

Proweld™ Equipment

Owner & Maintenance

Manual

FIELD 6 TRENCH

(Widos 4400)



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Section I - Safety Precautions for Trench Machines

1. Keep working area clean and tidy.
2. Keep electrical tools away from moisture. Never use in wet environment or humid conditions. Working area should be well illuminated. Keep tools away from chemicals and other corrosive materials.
3. Keep visitors at a safe distance.
4. Electrical tools not in use should be stored away safely.
5. Do not wear loose clothing or jewelry. They can inadvertently get stuck in the moving parts of the machine causing injury.
6. Never carry tools by the electric cable. Never unplug by pulling the cable. Keep cables away from oil, heat and sharp edges.
7. Always check that the pipe and fittings are clamped down tightly.
8. The heating element can reach temperatures in excess of 300°C (570°F). Do not touch the surface, and keep non-operating personnel at a safe distance.
9. Do not touch facing unit blades while tool is connected to power supply. Activate facing unit only when it is in the working position.
10. When bringing clamps and pipe together, make sure hands are not between the clamps.
11. Keep tools clean and sharpened. They produce better and safer results. Missing and worn-out parts should be replaced immediately. Always assure that the accessories are properly mounted on the machine. Only use factory parts.
12. Always disconnect the machine when not in use when performing maintenance or when accessories are being changed.
13. Before connecting to power, check that any accessory tools (e.g. facing unit motor) are turned off.
14. Always use correct extension cable.
15. Do not use tools and machines when housing or handles, specifically plastic ones, are bent or cracked. Dirt and humidity in any fracture can lead to electrical shock should the insulation in the machine be damaged.

Section II - Welding Conditions

1. The welding environment needs to be protected against unfavorable conditions, e.g. rain, wind, dust, excessive humidity or temperature below 5°C (41°F).
2. It needs to be assured that the pipe wall temperature is adequate for welding. If necessary, the pipe has to be warmed up or an environmentally controlled welding tent needs to be erected. If these conditions are met, the welding can be performed at virtually any environmental temperature. It is advisable to verify the weld quality by making some test welds at the given conditions.
3. Should the pipe be irregularly heated by intense sunshine, it may be necessary to cover the pipe ends to be welded so that a balanced temperature is obtained.
4. The pipe ends to be welded must be checked for damage and be free from oil, grease, dirt and other contaminants. Cleaning the pipe ends must be done just prior to welding.
5. The weld must be kept free from external stresses during the weld process until the material has sufficiently cooled.
6. The weld process has to be observed continuously. It is recommended to keep a record of each weld.
7. A stop watch is to be available in order to register the actual times for heating up and cooling down.
8. A heat stick or pyrometer is to be available in order to verify the correct heating element temperature.
9. A table is to be available from which you can read the parameters that are prescribed by the welding regulation for the pipe dimension to be welded.
10. The heating element surfaces are to be clean and, above all, free from grease. Therefore, they are to be cleaned with lint free paper and detergent (e.g. technical cleaned spirit) before every welding or if they are dirty.

Section III - Machine Set Up and Operation

1. General Tool Information

- A. Size Range: 1½" – 6" (50 mm – 160 mm)
Amperage: 20 Amp.
Voltage: 220 AC
- B. Additional Technical Data

Pipe/Fitting Material:	PE, PP, PVDF
Pipe/Fitting Sizes:	1½" – 6" (50 mm – 160 mm)
Transport box (LxBxH):	33 x 33 x 26 inches
Weight:	Appr. 270 lbs.
Fuse:	20 Amp
Voltage Requirement:	220 V (+/- 10%)

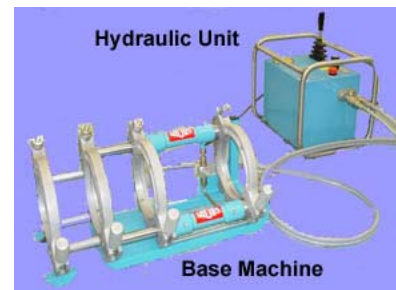
2. Hydraulic Hose Connection & Electrical Connection

- A. Use the two hydraulic hoses to connect the base machine to the hydraulic unit. The non-dripping quick couplings need to be kept free of dirt. When not in use, put on the red caps as protection.

⇒ Before disconnecting the hoses, make sure that there is zero pressure in the hoses. If there is pressure in the hoses, it will be difficult to re-connect the hoses.

- B. Put heater and facing unit into the storage case.

- C. Connect the heating element and facing unit power cables to the power outlets on the hydraulic unit.



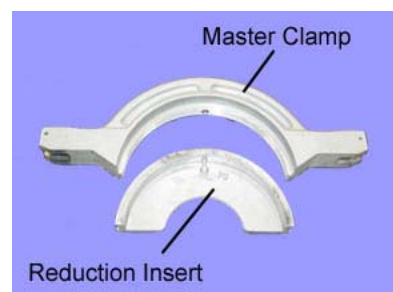
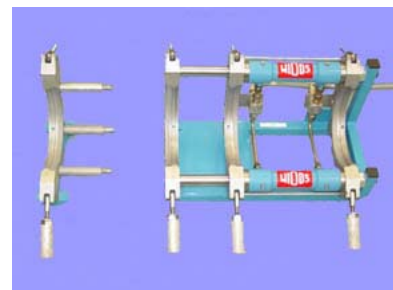
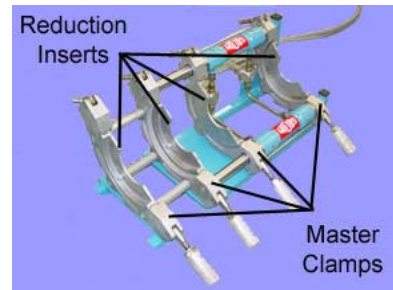
3. Heating Element Temperature Setting

- A. The thermostat is located on the handle of the heating element. The main amber light will be on when there is power to the unit. The green light will be on when the unit is heating and will blink when the unit is up to temperature.
- B. Set the thermostat to the appropriate temperature.
 - I. HDPE 215°C-230°C / 420°F-446°F
 - II. PP 200°C-210°C / 393°F-410°F
 - III. PVDF 225°C-230°C / 436°F-446°F



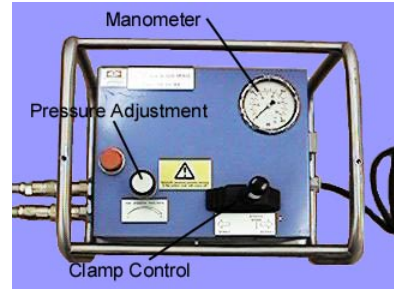
4. Installation of Reducer Inserts

- A. Unscrew the already mounted reduction inserts from the master clamps.
- B. Screw on the reduction inserts with the corresponding diameter into the master clamps.
- C. If necessary (e.g. T-pieces), the fixed outside clamping tool can be dismantled by unscrewing the three allen screws.



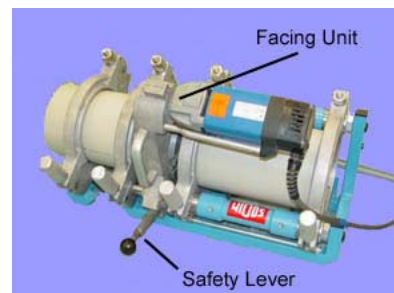
5. **Preparation For Welding**

- A. Place the hydraulic unit so that the manometer is easily visible. Pull the lever to (< >) and hold until the welding carrier has moved back all the way.
- B. Open the clamps and insert the pipe or fitting that is to be welded, allowing enough space between the pipe ends for placing the facing unit. Mount the upper clamps and tighten them with the brass nuts.
- C. Check whether both worked pieces are clamped tight by applying the weld pressure to ensure that they do not slide back in the clamps.



6. **Facing**

- A. Place the facing unit onto the machine shafts between the two pipe ends. Make sure the safety lever is locked in place.
- B. With the hydraulic unit, carefully move the welding carrier in to the rotating facing unit. Use the hydraulic control to adjust the proper pressure for facing. Do not use too much pressure during the facing process, as this can burn out the facing unit.



7. **Adjustment of Carrier Movement Pressure (Drag Pressure)**

- A. Turn the pressure control valve counter clockwise to release the hydraulic pressure.
- B. Move the lever on the hydraulic unit in the direction (> <) and slowly turn the pressure control valve in a clockwise direction until the carrier moves. Read off the pressure at the manometer (pressure gage on the hydraulic unit). This pressure (referred to as drag pressure) must be added to the calculated weld pressure.
- C. Bring the pipe ends together and turn the pressure control valve to set the weld pressure (carrier movement pressure + calculated weld pressure).

⇒ For welding pressures and times, please refer to the welding data charts located at the end of this instruction manual.

8. **Alignment**

- A. With the pipe ends together, check for any offset. Small adjustments for high low can be made by tightening and loosening the brass nuts. AWS/DVS standards allow a maximum tolerance of 10% of the wall thickness to be misaligned. After alignment is verified, move the pipe ends apart.

9. **Initial Heating**

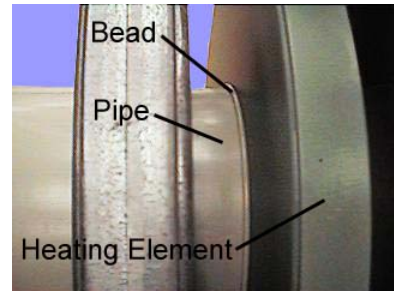
- A. Check temperature setting of the heating element (see the charts at the end of this manual for welding temperatures). A heat stick or pyrometer should be used to verify temperature. Once the heater is at the proper temperature, place the heating element between the pipe ends, so that it rests by the heater plate ears on the shafts.



- B. Using the control lever on the hydraulic unit, bring the pipe ends against the heater applying the proper weld pressure (see charts at the end of this manual for proper welding pressures).



- C. Watch for a continuous bead to form around both pipe ends (see pipe manufacturer or AWS/DVS standards for size). Bead must be formed 360° around each pipe.
- D. Lower hydraulic pressure by either carefully moving the lever or by turning the pressure control valve in a counter clockwise motion.



⇒ **Note:** If the control lever is moved too far in this direction, the motor will activate and the carrier will open, moving the pipe away from the heater causing a bad weld.

10. **Heat Soak**

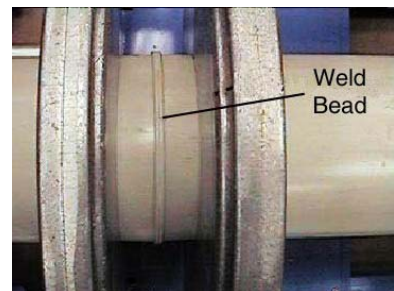
- A. With the pressure almost at zero, begin to time the heat soak process (see welding parameters). It is important to assure that the pipe ends remain in full contact with the heating element.

11. **Change Over Time**

- A. With the hydraulic unit, move the pipe ends apart. Remove the heating element and then bring the pipe ends back together.
- B. Bring the hydraulic pressure back to the original weld pressure. Do not over pressurize, as this will cause a bad weld. These steps must be performed within the allowable change over time (see parameters at the end of the manual for proper time).
- C. In the event that there is hydraulic pressure loss during the weld process, activate the hydraulic unit to bring the pressure back to the weld parameter as noted in the weld chart.

12. **Cooling Time**

- A. Keep the machine under pressure until the cooling time has expired.
- B. For PP and HDPE, Cooling time can be reduced by 50% under the following conditions:
 - I. Prefabrication under workshop conditions
 - II. Low additional pressure when unclamping
 - III. No additional pressure during further cool down
 - IV. System will not see pressure until cool down is complete



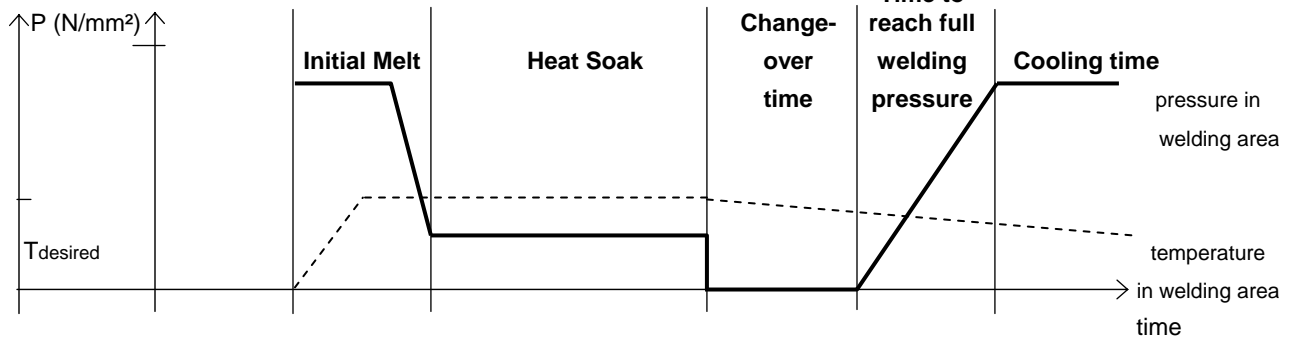
Section IV - Maintenance

To keep the machine in good working condition, the following should be observed:

1. Keep the hardened chrome guide shafts free of dirt.
2. Assure that the machine is always connected to proper power supply.
3. Keep heating element clean. Whenever necessary, wipe residue off with clean, lint free cloth while the element is at operating temperature.
4. Keep sufficient oil in the hydraulic tank in order not to damage the pump. Always use high quality hydraulic oil, commonly used in tractors and construction equipment.
5. All hydraulic quick couplings need to be kept free of dirt by keeping the protective caps in place at all times.
6. Assure that blades are sharp at all times. The blade design allows for reversal to use both sides. If necessary, replace blades.
7. For a long service life clean and grease regularly the threaded spindles and the joint parts which are used for clamping the pipe.
8. Asahi/America recommends maintenance work after one year for contractor owned tools.

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)
Pro 150						
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
Pro 45						
4	4.6 (68)	Almost	35	5	4.6 (68)	5
6	9.6 (141)	Zero	45	5	9.6 (141)	5
Air Pro						
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
PVDF						
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)
HDPE SDR 11 (IPS PE 80)						
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
HDPE SDR 17 (IPS PE 80)						
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
HDPE SDR 26 (IPS PE 80)						
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
HDPE SDR 32.5 (IPS PE 80)						
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)
Pro 150 x Pro 45						
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
Pro 150 x Pro 150						
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
PVDF x PVDF						
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
Poly-Flo Polypropylene						
4 x 6	17 (247)	Almost Zero	80	8	17 (247)	10
Poly-Flo HDPE						
4 x 6	25 (363)	Almost Zero	50	8	25 (363)	15
HDPE SDR 11 x SDR 11 (IPS PE 80)						
2 x 4	26 (385)	Almost Zero	104	4	26 (385)	16
HDPE SDR 11 x SDR 17 (IPS PE 80)						
2 x 4	19 (280)	Almost Zero	67	3	19 (280)	10
HDPE SDR 17 x SDR 17 (IPS PE 80)						
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

Notes:

Tool Department Contacts

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