

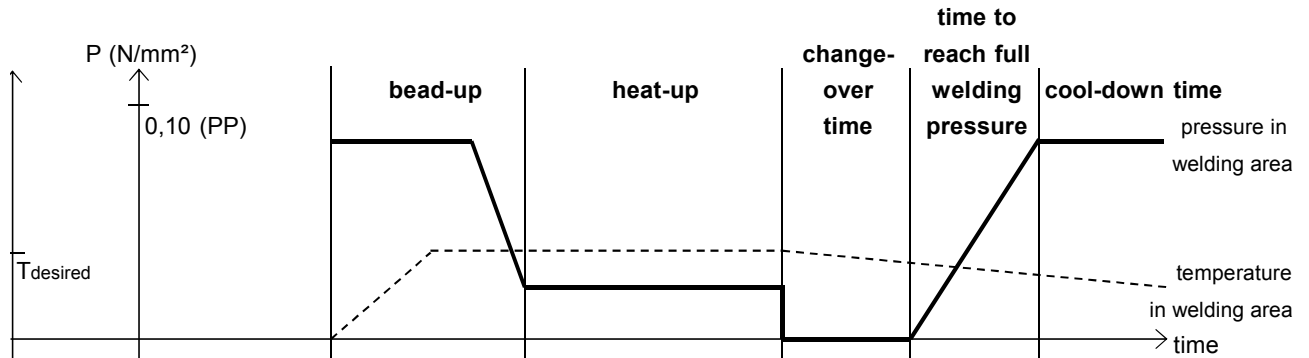
Table for PP

Foundation: 2207, 2208 DIN 16932 German association for welding
 Use for: **16000**

1 bar on manometer: **463 N**

The standard value for heating element temperature is 210° C +/- 10° C.
 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] ^①
1000	24,5	41	17	1,5	385	11	21	17	38
	30,6	33	21	2,0	436	12	26	21	46
	38,2	26	25	2,5	492	14	33	25	56
1200	29,4	41	24	2,0	426	12	25	24	45
	36,7	33	29	2,0	483	14	32	29	55
	45,9	26	36	2,5	536	16	40	36	65
1400	34,3	41	32	2,0	464	13	30	32	51
	42,9	33	40	2,5	519	15	37	40	62
	53,5	26	49	3,0	574	18	46	49	73
1600	39,2	41	42	2,5	498	15	34	42	58
	49,0	33	52	2,5	554	17	42	52	69
	61,2	26	64	3,0	605	19	52	64	81

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