

Table for PP



Foundation: 2207, 2208 DIN 16932 German association for welding

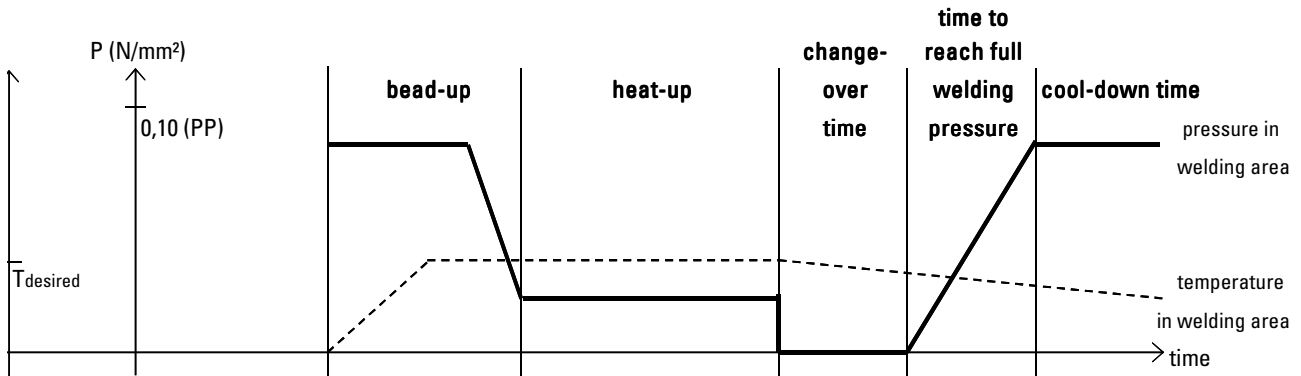
Use for: **8000 WM**

1 bar on manometer: **232 N**

The standard value for heating element temperature is $210\text{ °C} \pm 10\text{ °C}$ ($410\text{ °F} \pm 50\text{ °F}$).

The **smaller** the pipe wall the **higher** the temperature.

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]
500	12,3	41	9	1,0	249	7	11	9	20
	15,3	33	11	1,0	285	8	14	11	25
	19,1	26	13	1,5	331	9	17	13	30
	28,4	17,6	19	2,0	419	12	24	19	43
560	13,7	41	11	1,0	266	7	12	11	22
	17,2	33	13	1,0	308	8	15	13	27
	21,4	26	16	1,5	354	10	19	16	33
	31,7	17,6	23	2,0	444	13	27	23	48
630	15,4	41	13	1,0	286	8	14	13	25
	19,3	33	16	1,5	333	9	17	16	30
	24,1	26	20	1,5	381	10	21	20	37
	35,7	17,6	29	2,0	475	14	31	29	53
710	17,4	41	17	1,0	311	9	16	17	28
	21,8	33	21	1,5	358	10	19	21	34
	27,2	26	26	2,0	409	11	23	26	42
	40,2	17,6	37	2,5	503	15	35	37	59
800	19,6	41	21	1,5	336	9	17	21	31
	24,5	33	26	1,5	385	11	21	26	38
	30,6	26	32	2,0	436	12	26	32	46
	45,3	17,6	47	2,5	533	16	39	47	65

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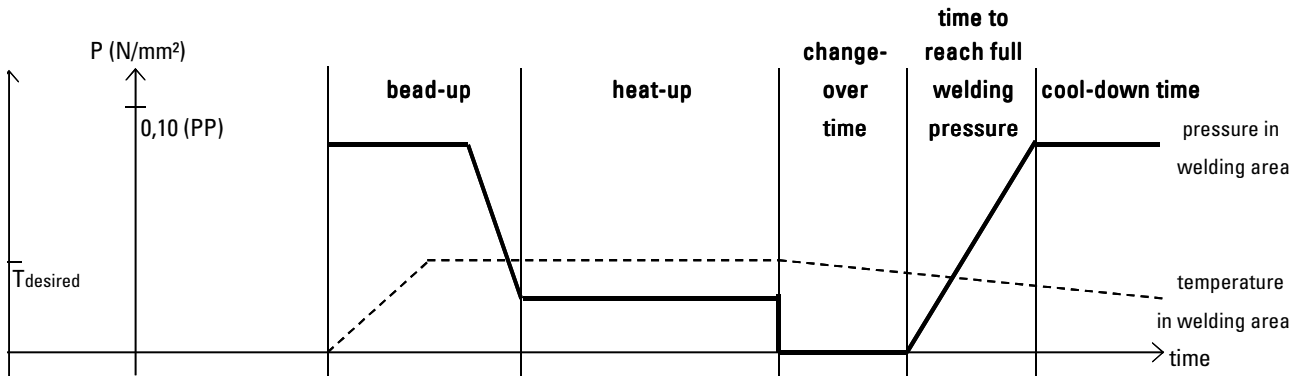
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900	22,0	41	27	1,5	360	10	19	27	34
	27,6	33	33	2,0	412	11	23	33	42
	34,4	26	41	2,0	465	13	30	41	51
	51,0	17,6	59	3,0	564	17	44	59	71
1000	24,5	41	33	1,5	385	11	21	33	38
	30,6	33	41	2,0	436	12	26	41	46
	38,2	26	50	2,5	492	14	33	50	56
1200	29,4	41	47	2,0	426	12	25	47	45
	36,7	33	58	2,0	483	14	32	58	55
	45,9	26	72	2,5	536	16	40	72	65

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