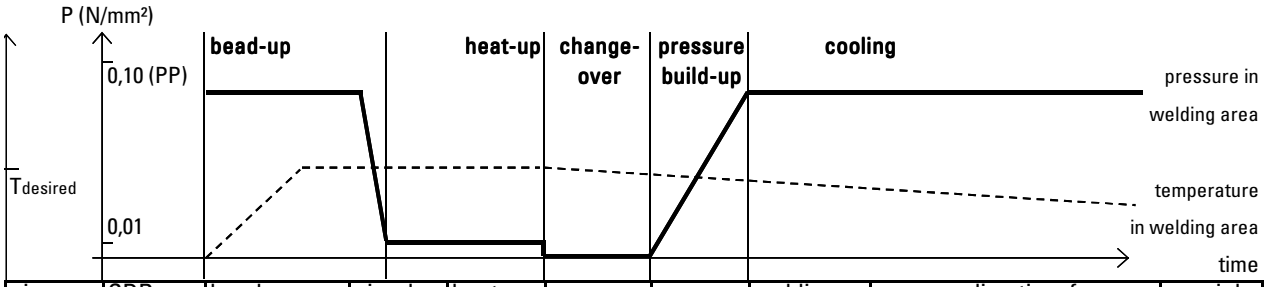

pipe wall (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature < 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	special cooling time ❶ [min:s]
DA	**250**										
6,2	41	9	0,5	01:12	6	7	9	05:22	06:42	08:32	04:31
7,7	33	10	1	01:29	6	8	10	06:29	08:08	10:20	05:25
9,6	26	13	1	01:49	7	9	13	07:49	09:50	12:37	06:34
14,2	17,6	18	1	02:37	8	13	18	10:55	13:53	18:10	09:15
14,8	17	19	1	02:43	8	13	19	11:18	14:24	18:54	09:36
22,7	11	28	1,5	04:00	10	20	28	16:39	21:10	28:14	14:07
27,9	9	33	2	04:47	12	24	33	20:23	25:44	34:15	17:13
34,2	7,4	40	2	05:39	13	29	40	24:58	31:27	41:41	21:13
DA	**280**										
6,9	41	11	0,5	01:20	6	7	11	05:55	07:24	09:23	04:56
8,6	33	13	1	01:38	6	8	13	07:07	08:56	11:25	05:58
10,7	26	16	1	02:01	7	10	16	08:35	10:50	13:56	07:13
15,9	17,6	23	1	02:55	8	14	23	12:00	15:21	20:14	10:14
16,6	17	24	1	03:02	8	15	24	12:27	15:57	21:05	10:38
25,4	11	35	1,5	04:25	11	22	35	18:34	23:29	31:19	15:39
31,3	9	42	2	05:15	12	27	42	22:51	28:49	38:16	19:22
38,3	7,4	50	2,5	06:11	14	33	50	27:54	35:12	46:36	23:48

Table for PP

Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4900 / 4911 / WELD IT 315 / WELD IT 315 Stahl / HRG 0315 250 Compact S /315 Compact S / 355 Compact A**

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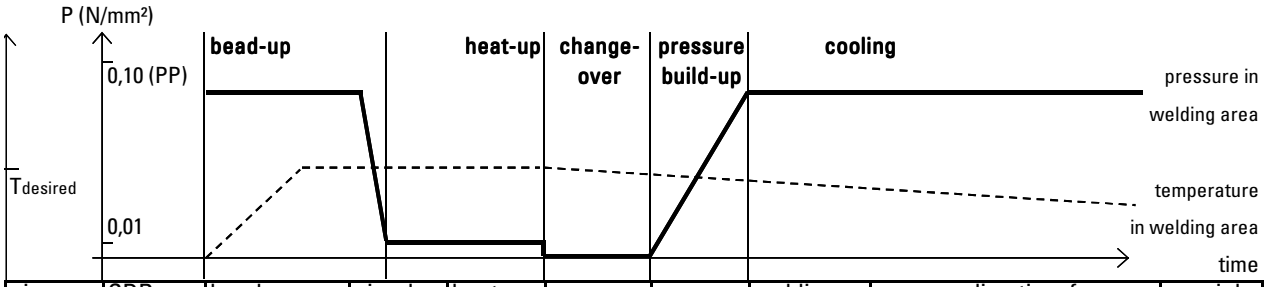

pipe wall (s) [mm]	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature < 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	special cooling time ❶ [min:s]
DA	**315**										
7,7	41	13	1	01:29	6	8	13	06:29	08:08	10:20	05:25
9,7	33	16	1	01:50	7	9	16	07:53	09:56	12:44	06:37
12,1	26	20	1	02:16	7	11	20	09:34	12:05	15:37	08:03
17,9	17,6	29	1	03:15	9	16	29	13:18	17:03	22:40	11:22
18,7	17	30	1	03:23	9	17	30	13:48	17:45	23:38	11:50
28,6	11	44	2	04:53	12	24	44	20:53	26:22	35:04	17:39
35,2	9	53	2	05:47	14	30	53	25:41	32:22	42:52	21:51
DA	**355**										
8,7	41	15	1,5	01:27	7	7	15	07:11	09:02	11:32	06:01
10,9	33	18	1,5	01:49	8	8	18	08:44	11:01	14:11	07:20
13,6	26	22	2	02:16	8	9	22	10:32	13:22	17:27	08:55
20,1	17,6	32	2,5	03:21	10	11	32	14:47	18:57	25:15	12:38
21,1	17	34	2,5	03:31	11	12	34	15:30	19:48	26:24	13:12
32,2	11	49	3	05:22	14	17	49	23:31	29:38	39:20	19:57
39,7	9	59	3,5	06:37	17	20	59	28:52	36:30	48:19	24:40