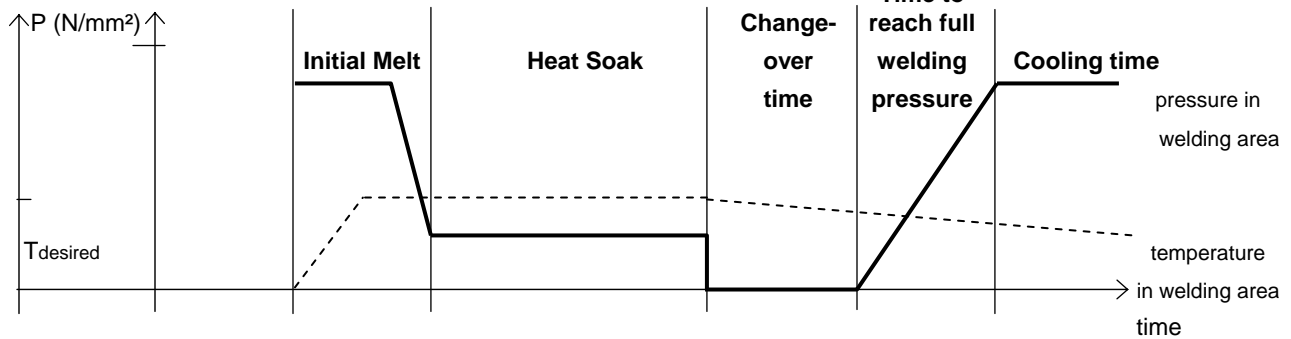


## Section V - Welding Parameters for Field 6 W4400

Example Graph



### Single Wall Butt Fusion

PIPE SIZE (INCHES)	INITIAL MELT PRESSURE BAR (PSI)	MELT PRESSURE	HEATSOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE BAR (PSI)	COOLING TIME (MIN)
<b>Pro 150</b>						
1 ½	2.5 (37)		35	4	2.5 (37)	6
2	4.1 (60)		45	5	4.1 (60)	7
2 ½	5.9 (86)	Almost	55	7	5.9 (86)	9
3	8.2 (120)	Zero	60	8	8.2 (120)	10
4	12.3 (180)		80	9	12.3 (180)	13
6	26.3 (387)		100	10	26.3 (387)	16
<b>Pro 45</b>						
4	4.6 (68)	Almost	35	5	4.6 (68)	5
6	9.6 (141)	Zero	45	5	9.6 (141)	5
<b>Air Pro</b>						
4 (230 psi)	12.5 (183)	Almost	100	9	12.5 (183)	13
6 (150 psi)	39.1 (575)	Zero	200	10	39.1 (575)	15
<b>PVDF</b>						
1 ½ (230 psi)	2.1 (32)		30	4	2.1 (32)	5
2 (230 psi)	2.8 (42)		35	4	2.8 (42)	5
2 ½ (230 psi)	2.8 (42)	Almost	40	4	2.8 (42)	5
3 (150 psi)	3.9 (58)	Zero	30	4	3.9 (58)	6
4 (150 psi)	6.0 (89)		40	4	6.0 (89)	7
6 (150 psi)	12.5 (183)		60	4	12.5 (183)	10

### 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 6 W4400**  
**Single Wall Butt Fusion**

PIPE SIZE (INCHES)	INITIAL MELT PRESSURE BAR (PSI)	MELT PRESSURE	HEATSOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE BAR (PSI)	COOLING TIME (MIN)
<b>HDPE SDR 11 (IPS PE 80)</b>						
2	6 (90)		55	5	6 (90)	10
3	12 (175)	Almost	81	5	12 (175)	16
4	20 (296)	Zero	104	6	20 (296)	16
<b>HDPE SDR 17 (IPS PE 80)</b>						
2	4 (60)		35	3	4 (60)	5
3	8 (120)	Almost	52	5	8 (120)	7
4	14 (205)	Zero	67	5	14 (205)	10
<b>HDPE SDR 26 (IPS PE 80)</b>						
2	3 (45)		23	3	3 (45)	5
3	6 (90)	Almost	34	3	6 (90)	6
4	9 (135)	Zero	44	4	9 (135)	6
<b>HDPE SDR 32.5 (IPS PE 80)</b>						
2	2 (30)		19	3	2 (30)	5
3	4 (60)	Almost	27	3	4 (60)	5
4	7 (105)	Zero	35	3	7 (105)	5

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 6 W4400**  
**Double Containment Butt Fusion**

PIPE SIZE (INCHES)	INITIAL MELT PRESSURE BAR (PSI)	MELT PRESSURE	HEATSOAK TIME (SEC)	CHANGE OVER TIME (SEC)	WELDING PRESSURE BAR (PSI)	COOLING TIME (MIN)
<b>Pro 150 x Pro 45</b>						
2 x 4	8.7 (128)	Almost	60	5	8.7 (128)	7
3 x 6	17.8 (261)	Zero	80	5	17.8 (261)	10
<b>Pro 150 x Pro 150</b>						
2 x 4	16.4 (241)	Almost	100	5	16.4 (241)	13
3 x 6	34.5 (507)	Zero	130	8	34.5 (507)	16
<b>PVDF x PVDF</b>						
2 x 4	8.9 (131)	Almost	50	4	8.9 (131)	7
3 x 6	16.4 (241)	Zero	70	4	16.4 (241)	10
<b>Poly-Flo Polypropylene</b>						
4 x 6	17 (247)	Almost Zero	80	8	17 (247)	10
<b>Poly-Flo HDPE</b>						
4 x 6	25 (363)	Almost Zero	50	8	25 (363)	15
<b>HDPE SDR 11 x SDR 11 (IPS PE 80)</b>						
2 x 4	26 (385)	Almost Zero	104	4	26 (385)	16
<b>HDPE SDR 11 x SDR 17 (IPS PE 80)</b>						
2 x 4	19 (280)	Almost Zero	67	3	19 (280)	10
<b>HDPE SDR 17 x SDR 17 (IPS PE 80)</b>						
2 x 4	17 (250)	Almost Zero	67	3	17 (250)	10

Welding Temperatures

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