

Section V - Welding Parameters Field 20 Widos (W5500)

Single Wall Butt Fusion

NOMINAL PIPE SIZE (INCHES)	INITIAL MELT PRESSURE		MELT PRESSURE	HEAT SOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE		COOLING TIME (MIN)
	BAR	(PSI)				BAR	(PSI)	
Pro 150								
8	10	(142)		180	10	10	(142)	27
10	14	(199)		200	10	14	(199)	29
12	21	(299)	Almost	260	12	21	(299)	37
14	26	(370)		295	15	26	(370)	42
16	41	(583)	Zero	340	15	41	(583)	47
18	48	(683)		380	15	48	(683)	53
20	52	(740)		420	15	52	(740)	59
Pro 45								
8	3	(45)		70	8	3	(45)	10
10	5	(71)		80	8	5	(71)	10
12	8	(114)	Almost	100	8	8	(114)	12
14	10	(140)		110	8	10	(140)	14
16	12	(171)	Zero	125	8	12	(171)	16
18	16	(228)		140	8	16	(228)	18
20	19	(270)		155	12	19	(270)	20
PVDF								
8	3.5	(49.3)	Almost	90	6	3.5	(49.3)	12
10	5.5	(78.5)		120	8	5.5	(78.5)	14
12	8.7	(124.2)	Zero	150	10	8.7	(124.2)	20

Welding Temperatures

HDPE	420°F-446°F	215°C-230°C
PP	393°F-410°F	200°C-210°C
PVDF	436°F-446°F	225°C-230°C

Field 20 Widos (W5500) Welding Parameters

Double Containment Butt Fusion

NOMINAL PIPE SIZE (INCHES)	INITIAL MELT PRESSURE BAR (PSI)	MELT PRESSURE	HEAT SOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE BAR (PSI)	COOLING TIME (MIN)
Pro 150 x 45						
6 x 10	8.8 (127)		130	8	8.8 (127)	16
8 x 12	13 (200)	Almost	180	8	13 (200)	23
10 x 14	19 (285)		230	8	19 (285)	29
12 x 16	24 (411)	Zero	290	8	24 (411)	37
14 x 18	35 (521)		325	8	35 (521)	42
16 x 20	45 (654)		370	12	45 (654)	47
Pro 150 x 150						
6 x 10	15.8 (230)	Almost	230	10	15.8 (230)	29
8 x 12	25.0 (364)		290	10	25.0 (364)	29
10 x 14	34 (493)	Zero	325	12	34 (493)	42
12 x 18	69 (982)		380	15	69 (982)	53
Pro 45 x 45						
6 x 10	6.1 (89)		80	8	6.1 (89)	10
8 x 12	9.1 (132)	Almost	100	8	9.1 (132)	12
10 x 14	12.4 (186)		110	8	12.4 (186)	14
12 x 16	17.0 (247)	Zero	125	8	17.0 (247)	18
14 x 18	21.5 (313)		140	8	21.5 (313)	20
16 x 20	27 (389)		158	8	27 (389)	20
PVDF x PVDF						
6 x 10	10.3 (150)		120	6	10.3 (150)	18
8 x 12	12 (173)	Zero	150	6	12 (173)	20

Welding Temperatures

HDPE	420°F-446°F	215°C-230°C
PP	393°F-410°F	200°C-210°C
PVDF	436°F-446°F	225°C-230°C