

4" Hand Socket Welding Parameters

CURRENT AS OF 09/01/2023

Product Line & Material	Pipe Size	Heatsoak Time	Changeover Time	Cooling Time
Air-Pro® (PE)	1/2" (20mm) SDR7	5 seconds	4 seconds	2.0 min
Air-Pro® (PE)	3/4" (25mm) SDR7	7 seconds	4 seconds	2.0 min
Air-Pro® (PE)	1" (32mm) SDR7	8 seconds	6 seconds	4.0 min
Air-Pro® (PE)	1-1/4" (40mm) SDR7	12 seconds	6 seconds	4.0 min
Air-Pro® (PE)	1-1/2" (50mm) SDR7	18 seconds	6 seconds	4.0 min
Air-Pro® (PE)	2" (63mm) SDR7	24 seconds	8 seconds	6.0 min
Air-Pro® (PE)	2-1/2" (75mm) SDR7	30 seconds	8 seconds	6.0 min
Air-Pro® (PE)	3" (90mm) SDR7	40 seconds	8 seconds	6.0 min
Air-Pro® (PE)	4" (110mm) SDR7	50 seconds	10 seconds	8.0 min
Asahitec™ Solid Wall (PP-RCT)	1/2" (20mm) SDR11	5 seconds	4 seconds	2.0 min
Asahitec™ Solid Wall (PP-RCT)	3/4" (25mm) SDR11	7 seconds	4 seconds	2.0 min
Asahitec™ Solid Wall (PP-RCT)	1" (32mm) SDR11	8 seconds	6 seconds	4.0 min
Asahitec™ Solid Wall (PP-RCT)	1-1/4" (40mm) SDR11	12 seconds	6 seconds	4.0 min



Welding Temperature
All Materials: 500F° (260°C)

The weldment must cool for a minimum time of 60 seconds under full force before it may be set aside to finish cooling for the complete time according to the Cooling Time column. The removed piece should be handled carefully and set down with minimal strain on the weld for the remainder of the cooling time.

Product Line & Material	Pipe Size	Heatsoak Time	Changeover Time	Cooling Time
Asahitec™ Solid Wall (PP-RCT)	1-1/2" (50mm) SDR11	18 seconds	6 seconds	4.0 min
Asahitec™ Solid Wall (PP-RCT)	2" (63mm) SDR11	24 seconds	8 seconds	6.0 min
Asahitec™ Solid Wall (PP-RCT)	2-1/2" (75mm) SDR11	30 seconds	8 seconds	6.0 min
Asahitec™ Solid Wall (PP-RCT)	3" (90mm) SDR11	40 seconds	8 seconds	6.0 min
Asahitec™ Solid Wall (PP-RCT)	4" (110mm) SDR11	50 seconds	10 seconds	8.0 min
Asahitec™ Solid Wall (PP-RCT)	5" (125mm) SDR11	60 seconds	10 seconds	8.0 min
Asahitec™ Solid Wall (PP-RCT)	1/2" (20mm) SDR7	5 seconds	4 seconds	2.0 min
Asahitec™ Solid Wall (PP-RCT)	3/4" (25mm) SDR7	7 seconds	4 seconds	2.0 min
Asahitec™ Solid Wall (PP-RCT)	1" (32mm) SDR7	8 seconds	6 seconds	4.0 min
Asahitec™ Solid Wall (PP-RCT)	1-1/4" (40mm) SDR7	12 seconds	6 seconds	4.0 min
Asahitec™ Solid Wall (PP-RCT)	1-1/2" (50mm) SDR7	18 seconds	6 seconds	4.0 min
Asahitec™ Solid Wall (PP-RCT)	2" (63mm) SDR7	24 seconds	8 seconds	6.0 min
Asahitec™ Solid Wall (PP-RCT)	2-1/2" (75mm) SDR7	30 seconds	8 seconds	6.0 min
Asahitec™ Solid Wall (PP-RCT)	3" (90mm) SDR7	40 seconds	8 seconds	6.0 min
Asahitec™ Solid Wall (PP-RCT)	4" (110mm) SDR7	50 seconds	10 seconds	8.0 min



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Product Line & Material	Pipe Size	Heatsoak Time	Changeover Time	Cooling Time
Asahitec™ Solid Wall (PP-RCT)	5" (125mm) SDR7	60 seconds	10 seconds	8.0 min
Chem Proline® (PE)	1/2" (20mm) SDR7	5 seconds	4 seconds	2.0 min
Chem Proline® (PE)	3/4" (25mm) SDR7	7 seconds	4 seconds	2.0 min
Chem Proline® (PE)	1" (32mm) SDR7	8 seconds	6 seconds	4.0 min
Chem Proline® (PE)	1-1/4" (40mm) SDR7	12 seconds	6 seconds	4.0 min
Chem Proline® (PE)	1-1/2" (50mm) SDR7	18 seconds	6 seconds	4.0 min
Chem Proline® (PE)	2" (63mm) SDR7	24 seconds	8 seconds	6.0 min
Chem Proline® (PE)	2-1/2" (75mm) SDR7	30 seconds	8 seconds	6.0 min
Chem Proline® (PE)	3" (90mm) SDR7	40 seconds	8 seconds	6.0 min
Chem Proline® (PE)	4" (110mm) SDR7	50 seconds	10 seconds	8.0 min
Climatec™ (PP-RCT)	1/2" (20mm) SDR7	5 seconds	4 seconds	2.0 min
Climatec™ (PP-RCT)	3/4" (25mm) SDR7	7 seconds	4 seconds	2.0 min
Climatec™ (PP-RCT)	1" (32mm) SDR9	8 seconds	6 seconds	4.0 min
Climatec™ (PP-RCT)	1-1/4" (40mm) SDR11	12 seconds	6 seconds	4.0 min
Climatec™ (PP-RCT)	1-1/2" (50mm) SDR11	18 seconds	6 seconds	4.0 min



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Product Line & Material	Pipe Size	Heatsoak Time	Changeover Time	Cooling Time
Climatec™ (PP-RCT)	2" (63mm) SDR11	24 seconds	8 seconds	6.0 min
Climatec™ (PP-RCT)	2-1/2" (75mm) SDR11	30 seconds	8 seconds	6.0 min
Climatec™ (PP-RCT)	3" (90mm) SDR11	40 seconds	8 seconds	6.0 min
Climatec™ (PP-RCT)	4" (110mm) SDR11	50 seconds	10 seconds	8.0 min
Climatec™ (PP-RCT)	5" (125mm) SDR11	60 seconds	10 seconds	8.0 min
Proline® PRO150 (PP)	1/2" (20mm) SDR11	5 seconds	4 seconds	2.0 min
Proline® PRO150 (PP)	3/4" (25mm) SDR11	7 seconds	4 seconds	2.0 min
Proline® PRO150 (PP)	1" (32mm) SDR11	8 seconds	6 seconds	4.0 min
Proline® PRO150 (PP)	1-1/4" (40mm) SDR11	12 seconds	6 seconds	4.0 min
Proline® PRO150 (PP)	1-1/2" (50mm) SDR11	18 seconds	6 seconds	4.0 min
Proline® PRO150 (PP)	2" (63mm) SDR11	24 seconds	8 seconds	6.0 min
Proline® PRO150 (PP)	2-1/2" (75mm) SDR11	30 seconds	8 seconds	6.0 min
Proline® PRO150 (PP)	3" (90mm) SDR11	40 seconds	8 seconds	6.0 min
Proline® PRO150 (PP)	4" (110mm) SDR11	50 seconds	10 seconds	8.0 min
Proline® PRO150 (PP)	4-1/2" (125mm) SDR11	60 seconds	10 seconds	8.0 min



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Product Line & Material	Pipe Size	Heatsoak Time	Changeover Time	Cooling Time
Super Proline® (PVDF)	1/2" (20mm) SDR21	6 seconds	4 seconds	2.0 min
Super Proline® (PVDF)	3/4" (25mm) SDR21	8 seconds	4 seconds	2.0 min
Super Proline® (PVDF)	1" (32mm) SDR21	10 seconds	4 seconds	4.0 min
Super Proline® (PVDF)	1-1/4" (40mm) SDR21	12 seconds	4 seconds	4.0 min
Super Proline® (PVDF)	1-1/2" (50mm) SDR21	18 seconds	4 seconds	4.0 min
Super Proline® (PVDF)	2" (63mm) SDR21	20 seconds	6 seconds	6.0 min
Super Proline® (PVDF)	2-1/2" (75mm) SDR21	22 seconds	6 seconds	6.0 min
Super Proline® (PVDF)	3" (90mm) SDR21	25 seconds	6 seconds	6.0 min
Super Proline® (PVDF)	4" (110mm) SDR21	30 seconds	6 seconds	8.0 min
Watertec™ (PP-RCT)	1/2" (20mm) SDR7	5 seconds	4 seconds	2.0 min
Watertec™ (PP-RCT)	3/4" (25mm) SDR7	7 seconds	4 seconds	2.0 min
Watertec™ (PP-RCT)	1" (32mm) SDR9	8 seconds	6 seconds	4.0 min
Watertec™ (PP-RCT)	1-1/4" (40mm) SDR9	12 seconds	6 seconds	4.0 min
Watertec™ (PP-RCT)	1-1/2" (50mm) SDR9	18 seconds	6 seconds	4.0 min
Watertec™ (PP-RCT)	2" (63mm) SDR9	24 seconds	8 seconds	6.0 min



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Product Line & Material	Pipe Size	Heatsoak Time	Changeover Time	Cooling Time
Watertec™ (PP-RCT)	2-1/2" (75mm) SDR9	30 seconds	8 seconds	6.0 min
Watertec™ (PP-RCT)	3" (90mm) SDR9	40 seconds	8 seconds	6.0 min
Watertec™ (PP-RCT)	4" (110mm) SDR9	50 seconds	10 seconds	8.0 min
Watertec™ (PP-RCT)	5" (125mm) SDR9	60 seconds	10 seconds	8.0 min



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