

Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **4502 / 4600 / 4702 / 4800 / WELD IT 250 / 12"**

1 bar on manometer: **52 N** (Effective surface of cylinder: 510 mm² / 0,79 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%.

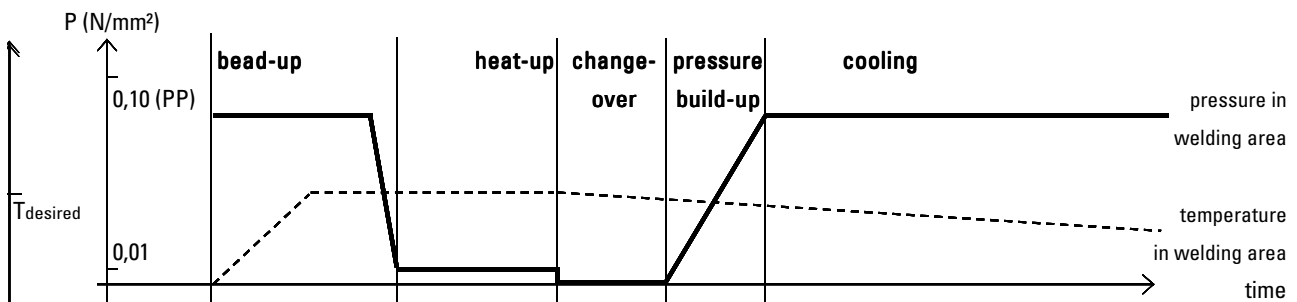
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All information without guarantee



pipe wall (s)	SDR degree	bead-up pressure	circular bead height min.	heat-up time	max. change-over time	pressure build-up time	welding pressure	cooling time for ambient temperature			special cooling time 1
								< 15°C < 59°F	15-25°C 59-77°F	> 25°C > 77°F	
[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 75											
1,9	41	1	0,5	00:24	5	6	1	04:00	05:00	06:30	03:30
2,3	33	2	0,5	00:27	5	6	2	04:00	05:00	06:30	03:30
2,9	26	2	0,5	00:34	5	6	2	04:00	05:00	06:30	03:30
4,3	17,6	2	0,5	00:51	5	6	2	04:00	05:00	06:30	03:30
4,5	17	2	0,5	00:53	5	6	2	04:00	05:00	06:30	03:30
6,8	11	3	0,5	01:19	6	7	3	05:50	07:18	09:16	04:53
8,4	9	4	1	01:36	6	8	4	06:59	08:46	11:11	05:50
10,3	7,4	5	1	01:57	7	10	5	08:19	10:28	13:28	06:59
12,5	6	5	1	02:20	7	11	5	09:49	12:26	16:06	08:17
15,1	5	6	1	02:46	8	14	6	11:30	14:39	19:16	09:46
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	5	1	01:34	6	8	5	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	7	1	02:45	8	14	7	11:26	14:34	19:09	09:43
18,1	5	8	1	03:17	9	16	8	13:25	17:14	22:54	11:29

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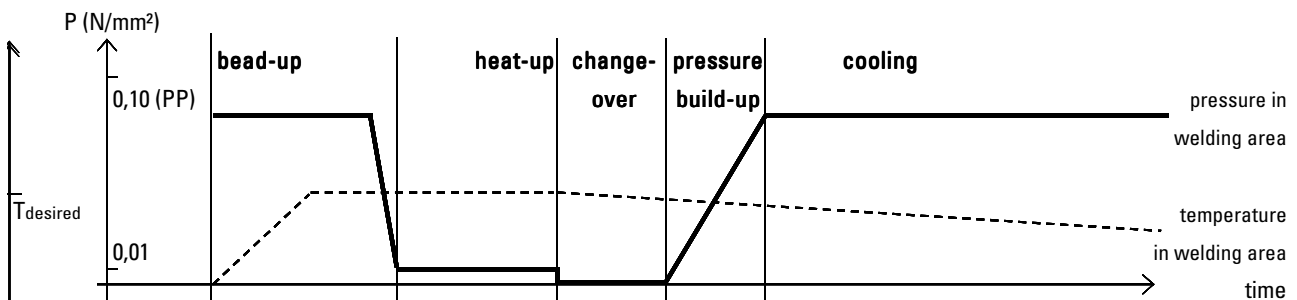
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 110											
2,7	41	2	0,5	00:32	5	6	2	04:00	05:00	06:30	03:30
3,4	33	3	0,5	00:40	5	6	3	04:00	05:00	06:30	03:30
4,2	26	3	0,5	00:49	5	6	3	04:00	05:00	06:30	03:30
6,3	17,6	4	0,5	01:13	6	7	4	05:26	06:48	08:40	04:35
6,6	17	5	0,5	01:17	6	7	5	05:41	07:06	09:01	04:46
10,0	11	7	1	01:53	7	9	7	08:06	10:12	13:06	06:48
12,3	9	8	1	02:18	7	11	8	09:42	12:15	15:52	08:10
15,1	7,4	9	1	02:46	8	14	9	11:30	14:39	19:16	09:46
18,3	6	11	1	03:19	9	16	11	13:33	17:24	23:09	11:36
22,1	5	12	1,5	03:55	10	19	12	16:13	20:39	27:33	13:46
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	6	1	01:22	6	7	6	06:04	07:35	09:37	05:04
7,4	17	6	1	01:25	6	7	6	06:17	07:52	09:59	05:14
11,4	11	8	1	02:09	7	11	8	09:05	11:28	14:47	07:38
14,0	9	10	1	02:35	8	13	10	10:47	13:43	17:56	09:09
17,1	7,4	12	1	03:07	8	15	12	12:47	16:22	21:42	10:55
20,8	6	14	1,5	03:43	10	18	14	15:17	19:33	26:03	13:02
25,1	5	16	1,5	04:23	11	21	16	18:21	23:14	30:58	15:29

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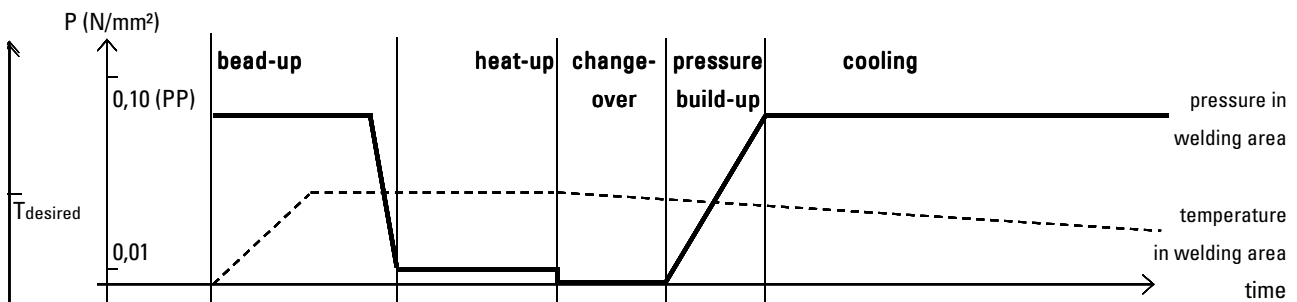
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 140											
3,5	41	3	0,5	00:41	5	6	3	04:00	05:00	06:30	03:30
4,3	33	4	0,5	00:51	5	6	4	04:00	05:00	06:30	03:30
5,4	26	5	0,5	01:03	5	6	5	04:43	05:54	07:35	04:02
8,0	17,6	7	1	01:32	6	8	7	06:42	08:24	10:42	05:36
8,3	17	7	1	01:35	6	8	7	06:55	08:40	11:04	05:47
12,7	11	10	1	02:22	7	12	10	09:57	12:36	16:21	08:24
15,7	9	12	1	02:53	8	14	12	11:53	15:10	20:00	10:07
19,2	7,4	15	1,5	03:28	9	17	15	14:09	18:10	24:14	12:07
23,3	6	17	1,5	04:06	10	20	17	17:04	21:41	28:55	14:27
28,1	5	19	2	04:48	12	24	19	20:32	25:55	34:29	17:20
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	9	1	01:44	6	9	9	07:28	09:23	12:01	06:16
9,5	17	9	1	01:48	6	9	9	07:45	09:45	12:30	06:30
14,6	11	13	1	02:41	8	13	13	11:10	14:14	18:39	09:29
17,9	9	16	1	03:15	9	16	16	13:18	17:03	22:40	11:22
21,9	7,4	19	1,5	03:53	10	19	19	16:04	20:29	27:19	13:39
26,6	6	22	2	04:36	11	23	22	19:26	24:33	32:43	16:23
32,1	5	25	2	05:21	13	28	25	23:26	29:33	39:13	19:53

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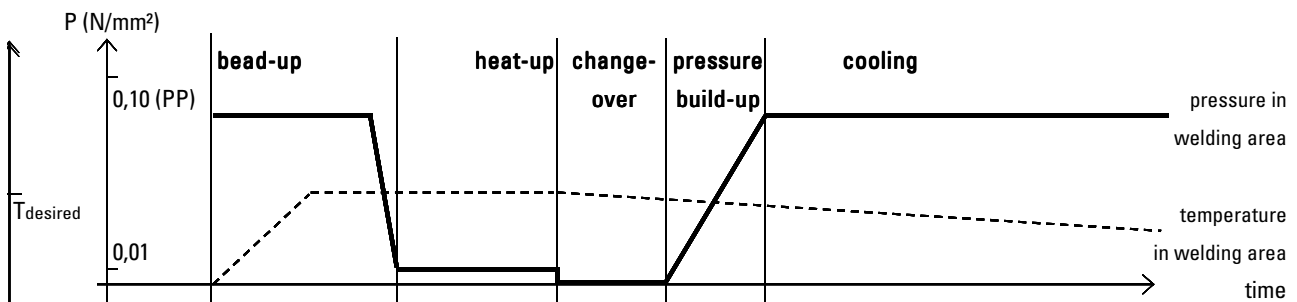
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 180											
4,4	41	5	0,5	00:52	5	6	5	04:00	05:00	06:30	03:30
5,5	33	6	0,5	01:04	5	6	6	04:48	06:00	07:42	04:06
6,9	26	8	0,5	01:20	6	7	8	05:55	07:24	09:23	04:56
10,2	17,6	11	1	01:56	7	10	11	08:14	10:23	13:20	06:55
10,7	17	11	1	02:01	7	10	11	08:35	10:50	13:56	07:13
16,4	11	17	1	03:00	8	15	17	12:20	15:46	20:51	10:31
20,1	9	20	1,5	03:36	9	18	20	14:47	18:57	25:15	12:38
24,6	7,4	24	1,5	04:18	11	21	24	18:00	22:48	30:24	15:12
29,0	6	27	2	04:56	12	25	27	21:11	26:44	35:33	17:55
36,1	5	32	2	05:55	14	31	32	26:21	33:11	43:56	22:26
DA 200											
4,9	41	6	0,5	00:57	5	6	6	04:19	05:24	06:59	03:44
6,2	33	8	0,5	01:12	6	7	8	05:22	06:42	08:32	04:31
7,7	26	9	1	01:29	6	8	9	06:29	08:08	10:20	05:25
11,4	17,6	13	1	02:09	7	11	13	09:05	11:28	14:47	07:38
11,9	17	14	1	02:14	7	11	14	09:26	11:55	15:23	07:56
18,2	11	20	1	03:18	9	16	20	13:29	17:19	23:02	11:33
22,4	9	25	1,5	03:58	10	19	25	16:26	20:55	27:53	13:57
27,4	7,4	29	2	04:43	11	23	29	20:01	25:16	33:39	16:53
33,2	6	34	2	05:31	13	29	34	24:14	30:33	40:31	20:35

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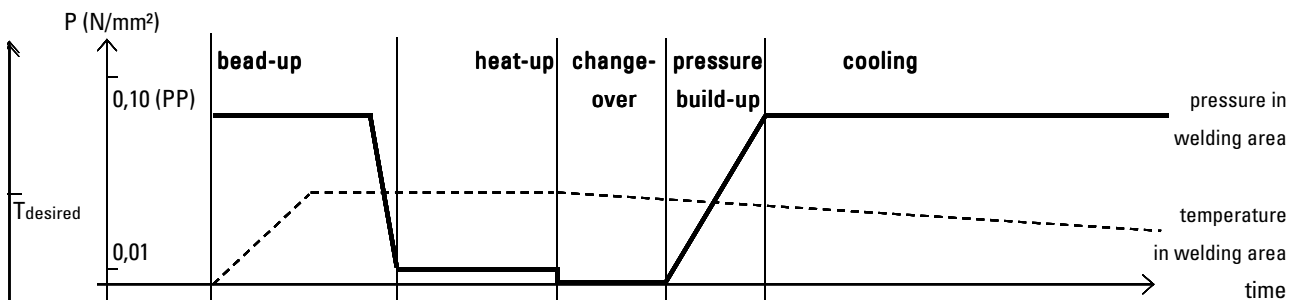
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 225											
5,5	41	8	0,5	01:04	5	6	8	04:48	06:00	07:42	04:06
6,9	33	10	0,5	01:20	6	7	10	05:55	07:24	09:23	04:56
8,6	26	12	1	01:38	6	8	12	07:07	08:56	11:25	05:58
12,8	17,6	17	1	02:23	7	12	17	10:01	12:41	16:28	08:27
13,4	17	18	1	02:29	7	12	18	10:24	13:12	17:12	08:48
20,5	11	26	1,5	03:40	9	18	26	15:04	19:17	25:43	12:51
25,2	9	31	1,5	04:24	11	21	31	18:26	23:19	31:05	15:33
30,8	7,4	37	2	05:11	12	26	37	22:29	28:22	37:40	19:03
37,4	6	43	2,5	06:05	14	32	43	27:17	34:22	45:30	23:15
DA 250											
6,2	41	10	0,5	01:12	6	7	10	05:22	06:42	08:32	04:31
7,7	33	12	1	01:29	6	8	12	06:29	08:08	10:20	05:25
9,6	26	14	1	01:49	7	9	14	07:49	09:50	12:37	06:34
14,2	17,6	21	1	02:37	8	13	21	10:55	13:53	18:10	09:15
14,8	17	22	1	02:43	8	13	22	11:18	14:24	18:54	09:36
22,7	11	32	1,5	04:00	10	20	32	16:39	21:10	28:14	14:07
27,9	9	38	2	04:47	12	24	38	20:23	25:44	34:15	17:13
34,2	7,4	45	2	05:39	13	29	45	24:58	31:27	41:41	21:13

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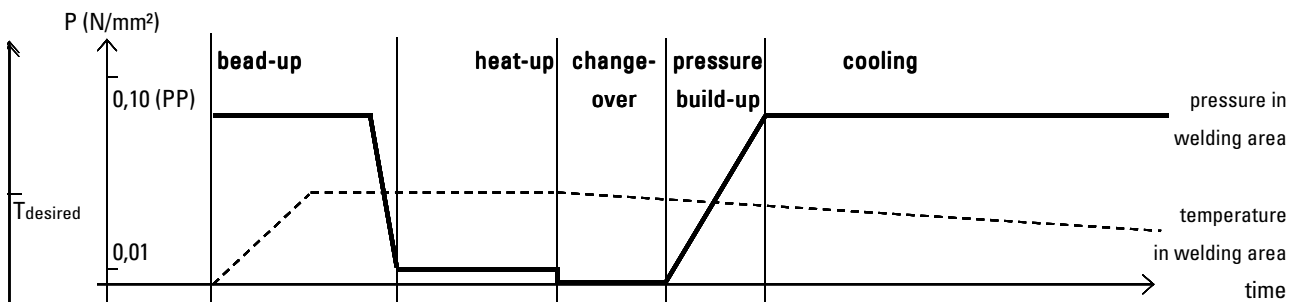
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[mm]		[bar]	[mm]	[min:s]	[s]	[s]	[bar]	[min:s]	[min:s]	[min:s]	[min:s]
DA 280											
6,9	41	12	0,5	01:20	6	7	12	05:55	07:24	09:23	04:56
8,6	33	15	1	01:38	6	8	15	07:07	08:56	11:25	05:58
10,7	26	18	1	02:01	7	10	18	08:35	10:50	13:56	07:13
15,9	17,6	26	1	02:55	8	14	26	12:00	15:21	20:14	10:14
16,6	17	27	1	03:02	8	15	27	12:27	15:57	21:05	10:38
25,4	11	40	1,5	04:25	11	22	40	18:34	23:29	31:19	15:39
31,3	9	48	2	05:15	12	27	48	22:51	28:49	38:16	19:22
38,3	7,4	56	2,5	06:11	14	33	56	27:54	35:12	46:36	23:48
DA 315											
7,7	41	15	1	01:29	6	8	15	06:29	08:08	10:20	05:25
9,7	33	18	1	01:50	7	9	18	07:53	09:56	12:44	06:37
12,1	26	23	1	02:16	7	11	23	09:34	12:05	15:37	08:03
17,9	17,6	33	1	03:15	9	16	33	13:18	17:03	22:40	11:22
18,7	17	34	1	03:23	9	17	34	13:48	17:45	23:38	11:50
28,6	11	50	2	04:53	12	24	50	20:53	26:22	35:04	17:39
35,2	9	60	2	05:47	14	30	60	25:41	32:22	42:52	21:51