

Shop 12 (Butt) Welding Parameters

CURRENT AS OF
04/11/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Air-Pro® (PE)	1-1/2" (50mm) SDR7	33.7 lbs	1 mm	Almost Zero	69 seconds	6 seconds	33.7 lbs	7.4 min
Air-Pro® (PE)	2" (63mm) SDR7	51.7 lbs	1.5 mm	Almost Zero	86 seconds	7 seconds	51.7 lbs	8.9 min
Air-Pro® (PE)	3" (90mm) SDR7	103.4 lbs	2 mm	Almost Zero	123 seconds	8 seconds	103.4 lbs	12.3 min
Air-Pro® (PE)	4" (110mm) SDR7	152.9 lbs	2 mm	Almost Zero	151 seconds	9 seconds	152.9 lbs	14.8 min
Air-Pro® (PE)	6" (160mm) SDR11	227.1 lbs	2 mm	Almost Zero	146 seconds	9 seconds	227.1 lbs	14.2 min
Asahitec™ Solid Wall (PP-RCT)	1-1/2" (50mm) SDR11	15.7 lbs	0.5 mm	Almost Zero	54 seconds	5 seconds	15.7 lbs	5.1 min
Asahitec™ Solid Wall (PP-RCT)	2" (63mm) SDR11	24.7 lbs	0.5 mm	Almost Zero	68 seconds	6 seconds	24.7 lbs	6.3 min
Asahitec™ Solid Wall (PP-RCT)	2-1/2" (75mm) SDR11	33.7 lbs	0.5 mm	Almost Zero	79 seconds	6 seconds	33.7 lbs	7.3 min
Asahitec™ Solid Wall (PP-RCT)	3" (90mm) SDR11	49.5 lbs	1 mm	Almost Zero	94 seconds	6 seconds	49.5 lbs	8.6 min
Asahitec™ Solid Wall (PP-RCT)	4" (110mm) SDR11	71.9 lbs	1 mm	Almost Zero	113 seconds	7 seconds	71.9 lbs	10.2 min
Asahitec™ Solid Wall (PP-RCT)	5" (125mm) SDR11	92.2 lbs	1 mm	Almost Zero	129 seconds	7 seconds	92.2 lbs	11.5 min
Asahitec™ Solid Wall (PP-RCT)	6" (160mm) SDR11	150.6 lbs	1 mm	Almost Zero	161 seconds	8 seconds	150.6 lbs	14.2 min
Asahitec™ Solid Wall (PP-RCT)	8" (200mm) SDR11	233.8 lbs	1 mm	Almost Zero	198 seconds	9 seconds	233.8 lbs	17.3 min



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Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Asahitec™ Solid Wall (PP-RCT)	1-1/2" (50mm) SDR7	22.5 lbs	0.5 mm	Almost Zero	80 seconds	6 seconds	22.5 lbs	7.4 min
Asahitec™ Solid Wall (PP-RCT)	2" (63mm) SDR7	33.7 lbs	1 mm	Almost Zero	98 seconds	6 seconds	33.7 lbs	8.9 min
Asahitec™ Solid Wall (PP-RCT)	2-1/2" (75mm) SDR7	47.2 lbs	1 mm	Almost Zero	117 seconds	7 seconds	47.2 lbs	10.5 min
Asahitec™ Solid Wall (PP-RCT)	3" (90mm) SDR7	69.7 lbs	1 mm	Almost Zero	138 seconds	7 seconds	69.7 lbs	12.3 min
Asahitec™ Solid Wall (PP-RCT)	4" (110mm) SDR7	103.4 lbs	1 mm	Almost Zero	166 seconds	8 seconds	103.4 lbs	14.7 min
Asahitec™ Solid Wall (PP-RCT)	5" (125mm) SDR7	130.4 lbs	1 mm	Almost Zero	187 seconds	8 seconds	130.4 lbs	16.4 min
Chem Proline® (PE)	1-1/2" (50mm) SDR11	22.5 lbs	1 mm	Almost Zero	46 seconds	5 seconds	22.5 lbs	5.1 min
Chem Proline® (PE)	2" (63mm) SDR11	36.0 lbs	1 mm	Almost Zero	58 seconds	5 seconds	36.0 lbs	6.3 min
Chem Proline® (PE)	3" (90mm) SDR11	71.9 lbs	1.5 mm	Almost Zero	82 seconds	6 seconds	71.9 lbs	8.6 min
Chem Proline® (PE)	4" (110mm) SDR11	107.9 lbs	1.5 mm	Almost Zero	100 seconds	7 seconds	107.9 lbs	10.2 min
Chem Proline® (PE)	6" (160mm) SDR11	227.1 lbs	2 mm	Almost Zero	146 seconds	9 seconds	227.1 lbs	14.2 min
Climatec™ (PP-RCT)	1-1/2" (50mm) SDR11	15.7 lbs	0.5 mm	Almost Zero	54 seconds	5 seconds	15.7 lbs	5.1 min
Climatec™ (PP-RCT)	2" (63mm) SDR11	24.7 lbs	0.5 mm	Almost Zero	68 seconds	6 seconds	24.7 lbs	6.3 min



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- the joint connection was created under workshop conditions and
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Climatec™ (PP-RCT)	2-1/2" (75mm) SDR11	33.7 lbs	0.5 mm	Almost Zero	79 seconds	6 seconds	33.7 lbs	7.3 min
Climatec™ (PP-RCT)	3" (90mm) SDR11	49.5 lbs	1 mm	Almost Zero	94 seconds	6 seconds	49.5 lbs	8.6 min
Climatec™ (PP-RCT)	4" (110mm) SDR11	71.9 lbs	1 mm	Almost Zero	113 seconds	7 seconds	71.9 lbs	10.2 min
Climatec™ (PP-RCT)	5" (125mm) SDR11	92.2 lbs	1 mm	Almost Zero	129 seconds	7 seconds	92.2 lbs	11.5 min
Climatec™ (PP-RCT)	6" (160mm) SDR17	101.2 lbs	1 mm	Almost Zero	108 seconds	6 seconds	101.2 lbs	9.8 min
Climatec™ (PP-RCT)	8" (200mm) SDR17	159.6 lbs	1 mm	Almost Zero	134 seconds	7 seconds	159.6 lbs	11.9 min
Climatec™ (PP-RCT)	10" (250mm) SDR17	247.3 lbs	1 mm	Almost Zero	163 seconds	8 seconds	247.3 lbs	14.4 min
Proline® PRO150 (PP)	1-1/2" (50mm) SDR11	15.7 lbs	0.5 mm	Almost Zero	54 seconds	5 seconds	15.7 lbs	5.1 min
Proline® PRO150 (PP)	2" (63mm) SDR11	24.7 lbs	0.5 mm	Almost Zero	68 seconds	6 seconds	24.7 lbs	6.3 min
Proline® PRO150 (PP)	2-1/2" (75mm) SDR11	33.7 lbs	0.5 mm	Almost Zero	79 seconds	6 seconds	33.7 lbs	7.3 min
Proline® PRO150 (PP)	3" (90mm) SDR11	49.5 lbs	1 mm	Almost Zero	94 seconds	6 seconds	49.5 lbs	8.6 min
Proline® PRO150 (PP)	4" (110mm) SDR11	71.9 lbs	1 mm	Almost Zero	113 seconds	7 seconds	71.9 lbs	10.2 min
Proline® PRO150 (PP)	4-1/2" (125mm) SDR11	92.2 lbs	1 mm	Almost Zero	129 seconds	7 seconds	92.2 lbs	11.5 min



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A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

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Proline® PRO150 (PP)	5" (140mm) SDR11	114.7 lbs	1 mm	Almost Zero	142 seconds	7 seconds	114.7 lbs	12.6 min
Proline® PRO150 (PP)	6" (160mm) SDR11	150.6 lbs	1 mm	Almost Zero	161 seconds	8 seconds	150.6 lbs	14.2 min
Proline® PRO150 (PP)	7" (180mm) SDR11	191.1 lbs	1 mm	Almost Zero	180 seconds	8 seconds	191.1 lbs	15.8 min
Proline® PRO150 (PP)	8" (200mm) SDR11	233.8 lbs	1 mm	Almost Zero	198 seconds	9 seconds	233.8 lbs	17.3 min
Proline® PRO90 (PP)	1-1/2" (50mm) SDR17.6	9.0 lbs	0.5 mm	Almost Zero	34 seconds	5 seconds	9.0 lbs	5.0 min
Proline® PRO90 (PP)	2" (63mm) SDR17.6	15.0 lbs	0.5 mm	Almost Zero	42 seconds	5 seconds	15.0 lbs	5.0 min
Proline® PRO90 (PP)	2-1/2" (75mm) SDR17.6	22.0 lbs	0.5 mm	Almost Zero	51 seconds	5 seconds	22.0 lbs	5.0 min
Proline® PRO90 (PP)	3" (90mm) SDR17.6	31.0 lbs	0.5 mm	Almost Zero	60 seconds	5 seconds	31.0 lbs	5.4 min
Proline® PRO90 (PP)	4" (110mm) SDR17.6	46.0 lbs	0.5 mm	Almost Zero	73 seconds	6 seconds	46.0 lbs	6.5 min
Proline® PRO90 (PP)	4-1/2" (125mm) SDR17.6	60.0 lbs	1 mm	Almost Zero	82 seconds	6 seconds	60.0 lbs	7.4 min
Proline® PRO90 (PP)	5" (140mm) SDR17.6	75.0 lbs	1 mm	Almost Zero	92 seconds	6 seconds	75.0 lbs	8.2 min
Proline® PRO90 (PP)	6" (160mm) SDR17.6	97.0 lbs	1 mm	Almost Zero	104 seconds	6 seconds	97.0 lbs	9.2 min
Proline® PRO90 (PP)	7" (180mm) SDR17.6	121.0 lbs	1 mm	Almost Zero	116 seconds	7 seconds	121.0 lbs	10.2 min



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Proline® PRO90 (PP)	8" (200mm) SDR17.6	150.0 lbs	1 mm	Almost Zero	129 seconds	7 seconds	150.0 lbs	11.3 min
Proline® PRO90 (PP)	9" (225mm) SDR17.6	190.0 lbs	1 mm	Almost Zero	143 seconds	7 seconds	190.0 lbs	12.4 min
Proline® PRO90 (PP)	10" (250mm) SDR17.6	234.0 lbs	1 mm	Almost Zero	157 seconds	8 seconds	234.0 lbs	13.5 min
Proline® PRO90 (PP)	11" (280mm) SDR17.6	291.0 lbs	1 mm	Almost Zero	175 seconds	8 seconds	291.0 lbs	15.2 min
Proline® PRO90 (PP)	12" (315mm) SDR17.6	370.0 lbs	1 mm	Almost Zero	198 seconds	9 seconds	370.0 lbs	17.0 min
Proline® PRO45 (PP)	4" (110mm) SDR33	27.0 lbs	0.5 mm	Almost Zero	40 seconds	5 seconds	27.0 lbs	5.0 min
Proline® PRO45 (PP)	4-1/2" (125mm) SDR33	33.7 lbs	0.5 mm	Almost Zero	46 seconds	5 seconds	33.7 lbs	5.0 min
Proline® PRO45 (PP)	5" (140mm) SDR33	42.7 lbs	0.5 mm	Almost Zero	51 seconds	5 seconds	42.7 lbs	5.0 min
Proline® PRO45 (PP)	6" (160mm) SDR33	54.0 lbs	0.5 mm	Almost Zero	57 seconds	5 seconds	54.0 lbs	5.0 min
Proline® PRO45 (PP)	7" (180mm) SDR33	69.7 lbs	0.5 mm	Almost Zero	64 seconds	5 seconds	69.7 lbs	6.0 min
Proline® PRO45 (PP)	8" (200mm) SDR33	85.4 lbs	0.5 mm	Almost Zero	72 seconds	6 seconds	85.4 lbs	6.7 min
Proline® PRO45 (PP)	9" (225mm) SDR33	107.9 lbs	0.5 mm	Almost Zero	80 seconds	6 seconds	107.9 lbs	7.4 min
Proline® PRO45 (PP)	10" (250mm) SDR33	132.6 lbs	1 mm	Almost Zero	89 seconds	6 seconds	132.6 lbs	8.1 min



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Proline® PRO45 (PP)	11" (280mm) SDR33	166.4 lbs	1 mm	Almost Zero	98 seconds	6 seconds	166.4 lbs	8.9 min
Proline® PRO45 (PP)	12" (315mm) SDR33	211.3 lbs	1 mm	Almost Zero	110 seconds	7 seconds	211.3 lbs	9.9 min
Super Proline® (PVDF)	1-1/2" (50mm) SDR21	10.0 lbs	0.5 mm	Almost Zero	70 seconds	3 seconds	10.0 lbs	5.5 min
Super Proline® (PVDF)	2" (63mm) SDR21	13.0 lbs	0.5 mm	Almost Zero	70 seconds	3 seconds	13.0 lbs	5.5 min
Super Proline® (PVDF)	2-1/2" (75mm) SDR21	18.0 lbs	0.5 mm	Almost Zero	76 seconds	3 seconds	18.0 lbs	6.5 min
Super Proline® (PVDF)	3" (90mm) SDR21	26.0 lbs	0.5 mm	Almost Zero	83 seconds	3 seconds	26.0 lbs	7.0 min
Super Proline® (PVDF)	4" (110mm) SDR21	38.0 lbs	0.5 mm	Almost Zero	93 seconds	3 seconds	38.0 lbs	8.5 min
Super Proline® (PVDF)	6" (160mm) SDR21	81.0 lbs	0.7 mm	Almost Zero	117 seconds	4 seconds	81.0 lbs	11.0 min
Super Proline® (PVDF)	8" (200mm) SDR21	125.0 lbs	1 mm	Almost Zero	136 seconds	4 seconds	125.0 lbs	13.5 min
Super Proline® (PVDF)	10" (250mm) SDR21	194.0 lbs	1.1 mm	Almost Zero	159 seconds	4 seconds	194.0 lbs	16.5 min
Super Proline® (PVDF)	3" (90mm) SDR33	17.0 lbs	0.5 mm	Almost Zero	68 seconds	3 seconds	17.0 lbs	5.5 min
Super Proline® (PVDF)	4" (110mm) SDR33	25.0 lbs	0.5 mm	Almost Zero	74 seconds	3 seconds	25.0 lbs	6.0 min
Super Proline® (PVDF)	6" (160mm) SDR33	52.0 lbs	0.5 mm	Almost Zero	89 seconds	3 seconds	52.0 lbs	8.0 min



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Super Proline® (PVDF)	8" (200mm) SDR33	83.0 lbs	0.6 mm	Almost Zero	102 seconds	4 seconds	83.0 lbs	9.5 min
Super Proline® (PVDF)	10" (250mm) SDR33	128.0 lbs	0.7 mm	Almost Zero	117 seconds	4 seconds	128.0 lbs	11.0 min
Super Proline® (PVDF)	12" (315mm) SDR33	203.0 lbs	1 mm	Almost Zero	137 seconds	4 seconds	203.0 lbs	13.5 min
Ultra Proline® (ECTFE)	1-1/2" (50mm) SDR21	9.0 lbs	0.5 mm	Almost Zero	25 seconds	4 seconds	9.0 lbs	5.0 min
Ultra Proline® (ECTFE)	2" (63mm) SDR21	11.0 lbs	0.5 mm	Almost Zero	25 seconds	4 seconds	11.0 lbs	5.0 min
Ultra Proline® (ECTFE)	3" (90mm) SDR21	22.0 lbs	0.5 mm	Almost Zero	34 seconds	4 seconds	22.0 lbs	6.0 min
Ultra Proline® (ECTFE)	4" (110mm) SDR21	33.0 lbs	0.5 mm	Almost Zero	40 seconds	4 seconds	33.0 lbs	7.0 min
Ultra Proline® (ECTFE)	6" (160mm) SDR21	81.0 lbs	1 mm	Almost Zero	117 seconds	4 seconds	81.0 lbs	11.0 min
Watertec™ (PP-RCT)	1-1/2" (50mm) SDR9	18.0 lbs	0.5 mm	Almost Zero	65 seconds	5 seconds	18.0 lbs	6.1 min
Watertec™ (PP-RCT)	2" (63mm) SDR9	29.2 lbs	1 mm	Almost Zero	82 seconds	6 seconds	29.2 lbs	7.6 min
Watertec™ (PP-RCT)	2-1/2" (75mm) SDR9	40.5 lbs	1 mm	Almost Zero	96 seconds	6 seconds	40.5 lbs	8.7 min
Watertec™ (PP-RCT)	3" (90mm) SDR9	58.5 lbs	1 mm	Almost Zero	114 seconds	7 seconds	58.5 lbs	10.3 min
Watertec™ (PP-RCT)	4" (110mm) SDR9	85.4 lbs	1 mm	Almost Zero	138 seconds	7 seconds	85.4 lbs	12.3 min



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Watertec™ (PP-RCT)	5" (125mm) SDR9	110.2 lbs	1 mm	Almost Zero	155 seconds	8 seconds	110.2 lbs	13.7 min
Watertec™ (PP-RCT)	6" (160mm) SDR11	150.6 lbs	1 mm	Almost Zero	161 seconds	8 seconds	150.6 lbs	14.2 min
Watertec™ (PP-RCT)	8" (200mm) SDR11	233.8 lbs	1 mm	Almost Zero	198 seconds	9 seconds	233.8 lbs	17.3 min
Chem Prolok® (PE)	2" X 4" (63mm X 110mm) SDR11X33	76.3 lbs	0.5 mm	Almost Zero	58 seconds	5 seconds	76.3 lbs	6.3 min
Chem Prolok® (PE)	3" X 6" (90mm X 160mm) SDR11X33	152.6 lbs	1 mm	Almost Zero	82 seconds	6 seconds	152.6 lbs	8.6 min
Chem Prolok® (PE)	4" X 8" (110mm X 200mm) SDR11X33	236.1 lbs	1 mm	Almost Zero	100 seconds	7 seconds	236.1 lbs	10.2 min
Chem Prolok® (PE)	2" X 6" (63mm X 160mm) SDR11X33	116.7 lbs	1 mm	Almost Zero	58 seconds	5 seconds	116.7 lbs	6.3 min
Duo-Pro® PRO150X150 (PP)	2" X 4" (63mm X 110mm) SDR11X11	96.7 lbs	1 mm	Almost Zero	113 seconds	7 seconds	96.7 lbs	10.2 min
Duo-Pro® PRO150X150 (PP)	3" X 6" (90mm X 160mm) SDR11X11	200.1 lbs	1 mm	Almost Zero	161 seconds	8 seconds	200.1 lbs	14.2 min
Duo-Pro® PRO150X150 (PP)	4" X 8" (110mm X 200mm) SDR11X11	305.7 lbs	1 mm	Almost Zero	198 seconds	9 seconds	305.7 lbs	17.3 min
Duo-Pro® PRO150X150 (PP)	2" X 6" (63mm X 160mm) SDR11X11	175.4 lbs	1 mm	Almost Zero	161 seconds	8 seconds	175.4 lbs	14.2 min
Duo-Pro® PRO150X45 (PP)	2" X 4" (63mm X 110mm) SDR11X33	51.7 lbs	0.5 mm	Almost Zero	68 seconds	6 seconds	51.7 lbs	6.3 min
Duo-Pro® PRO150X45 (PP)	3" X 6" (90mm X 160mm) SDR11X33	103.4 lbs	0.5 mm	Almost Zero	94 seconds	6 seconds	103.4 lbs	8.6 min



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Duo-Pro® PRO150X45 (PP)	4" X 8" (110mm X 200mm) SDR11X33	157.4 lbs	0.5 mm	Almost Zero	113 seconds	7 seconds	157.4 lbs	10.2 min
Duo-Pro® PRO150X45 (PP)	6" X 10" (160mm X 250mm) SDR11X33	283.3 lbs	1 mm	Almost Zero	161 seconds	8 seconds	283.3 lbs	14.2 min
Duo-Pro® PRO150X45 (PP)	2" X 6" (63mm X 160mm) SDR11X33	78.7 lbs	0.5 mm	Almost Zero	68 seconds	6 seconds	78.7 lbs	6.3 min
Duo-Pro® PRO45X45 (PP)	4" X 8" (110mm X 200mm) SDR33X33	112.4 lbs	0.5 mm	Almost Zero	72 seconds	6 seconds	112.4 lbs	6.7 min
Duo-Pro® PRO45X45 (PP)	6" X 10" (160mm X 250mm) SDR33X33	186.6 lbs	1 mm	Almost Zero	89 seconds	6 seconds	186.6 lbs	8.1 min
Duo-Pro® PRO45X45 (PP)	8" X 12" (200mm X 315mm) SDR33X33	296.7 lbs	1 mm	Almost Zero	110 seconds	7 seconds	296.7 lbs	9.9 min
Duo-Pro® PVDFXPVDF (PVDF)	2" X 4" (63mm X 110mm) SDR21X33	38.0 lbs	0.5 mm	Almost Zero	74 seconds	3 seconds	38.0 lbs	6.0 min
Duo-Pro® PVDFXPVDF (PVDF)	3" X 6" (90mm X 160mm) SDR33X33	69.0 lbs	0.5 mm	Almost Zero	89 seconds	3 seconds	69.0 lbs	8.0 min
Duo-Pro® PVDFXPVDF (PVDF)	4" X 8" (110mm X 200mm) SDR33X21	150.0 lbs	1 mm	Almost Zero	136 seconds	4 seconds	150.0 lbs	13.5 min
Duo-Pro® PVDFXPVDF (PVDF)	6" X 10" (160mm X 250mm) SDR33X21	246.0 lbs	1.1 mm	Almost Zero	159 seconds	4 seconds	246.0 lbs	16.5 min
Duo-Pro® PVDFXPVDF (PVDF)	2" X 6" (63mm X 160mm) SDR21X33	65.0 lbs	0.5 mm	Almost Zero	89 seconds	3 seconds	65.0 lbs	8.0 min
Fluidlok (IPS) (PE)	2" X 4" SDR11X17	108.0 lbs	mm	Almost Zero	67 seconds	3 seconds	108.0 lbs	10.0 min
Fluidlok (IPS) (PE)	3" X 6" SDR11X17	235.0 lbs	mm	Almost Zero	99 seconds	5 seconds	235.0 lbs	16.0 min
Poly-Flo® PE100RC (PE)	2" X 3" (63mm X 90mm) SDR11X17	65.0 lbs	1 mm	Almost Zero	35 seconds	5 seconds	65.0 lbs	8.0 min



Please visit the Asahi Weld App
at www.asahi-america.com for
up to date weld parameters

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

Shop 12 (Butt) Welding Parameters

CURRENT AS OF
04/11/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Poly-Flo® PE100RC (PE)	4" X 6" (110mm X 160mm) SDR11X17	223.0 lbs	1.5 mm	Almost Zero	80 seconds	7 seconds	223.0 lbs	14.0 min
Poly-Flo® PPR (PP)	2" X 3" (63mm X 90mm) SDR11X17	60.0 lbs	0.5 mm	Almost Zero	80 seconds	6 seconds	60.0 lbs	9.0 min
Poly-Flo® PPR (PP)	4" X 6" (110mm X 160mm) SDR11X17	185.0 lbs	1 mm	Almost Zero	150 seconds	7 seconds	185.0 lbs	17.0 min



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up to date weld parameters

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint