

Table for PP



Basis: DVS data sheets 2207, 2208 - State 2017

Field of application: **5100 / 5500**

1 bar on manometer: **141** N (Effective surface of cylinder: 1414 mm² / 2,19 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%.

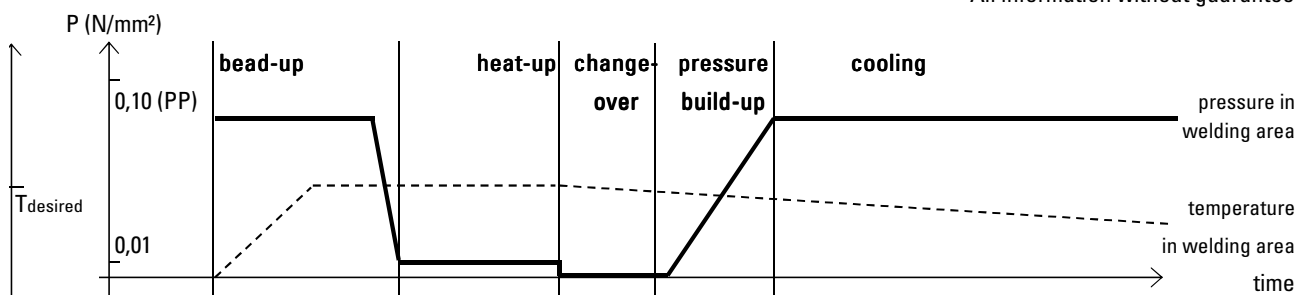
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All information without guarantee



pipe wall (s)	SDR degree	bead-up pressure [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 200											
4,9	41	3	0,5	00:57	5	6	3	04:19	05:24	06:59	03:44
6,2	33	3	0,5	01:12	6	7	3	05:22	06:42	08:32	04:31
7,7	26	4	1	01:29	6	8	4	06:29	08:08	10:20	05:25
11,4	17,6	5	1	02:09	7	11	5	09:05	11:28	14:47	07:38
11,9	17	5	1	02:14	7	11	5	09:26	11:55	15:23	07:56
18,2	11	8	1	03:18	9	16	8	13:29	17:19	23:02	11:33
22,4	9	9	1,5	03:58	10	19	9	16:26	20:55	27:53	13:57
27,4	7,4	11	2	04:43	11	23	11	20:01	25:16	33:39	16:53
33,2	6	13	2	05:31	13	29	13	24:14	30:33	40:31	20:35
DA 225											
5,5	41	3	0,5	01:04	5	6	3	04:48	06:00	07:42	04:06
6,9	33	4	0,5	01:20	6	7	4	05:55	07:24	09:23	04:56
8,6	26	5	1	01:38	6	8	5	07:07	08:56	11:25	05:58
12,8	17,6	7	1	02:23	7	12	7	10:01	12:41	16:28	08:27
13,4	17	7	1	02:29	7	12	7	10:24	13:12	17:12	08:48
20,5	11	10	1,5	03:40	9	18	10	15:04	19:17	25:43	12:51
25,2	9	12	1,5	04:24	11	21	12	18:26	23:19	31:05	15:33
30,8	7,4	14	2	05:11	12	26	14	22:29	28:22	37:40	19:03
37,4	6	16	2,5	06:05	14	32	16	27:17	34:22	45:30	23:15

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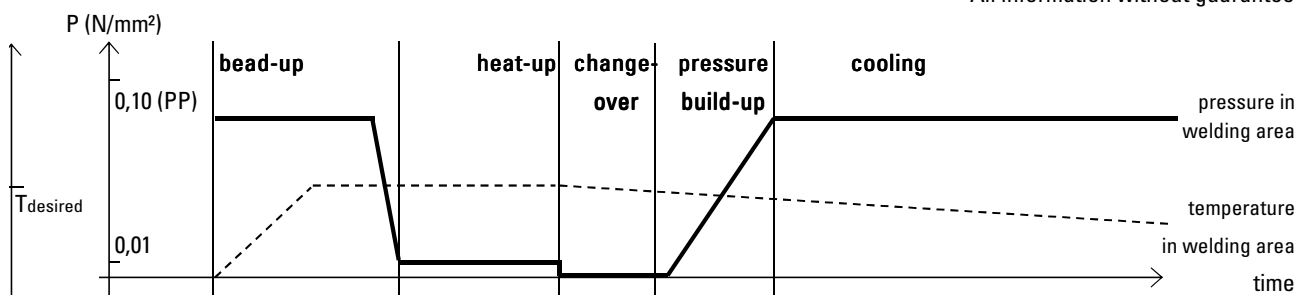
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 250											
6,2	41	4	0,5	01:12	6	7	4	05:22	06:42	08:32	04:31
7,7	33	5	1	01:29	6	8	5	06:29	08:08	10:20	05:25
9,6	26	6	1	01:49	7	9	6	07:49	09:50	12:37	06:34
14,2	17,6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

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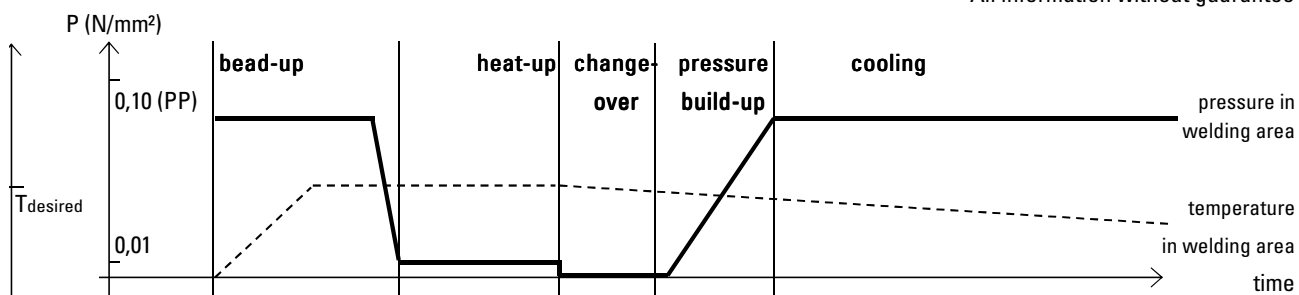
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 315											
7,7	41	6	1	01:29	6	8	6	06:29	08:08	10:20	05:25
9,7	33	7	1	01:50	7	9	7	07:53	09:56	12:44	06:37
12,1	26	9	1	02:16	7	11	9	09:34	12:05	15:37	08:03
17,9	17,6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

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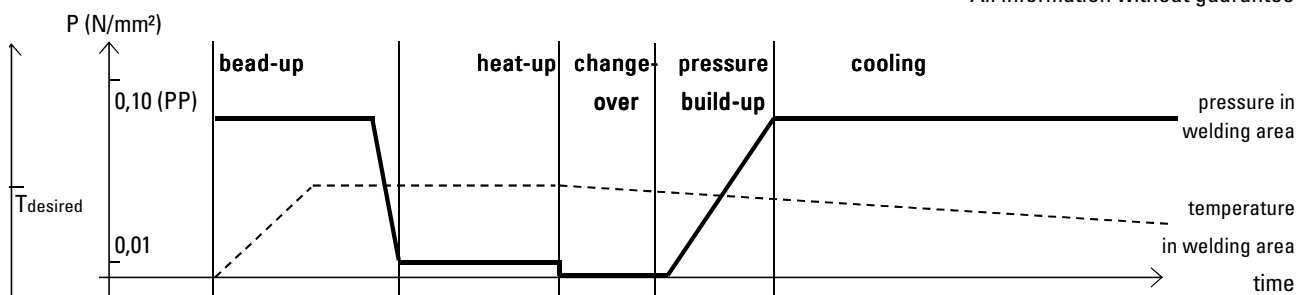
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								< 15°C < 59°F [min:s]	15-25°C 59-77°F [min:s]	> 25°C > 77°F [min:s]	
DA 400											
9,8	41	9	1	01:51	7	9	9	07:58	10:01	12:52	06:41
12,3	33	11	1	02:18	7	11	11	09:42	12:15	15:52	08:10
15,3	26	14	1	02:48	8	14	14	11:37	14:50	19:30	09:53
22,7	17,6	20	1,5	04:00	10	20	20	16:39	21:10	28:14	14:07
23,7	17	20	1,5	04:10	10	20	20	17:21	22:02	29:22	14:41
36,3	11	30	2	05:56	14	31	30	26:29	33:22	44:10	22:33
DA 450											
11,0	41	11	1	02:04	7	10	11	08:48	11:06	14:18	07:24
13,8	33	14	1	02:33	8	13	14	10:39	13:33	17:41	09:02
17,2	26	17	1	03:08	8	15	17	12:51	16:27	21:49	10:58
25,5	17,6	25	1,5	04:26	11	22	25	18:39	23:34	31:26	15:43
26,7	17	26	2	04:37	11	23	26	19:31	24:38	32:50	16:27
40,9	11	38	2,5	06:28	15	35	38	29:42	37:36	49:48	25:24
DA 500											
12,3	41	14	1	02:18	7	11	14	09:42	12:15	15:52	08:10
15,3	33	17	1	02:48	8	14	17	11:37	14:50	19:30	09:53
19,1	26	21	1,5	03:27	9	17	21	14:04	18:05	24:07	12:03
28,4	17,6	30	2	04:51	12	24	30	20:45	26:11	34:50	17:32
29,7	17	32	2	05:02	12	25	32	21:41	27:22	36:22	18:21