

# Table for PP



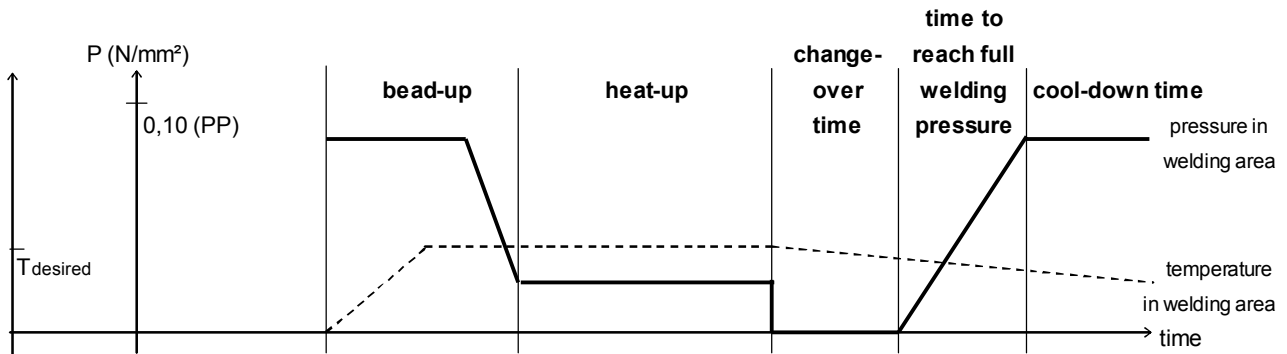
Foundation: 2207, 2208 DIN 16932 German association for welding

Use for: **6100 Steel / HRG 6 / 8000 (ab 06/2009)**

1 bar on manometer: **294,5 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] <b>①</b>
<b>315</b>	7,7	41	3	1,0	185	6	8	3	13
	9,7	33	4	1,0	213	7	9	4	16
	12,1	26	4	1,0	246	7	11	4	20
	17,9	17,6	6	1,0	317	9	16	6	28
	28,6	11	9	2,0	420	12	24	9	44
<b>355</b>	8,7	41	4	1,0	199	6	8	4	15
	10,9	33	5	1,0	230	7	10	5	18
	13,6	26	5	1,0	264	7	12	5	22
	20,1	17,6	8	1,5	341	9	18	8	32
	32,2	11	12	2,0	448	13	28	12	48
<b>400</b>	9,8	41	5	1,0	214	7	9	5	16
	12,3	33	6	1,0	249	7	11	6	20
	15,3	26	7	1,0	221	7	10	7	17
	22,7	17,6	10	1,5	367	10	20	10	35
	36,3	11	15	2,0	480	14	31	15	54
<b>450</b>	11,0	41	6	1,0	231	7	10	6	18
	13,8	33	7	1,0	267	8	13	7	23
	17,2	26	8	1,0	308	8	15	8	27
	25,5	17,6	12	1,5	395	11	22	12	39
	40,9	11	18	2,5	508	15	35	18	59
<b>500</b>	12,3	41	7	1,0	249	7	11	7	20
	15,3	33	8	1,0	285	8	14	8	25
	19,1	26	10	1,5	331	9	17	10	30
	28,4	17,6	15	2,0	419	12	24	15	43

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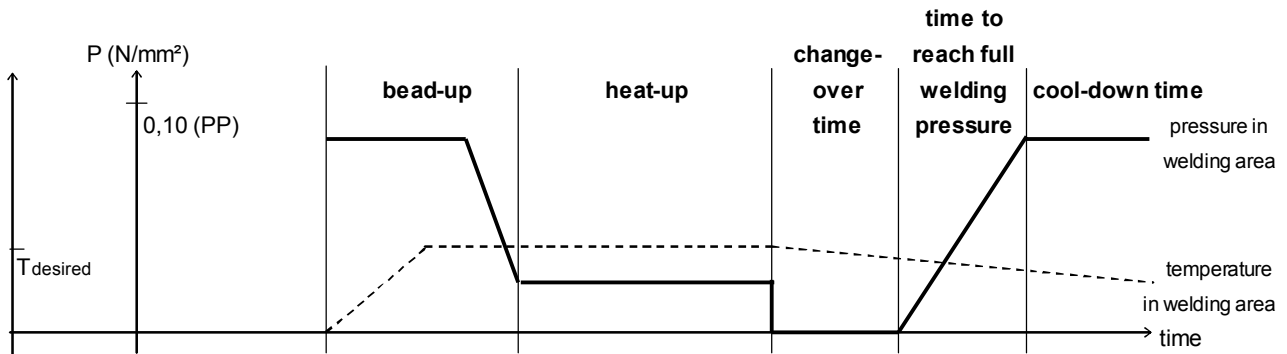
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pipe diameter OD [mm]	pipe wall (s) [mm]	SDR	bead-up pressure [bar]	circular bead min. [mm]	heat-up time [s]	max. change-over time [s]	time to reach welding pressure [s]	welding pressure [bar]	cool-down time [min] <sup>①</sup>
<b>560</b>	13,7	41	8	1,0	266	7	12	8	22
	17,2	33	10	1,0	308	8	15	10	27
	21,4	26	13	1,5	354	10	19	13	33
	31,7	17,6	18	2,0	444	13	27	18	48
<b>630</b>	15,4	41	11	1,0	286	8	14	11	25
	19,3	33	13	1,5	333	9	17	13	30
	24,1	26	16	1,5	381	10	21	16	37
	35,7	17,6	23	2,0	475	14	31	23	53
<b>710</b>	17,4	41	13	1,0	311	9	16	13	28
	21,8	33	17	1,5	358	10	19	17	34
	27,2	26	20	2,0	409	11	23	20	42
	40,2	17,6	29	2,5	503	15	35	29	59
<b>800</b>	19,6	41	17	1,5	338	9	18	17	31
	24,5	33	21	1,5	385	11	21	21	38
	30,6	26	26	2,0	436	12	26	26	46
	45,3	17,6	37	2,5	533	16	39	37	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