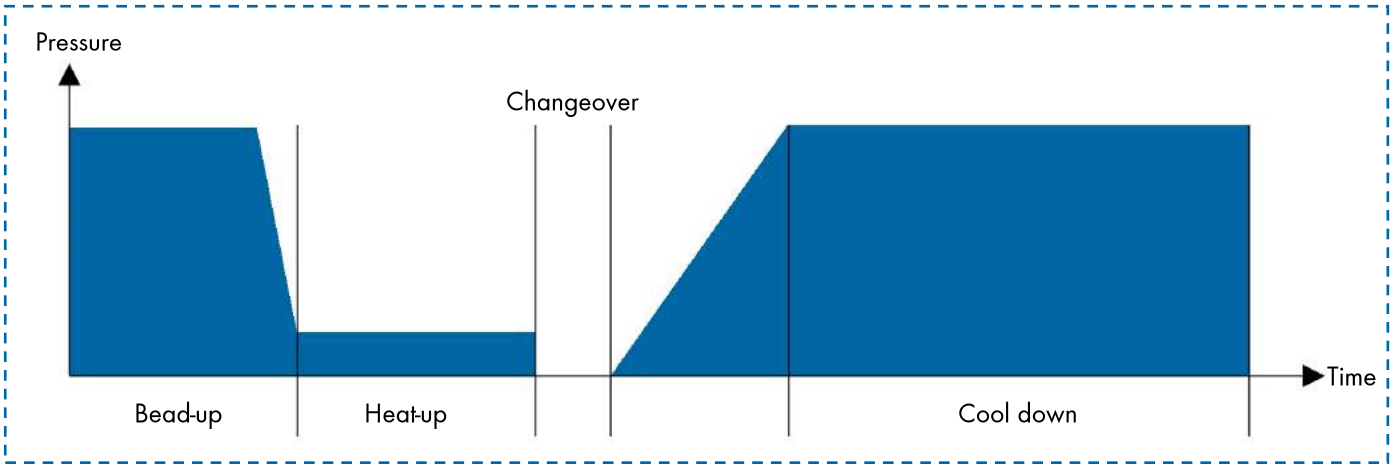
Rothenberger Roweld P 160 B

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 = 3.53 cm²
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
40 mm	SDR 17.6	1.90 bar	0.5 mm	35 s	5 s	5 s	1.90 bar	6 min
	SDR 17	1.90 bar	0.5 mm	36 s	5 s	5 s	1.90 bar	6 min
	SDR 13.6	2.20 bar	0.5 mm	43 s	5 s	5 s	2.20 bar	6 min
	SDR 11	2.50 bar	1 mm	50 s	5 s	5 s	2.50 bar	6 min
	SDR 9	2.90 bar	1 mm	58 s	5 s	5 s	2.90 bar	8 min
	SDR 7.4	3.30 bar	1 mm	69 s	5 s	5 s	3.30 bar	9 min
50 mm	SDR 17.6	2.80 bar	0.5 mm	43 s	5 s	5 s	2.80 bar	6 min
	SDR 17	2.90 bar	0.5 mm	44 s	5 s	5 s	2.90 bar	6 min
	SDR 13.6	3.30 bar	1 mm	52 s	5 s	5 s	3.30 bar	7 min
	SDR 11	3.80 bar	1 mm	61 s	5 s	5 s	3.80 bar	8 min
	SDR 9	4.40 bar	1.5 mm	72 s	6 s	6 s	4.40 bar	10 min
	SDR 7.4	5.10 bar	1.5 mm	85 s	6 s	6 s	5.10 bar	11 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 Rothenberger Roweld P 160 B

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	4.20 bar	1 mm	52 s	5 s	5 s	4.20 bar	7 min
	SDR 17	4.40 bar	1 mm	54 s	5 s	5 s	4.40 bar	7 min
	SDR 13.6	5.10 bar	1 mm	63 s	5 s	5 s	5.10 bar	8 min
	SDR 11	5.90 bar	1.5 mm	75 s	6 s	6 s	5.90 bar	10 min
	SDR 9	6.80 bar	1.5 mm	89 s	6 s	6 s	6.80 bar	12 min
	SDR 7.4	7.70 bar	1.5 mm	104 s	7 s	7 s	7.70 bar	14 min
75 mm	SDR 17.6	5.70 bar	1 mm	59 s	5 s	5 s	5.70 bar	8 min
	SDR 17	5.90 bar	1 mm	61 s	5 s	5 s	5.90 bar	8 min
	SDR 13.6	6.90 bar	1.5 mm	73 s	6 s	6 s	6.90 bar	10 min
	SDR 11	7.90 bar	1.5 mm	85 s	6 s	6 s	7.90 bar	11 min
	SDR 9	9.30 bar	1.5 mm	102 s	7 s	7 s	9.30 bar	13 min
	SDR 7.4	10.70 bar	2 mm	122 s	8 s	8 s	10.70 bar	16 min
90 mm	SDR 17.6	7.90 bar	1 mm	69 s	5 s	5 s	7.90 bar	9 min
	SDR 17	8.30 bar	1.5 mm	72 s	6 s	6 s	8.30 bar	10 min
	SDR 13.6	9.60 bar	1.5 mm	85 s	6 s	6 s	9.60 bar	11 min
	SDR 11	11.20 bar	1.5 mm	101 s	7 s	7 s	11.20 bar	13 min
	SDR 9	13.10 bar	2 mm	121 s	8 s	8 s	13.10 bar	16 min
	SDR 7.4	15.20 bar	2 mm	144 s	8 s	9 s	15.20 bar	18 min
110 mm	SDR 17.6	11.90 bar	1.5 mm	85 s	6 s	6 s	11.90 bar	11 min
	SDR 17	12.30 bar	1.5 mm	88 s	6 s	6 s	12.30 bar	12 min
	SDR 13.6	14.40 bar	1.5 mm	104 s	7 s	7 s	14.40 bar	14 min
	SDR 11	16.70 bar	2 mm	123 s	8 s	8 s	16.70 bar	16 min
	SDR 9	19.60 bar	2 mm	148 s	8 s	9 s	19.60 bar	19 min
	SDR 7.4	22.80 bar	2 mm	177 s	9 s	10 s	22.80 bar	22 min
125 mm	SDR 17.6	14.90 bar	1.5 mm	93 s	6 s	6 s	14.90 bar	12 min
	SDR 17	15.30 bar	1.5 mm	96 s	7 s	7 s	15.30 bar	13 min
	SDR 13.6	18.10 bar	1.5 mm	115 s	7 s	7 s	18.10 bar	15 min
	SDR 11	21.30 bar	2 mm	138 s	8 s	8 s	21.30 bar	18 min
	SDR 9	24.90 bar	2 mm	166 s	9 s	9 s	24.90 bar	21 min
	SDR 7.4	28.90 bar	2.5 mm	198 s	10 s	11 s	28.90 bar	24 min
140 mm	SDR 17.6	18.30 bar	1.5 mm	103 s	7 s	7 s	18.30 bar	13 min
	SDR 17	18.80 bar	1.5 mm	106 s	7 s	7 s	18.80 bar	14 min
	SDR 13.6	22.20 bar	2 mm	127 s	8 s	8 s	22.20 bar	16 min
	SDR 11	26.10 bar	2 mm	152 s	8 s	9 s	26.10 bar	19 min
	SDR 9	30.70 bar	2 mm	183 s	9 s	10 s	30.70 bar	23 min
	SDR 7.4	35.90 bar	2.5 mm	220 s	10 s	12 s	35.90 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.

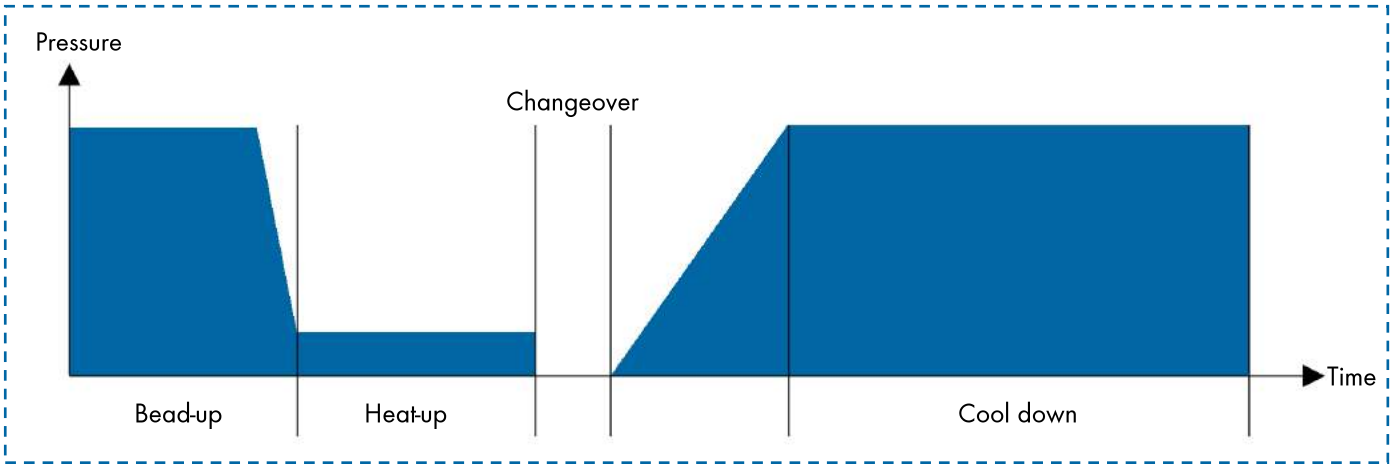
Rothenberger Roweld P 250 B

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 = 6.26 cm²
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
90 mm	SDR 17.6	4.50 bar	1 mm	69 s	5 s	5 s	4.50 bar	9 min
	SDR 17	4.70 bar	1.5 mm	72 s	6 s	6 s	4.70 bar	10 min
	SDR 13.6	5.50 bar	1.5 mm	85 s	6 s	6 s	5.50 bar	11 min
	SDR 11	6.40 bar	1.5 mm	101 s	7 s	7 s	6.40 bar	13 min
	SDR 9	7.40 bar	2 mm	121 s	8 s	8 s	7.40 bar	16 min
	SDR 7.4	8.60 bar	2 mm	144 s	8 s	9 s	8.60 bar	18 min
110 mm	SDR 17.6	6.80 bar	1.5 mm	85 s	6 s	6 s	6.80 bar	11 min
	SDR 17	7.00 bar	1.5 mm	88 s	6 s	6 s	7.00 bar	12 min
	SDR 13.6	8.10 bar	1.5 mm	104 s	7 s	7 s	8.10 bar	14 min
	SDR 11	9.50 bar	2 mm	123 s	8 s	8 s	9.50 bar	16 min
	SDR 9	11.10 bar	2 mm	148 s	8 s	9 s	11.10 bar	19 min
	SDR 7.4	12.90 bar	2 mm	177 s	9 s	10 s	12.90 bar	22 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 Rothenberger Roweld P 250 B

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
125 mm	SDR 17.6	8.40 bar	1.5 mm	93 s	6 s	6 s	8.40 bar	12 min
	SDR 17	8.70 bar	1.5 mm	96 s	7 s	7 s	8.70 bar	13 min
	SDR 13.6	10.20 bar	1.5 mm	115 s	7 s	7 s	10.20 bar	15 min
	SDR 11	12.00 bar	2 mm	138 s	8 s	8 s	12.00 bar	18 min
	SDR 9	14.00 bar	2 mm	166 s	9 s	9 s	14.00 bar	21 min
	SDR 7.4	16.30 bar	2.5 mm	198 s	10 s	11 s	16.30 bar	24 min
140 mm	SDR 17.6	10.40 bar	1.5 mm	103 s	7 s	7 s	10.40 bar	13 min
	SDR 17	10.60 bar	1.5 mm	106 s	7 s	7 s	10.60 bar	14 min
	SDR 13.6	12.60 bar	2 mm	127 s	8 s	8 s	12.60 bar	16 min
	SDR 11	14.70 bar	2 mm	152 s	8 s	9 s	14.70 bar	19 min
	SDR 9	17.40 bar	2 mm	183 s	9 s	10 s	17.40 bar	23 min
	SDR 7.4	20.20 bar	2.5 mm	220 s	10 s	12 s	20.20 bar	27 min
160 mm	SDR 17.6	13.80 bar	1.5 mm	119 s	7 s	7 s	13.80 bar	15 min
	SDR 17	14.20 bar	2 mm	123 s	8 s	8 s	14.20 bar	16 min
	SDR 13.6	16.70 bar	2 mm	147 s	8 s	9 s	16.70 bar	19 min
	SDR 11	19.60 bar	2 mm	177 s	9 s	10 s	19.60 bar	22 min
	SDR 9	22.90 bar	2.5 mm	211 s	10 s	11 s	22.90 bar	26 min
	SDR 7.4	26.70 bar	2.5 mm	253 s	11 s	13 s	26.70 bar	31 min
180 mm	SDR 17.6	17.90 bar	2 mm	137 s	8 s	8 s	17.90 bar	17 min
	SDR 17	18.50 bar	2 mm	142 s	8 s	8 s	18.50 bar	18 min
	SDR 13.6	21.70 bar	2 mm	170 s	9 s	10 s	21.70 bar	21 min
	SDR 11	25.30 bar	2.5 mm	202 s	10 s	11 s	25.30 bar	25 min
	SDR 9	29.50 bar	2.5 mm	241 s	11 s	13 s	29.50 bar	29 min
	SDR 7.4	34.20 bar	3 mm	288 s	13 s	15 s	34.20 bar	35 min
200 mm	SDR 17.6	21.60 bar	2 mm	150 s	8 s	9 s	21.60 bar	19 min
	SDR 17	22.30 bar	2 mm	155 s	8 s	9 s	22.30 bar	19 min
	SDR 13.6	26.10 bar	2 mm	184 s	9 s	10 s	26.10 bar	23 min
	SDR 11	30.70 bar	2.5 mm	221 s	10 s	12 s	30.70 bar	27 min
	SDR 9	35.90 bar	3 mm	265 s	12 s	14 s	35.90 bar	32 min
	SDR 7.4	41.80 bar	3 mm	318 s	14 s	16 s	41.80 bar	38 min
225 mm	SDR 17.6	26.60 bar	2 mm	164 s	9 s	9 s	26.60 bar	21 min
	SDR 17	27.60 bar	2 mm	171 s	9 s	10 s	27.60 bar	21 min
	SDR 13.6	32.50 bar	2.5 mm	204 s	10 s	11 s	32.50 bar	25 min
	SDR 11	38.20 bar	2.5 mm	245 s	11 s	13 s	38.20 bar	30 min
	SDR 9	44.80 bar	3 mm	295 s	13 s	15 s	44.80 bar	36 min
	SDR 7.4	52.20 bar	3 mm	353 s	15 s	18 s	52.20 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.

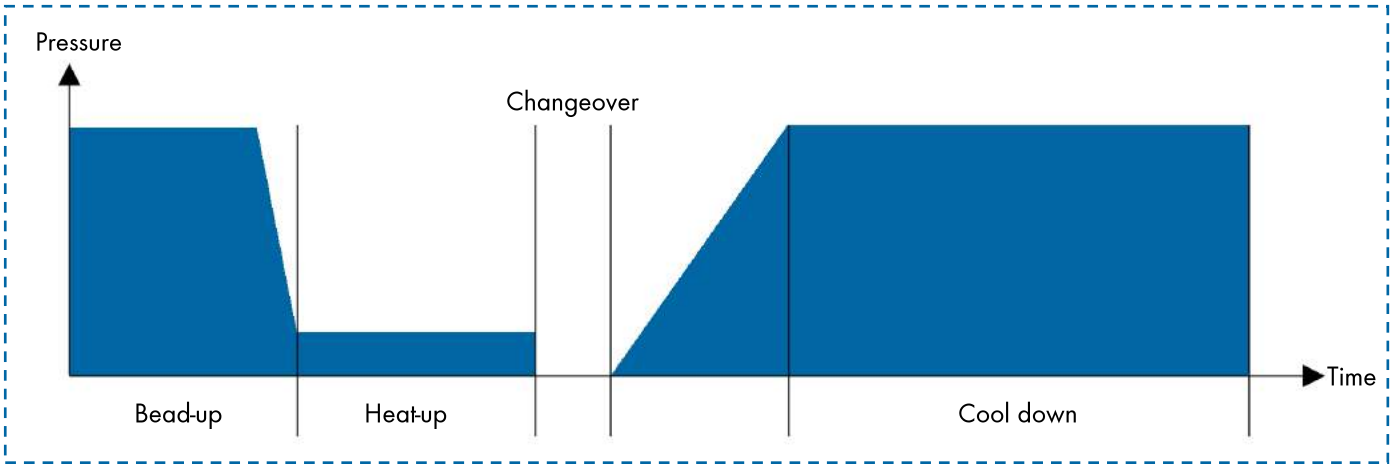
Rothenberger Roweld P 355 B

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 = 6.26 cm²
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
OD 90 mm	SDR 17.6	4.50 bar	1 mm	69 s	5 s	5 s	4.50 bar	9 min
	SDR 17	4.70 bar	1.5 mm	72 s	6 s	6 s	4.70 bar	10 min
	SDR 13.6	5.50 bar	1.5 mm	85 s	6 s	6 s	5.50 bar	11 min
	SDR 11	6.40 bar	1.5 mm	101 s	7 s	7 s	6.40 bar	13 min
	SDR 9	7.40 bar	2 mm	121 s	8 s	8 s	7.40 bar	16 min
	SDR 7.4	8.60 bar	2 mm	144 s	8 s	9 s	8.60 bar	18 min
OD 110 mm	SDR 17.6	6.80 bar	1.5 mm	85 s	6 s	6 s	6.80 bar	11 min
	SDR 17	7.00 bar	1.5 mm	88 s	6 s	6 s	7.00 bar	12 min
	SDR 13.6	8.10 bar	1.5 mm	104 s	7 s	7 s	8.10 bar	14 min
	SDR 11	9.50 bar	2 mm	123 s	8 s	8 s	9.50 bar	16 min
	SDR 9	11.10 bar	2 mm	148 s	8 s	9 s	11.10 bar	19 min
	SDR 7.4	12.90 bar	2 mm	177 s	9 s	10 s	12.90 bar	22 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 Rothenberger Roweld P 355 B

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
OD 125 mm	SDR 17.6	8.40 bar	1.5 mm	93 s	6 s	6 s	8.40 bar	12 min
	SDR 17	8.70 bar	1.5 mm	96 s	7 s	7 s	8.70 bar	13 min
	SDR 13.6	10.20 bar	1.5 mm	115 s	7 s	7 s	10.20 bar	15 min
	SDR 11	12.00 bar	2 mm	138 s	8 s	8 s	12.00 bar	18 min
	SDR 9	14.00 bar	2 mm	166 s	9 s	9 s	14.00 bar	21 min
	SDR 7.4	16.30 bar	2.5 mm	198 s	10 s	11 s	16.30 bar	24 min
OD 140 mm	SDR 17.6	10.40 bar	1.5 mm	103 s	7 s	7 s	10.40 bar	13 min
	SDR 17	10.60 bar	1.5 mm	106 s	7 s	7 s	10.60 bar	14 min
	SDR 13.6	12.60 bar	2 mm	127 s	8 s	8 s	12.60 bar	16 min
	SDR 11	14.70 bar	2 mm	152 s	8 s	9 s	14.70 bar	19 min
	SDR 9	17.40 bar	2 mm	183 s	9 s	10 s	17.40 bar	23 min
	SDR 7.4	20.20 bar	2.5 mm	220 s	10 s	12 s	20.20 bar	27 min
OD 160 mm	SDR 17.6	13.80 bar	1.5 mm	119 s	7 s	7 s	13.80 bar	15 min
	SDR 17	14.20 bar	2 mm	123 s	8 s	8 s	14.20 bar	16 min
	SDR 13.6	16.70 bar	2 mm	147 s	8 s	9 s	16.70 bar	19 min
	SDR 11	19.60 bar	2 mm	177 s	9 s	10 s	19.60 bar	22 min
	SDR 9	22.90 bar	2.5 mm	211 s	10 s	11 s	22.90 bar	26 min
	SDR 7.4	26.70 bar	2.5 mm	253 s	11 s	13 s	26.70 bar	31 min
OD 180 mm	SDR 17.6	17.90 bar	2 mm	137 s	8 s	8 s	17.90 bar	17 min
	SDR 17	18.50 bar	2 mm	142 s	8 s	8 s	18.50 bar	18 min
	SDR 13.6	21.70 bar	2 mm	170 s	9 s	10 s	21.70 bar	21 min
	SDR 11	25.30 bar	2.5 mm	202 s	10 s	11 s	25.30 bar	25 min
	SDR 9	29.50 bar	2.5 mm	241 s	11 s	13 s	29.50 bar	29 min
	SDR 7.4	34.20 bar	3 mm	288 s	13 s	15 s	34.20 bar	35 min
OD 200 mm	SDR 17.6	21.60 bar	2 mm	150 s	8 s	9 s	21.60 bar	19 min
	SDR 17	22.30 bar	2 mm	155 s	8 s	9 s	22.30 bar	19 min
	SDR 13.6	26.10 bar	2 mm	184 s	9 s	10 s	26.10 bar	23 min
	SDR 11	30.70 bar	2.5 mm	221 s	10 s	12 s	30.70 bar	27 min
	SDR 9	35.90 bar	3 mm	265 s	12 s	14 s	35.90 bar	32 min
	SDR 7.4	41.80 bar	3 mm	318 s	14 s	16 s	41.80 bar	38 min
OD 225 mm	SDR 17.6	26.60 bar	2 mm	164 s	9 s	9 s	26.60 bar	21 min
	SDR 17	27.60 bar	2 mm	171 s	9 s	10 s	27.60 bar	21 min
	SDR 13.6	32.50 bar	2.5 mm	204 s	10 s	11 s	32.50 bar	25 min
	SDR 11	38.20 bar	2.5 mm	245 s	11 s	13 s	38.20 bar	30 min
	SDR 9	44.80 bar	3 mm	295 s	13 s	15 s	44.80 bar	36 min
	SDR 7.4	52.20 bar	3 mm	353 s	15 s	18 s	52.20 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 Rothenberger Roweld P 355 B

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	32.20 bar	2 mm	179 s	9 s	10 s	32.20 bar	22 min
	SDR 17	33.20 bar	2 mm	185 s	9 s	10 s	33.20 bar	23 min
	SDR 13.6	39.40 bar	2.5 mm	223 s	10 s	12 s	39.40 bar	27 min
	SDR 11	46.40 bar	3 mm	268 s	12 s	14 s	46.40 bar	32 min
	SDR 9	54.50 bar	3 mm	323 s	14 s	16 s	54.50 bar	39 min
	SDR 7.4	63.80 bar	3.5 mm	389 s	16 s	16 s	63.80 bar	47 min
280 mm	SDR 17.6	39.50 bar	2.5 mm	197 s	10 s	11 s	39.50 bar	24 min
	SDR 17	40.90 bar	2.5 mm	204 s	10 s	11 s	40.90 bar	25 min
	SDR 13.6	48.60 bar	2.5 mm	246 s	11 s	13 s	48.60 bar	30 min
	SDR 11	57.40 bar	3 mm	297 s	13 s	15 s	57.40 bar	36 min
	SDR 9	67.70 bar	3 mm	359 s	15 s	18 s	67.70 bar	43 min
	SDR 7.4	79.20 bar	3.5 mm	432 s	17 s	18 s	79.20 bar	52 min
315 mm	SDR 17.6	49.90 bar	2.5 mm	221 s	10 s	12 s	49.90 bar	27 min
	SDR 17	51.70 bar	2.5 mm	229 s	11 s	12 s	51.70 bar	28 min
	SDR 13.6	61.40 bar	3 mm	277 s	12 s	14 s	61.40 bar	33 min
	SDR 11	72.50 bar	3 mm	333 s	14 s	17 s	72.50 bar	40 min
	SDR 9	76.20 bar	3 mm	353 s	15 s	18 s	76.20 bar	42 min
	SDR 7.4	100.10 bar	3.5 mm	486 s	19 s	21 s	100.10 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.

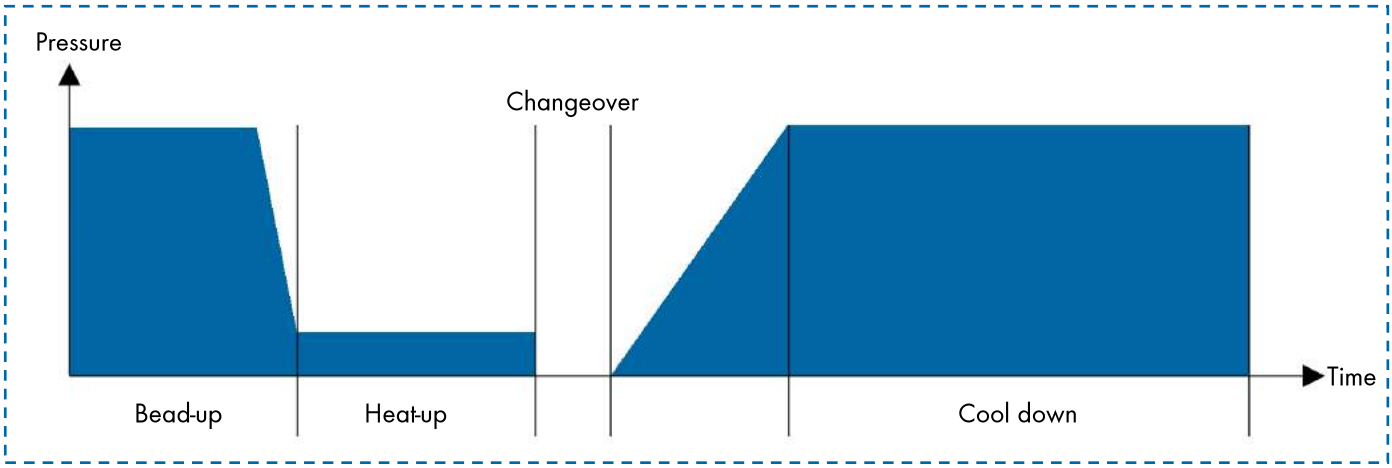
Rothenberger Roweld P 500 B

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 = 14.13 cm²
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	13.60 bar	2.5 mm	221 s	10 s	12 s	13.60 bar	27 min
	SDR 9	15.90 bar	3 mm	265 s	12 s	14 s	15.90 bar	32 min
	SDR 7.4	18.50 bar	3 mm	318 s	14 s	16 s	18.50 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	12.20 bar	2 mm	171 s	9 s	10 s	12.20 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	23.10 bar	3 mm	353 s	15 s	18 s	23.10 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 Rothenberger Roweld P 500 B

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	14.70 bar	2 mm	185 s	9 s	10 s	14.70 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	17.50 bar	2.5 mm	197 s	10 s	11 s	17.50 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	21.50 bar	2.5 mm	246 s	11 s	13 s	21.50 bar	30 min
	SDR 11	25.50 bar	3 mm	297 s	13 s	15 s	25.50 bar	36 min
	SDR 9	30.00 bar	3 mm	359 s	15 s	18 s	30.00 bar	43 min
	SDR 7.4	35.10 bar	3.5 mm	432 s	17 s	18 s	35.10 bar	52 min
315 mm	SDR 17.6	22.10 bar	2.5 mm	221 s	10 s	12 s	22.10 bar	27 min
	SDR 17	22.90 bar	2.5 mm	229 s	11 s	12 s	22.90 bar	28 min
	SDR 13.6	27.20 bar	3 mm	277 s	12 s	14 s	27.20 bar	33 min
	SDR 11	32.20 bar	3 mm	333 s	14 s	17 s	32.20 bar	40 min
	SDR 9	33.80 bar	3 mm	353 s	15 s	18 s	33.80 bar	42 min
	SDR 7.4	44.40 bar	3.5 mm	486 s	19 s	21 s	44.40 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	34.00 bar	3 mm	307 s	13 s	16 s	34.00 bar	37 min
	SDR 11	40.30 bar	3.5 mm	371 s	16 s	16 s	40.30 bar	45 min
	SDR 9	47.70 bar	3.5 mm	450 s	18 s	19 s	47.70 bar	54 min
	SDR 7.4	55.80 bar	4 mm	542 s	21 s	22 s	55.80 bar	64 min
400 mm	SDR 17.6	34.40 bar	3 mm	271 s	12 s	14 s	34.40 bar	33 min
	SDR 17	35.70 bar	3 mm	282 s	12 s	14 s	35.70 bar	34 min
	SDR 13.6	42.60 bar	3 mm	342 s	14 s	17 s	42.60 bar	41 min
	SDR 11	50.60 bar	3.5 mm	414 s	17 s	18 s	50.60 bar	50 min
	SDR 9	59.90 bar	4 mm	502 s	20 s	20 s	59.90 bar	60 min
	SDR 7.4	70.30 bar	4 mm	607 s	22 s	25 s	70.30 bar	70 min
450 mm	SDR 17.6	43.60 bar	3 mm	305 s	13 s	16 s	43.60 bar	37 min
	SDR 17	45.30 bar	3 mm	318 s	14 s	16 s	45.30 bar	38 min
	SDR 13.6	54.00 bar	3.5 mm	385 s	16 s	16 s	54.00 bar	46 min
	SDR 11	64.10 bar	3.5 mm	467 s	18 s	20 s	64.10 bar	56 min
	SDR 9	75.90 bar	4 mm	566 s	21 s	23 s	75.90 bar	66 min
	SDR 7.4	89.00 bar	4 mm	683 s	24 s	29 s	89.00 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.

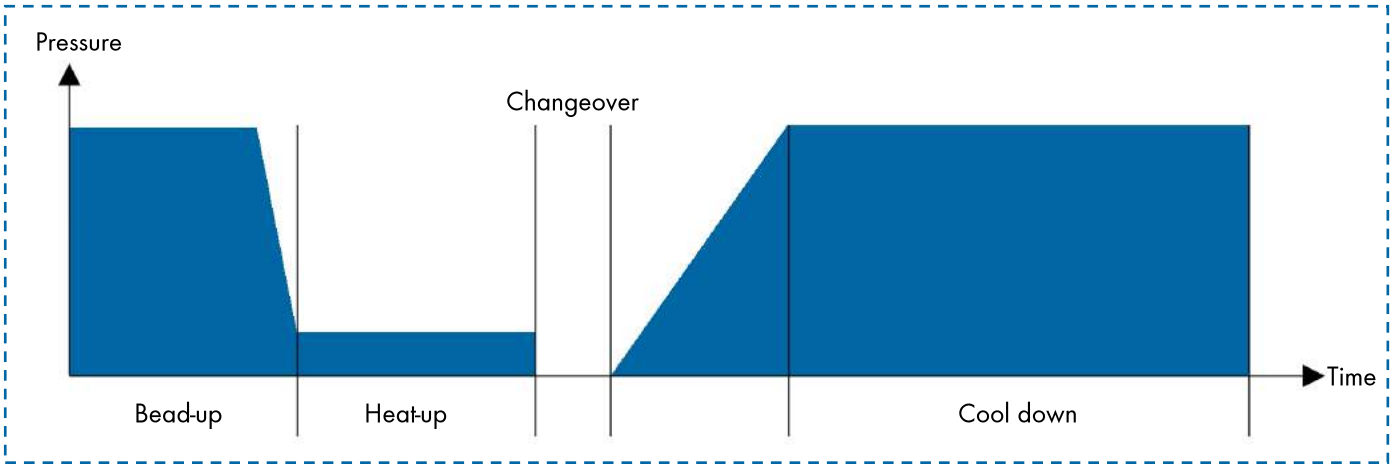
Rothenberger Roweld P 630 B

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 = 14.13 cm²
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	22.10 bar	2.5 mm	221 s	10 s	12 s	22.10 bar	27 min
	SDR 17	22.90 bar	2.5 mm	229 s	11 s	12 s	22.90 bar	28 min
	SDR 13.6	27.20 bar	3 mm	277 s	12 s	14 s	27.20 bar	33 min
	SDR 11	32.20 bar	3 mm	333 s	14 s	17 s	32.20 bar	40 min
	SDR 9	33.80 bar	3 mm	353 s	15 s	18 s	33.80 bar	42 min
	SDR 7.4	44.40 bar	3.5 mm	486 s	19 s	21 s	44.40 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	34.00 bar	3 mm	307 s	13 s	16 s	34.00 bar	37 min
	SDR 11	40.30 bar	3.5 mm	371 s	16 s	16 s	40.30 bar	45 min
	SDR 9	47.70 bar	3.5 mm	450 s	18 s	19 s	47.70 bar	54 min
	SDR 7.4	55.80 bar	4 mm	542 s	21 s	22 s	55.80 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 Rothenberger Roweld P 630 B

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	34.40 bar	3 mm	271 s	12 s	14 s	34.40 bar	33 min
	SDR 17	35.70 bar	3 mm	282 s	12 s	14 s	35.70 bar	34 min
	SDR 13.6	42.60 bar	3 mm	342 s	14 s	17 s	42.60 bar	41 min
	SDR 11	50.60 bar	3.5 mm	414 s	17 s	18 s	50.60 bar	50 min
	SDR 9	59.90 bar	4 mm	502 s	20 s	20 s	59.90 bar	60 min
	SDR 7.4	70.30 bar	4 mm	607 s	22 s	25 s	70.30 bar	70 min
450 mm	SDR 17.6	43.60 bar	3 mm	305 s	13 s	16 s	43.60 bar	37 min
	SDR 17	45.30 bar	3 mm	318 s	14 s	16 s	45.30 bar	38 min
	SDR 13.6	54.00 bar	3.5 mm	385 s	16 s	16 s	54.00 bar	46 min
	SDR 11	64.10 bar	3.5 mm	467 s	18 s	20 s	64.10 bar	56 min
	SDR 9	75.90 bar	4 mm	566 s	21 s	23 s	75.90 bar	66 min
	SDR 7.4	89.00 bar	4 mm	683 s	24 s	29 s	89.00 bar	78 min
500 mm	SDR 17.6	53.10 bar	3 mm	335 s	14 s	17 s	53.10 bar	40 min
	SDR 17	55.20 bar	3 mm	349 s	15 s	18 s	55.20 bar	42 min
	SDR 13.6	65.90 bar	3.5 mm	424 s	17 s	18 s	65.90 bar	51 min
	SDR 11	78.50 bar	4 mm	514 s	20 s	20 s	78.50 bar	61 min
	SDR 9	92.80 bar	4 mm	623 s	23 s	26 s	92.80 bar	72 min
560 mm	SDR 17.6	65.70 bar	3 mm	370 s	16 s	19 s	65.70 bar	45 min
	SDR 17	68.30 bar	3.5 mm	386 s	16 s	16 s	68.30 bar	46 min
	SDR 13.6	81.90 bar	3.5 mm	470 s	19 s	20 s	81.90 bar	56 min
	SDR 11	97.50 bar	4 mm	571 s	21 s	23 s	97.50 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.

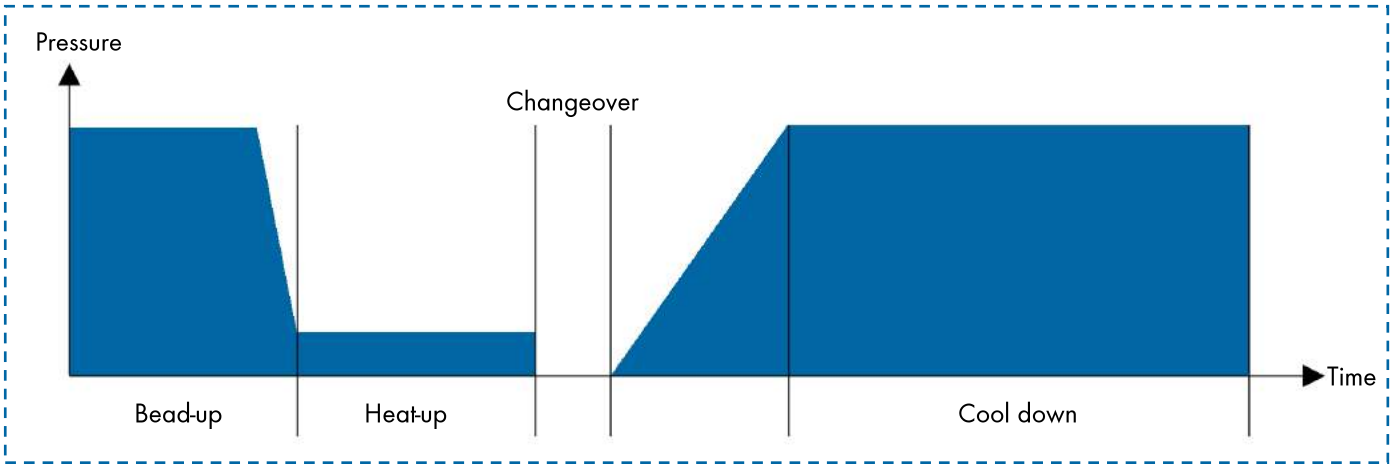
Rothenberger Roweld P 630 B plus

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 = 22.38 cm²
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	14.00 bar	2.5 mm	221 s	10 s	12 s	14.00 bar	27 min
	SDR 17	14.50 bar	2.5 mm	229 s	11 s	12 s	14.50 bar	28 min
	SDR 13.6	17.20 bar	3 mm	277 s	12 s	14 s	17.20 bar	33 min
	SDR 11	20.30 bar	3 mm	333 s	14 s	17 s	20.30 bar	40 min
	SDR 9	21.40 bar	3 mm	353 s	15 s	18 s	21.40 bar	42 min
	SDR 7.4	28.00 bar	3.5 mm	486 s	19 s	21 s	28.00 bar	58 min
355 mm	SDR 17.6	17.40 bar	2.5 mm	244 s	11 s	13 s	17.40 bar	30 min
	SDR 17	18.10 bar	2.5 mm	255 s	11 s	13 s	18.10 bar	31 min
	SDR 13.6	21.50 bar	3 mm	307 s	13 s	16 s	21.50 bar	37 min
	SDR 11	25.50 bar	3.5 mm	371 s	16 s	16 s	25.50 bar	45 min
	SDR 9	30.10 bar	3.5 mm	450 s	18 s	19 s	30.10 bar	54 min
	SDR 7.4	35.20 bar	4 mm	542 s	21 s	22 s	35.20 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 Rothenberger Roweld P 630 B plus

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	21.80 bar	3 mm	271 s	12 s	14 s	21.80 bar	33 min
	SDR 17	22.50 bar	3 mm	282 s	12 s	14 s	22.50 bar	34 min
	SDR 13.6	26.90 bar	3 mm	342 s	14 s	17 s	26.90 bar	41 min
	SDR 11	32.00 bar	3.5 mm	414 s	17 s	18 s	32.00 bar	50 min
	SDR 9	37.80 bar	4 mm	502 s	20 s	20 s	37.80 bar	60 min
	SDR 7.4	44.40 bar	4 mm	607 s	22 s	25 s	44.40 bar	70 min
450 mm	SDR 17.6	27.50 bar	3 mm	305 s	13 s	16 s	27.50 bar	37 min
	SDR 17	28.60 bar	3 mm	318 s	14 s	16 s	28.60 bar	38 min
	SDR 13.6	34.10 bar	3.5 mm	385 s	16 s	16 s	34.10 bar	46 min
	SDR 11	40.50 bar	3.5 mm	467 s	18 s	20 s	40.50 bar	56 min
	SDR 9	47.90 bar	4 mm	566 s	21 s	23 s	47.90 bar	66 min
	SDR 7.4	56.20 bar	4 mm	683 s	24 s	29 s	56.20 bar	78 min
500 mm	SDR 17.6	33.50 bar	3 mm	335 s	14 s	17 s	33.50 bar	40 min
	SDR 17	34.90 bar	3 mm	349 s	15 s	18 s	34.90 bar	42 min
	SDR 13.6	41.60 bar	3.5 mm	424 s	17 s	18 s	41.60 bar	51 min
	SDR 11	49.60 bar	4 mm	514 s	20 s	20 s	49.60 bar	61 min
	SDR 9	58.60 bar	4 mm	623 s	23 s	26 s	58.60 bar	72 min
560 mm	SDR 17.6	41.50 bar	3 mm	370 s	16 s	19 s	41.50 bar	45 min
	SDR 17	43.20 bar	3.5 mm	386 s	16 s	16 s	43.20 bar	46 min
	SDR 13.6	51.70 bar	3.5 mm	470 s	19 s	20 s	51.70 bar	56 min
	SDR 11	61.50 bar	4 mm	571 s	21 s	23 s	61.50 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.