

Section III - Bench Socket Welding Parameters

Nominal Pipe Size (inches)	Heat Soak Time (sec)	Adjusting Time (sec)	Cooling Time (min)
Pro 150			
1/2	5	4	2
3/4	7	4	2
1	8	6	4
1-1/4	12	6	4
1-1/2	18	6	4
2	24	8	6
2-1/2	30	8	6
3	40	8	6
4	50	10	8
Air Pro			
1/2	5	4	2
3/4	7	4	2
1	8	6	4
1-1/4	12	6	4
1-1/2	19	6	4
2	24	8	6
2-1/2	30	8	6
3	40	8	6
4	50	10	8
PVDF			
1/2	3	3	3
3/4	4	3	3
1	5	3	3
1-1/4	6	4	4
1-1/2	8	4	5
2	10	5	6
2-1/2	12	5	6
3	15	6	8
4	20	6	10

Welding Temperatures:

Pro 150	260°C = 500°F
Air Pro	260°C = 500°F
PVDF	260°C = 500°F

Note: Must use Purad PVDF 230 PSI pipe for 3" and 4" (90 and 110mm) Purad 230 is SDR21, PN 16 pipe material.