

Rolling 618 Welding Parameters

CURRENT AS OF
09/07/2023

Product Line & Material	Pipe Size	Initial Melt Pressure (psi)	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Air-Pro® (PE)	6" (160mm) SDR11	37	2 mm	Almost Zero	146 seconds	9 seconds	37	14.2 min
Air-Pro® (PE)	8" (200mm) SDR11	59	2 mm	Almost Zero	182 seconds	10 seconds	59	17.3 min
Air-Pro® (PE)	10" (250mm) SDR11	92	2.5 mm	Almost Zero	227 seconds	11 seconds	92	21.2 min
Air-Pro® (PE)	12" (315mm) SDR11	145	3 mm	Almost Zero	286 seconds	13 seconds	145	26.4 min
Asahitec™ Solid Wall (PP-RCT)	6" (160mm) SDR11	26	1 mm	Almost Zero	161 seconds	8 seconds	26	14.2 min
Asahitec™ Solid Wall (PP-RCT)	8" (200mm) SDR11	40	1 mm	Almost Zero	198 seconds	9 seconds	40	17.3 min
Asahitec™ Solid Wall (PP-RCT)	10" (250mm) SDR11	62	1.5 mm	Almost Zero	240 seconds	10 seconds	62	21.2 min
Asahitec™ Solid Wall (PP-RCT)	12" (315mm) SDR11	97	2 mm	Almost Zero	293 seconds	12 seconds	97	26.4 min
Asahitec™ Solid Wall (PP-RCT)	14" (355mm) SDR11	123	2 mm	Almost Zero	322 seconds	13 seconds	123	29.6 min
Chem Proline® (PE)	6" (160mm) SDR11	37	2 mm	Almost Zero	146 seconds	9 seconds	37	14.2 min
Chem Proline® (PE)	8" (200mm) SDR11	59	2 mm	Almost Zero	182 seconds	10 seconds	59	17.3 min
Chem Proline® (PE)	10" (250mm) SDR11	92	2.5 mm	Almost Zero	227 seconds	11 seconds	92	21.2 min



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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Chem Proline® (PE)	12" (315mm) SDR11	145	3 mm	Almost Zero	286 seconds	13 seconds	145	26.4 min
Chem Proline® (PE)	14" (355mm) SDR11	185	3 mm	Almost Zero	322 seconds	14 seconds	185	39.0 min
Climatec™ (PP-RCT)	6" (160mm) SDR17	17.6	1 mm	Almost Zero	108 seconds	6 seconds	17.6	9.8 min
Climatec™ (PP-RCT)	8" (200mm) SDR17	26	1 mm	Almost Zero	134 seconds	7 seconds	26	11.9 min
Climatec™ (PP-RCT)	10" (250mm) SDR17	42	1 mm	Almost Zero	163 seconds	8 seconds	42	14.4 min
Climatec™ (PP-RCT)	12" (315mm) SDR17	66	1 mm	Almost Zero	203 seconds	9 seconds	66	17.8 min
Climatec™ (PP-RCT)	14" (355mm) SDR17	85	1.5 mm	Almost Zero	225 seconds	10 seconds	85	19.8 min
Climatec™ (PP-RCT)	16" (400mm) SDR17	106	1.5 mm	Almost Zero	250 seconds	10 seconds	85	22 min
Proline® PRO150 (PP)	6" (160mm) SDR11	26	1 mm	Almost Zero	161 seconds	8 seconds	26	14.2 min
Proline® PRO150 (PP)	7" (180mm) SDR11	33	1 mm	Almost Zero	180 seconds	8 seconds	33	15.8 min
Proline® PRO150 (PP)	8" (200mm) SDR11	40	1 mm	Almost Zero	198 seconds	9 seconds	40	17.3 min
Proline® PRO150 (PP)	9" (225mm) SDR11	51	1.5 mm	Almost Zero	220 seconds	9 seconds	51	19.3 min



Welding Temperatures

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Proline® PRO150 (PP)	10" (250mm) SDR11	62	1.5 mm	Almost Zero	240 seconds	10 seconds	62	21.2 min
Proline® PRO150 (PP)	11" (280mm) SDR11	77	1.5 mm	Almost Zero	265 seconds	11 seconds	77	23.5 min
Proline® PRO150 (PP)	12" (315mm) SDR11	97	2 mm	Almost Zero	293 seconds	12 seconds	97	26.4 min
Proline® PRO150 (PP)	14" (355mm) SDR11	123	2 mm	Almost Zero	322 seconds	13 seconds	123	29.6 min
Proline® PRO150 (PP)	16" (400mm) SDR11	155	2 mm	Almost Zero	356 seconds	13 seconds	123	33.4 min
Proline® PRO150 (PP)	18" (450mm) SDR11	200	2 mm	Almost Zero	388 seconds	13 seconds	123	37.6 min
Proline® PRO90 (PP)	6" (160mm) SDR17.6	18	1 mm	Almost Zero	104 seconds	6 seconds	18	5.0 min
Proline® PRO90 (PP)	7" (180mm) SDR17.6	22	1 mm	Almost Zero	116 seconds	7 seconds	22	9.2 min
Proline® PRO90 (PP)	8" (200mm) SDR17.6	26	1 mm	Almost Zero	129 seconds	7 seconds	26	11.3 min
Proline® PRO90 (PP)	9" (225mm) SDR17.6	37	1 mm	Almost Zero	143 seconds	7 seconds	37	12.4 min
Proline® PRO90 (PP)	10" (250mm) SDR17.6	42	1 mm	Almost Zero	157 seconds	8 seconds	42	13.5 min
Proline® PRO90 (PP)	11" (280mm) SDR17.6	53	1 mm	Almost Zero	175 seconds	8 seconds	53	15.2 min



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Proline® PRO90 (PP)	12" (315mm) SDR17.6	64	1 mm	Almost Zero	195 seconds	9 seconds	64	17.0 min
Proline® PRO90 (PP)	14" (355mm) SDR17.6	79	1.5 mm	Almost Zero	201 seconds	10 seconds	79	18.6 min
Proline® PRO90 (PP)	16" (400mm) SDR17.6	85	1.5 mm	Almost Zero	240 seconds	10 seconds	80	21.1 min
Proline® PRO90 (PP)	18" (450mm) SDR17.6	106	1.5 mm	Almost Zero	266 seconds	11 seconds	80	23.3 min
Proline® PRO45 (PP)	6" (160mm) SDR33	11	0.5 mm	Almost Zero	57 seconds	5 seconds	11	5.4 min
Proline® PRO45 (PP)	7" (180mm) SDR33	13.2	0.5 mm	Almost Zero	64 seconds	5 seconds	13.2	6.0 min
Proline® PRO45 (PP)	8" (200mm) SDR33	15.4	0.5 mm	Almost Zero	72 seconds	6 seconds	15.4	6.7 min
Proline® PRO45 (PP)	9" (225mm) SDR33	20	0.5 mm	Almost Zero	80 seconds	6 seconds	20	7.4 min
Proline® PRO45 (PP)	10" (250mm) SDR33	22	1 mm	Almost Zero	89 seconds	6 seconds	22	8.1 min
Proline® PRO45 (PP)	11" (280mm) SDR33	29	1 mm	Almost Zero	98 seconds	6 seconds	29	8.9 min
Proline® PRO45 (PP)	12" (315mm) SDR33	35	1 mm	Almost Zero	110 seconds	7 seconds	35	9.9 min
Proline® PRO45 (PP)	14" (355mm) SDR33	48	1 mm	Almost Zero	123 seconds	7 seconds	48	11.0 min



Welding Temperatures

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PVDF:	436°F - 446°F (225°C - 230°C)
ECTFE:	527°F - 536°F (275°C - 280°C)

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Proline® PRO45 (PP)	16" (400mm) SDR33	58	1 mm	Almost Zero	138 seconds	7 seconds	58	12.3 min
Proline® PRO45 (PP)	18" (450mm) SDR33	74	1 mm	Almost Zero	153 seconds	8 seconds	74	13.6 min
Super Proline® (PVDF)	6" (160mm) SDR21	15	.7 mm	Almost Zero	117 seconds	4 seconds	15	11.0 min
Super Proline® (PVDF)	8" (200mm) SDR21	22	1.0 mm	Almost Zero	136 seconds	4 seconds	22	13.5 min
Super Proline® (PVDF)	10" (250mm) SDR21	35	1.1 mm	Almost Zero	159 seconds	4 seconds	35	16.5 min
Super Proline® (PVDF)	6" (160mm) SDR33	10	0.5 mm	Almost Zero	89 seconds	3 seconds	10	8.0 min
Super Proline® (PVDF)	8" (200mm) SDR33	15	0.6 mm	Almost Zero	102 seconds	4 seconds	15	9.5 min
Super Proline® (PVDF)	10" (250mm) SDR33	22	0.7 mm	Almost Zero	117 seconds	4 seconds	22	11.0 min
Super Proline® (PVDF)	12" (315mm) SDR33	35	1 mm	Almost Zero	137 seconds	4 seconds	35	13.5 min
Watertec™ (PP-RCT)	6" (160mm) SDR11	26	1 mm	Almost Zero	161 seconds	8 seconds	26	14.2 min
Watertec™ (PP-RCT)	8" (200mm) SDR11	39	1 mm	Almost Zero	198 seconds	9 seconds	39	17.3 min
Watertec™ (PP-RCT)	10" (250mm) SDR11	62	1.5 mm	Almost Zero	240 seconds	10 seconds	62	21.2 min



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Watertec™ (PP-RCT)	12" (315mm) SDR11	97	2 mm	Almost Zero	293 seconds	12 seconds	97	26.4 min
Watertec™ (PP-RCT)	14" (355mm) SDR11	127	2 mm	Almost Zero	322 seconds	13 seconds	127	29.6 min
Chem Prolok® (PE)	6" X 10" (160mm X 250mm) SDR11X33	99	1.5 mm	Almost Zero	146 seconds	9 seconds	99	14.2 min
Chem Prolok® (PE)	8" X 12" (200mm X 315mm) SDR11X33	114	1 mm	Almost Zero	182 seconds	10 seconds	114	17.3 min
Chem Prolok® (PE)	10" X 14" (250mm X 355mm) SDR11X33	164	1 mm	Almost Zero	227 seconds	11 seconds	164	21.2 min
Duo-Pro® PRO150X150 (PP)	6" X 10" (160mm X 250mm) SDR11X11	88	1.5 mm	Almost Zero	240 seconds	10 seconds	88	21.2 min
Duo-Pro® PRO150X150 (PP)	8" X 12" (200mm X 315mm) SDR11X11	140	2 mm	Almost Zero	293 seconds	12 seconds	140	26.4 min
Duo-Pro® PRO150X150 (PP)	10" X 14" (250mm X 355mm) SDR11X11	185	2 mm	Almost Zero	322 seconds	13 seconds	185	29.6 min
Duo-Pro® PRO150X45 (PP)	6" X 10" (160mm X 250mm) SDR11X33	48	1 mm	Almost Zero	161 seconds	8 seconds	48	14.2 min
Duo-Pro® PRO150X45 (PP)	8" X 12" (200mm X 315mm) SDR11X33	76	1 mm	Almost Zero	198 seconds	9 seconds	76	17.3 min
Duo-Pro® PRO150X45 (PP)	10" X 14" (250mm X 355mm) SDR11X33	111	1 mm	Almost Zero	240 seconds	10 seconds	111	21.2 min



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PP:	393°F - 410°F (200°C - 210°C)
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