

Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4000 / 4001 / 4002 (with 2. cylinder)**

1 bar on manometer: **36** N (Effective surface of cylinder: 362 mm² / 0,56 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 overrun by up to 50%.

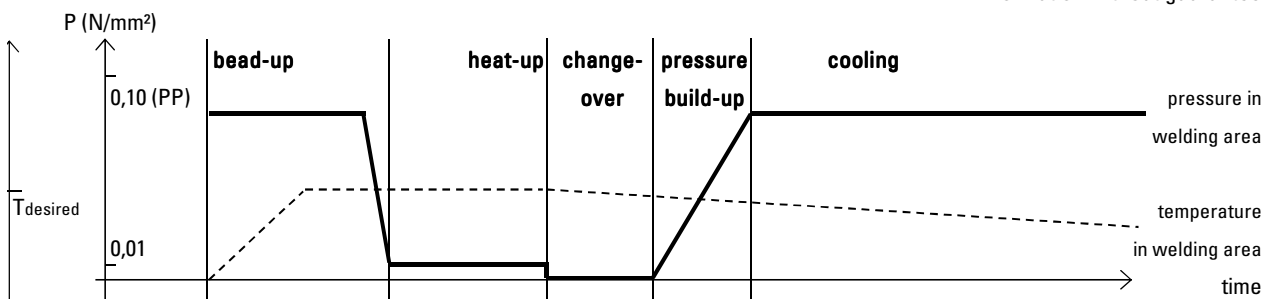
You must add the motion pressure of the welding machine to the indicated bead-up and welding pressure in each case!

The maximum pressure of the welding machine is to be observed.

1 These cooling times are only valid under the following conditions:

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- Removal from the welding machine and temporary storage until complete cooling time elapses only cause minor strain for the welding connection

All information without guarantee



pipe wall (s)	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			special cooling time 1 [min:s]
								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [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	3	0,5	00:33	5	6	3	04:00	05:00	06:30	03:30
3,5	26	3	0,5	00:41	5	6	3	04:00	05:00	06:30	03:30
5,1	17,6	4	0,5	01:00	5	6	4	04:29	05:36	07:13	03:52
5,4	17	4	0,5	01:03	5	6	4	04:43	05:54	07:35	04:02
8,2	11	6	1	01:34	6	8	6	06:50	08:35	10:56	05:43
10,1	9	8	1	01:54	7	9	8	08:10	10:17	13:13	06:52
12,3	7,4	9	1	02:18	7	11	9	09:42	12:15	15:52	08:10
15,0	6	10	1	02:45	8	14	10	11:26	14:34	19:09	09:43
18,1	5	12	1	03:17	9	16	12	13:25	17:14	22:54	11:29
DA 110											
2,7	41	3	0,5	00:32	5	6	3	04:00	05:00	06:30	03:30
3,4	33	4	0,5	00:40	5	6	4	04:00	05:00	06:30	03:30
4,2	26	4	0,5	00:49	5	6	4	04:00	05:00	06:30	03:30
6,3	17,6	6	0,5	01:13	6	7	6	05:26	06:48	08:40	04:35
6,6	17	6	0,5	01:17	6	7	6	05:41	07:06	09:01	04:46
10,0	11	9	1	01:53	7	9	9	08:06	10:12	13:06	06:48
12,3	9	11	1	02:18	7	11	11	09:42	12:15	15:52	08:10
15,1	7,4	13	1	02:46	8	14	13	11:30	14:39	19:16	09:46
18,3	6	15	1	03:19	9	16	15	13:33	17:24	23:09	11:36
22,1	5	17	1,5	03:55	10	19	17	16:13	20:39	27:33	13:46

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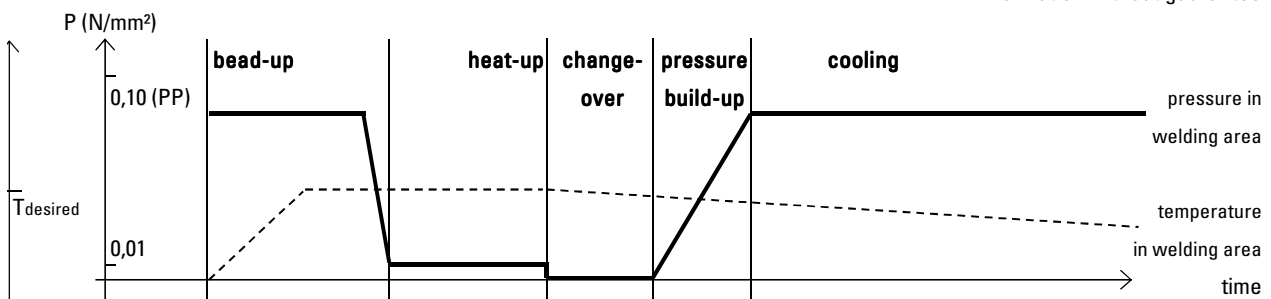
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 125											
3,1	41	4	0,5	00:37	5	6	4	04:00	05:00	06:30	03:30
3,9	33	5	0,5	00:46	5	6	5	04:00	05:00	06:30	03:30
4,8	26	6	0,5	00:56	5	6	6	04:14	05:18	06:52	03:41
7,1	17,6	8	1	01:22	6	7	8	06:04	07:35	09:37	05:04
7,4	17	8	1	01:25	6	7	8	06:17	07:52	09:59	05:14
11,4	11	12	1	02:09	7	11	12	09:05	11:28	14:47	07:38
14,0	9	14	1	02:35	8	13	14	10:47	13:43	17:56	09:09
17,1	7,4	17	1	03:07	8	15	17	12:47	16:22	21:42	10:55
20,8	6	19	1,5	03:43	10	18	19	15:17	19:33	26:03	13:02
25,1	5	22	1,5	04:23	11	21	22	18:21	23:14	30:58	15:29
DA 140											
3,5	41	5	0,5	00:41	5	6	5	04:00	05:00	06:30	03:30
4,3	33	6	0,5	00:51	5	6	6	04:00	05:00	06:30	03:30
5,4	26	7	0,5	01:03	5	6	7	04:43	05:54	07:35	04:02
8,0	17,6	10	1	01:32	6	8	10	06:42	08:24	10:42	05:36
8,3	17	10	1	01:35	6	8	10	06:55	08:40	11:04	05:47
12,7	11	15	1	02:22	7	12	15	09:57	12:36	16:21	08:24
15,7	9	18	1	02:53	8	14	18	11:53	15:10	20:00	10:07
19,2	7,4	21	1,5	03:28	9	17	21	14:09	18:10	24:14	12:07
23,3	6	24	1,5	04:06	10	20	24	17:04	21:41	28:55	14:27
28,1	5	28	2	04:48	12	24	28	20:32	25:55	34:29	17:20

Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4000 / 4001 / 4002 (with 2. cylinder)**

1 bar on manometer: **36** N (Effective surface of cylinder: 362 mm² / 0,56 inch²)

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The change-over time should be kept as low as possible.

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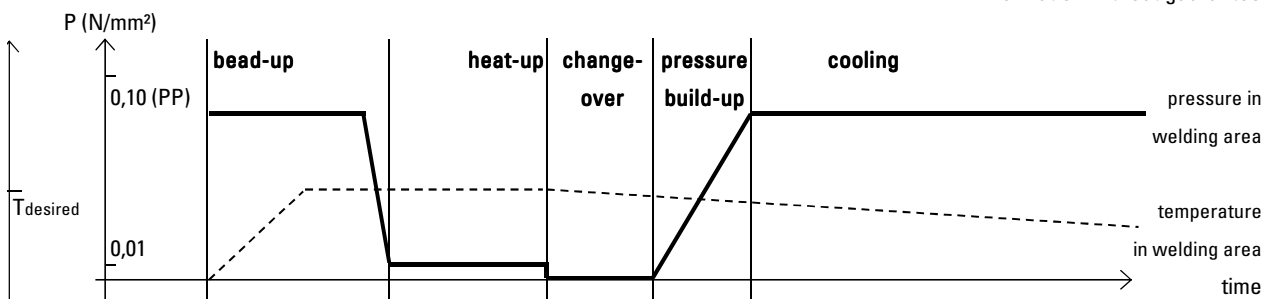
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pipe wall (s)	SDR degree	bead-up pressure [bar]	circular bead height min. [mm]	heat-up time [min:s]	max. change-over time [s]	pressure build-up time [s]	welding pressure [bar]	cooling time for ambient temperature			special cooling time 1 [min:s]
								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 160											
4,0	41	6	0,5	00:47	5	6	6	04:00	05:00	06:30	03:30
4,9	33	7	0,5	00:57	5	6	7	04:19	05:24	06:59	03:44
6,2	26	9	0,5	01:12	6	7	9	05:22	06:42	08:32	04:31
9,1	17,6	12	1	01:44	6	9	12	07:28	09:23	12:01	06:16
9,5	17	13	1	01:48	6	9	13	07:45	09:45	12:30	06:30
14,6	11	19	1	02:41	8	13	19	11:10	14:14	18:39	09:29
17,9	9	23	1	03:15	9	16	23	13:18	17:03	22:40	11:22
21,9	7,4	27	1,5	03:53	10	19	27	16:04	20:29	27:19	13:39
26,6	6	31	2	04:36	11	23	31	19:26	24:33	32:43	16:23
32,1	5	36	2	05:21	13	28	36	23:26	29:33	39:13	19:53
DA 180											
4,4	41	7	0,5	00:52	5	6	7	04:00	05:00	06:30	03:30
5,5	33	9	0,5	01:04	5	6	9	04:48	06:00	07:42	04:06
6,9	26	11	0,5	01:20	6	7	11	05:55	07:24	09:23	04:56
10,2	17,6	16	1	01:56	7	10	16	08:14	10:23	13:20	06:55
10,7	17	16	1	02:01	7	10	16	08:35	10:50	13:56	07:13
16,4	11	24	1	03:00	8	15	24	12:20	15:46	20:51	10:31
20,1	9	29	1,5	03:36	9	18	29	14:47	18:57	25:15	12:38
24,6	7,4	34	1,5	04:18	11	21	34	18:00	22:48	30:24	15:12
29,0	6	39	2	04:56	12	25	39	21:11	26:44	35:33	17:55
36,1	5	46	2	05:55	14	31	46	26:21	33:11	43:56	22:26

Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4000 / 4001 / 4002 (with 2. cylinder)**

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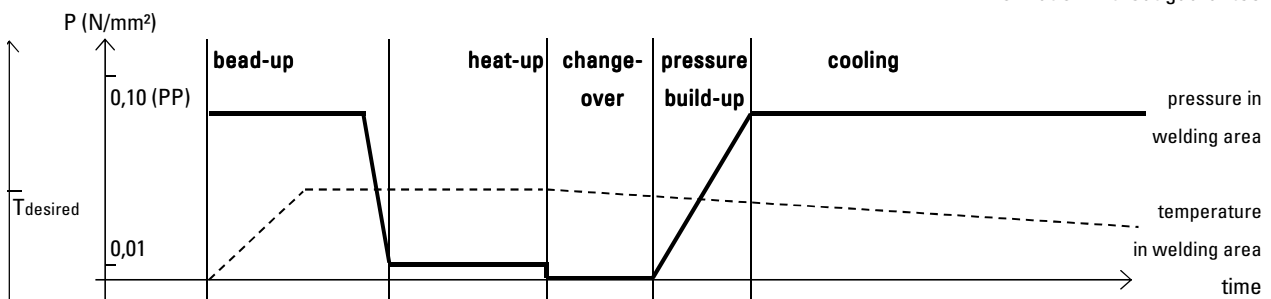
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 200											
4,9	41	9	0,5	00:57	5	6	9	04:19	05:24	06:59	03:44
6,2	33	11	0,5	01:12	6	7	11	05:22	06:42	08:32	04:31
7,7	26	13	1	01:29	6	8	13	06:29	08:08	10:20	05:25
11,4	17,6	19	1	02:09	7	11	19	09:05	11:28	14:47	07:38
11,9	17	20	1	02:14	7	11	20	09:26	11:55	15:23	07:56
18,2	11	29	1	03:18	9	16	29	13:29	17:19	23:02	11:33
22,4	9	35	1,5	03:58	10	19	35	16:26	20:55	27:53	13:57
27,4	7,4	42	2	04:43	11	23	42	20:01	25:16	33:39	16:53
33,2	6	49	2	05:31	13	29	49	24:14	30:33	40:31	20:35
DA 225											
5,5	41	11	0,5	01:04	5	6	11	04:48	06:00	07:42	04:06
6,9	33	14	0,5	01:20	6	7	14	05:55	07:24	09:23	04:56
8,6	26	17	1	01:38	6	8	17	07:07	08:56	11:25	05:58
12,8	17,6	24	1	02:23	7	12	24	10:01	12:41	16:28	08:27
13,4	17	25	1	02:29	7	12	25	10:24	13:12	17:12	08:48
20,5	11	37	1,5	03:40	9	18	37	15:04	19:17	25:43	12:51
25,2	9	44	1,5	04:24	11	21	44	18:26	23:19	31:05	15:33
30,8	7,4	53	2	05:11	12	26	53	22:29	28:22	37:40	19:03
37,4	6	62	2,5	06:05	14	32	62	27:17	34:22	45:30	23:15

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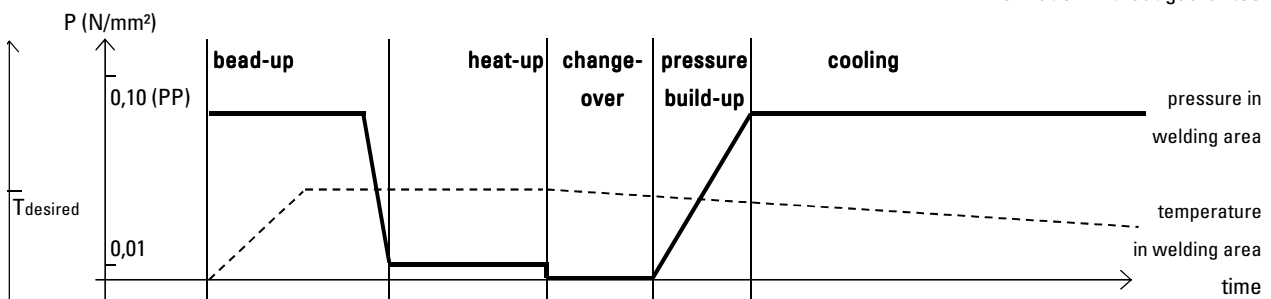
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 250											
6,2	41	14	0,5	01:12	6	7	14	05:22	06:42	08:32	04:31
7,7	33	17	1	01:29	6	8	17	06:29	08:08	10:20	05:25
9,6	26	21	1	01:49	7	9	21	07:49	09:50	12:37	06:34
14,2	17,6	30	1	02:37	8	13	30	10:55	13:53	18:10	09:15
14,8	17	31	1	02:43	8	13	31	11:18	14:24	18:54	09:36
22,7	11	46	1,5	04:00	10	20	46	16:39	21:10	28:14	14:07
27,9	9	55	2	04:47	12	24	55	20:23	25:44	34:15	17:13
34,2	7,4	65	2	05:39	13	29	65	24:58	31:27	41:41	21:13
DA 280											
6,9	41	17	0,5	01:20	6	7	17	05:55	07:24	09:23	04:56
8,6	33	21	1	01:38	6	8	21	07:07	08:56	11:25	05:58
10,7	26	26	1	02:01	7	10	26	08:35	10:50	13:56	07:13
15,9	17,6	37	1	02:55	8	14	37	12:00	15:21	20:14	10:14
16,6	17	39	1	03:02	8	15	39	12:27	15:57	21:05	10:38
25,4	11	57	1,5	04:25	11	22	57	18:34	23:29	31:19	15:39
31,3	9	68	2	05:15	12	27	68	22:51	28:49	38:16	19:22
38,3	7,4	81	2,5	06:11	14	33	81	27:54	35:12	46:36	23:48

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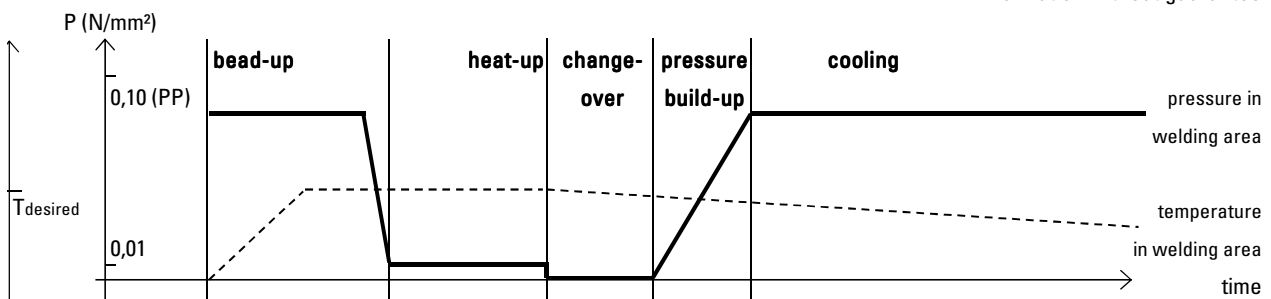
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 315											
7,7	41	21	1	01:29	6	8	21	06:29	08:08	10:20	05:25
9,7	33	26	1	01:50	7	9	26	07:53	09:56	12:44	06:37
12,1	26	32	1	02:16	7	11	32	09:34	12:05	15:37	08:03
17,9	17,6	47	1	03:15	9	16	47	13:18	17:03	22:40	11:22
18,7	17	49	1	03:23	9	17	49	13:48	17:45	23:38	11:50
28,6	11	72	2	04:53	12	24	72	20:53	26:22	35:04	17:39
35,2	9	86	2	05:47	14	30	86	25:41	32:22	42:52	21:51
DA 355											
8,7	41	27	1	01:39	6	8	27	07:11	09:02	11:32	06:01
10,9	33	33	1	02:03	7	10	33	08:44	11:01	14:11	07:20
13,6	26	41	1	02:31	7	12	41	10:32	13:22	17:27	08:55
20,1	17,6	59	1,5	03:36	9	18	59	14:47	18:57	25:15	12:38
21,1	17	62	1,5	03:45	10	19	62	15:30	19:48	26:24	13:12
32,2	11	91	2	05:22	13	28	91	23:31	29:38	39:20	19:57
39,7	9	110	2,5	06:20	15	34	110	28:52	36:30	48:19	24:40

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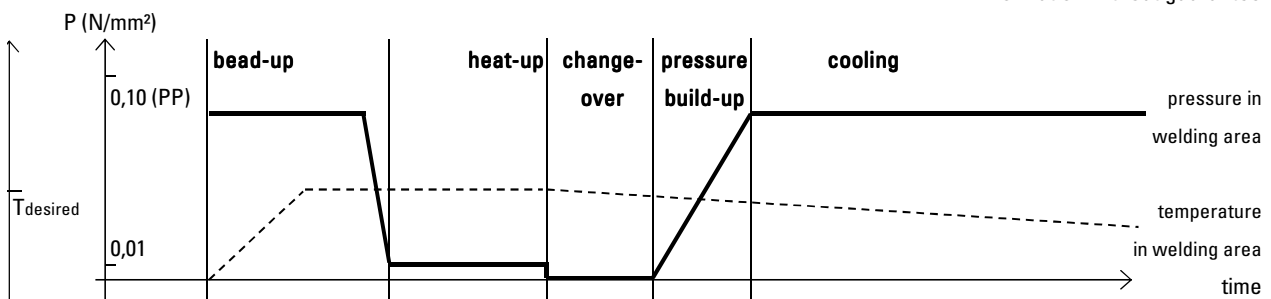
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 400											
9,8	41	34	1	01:51	7	9	34	07:58	10:01	12:52	06:41
12,3	33	42	1	02:18	7	11	42	09:42	12:15	15:52	08:10
15,3	26	52	1	02:48	8	14	52	11:37	14:50	19:30	09:53
22,7	17,6	75	1,5	04:00	10	20	75	16:39	21:10	28:14	14:07
23,7	17	78	1,5	04:10	10	20	78	17:21	22:02	29:22	14:41
36,3	11	116	2	05:56	14	31	116	26:29	33:22	44:10	22:33
DA 450											
11,0	41	43	1	02:04	7	10	43	08:48	11:06	14:18	07:24
13,8	33	53	1	02:33	8	13	53	10:39	13:33	17:41	09:02
17,2	26	65	1	03:08	8	15	65	12:51	16:27	21:49	10:58
25,5	17,6	95	1,5	04:26	11	22	95	18:39	23:34	31:26	15:43
26,7	17	99	2	04:37	11	23	99	19:31	24:38	32:50	16:27
40,9	11	147	2,5	06:28	15	35	147	29:42	37:36	49:48	25:24