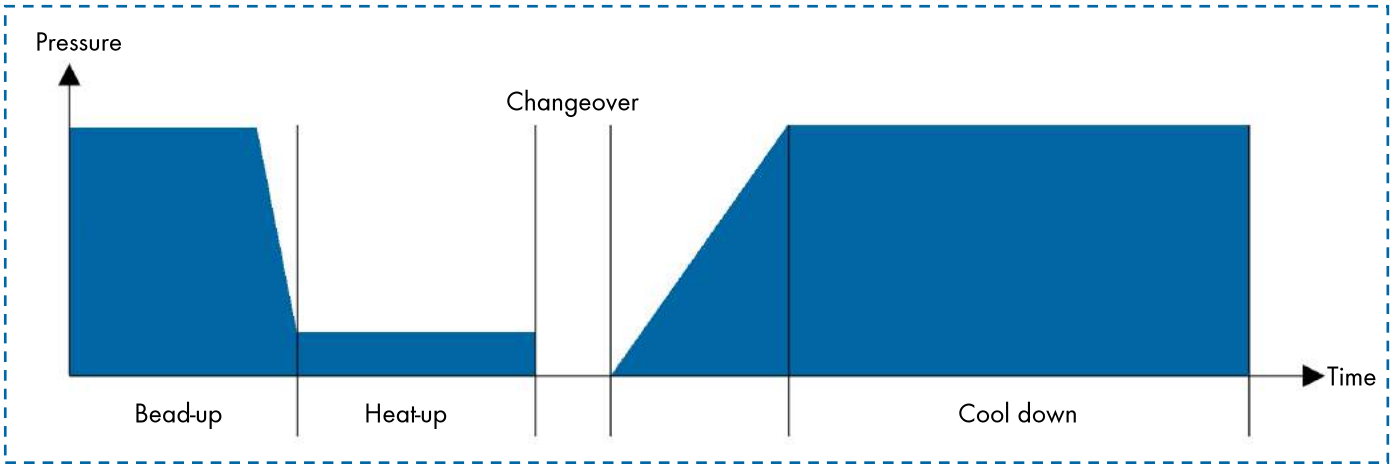
Widos 4400

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 250 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
50 mm	SDR 17.6	4.00 bar	0.5 mm	43 s	5 s	5 s	4.00 bar	6 min
	SDR 17	4.00 bar	0.5 mm	44 s	5 s	5 s	4.00 bar	6 min
	SDR 13.6	4.70 bar	1 mm	52 s	5 s	5 s	4.70 bar	7 min
	SDR 11	5.40 bar	1 mm	61 s	5 s	5 s	5.40 bar	8 min
	SDR 9	6.20 bar	1.5 mm	72 s	6 s	6 s	6.20 bar	10 min
	SDR 7.4	7.10 bar	1.5 mm	85 s	6 s	6 s	7.10 bar	11 min
63 mm	SDR 17.6	5.90 bar	1 mm	52 s	5 s	5 s	5.90 bar	7 min
	SDR 17	6.10 bar	1 mm	54 s	5 s	5 s	6.10 bar	7 min
	SDR 13.6	7.10 bar	1 mm	63 s	5 s	5 s	7.10 bar	8 min
	SDR 11	8.20 bar	1.5 mm	75 s	6 s	6 s	8.20 bar	10 min
	SDR 9	9.60 bar	1.5 mm	89 s	6 s	6 s	9.60 bar	12 min
	SDR 7.4	10.90 bar	1.5 mm	104 s	7 s	7 s	10.90 bar	14 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 4400

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
75 mm	SDR 17.6	8.10 bar	1 mm	59 s	5 s	5 s	8.10 bar	8 min
	SDR 17	8.30 bar	1 mm	61 s	5 s	5 s	8.30 bar	8 min
	SDR 13.6	9.70 bar	1.5 mm	73 s	6 s	6 s	9.70 bar	10 min
	SDR 11	11.20 bar	1.5 mm	85 s	6 s	6 s	11.20 bar	11 min
	SDR 9	13.10 bar	1.5 mm	102 s	7 s	7 s	13.10 bar	13 min
	SDR 7.4	15.10 bar	2 mm	122 s	8 s	8 s	15.10 bar	16 min
90 mm	SDR 17.6	11.20 bar	1 mm	69 s	5 s	5 s	11.20 bar	9 min
	SDR 17	11.60 bar	1.5 mm	72 s	6 s	6 s	11.60 bar	10 min
	SDR 13.6	13.60 bar	1.5 mm	85 s	6 s	6 s	13.60 bar	11 min
	SDR 11	15.90 bar	1.5 mm	101 s	7 s	7 s	15.90 bar	13 min
	SDR 9	18.50 bar	2 mm	121 s	8 s	8 s	18.50 bar	16 min
	SDR 7.4	21.40 bar	2 mm	144 s	8 s	9 s	21.40 bar	18 min
110 mm	SDR 17.6	16.80 bar	1.5 mm	85 s	6 s	6 s	16.80 bar	11 min
	SDR 17	17.40 bar	1.5 mm	88 s	6 s	6 s	17.40 bar	12 min
	SDR 13.6	20.20 bar	1.5 mm	104 s	7 s	7 s	20.20 bar	14 min
	SDR 11	23.60 bar	2 mm	123 s	8 s	8 s	23.60 bar	16 min
	SDR 9	27.60 bar	2 mm	148 s	8 s	9 s	27.60 bar	19 min
	SDR 7.4	32.10 bar	2 mm	177 s	9 s	10 s	32.10 bar	22 min
125 mm	SDR 17.6	21.00 bar	1.5 mm	93 s	6 s	6 s	21.00 bar	12 min
	SDR 17	21.60 bar	1.5 mm	96 s	7 s	7 s	21.60 bar	13 min
	SDR 13.6	25.50 bar	1.5 mm	115 s	7 s	7 s	25.50 bar	15 min
	SDR 11	30.00 bar	2 mm	138 s	8 s	8 s	30.00 bar	18 min
	SDR 9	35.10 bar	2 mm	166 s	9 s	9 s	35.10 bar	21 min
	SDR 7.4	40.80 bar	2.5 mm	198 s	10 s	11 s	40.80 bar	24 min
140 mm	SDR 17.6	25.90 bar	1.5 mm	103 s	7 s	7 s	25.90 bar	13 min
	SDR 17	26.60 bar	1.5 mm	106 s	7 s	7 s	26.60 bar	14 min
	SDR 13.6	31.40 bar	2 mm	127 s	8 s	8 s	31.40 bar	16 min
	SDR 11	36.80 bar	2 mm	152 s	8 s	9 s	36.80 bar	19 min
	SDR 9	43.40 bar	2 mm	183 s	9 s	10 s	43.40 bar	23 min
	SDR 7.4	50.60 bar	2.5 mm	220 s	10 s	12 s	50.60 bar	27 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

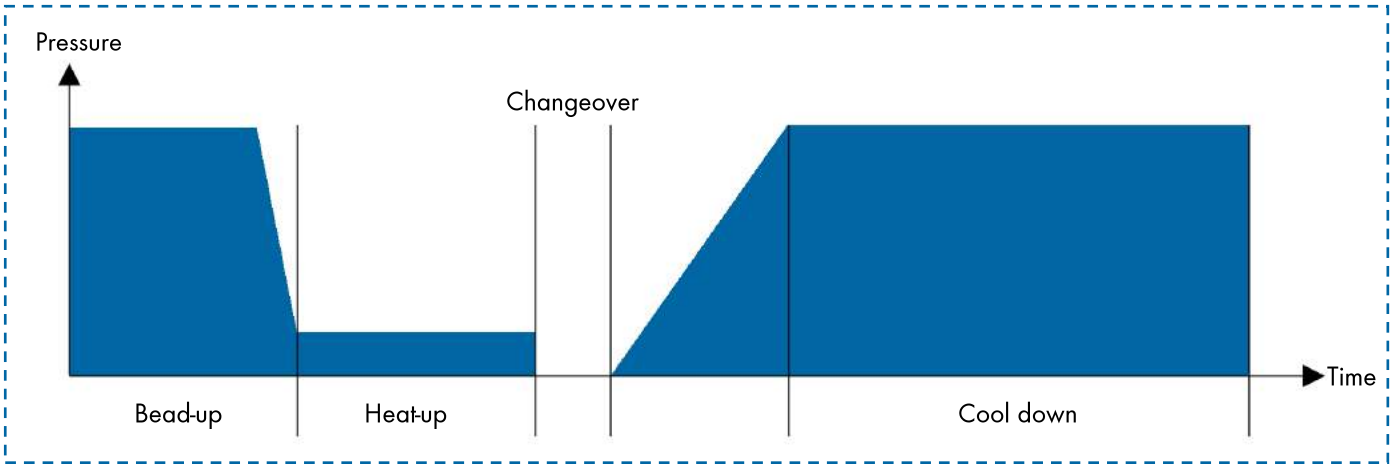
Widos 4600 — 4800

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 520 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
75 mm	SDR 17.6	3.90 bar	1 mm	59 s	5 s	5 s	3.90 bar	8 min
	SDR 17	4.00 bar	1 mm	61 s	5 s	5 s	4.00 bar	8 min
	SDR 13.6	4.70 bar	1.5 mm	73 s	6 s	6 s	4.70 bar	10 min
	SDR 11	5.40 bar	1.5 mm	85 s	6 s	6 s	5.40 bar	11 min
	SDR 9	6.30 bar	1.5 mm	102 s	7 s	7 s	6.30 bar	13 min
	SDR 7.4	7.30 bar	2 mm	122 s	8 s	8 s	7.30 bar	16 min
90 mm	SDR 17.6	5.40 bar	1 mm	69 s	5 s	5 s	5.40 bar	9 min
	SDR 17	5.60 bar	1.5 mm	72 s	6 s	6 s	5.60 bar	10 min
	SDR 13.6	6.60 bar	1.5 mm	85 s	6 s	6 s	6.60 bar	11 min
	SDR 11	7.60 bar	1.5 mm	101 s	7 s	7 s	7.60 bar	13 min
	SDR 9	8.90 bar	2 mm	121 s	8 s	8 s	8.90 bar	16 min
	SDR 7.4	10.30 bar	2 mm	144 s	8 s	9 s	10.30 bar	18 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 4600 – 4800

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
110 mm	SDR 17.6	8.10 bar	1.5 mm	85 s	6 s	6 s	8.10 bar	11 min
	SDR 17	8.40 bar	1.5 mm	88 s	6 s	6 s	8.40 bar	12 min
	SDR 13.6	9.80 bar	1.5 mm	104 s	7 s	7 s	9.80 bar	14 min
	SDR 11	11.40 bar	2 mm	123 s	8 s	8 s	11.40 bar	16 min
	SDR 9	13.30 bar	2 mm	148 s	8 s	9 s	13.30 bar	19 min
	SDR 7.4	15.50 bar	2 mm	177 s	9 s	10 s	15.50 bar	22 min
125 mm	SDR 17.6	10.10 bar	1.5 mm	93 s	6 s	6 s	10.10 bar	12 min
	SDR 17	10.40 bar	1.5 mm	96 s	7 s	7 s	10.40 bar	13 min
	SDR 13.6	12.30 bar	1.5 mm	115 s	7 s	7 s	12.30 bar	15 min
	SDR 11	14.40 bar	2 mm	138 s	8 s	8 s	14.40 bar	18 min
	SDR 9	16.90 bar	2 mm	166 s	9 s	9 s	16.90 bar	21 min
	SDR 7.4	19.60 bar	2.5 mm	198 s	10 s	11 s	19.60 bar	24 min
140 mm	SDR 17.6	12.50 bar	1.5 mm	103 s	7 s	7 s	12.50 bar	13 min
	SDR 17	12.80 bar	1.5 mm	106 s	7 s	7 s	12.80 bar	14 min
	SDR 13.6	15.10 bar	2 mm	127 s	8 s	8 s	15.10 bar	16 min
	SDR 11	17.70 bar	2 mm	152 s	8 s	9 s	17.70 bar	19 min
	SDR 9	20.90 bar	2 mm	183 s	9 s	10 s	20.90 bar	23 min
	SDR 7.4	24.40 bar	2.5 mm	220 s	10 s	12 s	24.40 bar	27 min
160 mm	SDR 17.6	16.60 bar	1.5 mm	119 s	7 s	7 s	16.60 bar	15 min
	SDR 17	17.10 bar	2 mm	123 s	8 s	8 s	17.10 bar	16 min
	SDR 13.6	20.10 bar	2 mm	147 s	8 s	9 s	20.10 bar	19 min
	SDR 11	23.60 bar	2 mm	177 s	9 s	10 s	23.60 bar	22 min
	SDR 9	27.60 bar	2.5 mm	211 s	10 s	11 s	27.60 bar	26 min
	SDR 7.4	32.10 bar	2.5 mm	253 s	11 s	13 s	32.10 bar	31 min
180 mm	SDR 17.6	21.50 bar	2 mm	137 s	8 s	8 s	21.50 bar	17 min
	SDR 17	22.20 bar	2 mm	142 s	8 s	8 s	22.20 bar	18 min
	SDR 13.6	26.10 bar	2 mm	170 s	9 s	10 s	26.10 bar	21 min
	SDR 11	30.50 bar	2.5 mm	202 s	10 s	11 s	30.50 bar	25 min
	SDR 9	35.50 bar	2.5 mm	241 s	11 s	13 s	35.50 bar	29 min
	SDR 7.4	41.20 bar	3 mm	288 s	13 s	15 s	41.20 bar	35 min
200 mm	SDR 17.6	26.00 bar	2 mm	150 s	8 s	9 s	26.00 bar	19 min
	SDR 17	26.80 bar	2 mm	155 s	8 s	9 s	26.80 bar	19 min
	SDR 13.6	31.40 bar	2 mm	184 s	9 s	10 s	31.40 bar	23 min
	SDR 11	37.00 bar	2.5 mm	221 s	10 s	12 s	37.00 bar	27 min
	SDR 9	43.30 bar	3 mm	265 s	12 s	14 s	43.30 bar	32 min
	SDR 7.4	50.30 bar	3 mm	318 s	14 s	16 s	50.30 bar	38 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 4600 – 4800

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
225 mm	SDR 17.6	32.00 bar	2 mm	164 s	9 s	9 s	32.00 bar	21 min
	SDR 17	33.20 bar	2 mm	171 s	9 s	10 s	33.20 bar	21 min
	SDR 13.6	39.10 bar	2.5 mm	204 s	10 s	11 s	39.10 bar	25 min
	SDR 11	46.00 bar	2.5 mm	245 s	11 s	13 s	46.00 bar	30 min
	SDR 9	54.00 bar	3 mm	295 s	13 s	15 s	54.00 bar	36 min
	SDR 7.4	62.80 bar	3 mm	353 s	15 s	18 s	62.80 bar	42 min
250 mm	SDR 17.6	38.80 bar	2 mm	179 s	9 s	10 s	38.80 bar	22 min
	SDR 17	40.00 bar	2 mm	185 s	9 s	10 s	40.00 bar	23 min
	SDR 13.6	47.40 bar	2.5 mm	223 s	10 s	12 s	47.40 bar	27 min
	SDR 11	55.80 bar	3 mm	268 s	12 s	14 s	55.80 bar	32 min
	SDR 9	65.60 bar	3 mm	323 s	14 s	16 s	65.60 bar	39 min
	SDR 7.4	76.80 bar	3.5 mm	389 s	16 s	16 s	76.80 bar	47 min
280 mm	SDR 17.6	47.60 bar	2.5 mm	197 s	10 s	11 s	47.60 bar	24 min
	SDR 17	49.30 bar	2.5 mm	204 s	10 s	11 s	49.30 bar	25 min
	SDR 13.6	58.50 bar	2.5 mm	246 s	11 s	13 s	58.50 bar	30 min
	SDR 11	69.10 bar	3 mm	297 s	13 s	15 s	69.10 bar	36 min
	SDR 9	81.50 bar	3 mm	359 s	15 s	18 s	81.50 bar	43 min
	SDR 7.4	95.40 bar	3.5 mm	432 s	17 s	18 s	95.40 bar	52 min
315 mm	SDR 17.6	60.10 bar	2.5 mm	221 s	10 s	12 s	60.10 bar	27 min
	SDR 17	62.20 bar	2.5 mm	229 s	11 s	12 s	62.20 bar	28 min
	SDR 13.6	73.90 bar	3 mm	277 s	12 s	14 s	73.90 bar	33 min
	SDR 11	87.30 bar	3 mm	333 s	14 s	17 s	87.30 bar	40 min
	SDR 9	91.80 bar	3 mm	353 s	15 s	18 s	91.80 bar	42 min
	SDR 7.4	120.50 bar	3.5 mm	486 s	19 s	21 s	120.50 bar	58 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

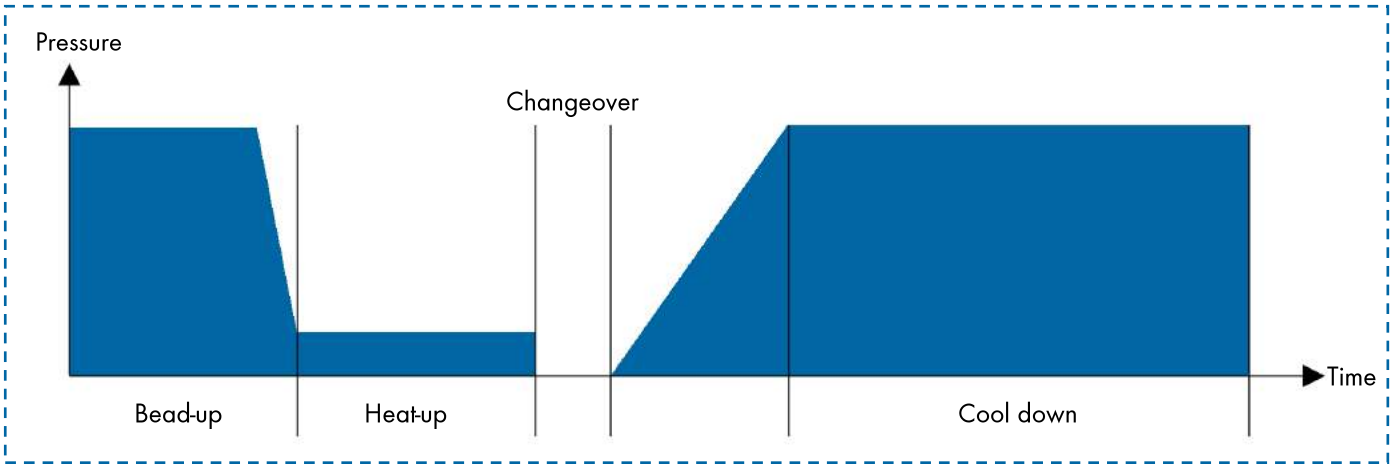
Widos 4900

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 590 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
63 mm	SDR 17.6	2.50 bar	1 mm	52 s	5 s	5 s	2.50 bar	7 min
	SDR 17	2.60 bar	1 mm	54 s	5 s	5 s	2.60 bar	7 min
	SDR 13.6	3.00 bar	1 mm	63 s	5 s	5 s	3.00 bar	8 min
	SDR 11	3.50 bar	1.5 mm	75 s	6 s	6 s	3.50 bar	10 min
	SDR 9	4.10 bar	1.5 mm	89 s	6 s	6 s	4.10 bar	12 min
	SDR 7.4	4.70 bar	1.5 mm	104 s	7 s	7 s	4.70 bar	14 min
75 mm	SDR 17.6	3.40 bar	1 mm	59 s	5 s	5 s	3.40 bar	8 min
	SDR 17	3.50 bar	1 mm	61 s	5 s	5 s	3.50 bar	8 min
	SDR 13.6	4.10 bar	1.5 mm	73 s	6 s	6 s	4.10 bar	10 min
	SDR 11	4.80 bar	1.5 mm	85 s	6 s	6 s	4.80 bar	11 min
	SDR 9	5.60 bar	1.5 mm	102 s	7 s	7 s	5.60 bar	13 min
	SDR 7.4	6.40 bar	2 mm	122 s	8 s	8 s	6.40 bar	16 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Fortsetzung Widos 4900

OD Kernrohr	SDR Kernrohr*	Angleichen		Anwärmen	Umstellen	Fügedruck-aufbauzeit	Abkühlen	
[mm]		P	Wulst	t	t	t	P	t
90 mm	SDR 17,6	4,80 bar	1 mm	69 s	5 s	5 s	4,80 bar	9 min
	SDR 17	5,00 bar	1,5 mm	72 s	6 s	6 s	5,00 bar	10 min
	SDR 13,6	5,80 bar	1,5 mm	85 s	6 s	6 s	5,80 bar	11 min
	SDR 11	6,70 bar	1,5 mm	101 s	7 s	7 s	6,70 bar	13 min
	SDR 9	7,90 bar	2 mm	121 s	8 s	8 s	7,90 bar	16 min
	SDR 7,4	9,10 bar	2 mm	144 s	8 s	9 s	9,10 bar	18 min
110 mm	SDR 17,6	7,20 bar	1,5 mm	85 s	6 s	6 s	7,20 bar	11 min
	SDR 17	7,40 bar	1,5 mm	88 s	6 s	6 s	7,40 bar	12 min
	SDR 13,6	8,60 bar	1,5 mm	104 s	7 s	7 s	8,60 bar	14 min
	SDR 11	10,00 bar	2 mm	123 s	8 s	8 s	10,00 bar	16 min
	SDR 9	11,70 bar	2 mm	148 s	8 s	9 s	11,70 bar	19 min
	SDR 7,4	13,60 bar	2 mm	177 s	9 s	10 s	13,60 bar	22 min
125 mm	SDR 17,6	8,90 bar	1,5 mm	93 s	6 s	6 s	8,90 bar	12 min
	SDR 17	9,20 bar	1,5 mm	96 s	7 s	7 s	9,20 bar	13 min
	SDR 13,6	10,80 bar	1,5 mm	115 s	7 s	7 s	10,80 bar	15 min
	SDR 11	12,70 bar	2 mm	138 s	8 s	8 s	12,70 bar	18 min
	SDR 9	14,90 bar	2 mm	166 s	9 s	9 s	14,90 bar	21 min
	SDR 7,4	17,30 bar	2,5 mm	198 s	10 s	11 s	17,30 bar	24 min
140 mm	SDR 17,6	11,00 bar	1,5 mm	103 s	7 s	7 s	11,00 bar	13 min
	SDR 17	11,30 bar	1,5 mm	106 s	7 s	7 s	11,30 bar	14 min
	SDR 13,6	13,30 bar	2 mm	127 s	8 s	8 s	13,30 bar	16 min
	SDR 11	15,60 bar	2 mm	152 s	8 s	9 s	15,60 bar	19 min
	SDR 9	18,40 bar	2 mm	183 s	9 s	10 s	18,40 bar	23 min
	SDR 7,4	21,50 bar	2,5 mm	220 s	10 s	12 s	21,50 bar	27 min
160 mm	SDR 17,6	14,60 bar	1,5 mm	119 s	7 s	7 s	14,60 bar	15 min
	SDR 17	15,10 bar	2 mm	123 s	8 s	8 s	15,10 bar	16 min
	SDR 13,6	17,70 bar	2 mm	147 s	8 s	9 s	17,70 bar	19 min
	SDR 11	20,80 bar	2 mm	177 s	9 s	10 s	20,80 bar	22 min
	SDR 9	24,30 bar	2,5 mm	211 s	10 s	11 s	24,30 bar	26 min
	SDR 7,4	28,30 bar	2,5 mm	253 s	11 s	13 s	28,30 bar	31 min
180 mm	SDR 17,6	18,90 bar	2 mm	137 s	8 s	8 s	18,90 bar	17 min
	SDR 17	19,60 bar	2 mm	142 s	8 s	8 s	19,60 bar	18 min
	SDR 13,6	23,00 bar	2 mm	170 s	9 s	10 s	23,00 bar	21 min
	SDR 11	26,90 bar	2,5 mm	202 s	10 s	11 s	26,90 bar	25 min
	SDR 9	31,30 bar	2,5 mm	241 s	11 s	13 s	31,30 bar	29 min
	SDR 7,4	36,30 bar	3 mm	288 s	13 s	15 s	36,30 bar	35 min

*Die angegebene SDR-Klasse bezieht sich auf das Kernrohr.
Bei den in den Tabellen berechneten Parametern ist der additive Schutzmantel der egeplast SLM® 3.0 Rohre bereits berücksichtigt.

Continuation Widos 4900

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
200 mm	SDR 17.6	22.90 bar	2 mm	150 s	8 s	9 s	22.90 bar	19 min
	SDR 17	23.60 bar	2 mm	155 s	8 s	9 s	23.60 bar	19 min
	SDR 13.6	27.70 bar	2 mm	184 s	9 s	10 s	27.70 bar	23 min
	SDR 11	32.60 bar	2.5 mm	221 s	10 s	12 s	32.60 bar	27 min
	SDR 9	38.10 bar	3 mm	265 s	12 s	14 s	38.10 bar	32 min
	SDR 7.4	44.30 bar	3 mm	318 s	14 s	16 s	44.30 bar	38 min
225 mm	SDR 17.6	28.20 bar	2 mm	164 s	9 s	9 s	28.20 bar	21 min
	SDR 17	29.30 bar	2 mm	171 s	9 s	10 s	29.30 bar	21 min
	SDR 13.6	34.40 bar	2.5 mm	204 s	10 s	11 s	34.40 bar	25 min
	SDR 11	40.60 bar	2.5 mm	245 s	11 s	13 s	40.60 bar	30 min
	SDR 9	47.60 bar	3 mm	295 s	13 s	15 s	47.60 bar	36 min
	SDR 7.4	55.40 bar	3 mm	353 s	15 s	18 s	55.40 bar	42 min
250 mm	SDR 17.6	34.20 bar	2 mm	179 s	9 s	10 s	34.20 bar	22 min
	SDR 17	35.20 bar	2 mm	185 s	9 s	10 s	35.20 bar	23 min
	SDR 13.6	41.80 bar	2.5 mm	223 s	10 s	12 s	41.80 bar	27 min
	SDR 11	49.20 bar	3 mm	268 s	12 s	14 s	49.20 bar	32 min
	SDR 9	57.80 bar	3 mm	323 s	14 s	16 s	57.80 bar	39 min
	SDR 7.4	67.70 bar	3.5 mm	389 s	16 s	16 s	67.70 bar	47 min
280 mm	SDR 17.6	42.00 bar	2.5 mm	197 s	10 s	11 s	42.00 bar	24 min
	SDR 17	43.40 bar	2.5 mm	204 s	10 s	11 s	43.40 bar	25 min
	SDR 13.6	51.50 bar	2.5 mm	246 s	11 s	13 s	51.50 bar	30 min
	SDR 11	60.90 bar	3 mm	297 s	13 s	15 s	60.90 bar	36 min
	SDR 9	71.90 bar	3 mm	359 s	15 s	18 s	71.90 bar	43 min
	SDR 7.4	84.10 bar	3.5 mm	432 s	17 s	18 s	84.10 bar	52 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

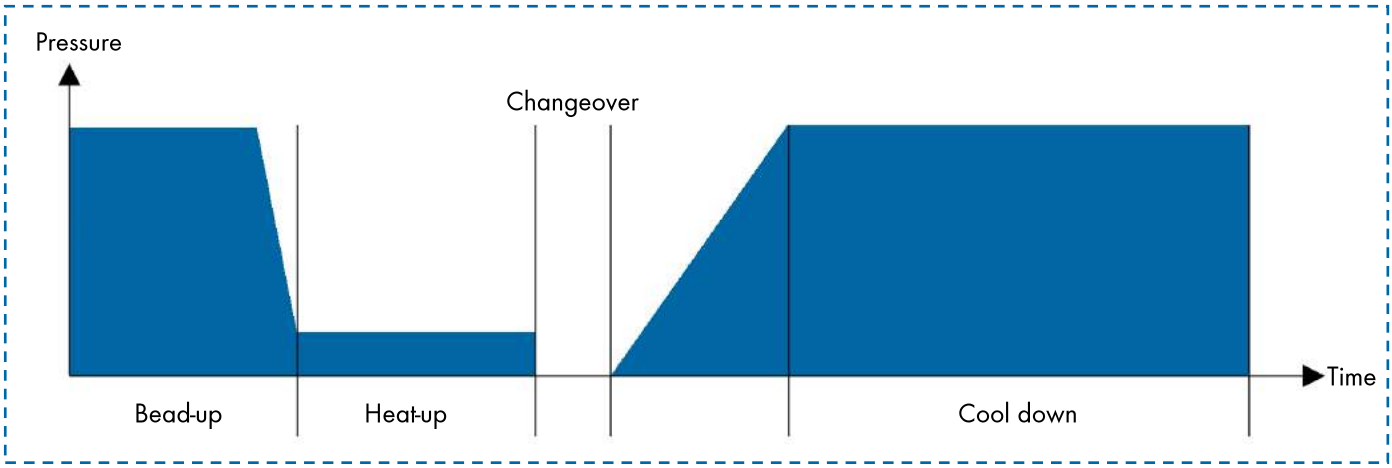
Widos 5100 — 5500

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 1414 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
200 mm	SDR 17.6	9.60 bar	2 mm	150 s	8 s	9 s	9.60 bar	19 min
	SDR 17	9.90 bar	2 mm	155 s	8 s	9 s	9.90 bar	19 min
	SDR 13.6	11.60 bar	2 mm	184 s	9 s	10 s	11.60 bar	23 min
	SDR 11	13.70 bar	2.5 mm	221 s	10 s	12 s	13.70 bar	27 min
	SDR 9	16.00 bar	3 mm	265 s	12 s	14 s	16.00 bar	32 min
	SDR 7.4	18.60 bar	3 mm	318 s	14 s	16 s	18.60 bar	38 min
225 mm	SDR 17.6	11.80 bar	2 mm	164 s	9 s	9 s	11.80 bar	21 min
	SDR 17	12.30 bar	2 mm	171 s	9 s	10 s	12.30 bar	21 min
	SDR 13.6	14.40 bar	2.5 mm	204 s	10 s	11 s	14.40 bar	25 min
	SDR 11	17.00 bar	2.5 mm	245 s	11 s	13 s	17.00 bar	30 min
	SDR 9	19.90 bar	3 mm	295 s	13 s	15 s	19.90 bar	36 min
	SDR 7.4	23.20 bar	3 mm	353 s	15 s	18 s	23.20 bar	42 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 5100 – 5500

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
250 mm	SDR 17.6	14.30 bar	2 mm	179 s	9 s	10 s	14.30 bar	22 min
	SDR 17	14.80 bar	2 mm	185 s	9 s	10 s	14.80 bar	23 min
	SDR 13.6	17.50 bar	2.5 mm	223 s	10 s	12 s	17.50 bar	27 min
	SDR 11	20.60 bar	3 mm	268 s	12 s	14 s	20.60 bar	32 min
	SDR 9	24.20 bar	3 mm	323 s	14 s	16 s	24.20 bar	39 min
	SDR 7.4	28.30 bar	3.5 mm	389 s	16 s	16 s	28.30 bar	47 min
280 mm	SDR 17.6	17.60 bar	2.5 mm	197 s	10 s	11 s	17.60 bar	24 min
	SDR 17	18.20 bar	2.5 mm	204 s	10 s	11 s	18.20 bar	25 min
	SDR 13.6	21.60 bar	2.5 mm	246 s	11 s	13 s	21.60 bar	30 min
	SDR 11	25.50 bar	3 mm	297 s	13 s	15 s	25.50 bar	36 min
	SDR 9	30.10 bar	3 mm	359 s	15 s	18 s	30.10 bar	43 min
	SDR 7.4	35.20 bar	3.5 mm	432 s	17 s	18 s	35.20 bar	52 min
315 mm	SDR 17.6	22.20 bar	2.5 mm	221 s	10 s	12 s	22.20 bar	27 min
	SDR 17	23.00 bar	2.5 mm	229 s	11 s	12 s	23.00 bar	28 min
	SDR 13.6	27.30 bar	3 mm	277 s	12 s	14 s	27.30 bar	33 min
	SDR 11	32.20 bar	3 mm	333 s	14 s	17 s	32.20 bar	40 min
	SDR 9	33.90 bar	3 mm	353 s	15 s	18 s	33.90 bar	42 min
	SDR 7.4	44.50 bar	3.5 mm	486 s	19 s	21 s	44.50 bar	58 min
355 mm	SDR 17.6	27.60 bar	2.5 mm	244 s	11 s	13 s	27.60 bar	30 min
	SDR 17	28.70 bar	2.5 mm	255 s	11 s	13 s	28.70 bar	31 min
	SDR 13.6	34.10 bar	3 mm	307 s	13 s	16 s	34.10 bar	37 min
	SDR 11	40.40 bar	3.5 mm	371 s	16 s	16 s	40.40 bar	45 min
	SDR 9	47.80 bar	3.5 mm	450 s	18 s	19 s	47.80 bar	54 min
	SDR 7.4	55.90 bar	4 mm	542 s	21 s	22 s	55.90 bar	64 min
400 mm	SDR 17.6	34.50 bar	3 mm	271 s	12 s	14 s	34.50 bar	33 min
	SDR 17	35.70 bar	3 mm	282 s	12 s	14 s	35.70 bar	34 min
	SDR 13.6	42.70 bar	3 mm	342 s	14 s	17 s	42.70 bar	41 min
	SDR 11	50.70 bar	3.5 mm	414 s	17 s	18 s	50.70 bar	50 min
	SDR 9	60.00 bar	4 mm	502 s	20 s	20 s	60.00 bar	60 min
	SDR 7.4	70.40 bar	4 mm	607 s	22 s	25 s	70.40 bar	70 min
450 mm	SDR 17.6	43.70 bar	3 mm	305 s	13 s	16 s	43.70 bar	37 min
	SDR 17	45.30 bar	3 mm	318 s	14 s	16 s	45.30 bar	38 min
	SDR 13.6	54.10 bar	3.5 mm	385 s	16 s	16 s	54.10 bar	46 min
	SDR 11	64.30 bar	3.5 mm	467 s	18 s	20 s	64.30 bar	56 min
	SDR 9	76.00 bar	4 mm	566 s	21 s	23 s	76.00 bar	66 min
	SDR 7.4	89.20 bar	4 mm	683 s	24 s	29 s	89.20 bar	78 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

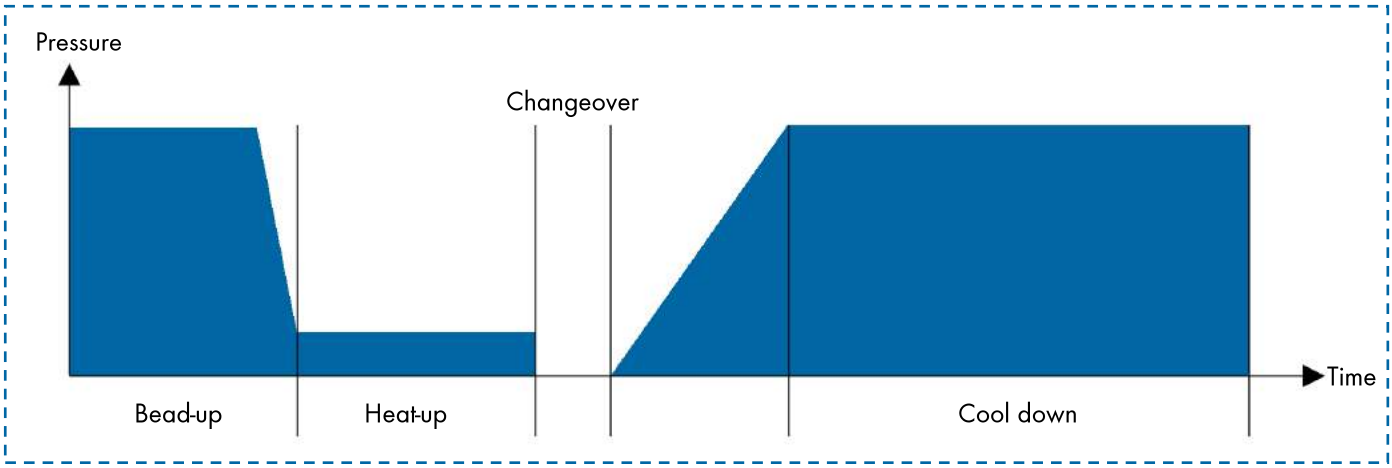
Widos 6100

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 1728 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
315 mm	SDR 17.6	18.10 bar	2.5 mm	221 s	10 s	12 s	18.10 bar	27 min
	SDR 17	18.70 bar	2.5 mm	229 s	11 s	12 s	18.70 bar	28 min
	SDR 13.6	22.20 bar	3 mm	277 s	12 s	14 s	22.20 bar	33 min
	SDR 11	26.30 bar	3 mm	333 s	14 s	17 s	26.30 bar	40 min
	SDR 9	27.60 bar	3 mm	353 s	15 s	18 s	27.60 bar	42 min
	SDR 7.4	36.30 bar	3.5 mm	486 s	19 s	21 s	36.30 bar	58 min
355 mm	SDR 17.6	22.20 bar	2.5 mm	244 s	11 s	13 s	22.20 bar	30 min
	SDR 17	23.10 bar	2.5 mm	255 s	11 s	13 s	23.10 bar	31 min
	SDR 13.6	27.40 bar	3 mm	307 s	13 s	16 s	27.40 bar	37 min
	SDR 11	32.40 bar	3.5 mm	371 s	16 s	16 s	32.40 bar	45 min
	SDR 9	38.30 bar	3.5 mm	450 s	18 s	19 s	38.30 bar	54 min
	SDR 7.4	44.80 bar	4 mm	542 s	21 s	22 s	44.80 bar	64 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 6100

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
400 mm	SDR 17.6	28.10 bar	3 mm	271 s	12 s	14 s	28.10 bar	33 min
	SDR 17	29.10 bar	3 mm	282 s	12 s	14 s	29.10 bar	34 min
	SDR 13.6	34.80 bar	3 mm	342 s	14 s	17 s	34.80 bar	41 min
	SDR 11	41.30 bar	3.5 mm	414 s	17 s	18 s	41.30 bar	50 min
	SDR 9	48.90 bar	4 mm	502 s	20 s	20 s	48.90 bar	60 min
	SDR 7.4	57.40 bar	4 mm	607 s	22 s	25 s	57.40 bar	70 min
450 mm	SDR 17.6	35.60 bar	3 mm	305 s	13 s	16 s	35.60 bar	37 min
	SDR 17	37.00 bar	3 mm	318 s	14 s	16 s	37.00 bar	38 min
	SDR 13.6	44.10 bar	3.5 mm	385 s	16 s	16 s	44.10 bar	46 min
	SDR 11	52.40 bar	3.5 mm	467 s	18 s	20 s	52.40 bar	56 min
	SDR 9	62.00 bar	4 mm	566 s	21 s	23 s	62.00 bar	66 min
	SDR 7.4	72.70 bar	4 mm	683 s	24 s	29 s	72.70 bar	78 min
500 mm	SDR 17.6	43.40 bar	3 mm	335 s	14 s	17 s	43.40 bar	40 min
	SDR 17	45.10 bar	3 mm	349 s	15 s	18 s	45.10 bar	42 min
	SDR 13.6	53.90 bar	3.5 mm	424 s	17 s	18 s	53.90 bar	51 min
	SDR 11	64.10 bar	4 mm	514 s	20 s	20 s	64.10 bar	61 min
	SDR 9	75.80 bar	4 mm	623 s	23 s	26 s	75.80 bar	72 min
560 mm	SDR 17.6	53.70 bar	3 mm	370 s	16 s	19 s	53.70 bar	45 min
	SDR 17	55.80 bar	3.5 mm	386 s	16 s	16 s	55.80 bar	46 min
	SDR 13.6	66.90 bar	3.5 mm	470 s	19 s	20 s	66.90 bar	56 min
	SDR 11	79.60 bar	4 mm	571 s	21 s	23 s	79.60 bar	67 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

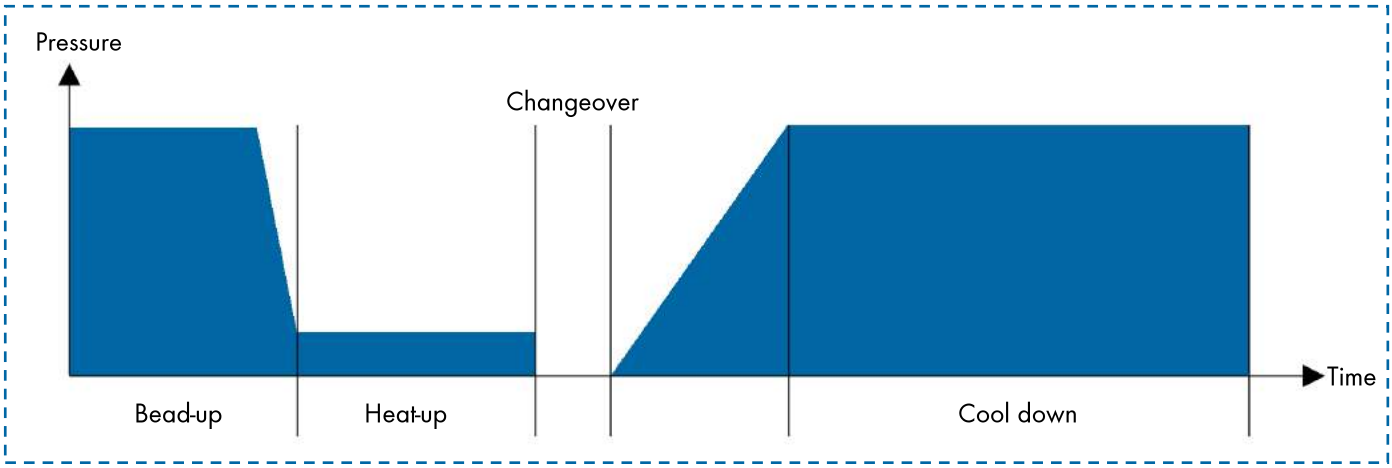
Widos 6100 Steel (since 6/2009)

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 2945 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
315 mm	SDR 17.6	10.60 bar	2.5 mm	221 s	10 s	12 s	10.60 bar	27 min
	SDR 17	11.00 bar	2.5 mm	229 s	11 s	12 s	11.00 bar	28 min
	SDR 13.6	13.10 bar	3 mm	277 s	12 s	14 s	13.10 bar	33 min
	SDR 11	15.50 bar	3 mm	333 s	14 s	17 s	15.50 bar	40 min
	SDR 9	16.20 bar	3 mm	353 s	15 s	18 s	16.20 bar	42 min
	SDR 7.4	21.30 bar	3.5 mm	486 s	19 s	21 s	21.30 bar	58 min
355 mm	SDR 17.6	13.30 bar	2.5 mm	244 s	11 s	13 s	13.30 bar	30 min
	SDR 17	13.80 bar	2.5 mm	255 s	11 s	13 s	13.80 bar	31 min
	SDR 13.6	16.30 bar	3 mm	307 s	13 s	16 s	16.30 bar	37 min
	SDR 11	19.40 bar	3.5 mm	371 s	16 s	16 s	19.40 bar	45 min
	SDR 9	22.90 bar	3.5 mm	450 s	18 s	19 s	22.90 bar	54 min
	SDR 7.4	26.80 bar	4 mm	542 s	21 s	22 s	26.80 bar	64 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 6100 Steel (since 6/2009)

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
400 mm	SDR 17.6	16.50 bar	3 mm	271 s	12 s	14 s	16.50 bar	33 min
	SDR 17	17.10 bar	3 mm	282 s	12 s	14 s	17.10 bar	34 min
	SDR 13.6	20.50 bar	3 mm	342 s	14 s	17 s	20.50 bar	41 min
	SDR 11	24.30 bar	3.5 mm	414 s	17 s	18 s	24.30 bar	50 min
	SDR 9	28.80 bar	4 mm	502 s	20 s	20 s	28.80 bar	60 min
	SDR 7.4	33.70 bar	4 mm	607 s	22 s	25 s	33.70 bar	70 min
450 mm	SDR 17.6	20.90 bar	3 mm	305 s	13 s	16 s	20.90 bar	37 min
	SDR 17	21.70 bar	3 mm	318 s	14 s	16 s	21.70 bar	38 min
	SDR 13.6	25.90 bar	3.5 mm	385 s	16 s	16 s	25.90 bar	46 min
	SDR 11	30.80 bar	3.5 mm	467 s	18 s	20 s	30.80 bar	56 min
	SDR 9	36.40 bar	4 mm	566 s	21 s	23 s	36.40 bar	66 min
	SDR 7.4	42.70 bar	4 mm	683 s	24 s	29 s	42.70 bar	78 min
500 mm	SDR 17.6	25.50 bar	3 mm	335 s	14 s	17 s	25.50 bar	40 min
	SDR 17	26.50 bar	3 mm	349 s	15 s	18 s	26.50 bar	42 min
	SDR 13.6	31.70 bar	3.5 mm	424 s	17 s	18 s	31.70 bar	51 min
	SDR 11	37.70 bar	4 mm	514 s	20 s	20 s	37.70 bar	61 min
	SDR 9	44.60 bar	4 mm	623 s	23 s	26 s	44.60 bar	72 min
560 mm	SDR 17.6	31.50 bar	3 mm	370 s	16 s	19 s	31.50 bar	45 min
	SDR 17	32.80 bar	3.5 mm	386 s	16 s	16 s	32.80 bar	46 min
	SDR 13.6	39.30 bar	3.5 mm	470 s	19 s	20 s	39.30 bar	56 min
	SDR 11	46.80 bar	4 mm	571 s	21 s	23 s	46.80 bar	67 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

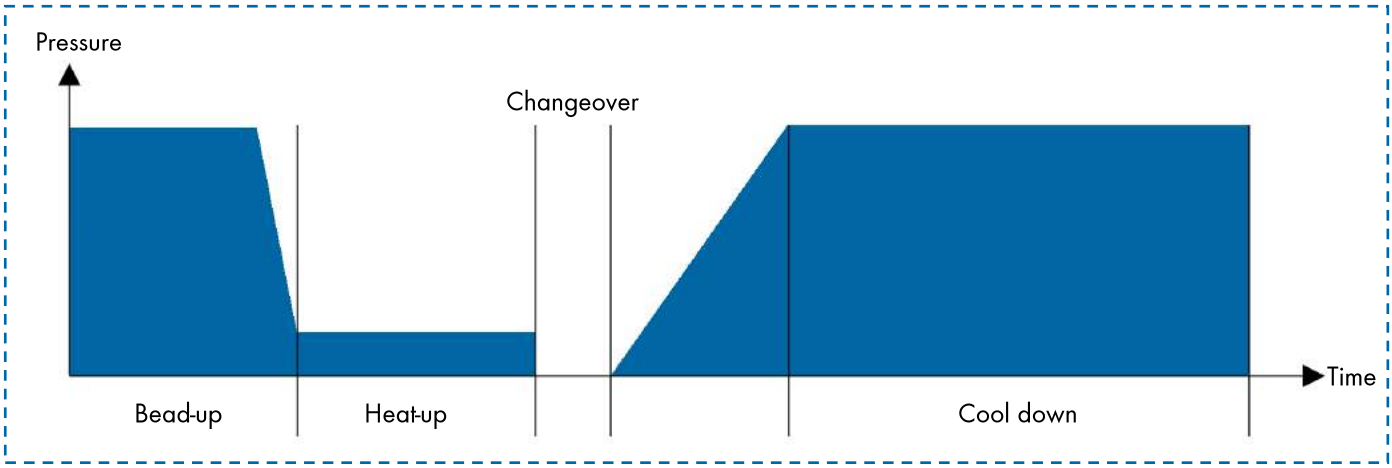
Widos 8000 (7/2000 to 5/2009) – 10000 (since 7/2000)

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 4626 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
450 mm	SDR 17.6	13.30 bar	3 mm	305 s	13 s	16 s	13.30 bar	37 min
	SDR 17	13.80 bar	3 mm	318 s	14 s	16 s	13.80 bar	38 min
	SDR 13.6	16.50 bar	3.5 mm	385 s	16 s	16 s	16.50 bar	46 min
	SDR 11	19.60 bar	3.5 mm	467 s	18 s	20 s	19.60 bar	56 min
	SDR 9	23.20 bar	4 mm	566 s	21 s	23 s	23.20 bar	66 min
	SDR 7.4	27.20 bar	4 mm	683 s	24 s	29 s	27.20 bar	78 min
500 mm	SDR 17.6	16.20 bar	3 mm	335 s	14 s	17 s	16.20 bar	40 min
	SDR 17	16.90 bar	3 mm	349 s	15 s	18 s	16.90 bar	42 min
	SDR 13.6	20.20 bar	3.5 mm	424 s	17 s	18 s	20.20 bar	51 min
	SDR 11	24.00 bar	4 mm	514 s	20 s	20 s	24.00 bar	61 min
	SDR 9	28.40 bar	4 mm	623 s	23 s	26 s	28.40 bar	72 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 8000 (7/2000 to 5/2009) – 10000 (since 7/2000)

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
560 mm	SDR 17.6	20.10 bar	3 mm	370 s	16 s	19 s	20.10 bar	45 min
	SDR 17	20.90 bar	3.5 mm	386 s	16 s	16 s	20.90 bar	46 min
	SDR 13.6	25.00 bar	3.5 mm	470 s	19 s	20 s	25.00 bar	56 min
	SDR 11	29.80 bar	4 mm	571 s	21 s	23 s	29.80 bar	67 min
630 mm	SDR 17.6	25.10 bar	3.5 mm	412 s	17 s	17 s	25.10 bar	49 min
	SDR 17	26.10 bar	3.5 mm	430 s	17 s	18 s	26.10 bar	51 min
	SDR 13.6	31.30 bar	4 mm	524 s	20 s	21 s	31.30 bar	62 min
	SDR 11	37.40 bar	4 mm	638 s	23 s	26 s	37.40 bar	73 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

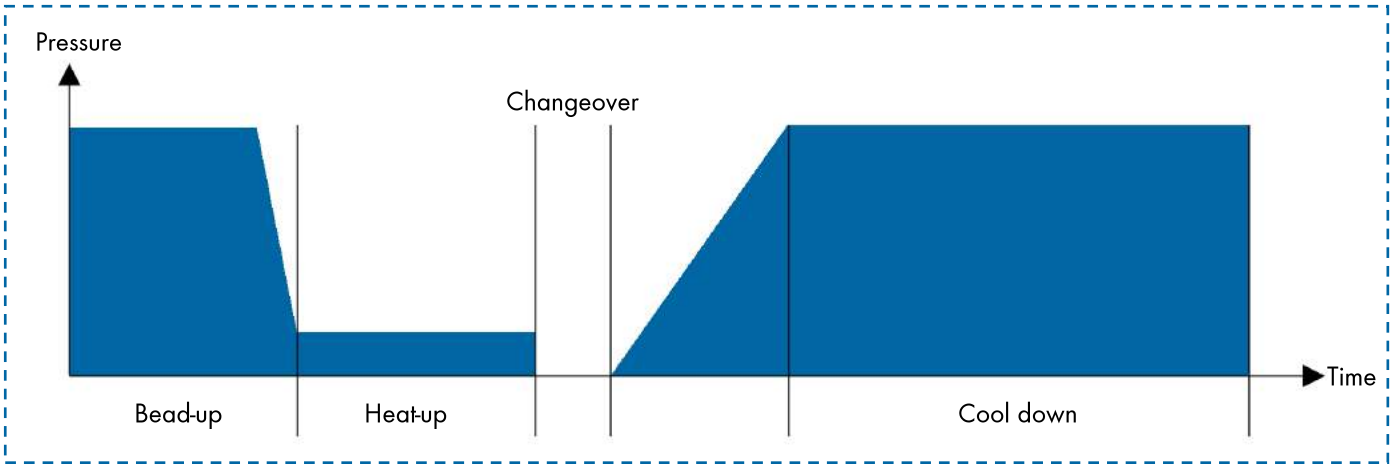
Widos 8000 (since 6/2009)

Welding parameters for egeplast SLM® 3.0 pipes – butt fusion jointing WITHOUT cutting back the coating

Welding takes place according to the relevant DVS guidelines DVS 2207 and 2208.
The following parameters apply to the machine type listed above only.
Reference value for the heating element temperature is 220 °C. Changeover time should be kept as short as possible.

Additionally to the given bead-up force and welding foce, the moving force of the support must be added.

Cylinder cross-section = 2945 mm²
Please compare the specified cylinder cross-section with the label on your machine. If this differs, please contact your egeplast representative.



Schematic presentation of the welding process

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
450 mm	SDR 17.6	20.90 bar	3 mm	305 s	13 s	16 s	20.90 bar	37 min
	SDR 17	21.70 bar	3 mm	318 s	14 s	16 s	21.70 bar	38 min
	SDR 13.6	25.90 bar	3.5 mm	385 s	16 s	16 s	25.90 bar	46 min
	SDR 11	30.80 bar	3.5 mm	467 s	18 s	20 s	30.80 bar	56 min
	SDR 9	36.40 bar	4 mm	566 s	21 s	23 s	36.40 bar	66 min
	SDR 7.4	42.70 bar	4 mm	683 s	24 s	29 s	42.70 bar	78 min
500 mm	SDR 17.6	25.50 bar	3 mm	335 s	14 s	17 s	25.50 bar	40 min
	SDR 17	26.50 bar	3 mm	349 s	15 s	18 s	26.50 bar	42 min
	SDR 13.6	31.70 bar	3.5 mm	424 s	17 s	18 s	31.70 bar	51 min
	SDR 11	37.70 bar	4 mm	514 s	20 s	20 s	37.70 bar	61 min
	SDR 9	44.60 bar	4 mm	623 s	23 s	26 s	44.60 bar	72 min

*The indicated SDR-rate refers to the core pipe.
The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.

Continuation Widos 8000 (since 6/2009)

OD core pipe	SDR core pipe*	Bead-up time		Heat-up time	Changeover time (max)	Joining pressure build-up time	Cool-down time	
[mm]		P	Bead size	t	t	t	P	t
560 mm	SDR 17.6	31.50 bar	3 mm	370 s	16 s	19 s	31.50 bar	45 min
	SDR 17	32.80 bar	3.5 mm	386 s	16 s	16 s	32.80 bar	46 min
	SDR 13.6	39.30 bar	3.5 mm	470 s	19 s	20 s	39.30 bar	56 min
	SDR 11	46.80 bar	4 mm	571 s	21 s	23 s	46.80 bar	67 min
630 mm	SDR 17.6	39.50 bar	3.5 mm	412 s	17 s	17 s	39.50 bar	49 min
	SDR 17	41.10 bar	3.5 mm	430 s	17 s	18 s	41.10 bar	51 min
	SDR 13.6	49.20 bar	4 mm	524 s	20 s	21 s	49.20 bar	62 min
	SDR 11	58.80 bar	4 mm	638 s	23 s	26 s	58.80 bar	73 min

*The indicated SDR-rate refers to the core pipe.

The calculated parameters in the tables already take into account the additional protective coating of the egeplast SLM® 3.0 pipes.