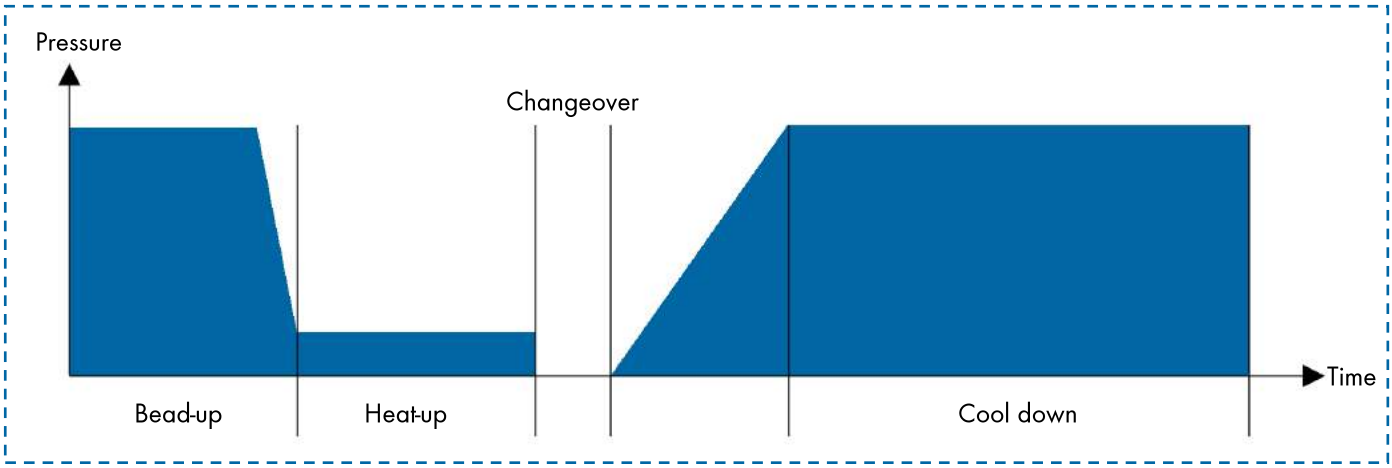
# Hürner HST-160-H

## 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 = 1.95 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 | 3.30 bar | 0.5 mm | 35 s | 5 s | 5 s | 3.30 bar | 6 min |
| | SDR 17 | 3.40 bar | 0.5 mm | 36 s | 5 s | 5 s | 3.40 bar | 6 min |
| | SDR 13.6 | 3.90 bar | 0.5 mm | 43 s | 5 s | 5 s | 3.90 bar | 6 min |
| | SDR 11 | 4.50 bar | 1 mm | 50 s | 5 s | 5 s | 4.50 bar | 6 min |
| | SDR 9 | 5.20 bar | 1 mm | 58 s | 5 s | 5 s | 5.20 bar | 8 min |
| | SDR 7.4 | 5.90 bar | 1 mm | 69 s | 5 s | 5 s | 5.90 bar | 9 min |
| 50 mm | SDR 17.6 | 5.10 bar | 0.5 mm | 43 s | 5 s | 5 s | 5.10 bar | 6 min |
| | SDR 17 | 5.20 bar | 0.5 mm | 44 s | 5 s | 5 s | 5.20 bar | 6 min |
| | SDR 13.6 | 6.00 bar | 1 mm | 52 s | 5 s | 5 s | 6.00 bar | 7 min |
| | SDR 11 | 6.90 bar | 1 mm | 61 s | 5 s | 5 s | 6.90 bar | 8 min |
| | SDR 9 | 7.90 bar | 1.5 mm | 72 s | 6 s | 6 s | 7.90 bar | 10 min |
| | SDR 7.4 | 9.10 bar | 1.5 mm | 85 s | 6 s | 6 s | 9.10 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 Hürner HST-160-H

| 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 | 7.60 bar | 1 mm | 52 s | 5 s | 5 s | 7.60 bar | 7 min |
| | SDR 17 | 7.90 bar | 1 mm | 54 s | 5 s | 5 s | 7.90 bar | 7 min |
| | SDR 13.6 | 9.10 bar | 1 mm | 63 s | 5 s | 5 s | 9.10 bar | 8 min |
| | SDR 11 | 10.60 bar | 1.5 mm | 75 s | 6 s | 6 s | 10.60 bar | 10 min |
| | SDR 9 | 12.20 bar | 1.5 mm | 89 s | 6 s | 6 s | 12.20 bar | 12 min |
| | SDR 7.4 | 14.00 bar | 1.5 mm | 104 s | 7 s | 7 s | 14.00 bar | 14 min |
| 75 mm | SDR 17.6 | 10.30 bar | 1 mm | 59 s | 5 s | 5 s | 10.30 bar | 8 min |
| | SDR 17 | 10.60 bar | 1 mm | 61 s | 5 s | 5 s | 10.60 bar | 8 min |
| | SDR 13.6 | 12.40 bar | 1.5 mm | 73 s | 6 s | 6 s | 12.40 bar | 10 min |
| | SDR 11 | 14.30 bar | 1.5 mm | 85 s | 6 s | 6 s | 14.30 bar | 11 min |
| | SDR 9 | 16.70 bar | 1.5 mm | 102 s | 7 s | 7 s | 16.70 bar | 13 min |
| | SDR 7.4 | 19.40 bar | 2 mm | 122 s | 8 s | 8 s | 19.40 bar | 16 min |
| 90 mm | SDR 17.6 | 14.30 bar | 1 mm | 69 s | 5 s | 5 s | 14.30 bar | 9 min |
| | SDR 17 | 14.90 bar | 1.5 mm | 72 s | 6 s | 6 s | 14.90 bar | 10 min |
| | SDR 13.6 | 17.40 bar | 1.5 mm | 85 s | 6 s | 6 s | 17.40 bar | 11 min |
| | SDR 11 | 20.30 bar | 1.5 mm | 101 s | 7 s | 7 s | 20.30 bar | 13 min |
| | SDR 9 | 23.70 bar | 2 mm | 121 s | 8 s | 8 s | 23.70 bar | 16 min |
| | SDR 7.4 | 27.40 bar | 2 mm | 144 s | 8 s | 9 s | 27.40 bar | 18 min |
| 110 mm | SDR 17.6 | 21.60 bar | 1.5 mm | 85 s | 6 s | 6 s | 21.60 bar | 11 min |
| | SDR 17 | 22.30 bar | 1.5 mm | 88 s | 6 s | 6 s | 22.30 bar | 12 min |
| | SDR 13.6 | 25.90 bar | 1.5 mm | 104 s | 7 s | 7 s | 25.90 bar | 14 min |
| | SDR 11 | 30.20 bar | 2 mm | 123 s | 8 s | 8 s | 30.20 bar | 16 min |
| | SDR 9 | 35.40 bar | 2 mm | 148 s | 8 s | 9 s | 35.40 bar | 19 min |
| | SDR 7.4 | 41.20 bar | 2 mm | 177 s | 9 s | 10 s | 41.20 bar | 22 min |
| 125 mm | SDR 17.6 | 26.90 bar | 1.5 mm | 93 s | 6 s | 6 s | 26.90 bar | 12 min |
| | SDR 17 | 27.70 bar | 1.5 mm | 96 s | 7 s | 7 s | 27.70 bar | 13 min |
| | SDR 13.6 | 32.70 bar | 1.5 mm | 115 s | 7 s | 7 s | 32.70 bar | 15 min |
| | SDR 11 | 38.40 bar | 2 mm | 138 s | 8 s | 8 s | 38.40 bar | 18 min |
| | SDR 9 | 45.00 bar | 2 mm | 166 s | 9 s | 9 s | 45.00 bar | 21 min |
| | SDR 7.4 | 52.30 bar | 2.5 mm | 198 s | 10 s | 11 s | 52.30 bar | 24 min |
| 140 mm | SDR 17.6 | 33.20 bar | 1.5 mm | 103 s | 7 s | 7 s | 33.20 bar | 13 min |
| | SDR 17 | 34.10 bar | 1.5 mm | 106 s | 7 s | 7 s | 34.10 bar | 14 min |
| | SDR 13.6 | 40.20 bar | 2 mm | 127 s | 8 s | 8 s | 40.20 bar | 16 min |
| | SDR 11 | 47.20 bar | 2 mm | 152 s | 8 s | 9 s | 47.20 bar | 19 min |
| | SDR 9 | 55.60 bar | 2 mm | 183 s | 9 s | 10 s | 55.60 bar | 23 min |
| | SDR 7.4 | 64.90 bar | 2.5 mm | 220 s | 10 s | 12 s | 64.90 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.

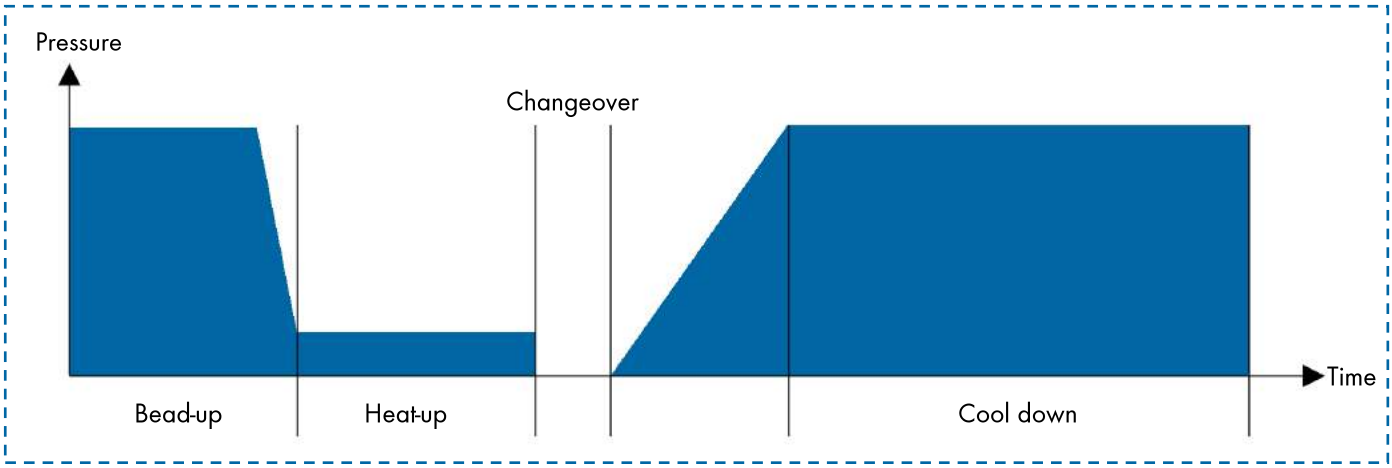
# Hürner HST-160-H1

## 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 = 2.94 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 | 2.2 bar | 0.5 mm | 35 s | 5 s | 5 s | 2.2 bar | 6 min |
| | SDR 17 | 2.2 bar | 0.5 mm | 36 s | 5 s | 5 s | 2.2 bar | 6 min |
| | SDR 13.6 | 2.6 bar | 0.5 mm | 43 s | 5 s | 5 s | 2.6 bar | 6 min |
| | SDR 11 | 2.9 bar | 1 mm | 50 s | 5 s | 5 s | 2.9 bar | 6 min |
| | SDR 9 | 3.4 bar | 1 mm | 58 s | 5 s | 5 s | 3.4 bar | 8 min |
| | SDR 7.4 | 3.9 bar | 1 mm | 69 s | 5 s | 5 s | 3.9 bar | 9 min |
| 50 mm | SDR 17.6 | 3.3 bar | 0.5 mm | 43 s | 5 s | 5 s | 3.3 bar | 6 min |
| | SDR 17 | 3.4 bar | 0.5 mm | 44 s | 5 s | 5 s | 3.4 bar | 6 min |
| | SDR 13.6 | 3.9 bar | 1 mm | 52 s | 5 s | 5 s | 3.9 bar | 7 min |
| | SDR 11 | 4.5 bar | 1 mm | 61 s | 5 s | 5 s | 4.5 bar | 8 min |
| | SDR 9 | 5.2 bar | 1.5 mm | 72 s | 6 s | 6 s | 5.2 bar | 10 min |
| | SDR 7.4 | 5.9 bar | 1.5 mm | 85 s | 6 s | 6 s | 5.9 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 Hürner HST-160-H1

| 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 | 5.0 bar | 1 mm | 52 s | 5 s | 5 s | 5.0 bar | 7 min |
| | SDR 17 | 5.1 bar | 1 mm | 54 s | 5 s | 5 s | 5.1 bar | 7 min |
| | SDR 13.6 | 5.9 bar | 1 mm | 63 s | 5 s | 5 s | 5.9 bar | 8 min |
| | SDR 11 | 6.9 bar | 1.5 mm | 75 s | 6 s | 6 s | 6.9 bar | 10 min |
| | SDR 9 | 8.0 bar | 1.5 mm | 89 s | 6 s | 6 s | 8.0 bar | 12 min |
| | SDR 7.4 | 9.1 bar | 1.5 mm | 104 s | 7 s | 7 s | 9.1 bar | 14 min |
| 75 mm | SDR 17.6 | 6.7 bar | 1 mm | 59 s | 5 s | 5 s | 6.7 bar | 8 min |
| | SDR 17 | 6.9 bar | 1 mm | 61 s | 5 s | 5 s | 6.9 bar | 8 min |
| | SDR 13.6 | 8.1 bar | 1.5 mm | 73 s | 6 s | 6 s | 8.1 bar | 10 min |
| | SDR 11 | 9.3 bar | 1.5 mm | 85 s | 6 s | 6 s | 9.3 bar | 11 min |
| | SDR 9 | 10.9 bar | 1.5 mm | 102 s | 7 s | 7 s | 10.9 bar | 13 min |
| | SDR 7.4 | 12.6 bar | 2 mm | 122 s | 8 s | 8 s | 12.6 bar | 16 min |
| 90 mm | SDR 17.6 | 9.3 bar | 1 mm | 69 s | 5 s | 5 s | 9.3 bar | 9 min |
| | SDR 17 | 9.7 bar | 1.5 mm | 72 s | 6 s | 6 s | 9.7 bar | 10 min |
| | SDR 13.6 | 11.4 bar | 1.5 mm | 85 s | 6 s | 6 s | 11.4 bar | 11 min |
| | SDR 11 | 13.2 bar | 1.5 mm | 101 s | 7 s | 7 s | 13.2 bar | 13 min |
| | SDR 9 | 15.5 bar | 2 mm | 121 s | 8 s | 8 s | 15.5 bar | 16 min |
| | SDR 7.4 | 17.9 bar | 2 mm | 144 s | 8 s | 9 s | 17.9 bar | 18 min |
| 110 mm | SDR 17.6 | 14.1 bar | 1.5 mm | 85 s | 6 s | 6 s | 14.1 bar | 11 min |
| | SDR 17 | 14.5 bar | 1.5 mm | 88 s | 6 s | 6 s | 14.5 bar | 12 min |
| | SDR 13.6 | 16.9 bar | 1.5 mm | 104 s | 7 s | 7 s | 16.9 bar | 14 min |
| | SDR 11 | 19.7 bar | 2 mm | 123 s | 8 s | 8 s | 19.7 bar | 16 min |
| | SDR 9 | 23.0 bar | 2 mm | 148 s | 8 s | 9 s | 23.0 bar | 19 min |
| | SDR 7.4 | 26.8 bar | 2 mm | 177 s | 9 s | 10 s | 26.8 bar | 22 min |
| 125 mm | SDR 17.6 | 17.5 bar | 1.5 mm | 93 s | 6 s | 6 s | 17.5 bar | 12 min |
| | SDR 17 | 18.1 bar | 1.5 mm | 96 s | 7 s | 7 s | 18.1 bar | 13 min |
| | SDR 13.6 | 21.3 bar | 1.5 mm | 115 s | 7 s | 7 s | 21.3 bar | 15 min |
| | SDR 11 | 25.0 bar | 2 mm | 138 s | 8 s | 8 s | 25.0 bar | 18 min |
| | SDR 9 | 29.3 bar | 2 mm | 166 s | 9 s | 9 s | 29.3 bar | 21 min |
| | SDR 7.4 | 34.0 bar | 2.5 mm | 198 s | 10 s | 11 s | 34.0 bar | 24 min |
| 140 mm | SDR 17.6 | 21.6 bar | 1.5 mm | 103 s | 7 s | 7 s | 21.6 bar | 13 min |
| | SDR 17 | 22.2 bar | 1.5 mm | 106 s | 7 s | 7 s | 22.2 bar | 14 min |
| | SDR 13.6 | 26.2 bar | 2 mm | 127 s | 8 s | 8 s | 26.2 bar | 16 min |
| | SDR 11 | 30.7 bar | 2 mm | 152 s | 8 s | 9 s | 30.7 bar | 19 min |
| | SDR 9 | 36.2 bar | 2 mm | 183 s | 9 s | 10 s | 36.2 bar | 23 min |
| | SDR 7.4 | 42.2 bar | 2.5 mm | 220 s | 10 s | 12 s | 42.2 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.

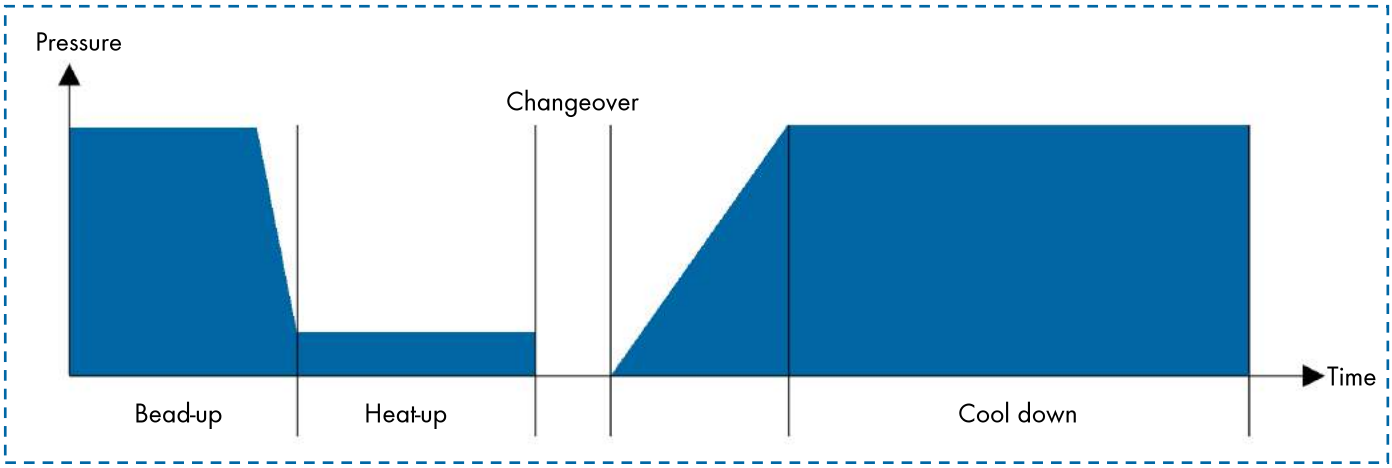
# Hürner HST-200-H

## 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 = 3.16 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 |
| 63 mm | SDR 17.6 | 4.70 bar | 1 mm | 52 s | 5 s | 5 s | 4.70 bar | 7 min |
| | SDR 17 | 4.90 bar | 1 mm | 54 s | 5 s | 5 s | 4.90 bar | 7 min |
| | SDR 13.6 | 5.70 bar | 1 mm | 63 s | 5 s | 5 s | 5.70 bar | 8 min |
| | SDR 11 | 6.60 bar | 1.5 mm | 75 s | 6 s | 6 s | 6.60 bar | 10 min |
| | SDR 9 | 7.60 bar | 1.5 mm | 89 s | 6 s | 6 s | 7.60 bar | 12 min |
| | SDR 7.4 | 8.70 bar | 1.5 mm | 104 s | 7 s | 7 s | 8.70 bar | 14 min |
| 75 mm | SDR 17.6 | 6.40 bar | 1 mm | 59 s | 5 s | 5 s | 6.40 bar | 8 min |
| | SDR 17 | 6.60 bar | 1 mm | 61 s | 5 s | 5 s | 6.60 bar | 8 min |
| | SDR 13.6 | 7.70 bar | 1.5 mm | 73 s | 6 s | 6 s | 7.70 bar | 10 min |
| | SDR 11 | 8.90 bar | 1.5 mm | 85 s | 6 s | 6 s | 8.90 bar | 11 min |
| | SDR 9 | 10.40 bar | 1.5 mm | 102 s | 7 s | 7 s | 10.40 bar | 13 min |
| | SDR 7.4 | 12.00 bar | 2 mm | 122 s | 8 s | 8 s | 12.00 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.

Continuation Hürner HST-200-H

| 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 | 8.90 bar | 1 mm | 69 s | 5 s | 5 s | 8.90 bar | 9 min |
| | SDR 17 | 9.20 bar | 1.5 mm | 72 s | 6 s | 6 s | 9.20 bar | 10 min |
| | SDR 13.6 | 10.80 bar | 1.5 mm | 85 s | 6 s | 6 s | 10.80 bar | 11 min |
| | SDR 11 | 12.60 bar | 1.5 mm | 101 s | 7 s | 7 s | 12.60 bar | 13 min |
| | SDR 9 | 14.70 bar | 2 mm | 121 s | 8 s | 8 s | 14.70 bar | 16 min |
| | SDR 7.4 | 17.00 bar | 2 mm | 144 s | 8 s | 9 s | 17.00 bar | 18 min |
| 110 mm | SDR 17.6 | 13.40 bar | 1.5 mm | 85 s | 6 s | 6 s | 13.40 bar | 11 min |
| | SDR 17 | 13.80 bar | 1.5 mm | 88 s | 6 s | 6 s | 13.80 bar | 12 min |
| | SDR 13.6 | 16.10 bar | 1.5 mm | 104 s | 7 s | 7 s | 16.10 bar | 14 min |
| | SDR 11 | 18.70 bar | 2 mm | 123 s | 8 s | 8 s | 18.70 bar | 16 min |
| | SDR 9 | 21.90 bar | 2 mm | 148 s | 8 s | 9 s | 21.90 bar | 19 min |
| | SDR 7.4 | 25.50 bar | 2 mm | 177 s | 9 s | 10 s | 25.50 bar | 22 min |
| 125 mm | SDR 17.6 | 16.70 bar | 1.5 mm | 93 s | 6 s | 6 s | 16.70 bar | 12 min |
| | SDR 17 | 17.20 bar | 1.5 mm | 96 s | 7 s | 7 s | 17.20 bar | 13 min |
| | SDR 13.6 | 20.20 bar | 1.5 mm | 115 s | 7 s | 7 s | 20.20 bar | 15 min |
| | SDR 11 | 23.80 bar | 2 mm | 138 s | 8 s | 8 s | 23.80 bar | 18 min |
| | SDR 9 | 27.90 bar | 2 mm | 166 s | 9 s | 9 s | 27.90 bar | 21 min |
| | SDR 7.4 | 32.40 bar | 2.5 mm | 198 s | 10 s | 11 s | 32.40 bar | 24 min |
| 140 mm | SDR 17.6 | 20.60 bar | 1.5 mm | 103 s | 7 s | 7 s | 20.60 bar | 13 min |
| | SDR 17 | 21.10 bar | 1.5 mm | 106 s | 7 s | 7 s | 21.10 bar | 14 min |
| | SDR 13.6 | 24.90 bar | 2 mm | 127 s | 8 s | 8 s | 24.90 bar | 16 min |
| | SDR 11 | 29.20 bar | 2 mm | 152 s | 8 s | 9 s | 29.20 bar | 19 min |
| | SDR 9 | 34.40 bar | 2 mm | 183 s | 9 s | 10 s | 34.40 bar | 23 min |
| | SDR 7.4 | 40.20 bar | 2.5 mm | 220 s | 10 s | 12 s | 40.20 bar | 27 min |
| 160 mm | SDR 17.6 | 27.30 bar | 1.5 mm | 119 s | 7 s | 7 s | 27.30 bar | 15 min |
| | SDR 17 | 28.10 bar | 2 mm | 123 s | 8 s | 8 s | 28.10 bar | 16 min |
| | SDR 13.6 | 33.10 bar | 2 mm | 147 s | 8 s | 9 s | 33.10 bar | 19 min |
| | SDR 11 | 39.00 bar | 2 mm | 177 s | 9 s | 10 s | 39.00 bar | 22 min |
| | SDR 9 | 45.50 bar | 2.5 mm | 211 s | 10 s | 11 s | 45.50 bar | 26 min |
| | SDR 7.4 | 52.90 bar | 2.5 mm | 253 s | 11 s | 13 s | 52.90 bar | 31 min |
| 180 mm | SDR 17.6 | 35.40 bar | 2 mm | 137 s | 8 s | 8 s | 35.40 bar | 17 min |
| | SDR 17 | 36.60 bar | 2 mm | 142 s | 8 s | 8 s | 36.60 bar | 18 min |
| | SDR 13.6 | 43.00 bar | 2 mm | 170 s | 9 s | 10 s | 43.00 bar | 21 min |
| | SDR 11 | 50.30 bar | 2.5 mm | 202 s | 10 s | 11 s | 50.30 bar | 25 min |
| | SDR 9 | 58.50 bar | 2.5 mm | 241 s | 11 s | 13 s | 58.50 bar | 29 min |
| | SDR 7.4 | 67.90 bar | 3 mm | 288 s | 13 s | 15 s | 67.90 bar | 35 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.

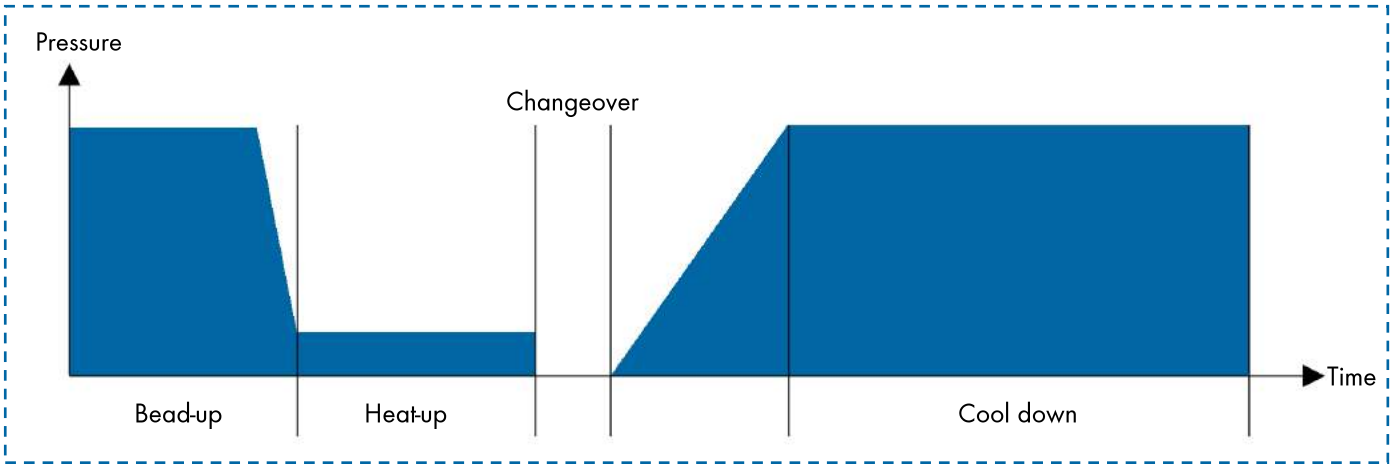
# Hürner HST-250-H

## 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 = 5.10 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 |
| 75 mm | SDR 17.6 | 4.00 bar | 1 mm | 59 s | 5 s | 5 s | 4.00 bar | 8 min |
| | SDR 17 | 4.10 bar | 1 mm | 61 s | 5 s | 5 s | 4.10 bar | 8 min |
| | SDR 13.6 | 4.80 bar | 1.5 mm | 73 s | 6 s | 6 s | 4.80 bar | 10 min |
| | SDR 11 | 5.50 bar | 1.5 mm | 85 s | 6 s | 6 s | 5.50 bar | 11 min |
| | SDR 9 | 6.40 bar | 1.5 mm | 102 s | 7 s | 7 s | 6.40 bar | 13 min |
| | SDR 7.4 | 7.50 bar | 2 mm | 122 s | 8 s | 8 s | 7.50 bar | 16 min |
| 90 mm | SDR 17.6 | 5.50 bar | 1 mm | 69 s | 5 s | 5 s | 5.50 bar | 9 min |
| | SDR 17 | 5.70 bar | 1.5 mm | 72 s | 6 s | 6 s | 5.70 bar | 10 min |
| | SDR 13.6 | 6.70 bar | 1.5 mm | 85 s | 6 s | 6 s | 6.70 bar | 11 min |
| | SDR 11 | 7.80 bar | 1.5 mm | 101 s | 7 s | 7 s | 7.80 bar | 13 min |
| | SDR 9 | 9.10 bar | 2 mm | 121 s | 8 s | 8 s | 9.10 bar | 16 min |
| | SDR 7.4 | 10.50 bar | 2 mm | 144 s | 8 s | 9 s | 10.50 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 Hürner HST-250-H

| 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 | 8.30 bar | 1.5 mm | 85 s | 6 s | 6 s | 8.30 bar | 11 min |
| | SDR 17 | 8.50 bar | 1.5 mm | 88 s | 6 s | 6 s | 8.50 bar | 12 min |
| | SDR 13.6 | 9.90 bar | 1.5 mm | 104 s | 7 s | 7 s | 9.90 bar | 14 min |
| | SDR 11 | 11.60 bar | 2 mm | 123 s | 8 s | 8 s | 11.60 bar | 16 min |
| | SDR 9 | 13.60 bar | 2 mm | 148 s | 8 s | 9 s | 13.60 bar | 19 min |
| | SDR 7.4 | 15.80 bar | 2 mm | 177 s | 9 s | 10 s | 15.80 bar | 22 min |
| 125 mm | SDR 17.6 | 10.30 bar | 1.5 mm | 93 s | 6 s | 6 s | 10.30 bar | 12 min |
| | SDR 17 | 10.60 bar | 1.5 mm | 96 s | 7 s | 7 s | 10.60 bar | 13 min |
| | SDR 13.6 | 12.50 bar | 1.5 mm | 115 s | 7 s | 7 s | 12.50 bar | 15 min |
| | SDR 11 | 14.70 bar | 2 mm | 138 s | 8 s | 8 s | 14.70 bar | 18 min |
| | SDR 9 | 17.20 bar | 2 mm | 166 s | 9 s | 9 s | 17.20 bar | 21 min |
| | SDR 7.4 | 20.00 bar | 2.5 mm | 198 s | 10 s | 11 s | 20.00 bar | 24 min |
| 140 mm | SDR 17.6 | 12.70 bar | 1.5 mm | 103 s | 7 s | 7 s | 12.70 bar | 13 min |
| | SDR 17 | 13.10 bar | 1.5 mm | 106 s | 7 s | 7 s | 13.10 bar | 14 min |
| | SDR 13.6 | 15.40 bar | 2 mm | 127 s | 8 s | 8 s | 15.40 bar | 16 min |
| | SDR 11 | 18.10 bar | 2 mm | 152 s | 8 s | 9 s | 18.10 bar | 19 min |
| | SDR 9 | 21.30 bar | 2 mm | 183 s | 9 s | 10 s | 21.30 bar | 23 min |
| | SDR 7.4 | 24.80 bar | 2.5 mm | 220 s | 10 s | 12 s | 24.80 bar | 27 min |
| 160 mm | SDR 17.6 | 16.90 bar | 1.5 mm | 119 s | 7 s | 7 s | 16.90 bar | 15 min |
| | SDR 17 | 17.40 bar | 2 mm | 123 s | 8 s | 8 s | 17.40 bar | 16 min |
| | SDR 13.6 | 20.50 bar | 2 mm | 147 s | 8 s | 9 s | 20.50 bar | 19 min |
| | SDR 11 | 24.10 bar | 2 mm | 177 s | 9 s | 10 s | 24.10 bar | 22 min |
| | SDR 9 | 28.10 bar | 2.5 mm | 211 s | 10 s | 11 s | 28.10 bar | 26 min |
| | SDR 7.4 | 32.70 bar | 2.5 mm | 253 s | 11 s | 13 s | 32.70 bar | 31 min |
| 180 mm | SDR 17.6 | 21.90 bar | 2 mm | 137 s | 8 s | 8 s | 21.90 bar | 17 min |
| | SDR 17 | 22.60 bar | 2 mm | 142 s | 8 s | 8 s | 22.60 bar | 18 min |
| | SDR 13.6 | 26.60 bar | 2 mm | 170 s | 9 s | 10 s | 26.60 bar | 21 min |
| | SDR 11 | 31.10 bar | 2.5 mm | 202 s | 10 s | 11 s | 31.10 bar | 25 min |
| | SDR 9 | 36.20 bar | 2.5 mm | 241 s | 11 s | 13 s | 36.20 bar | 29 min |
| | SDR 7.4 | 42.00 bar | 3 mm | 288 s | 13 s | 15 s | 42.00 bar | 35 min |
| 200 mm | SDR 17.6 | 26.50 bar | 2 mm | 150 s | 8 s | 9 s | 26.50 bar | 19 min |
| | SDR 17 | 27.30 bar | 2 mm | 155 s | 8 s | 9 s | 27.30 bar | 19 min |
| | SDR 13.6 | 32.00 bar | 2 mm | 184 s | 9 s | 10 s | 32.00 bar | 23 min |
| | SDR 11 | 37.70 bar | 2.5 mm | 221 s | 10 s | 12 s | 37.70 bar | 27 min |
| | SDR 9 | 44.10 bar | 3 mm | 265 s | 12 s | 14 s | 44.10 bar | 32 min |
| | SDR 7.4 | 51.30 bar | 3 mm | 318 s | 14 s | 16 s | 51.30 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.

ContinuatiorHürner HST-250-H

| 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 | 32.60 bar | 2 mm | 164 s | 9 s | 9 s | 32.60 bar | 21 min |
| | SDR 17 | 33.80 bar | 2 mm | 171 s | 9 s | 10 s | 33.80 bar | 21 min |
| | SDR 13.6 | 39.80 bar | 2.5 mm | 204 s | 10 s | 11 s | 39.80 bar | 25 min |
| | SDR 11 | 46.90 bar | 2.5 mm | 245 s | 11 s | 13 s | 46.90 bar | 30 min |
| | SDR 9 | 55.00 bar | 3 mm | 295 s | 13 s | 15 s | 55.00 bar | 36 min |
| | SDR 7.4 | 64.00 bar | 3 mm | 353 s | 15 s | 18 s | 64.00 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.

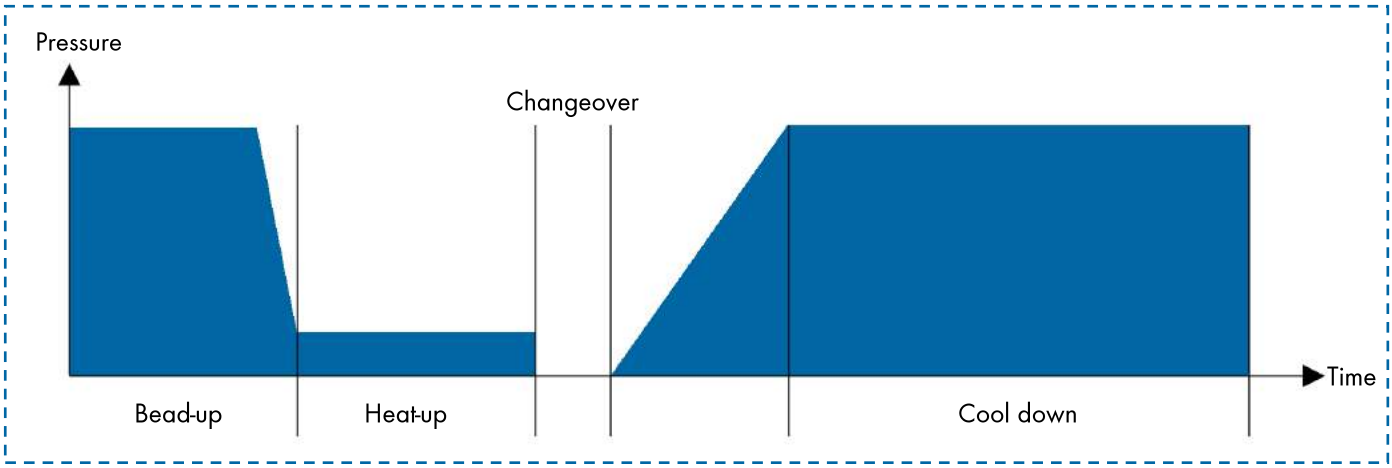
# Hürner HST-315-H

## 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 = 5.89 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 | 4.80 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 | 6.80 bar | 1.5 mm | 101 s | 7 s | 7 s | 6.80 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 | 13.70 bar | 2 mm | 177 s | 9 s | 10 s | 13.70 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 Hürner HST-315-H

| 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 | 8.90 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 | 10.90 bar | 1.5 mm | 115 s | 7 s | 7 s | 10.90 bar | 15 min |
| | SDR 11 | 12.80 bar | 2 mm | 138 s | 8 s | 8 s | 12.80 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 | 15.70 bar | 2 mm | 152 s | 8 s | 9 s | 15.70 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 | 20.90 bar | 2 mm | 177 s | 9 s | 10 s | 20.90 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 | 19.00 bar | 2 mm | 137 s | 8 s | 8 s | 19.00 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 | 36.40 bar | 3 mm | 288 s | 13 s | 15 s | 36.40 bar | 35 min |
| 200 mm | SDR 17.6 | 22.90 bar | 2 mm | 150 s | 8 s | 9 s | 22.90 bar | 19 min |
| | SDR 17 | 23.70 bar | 2 mm | 155 s | 8 s | 9 s | 23.70 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 | 38.20 bar | 3 mm | 265 s | 12 s | 14 s | 38.20 bar | 32 min |
| | SDR 7.4 | 44.40 bar | 3 mm | 318 s | 14 s | 16 s | 44.40 bar | 38 min |
| 225 mm | SDR 17.6 | 28.30 bar | 2 mm | 164 s | 9 s | 9 s | 28.30 bar | 21 min |
| | SDR 17 | 29.30 bar | 2 mm | 171 s | 9 s | 10 s | 29.30 bar | 21 min |
| | SDR 13.6 | 34.50 bar | 2.5 mm | 204 s | 10 s | 11 s | 34.50 bar | 25 min |
| | SDR 11 | 40.60 bar | 2.5 mm | 245 s | 11 s | 13 s | 40.60 bar | 30 min |
| | SDR 9 | 47.70 bar | 3 mm | 295 s | 13 s | 15 s | 47.70 bar | 36 min |
| | SDR 7.4 | 55.50 bar | 3 mm | 353 s | 15 s | 18 s | 55.50 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 Hürner HST-315-H

| OD core pipe | SDR core pipe* | Bead-up time | | Heat-up time | Changeover time (max) | Joining presure build-up time | Cool-down time | |
|---|---|---|---|---|---|---|---|---|
| [mm] | | P | Bead size | t | t | t | P | t |
| 250 mm | SDR 17.6 | 34.20 bar | 2 mm | 179 s | 9 s | 10 s | 34.20 bar | 22 min |
| | SDR 17 | 35.30 bar | 2 mm | 185 s | 9 s | 10 s | 35.30 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 | 49.30 bar | 3 mm | 268 s | 12 s | 14 s | 49.30 bar | 32 min |
| | SDR 9 | 57.90 bar | 3 mm | 323 s | 14 s | 16 s | 57.90 bar | 39 min |
| | SDR 7.4 | 67.80 bar | 3.5 mm | 389 s | 16 s | 16 s | 67.80 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 | 43.50 bar | 2.5 mm | 204 s | 10 s | 11 s | 43.50 bar | 25 min |
| | SDR 13.6 | 51.60 bar | 2.5 mm | 246 s | 11 s | 13 s | 51.60 bar | 30 min |
| | SDR 11 | 61.00 bar | 3 mm | 297 s | 13 s | 15 s | 61.00 bar | 36 min |
| | SDR 9 | 72.00 bar | 3 mm | 359 s | 15 s | 18 s | 72.00 bar | 43 min |
| | SDR 7.4 | 84.20 bar | 3.5 mm | 432 s | 17 s | 18 s | 84.20 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.


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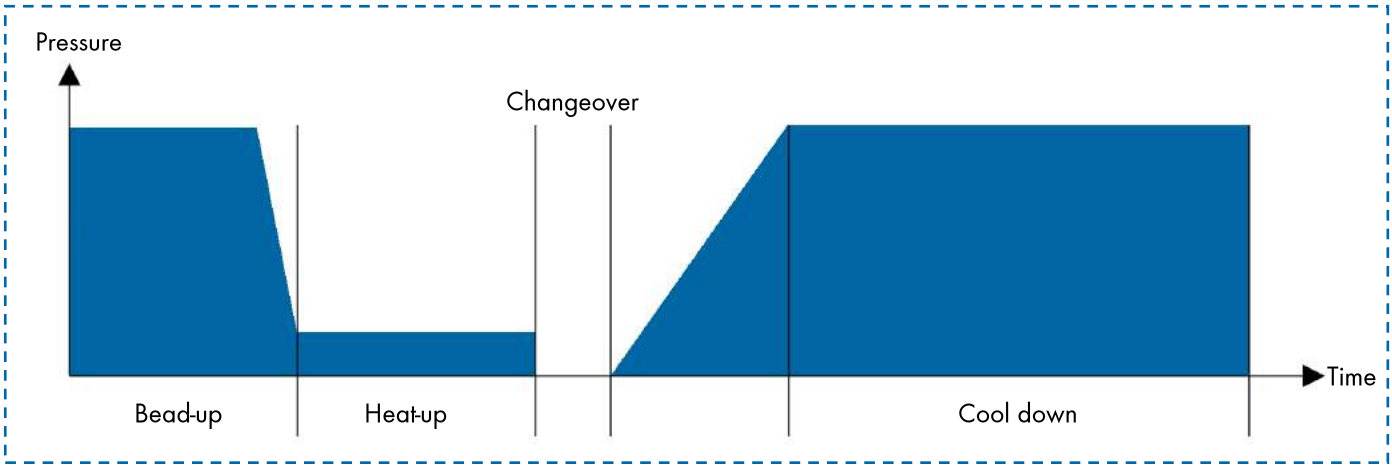
# Hürner HST-355-H

## 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 = 6.60 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 | 4.30 bar | 1 mm | 69 s | 5 s | 5 s | 4.30 bar | 9 min |
| | SDR 17 | 4.40 bar | 1.5 mm | 72 s | 6 s | 6 s | 4.40 bar | 10 min |
| | SDR 13.6 | 5.20 bar | 1.5 mm | 85 s | 6 s | 6 s | 5.20 bar | 11 min |
| | SDR 11 | 6.00 bar | 1.5 mm | 101 s | 7 s | 7 s | 6.00 bar | 13 min |
| | SDR 9 | 7.00 bar | 2 mm | 121 s | 8 s | 8 s | 7.00 bar | 16 min |
| | SDR 7.4 | 8.10 bar | 2 mm | 144 s | 8 s | 9 s | 8.10 bar | 18 min |
| 110 mm | SDR 17.6 | 6.40 bar | 1.5 mm | 85 s | 6 s | 6 s | 6.40 bar | 11 min |
| | SDR 17 | 6.60 bar | 1.5 mm | 88 s | 6 s | 6 s | 6.60 bar | 12 min |
| | SDR 13.6 | 7.70 bar | 1.5 mm | 104 s | 7 s | 7 s | 7.70 bar | 14 min |
| | SDR 11 | 9.00 bar | 2 mm | 123 s | 8 s | 8 s | 9.00 bar | 16 min |
| | SDR 9 | 10.50 bar | 2 mm | 148 s | 8 s | 9 s | 10.50 bar | 19 min |
| | SDR 7.4 | 12.20 bar | 2 mm | 177 s | 9 s | 10 s | 12.20 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 Hürner HST-355-H

| 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 | 8.00 bar | 1.5 mm | 93 s | 6 s | 6 s | 8.00 bar | 12 min |
| | SDR 17 | 8.20 bar | 1.5 mm | 96 s | 7 s | 7 s | 8.20 bar | 13 min |
| | SDR 13.6 | 9.70 bar | 1.5 mm | 115 s | 7 s | 7 s | 9.70 bar | 15 min |
| | SDR 11 | 11.40 bar | 2 mm | 138 s | 8 s | 8 s | 11.40 bar | 18 min |
| | SDR 9 | 13.30 bar | 2 mm | 166 s | 9 s | 9 s | 13.30 bar | 21 min |
| | SDR 7.4 | 15.50 bar | 2.5 mm | 198 s | 10 s | 11 s | 15.50 bar | 24 min |
| 140 mm | SDR 17.6 | 9.80 bar | 1.5 mm | 103 s | 7 s | 7 s | 9.80 bar | 13 min |
| | SDR 17 | 10.10 bar | 1.5 mm | 106 s | 7 s | 7 s | 10.10 bar | 14 min |
| | SDR 13.6 | 11.90 bar | 2 mm | 127 s | 8 s | 8 s | 11.90 bar | 16 min |
| | SDR 11 | 14.00 bar | 2 mm | 152 s | 8 s | 9 s | 14.00 bar | 19 min |
| | SDR 9 | 16.50 bar | 2 mm | 183 s | 9 s | 10 s | 16.50 bar | 23 min |
| | SDR 7.4 | 19.20 bar | 2.5 mm | 220 s | 10 s | 12 s | 19.20 bar | 27 min |
| 160 mm | SDR 17.6 | 13.10 bar | 1.5 mm | 119 s | 7 s | 7 s | 13.10 bar | 15 min |
| | SDR 17 | 13.50 bar | 2 mm | 123 s | 8 s | 8 s | 13.50 bar | 16 min |
| | SDR 13.6 | 15.80 bar | 2 mm | 147 s | 8 s | 9 s | 15.80 bar | 19 min |
| | SDR 11 | 18.60 bar | 2 mm | 177 s | 9 s | 10 s | 18.60 bar | 22 min |
| | SDR 9 | 21.70 bar | 2.5 mm | 211 s | 10 s | 11 s | 21.70 bar | 26 min |
| | SDR 7.4 | 25.30 bar | 2.5 mm | 253 s | 11 s | 13 s | 25.30 bar | 31 min |
| 180 mm | SDR 17.6 | 16.90 bar | 2 mm | 137 s | 8 s | 8 s | 16.90 bar | 17 min |
| | SDR 17 | 17.50 bar | 2 mm | 142 s | 8 s | 8 s | 17.50 bar | 18 min |
| | SDR 13.6 | 20.60 bar | 2 mm | 170 s | 9 s | 10 s | 20.60 bar | 21 min |
| | SDR 11 | 24.00 bar | 2.5 mm | 202 s | 10 s | 11 s | 24.00 bar | 25 min |
| | SDR 9 | 28.00 bar | 2.5 mm | 241 s | 11 s | 13 s | 28.00 bar | 29 min |
| | SDR 7.4 | 32.40 bar | 3 mm | 288 s | 13 s | 15 s | 32.40 bar | 35 min |
| 200 mm | SDR 17.6 | 20.50 bar | 2 mm | 150 s | 8 s | 9 s | 20.50 bar | 19 min |
| | SDR 17 | 21.10 bar | 2 mm | 155 s | 8 s | 9 s | 21.10 bar | 19 min |
| | SDR 13.6 | 24.70 bar | 2 mm | 184 s | 9 s | 10 s | 24.70 bar | 23 min |
| | SDR 11 | 29.10 bar | 2.5 mm | 221 s | 10 s | 12 s | 29.10 bar | 27 min |
| | SDR 9 | 34.10 bar | 3 mm | 265 s | 12 s | 14 s | 34.10 bar | 32 min |
| | SDR 7.4 | 39.60 bar | 3 mm | 318 s | 14 s | 16 s | 39.60 bar | 38 min |
| 225 mm | SDR 17.6 | 25.20 bar | 2 mm | 164 s | 9 s | 9 s | 25.20 bar | 21 min |
| | SDR 17 | 26.20 bar | 2 mm | 171 s | 9 s | 10 s | 26.20 bar | 21 min |
| | SDR 13.6 | 30.80 bar | 2.5 mm | 204 s | 10 s | 11 s | 30.80 bar | 25 min |
| | SDR 11 | 36.30 bar | 2.5 mm | 245 s | 11 s | 13 s | 36.30 bar | 30 min |
| | SDR 9 | 42.50 bar | 3 mm | 295 s | 13 s | 15 s | 42.50 bar | 36 min |
| | SDR 7.4 | 49.50 bar | 3 mm | 353 s | 15 s | 18 s | 49.50 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 Hürner HST-355-H

| 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 | 30.60 bar | 2 mm | 179 s | 9 s | 10 s | 30.60 bar | 22 min |
| | SDR 17 | 31.50 bar | 2 mm | 185 s | 9 s | 10 s | 31.50 bar | 23 min |
| | SDR 13.6 | 37.30 bar | 2.5 mm | 223 s | 10 s | 12 s | 37.30 bar | 27 min |
| | SDR 11 | 44.00 bar | 3 mm | 268 s | 12 s | 14 s | 44.00 bar | 32 min |
| | SDR 9 | 51.70 bar | 3 mm | 323 s | 14 s | 16 s | 51.70 bar | 39 min |
| | SDR 7.4 | 60.50 bar | 3.5 mm | 389 s | 16 s | 16 s | 60.50 bar | 47 min |
| 280 mm | SDR 17.6 | 37.50 bar | 2.5 mm | 197 s | 10 s | 11 s | 37.50 bar | 24 min |
| | SDR 17 | 38.80 bar | 2.5 mm | 204 s | 10 s | 11 s | 38.80 bar | 25 min |
| | SDR 13.6 | 46.10 bar | 2.5 mm | 246 s | 11 s | 13 s | 46.10 bar | 30 min |
| | SDR 11 | 54.50 bar | 3 mm | 297 s | 13 s | 15 s | 54.50 bar | 36 min |
| | SDR 9 | 64.20 bar | 3 mm | 359 s | 15 s | 18 s | 64.20 bar | 43 min |
| | SDR 7.4 | 75.10 bar | 3.5 mm | 432 s | 17 s | 18 s | 75.10 bar | 52 min |
| 315 mm | SDR 17.6 | 47.30 bar | 2.5 mm | 221 s | 10 s | 12 s | 47.30 bar | 27 min |
| | SDR 17 | 49.00 bar | 2.5 mm | 229 s | 11 s | 12 s | 49.00 bar | 28 min |
| | SDR 13.6 | 58.20 bar | 3 mm | 277 s | 12 s | 14 s | 58.20 bar | 33 min |
| | SDR 11 | 68.80 bar | 3 mm | 333 s | 14 s | 17 s | 68.80 bar | 40 min |
| | SDR 9 | 72.30 bar | 3 mm | 353 s | 15 s | 18 s | 72.30 bar | 42 min |
| | SDR 7.4 | 95.00 bar | 3.5 mm | 486 s | 19 s | 21 s | 95.00 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.

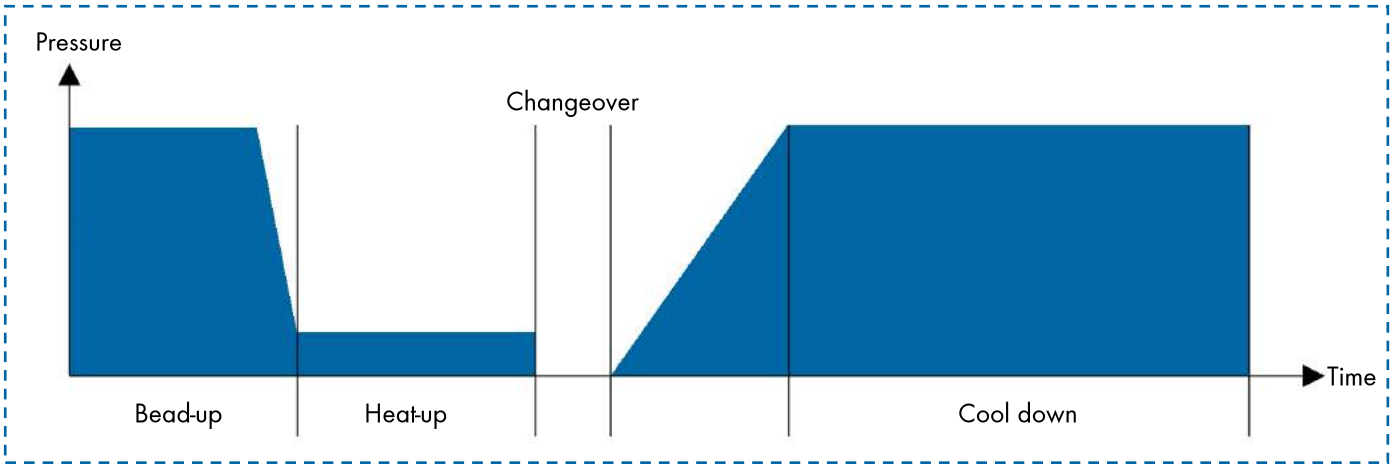
# Hürner HST-500-O

## 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 = 22.37 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 | 6.10 bar | 2 mm | 150 s | 8 s | 9 s | 6.10 bar | 19 min |
| | SDR 17 | 6.30 bar | 2 mm | 155 s | 8 s | 9 s | 6.30 bar | 19 min |
| | SDR 13.6 | 7.30 bar | 2 mm | 184 s | 9 s | 10 s | 7.30 bar | 23 min |
| | SDR 11 | 8.60 bar | 2.5 mm | 221 s | 10 s | 12 s | 8.60 bar | 27 min |
| | SDR 9 | 10.10 bar | 3 mm | 265 s | 12 s | 14 s | 10.10 bar | 32 min |
| | SDR 7.4 | 11.70 bar | 3 mm | 318 s | 14 s | 16 s | 11.70 bar | 38 min |
| 225 mm | SDR 17.6 | 7.50 bar | 2 mm | 164 s | 9 s | 9 s | 7.50 bar | 21 min |
| | SDR 17 | 7.80 bar | 2 mm | 171 s | 9 s | 10 s | 7.80 bar | 21 min |
| | SDR 13.6 | 9.10 bar | 2.5 mm | 204 s | 10 s | 11 s | 9.10 bar | 25 min |
| | SDR 11 | 10.70 bar | 2.5 mm | 245 s | 11 s | 13 s | 10.70 bar | 30 min |
| | SDR 9 | 12.60 bar | 3 mm | 295 s | 13 s | 15 s | 12.60 bar | 36 min |
| | SDR 7.4 | 14.60 bar | 3 mm | 353 s | 15 s | 18 s | 14.60 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 Hürner HST-500-O

| 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 | 9.00 bar | 2 mm | 179 s | 9 s | 10 s | 9.00 bar | 22 min |
| | SDR 17 | 9.30 bar | 2 mm | 185 s | 9 s | 10 s | 9.30 bar | 23 min |
| | SDR 13.6 | 11.10 bar | 2.5 mm | 223 s | 10 s | 12 s | 11.10 bar | 27 min |
| | SDR 11 | 13.00 bar | 3 mm | 268 s | 12 s | 14 s | 13.00 bar | 32 min |
| | SDR 9 | 15.30 bar | 3 mm | 323 s | 14 s | 16 s | 15.30 bar | 39 min |
| | SDR 7.4 | 17.90 bar | 3.5 mm | 389 s | 16 s | 16 s | 17.90 bar | 47 min |
| 280 mm | SDR 17.6 | 11.10 bar | 2.5 mm | 197 s | 10 s | 11 s | 11.10 bar | 24 min |
| | SDR 17 | 11.50 bar | 2.5 mm | 204 s | 10 s | 11 s | 11.50 bar | 25 min |
| | SDR 13.6 | 13.60 bar | 2.5 mm | 246 s | 11 s | 13 s | 13.60 bar | 30 min |
| | SDR 11 | 16.10 bar | 3 mm | 297 s | 13 s | 15 s | 16.10 bar | 36 min |
| | SDR 9 | 19.00 bar | 3 mm | 359 s | 15 s | 18 s | 19.00 bar | 43 min |
| | SDR 7.4 | 22.20 bar | 3.5 mm | 432 s | 17 s | 18 s | 22.20 bar | 52 min |
| 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 | 28.10 bar | 3.5 mm | 486 s | 19 s | 21 s | 28.10 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 | 35.30 bar | 4 mm | 542 s | 21 s | 22 s | 35.30 bar | 64 min |
| 400 mm | SDR 17.6 | 21.80 bar | 3 mm | 271 s | 12 s | 14 s | 21.80 bar | 33 min |
| | SDR 17 | 22.60 bar | 3 mm | 282 s | 12 s | 14 s | 22.60 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 | 27.60 bar | 3 mm | 305 s | 13 s | 16 s | 27.60 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 | 48.00 bar | 4 mm | 566 s | 21 s | 23 s | 48.00 bar | 66 min |
| | SDR 7.4 | 56.20 bar | 4 mm | 683 s | 24 s | 29 s | 56.20 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.

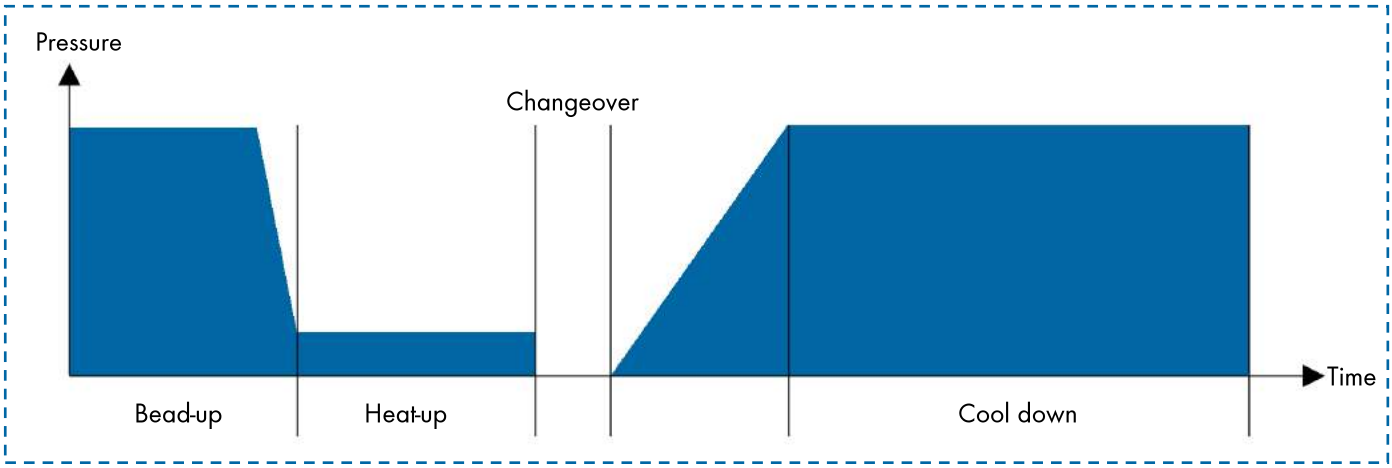
# Hürner HST-630-O1

## 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 = 31.40 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 | 9.8 bar | 2.5 mm | 221 s | 10 s | 12 s | 9.8 bar | 27 min |
| | SDR 17 | 10.1 bar | 2.5 mm | 229 s | 11 s | 12 s | 10.1 bar | 28 min |
| | SDR 13.6 | 12.0 bar | 3 mm | 277 s | 12 s | 14 s | 12.0 bar | 33 min |
| | SDR 11 | 14.2 bar | 3 mm | 333 s | 14 s | 17 s | 14.2 bar | 40 min |
| | SDR 9 | 16.8 bar | 3.5 mm | 403 s | 17 s | 17 s | 16.8 bar | 48 min |
| | SDR 7.4 | 19.6 bar | 3.5 mm | 486 s | 19 s | 21 s | 19.6 bar | 58 min |
| 355 mm | SDR 17.6 | 12.2 bar | 2.5 mm | 244 s | 11 s | 13 s | 12.2 bar | 30 min |
| | SDR 17 | 12.7 bar | 2.5 mm | 255 s | 11 s | 13 s | 12.7 bar | 31 min |
| | SDR 13.6 | 15.0 bar | 3 mm | 307 s | 13 s | 16 s | 15.0 bar | 37 min |
| | SDR 11 | 17.8 bar | 3.5 mm | 371 s | 16 s | 16 s | 17.8 bar | 45 min |
| | SDR 9 | 21.1 bar | 3.5 mm | 450 s | 18 s | 19 s | 21.1 bar | 54 min |
| | SDR 7.4 | 24.7 bar | 4 mm | 542 s | 21 s | 22 s | 24.7 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 Hürner HST-630-O1

| 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 | 15.2 bar | 3 mm | 271 s | 12 s | 14 s | 15.2 bar | 33 min |
| | SDR 17 | 15.8 bar | 3 mm | 282 s | 12 s | 14 s | 15.8 bar | 34 min |
| | SDR 13.6 | 18.8 bar | 3 mm | 342 s | 14 s | 17 s | 18.8 bar | 41 min |
| | SDR 11 | 22.4 bar | 3.5 mm | 414 s | 17 s | 18 s | 22.4 bar | 50 min |
| | SDR 9 | 26.5 bar | 4 mm | 502 s | 20 s | 20 s | 26.5 bar | 60 min |
| | SDR 7.4 | 31.1 bar | 4 mm | 607 s | 22 s | 25 s | 31.1 bar | 70 min |
| 450 mm | SDR 17.6 | 19.3 bar | 3 mm | 305 s | 13 s | 16 s | 19.3 bar | 37 min |
| | SDR 17 | 20.0 bar | 3 mm | 318 s | 14 s | 16 s | 20.0 bar | 38 min |
| | SDR 13.6 | 23.9 bar | 3.5 mm | 385 s | 16 s | 16 s | 23.9 bar | 46 min |
| | SDR 11 | 28.3 bar | 3.5 mm | 467 s | 18 s | 20 s | 28.3 bar | 56 min |
| | SDR 9 | 33.5 bar | 4 mm | 566 s | 21 s | 23 s | 33.5 bar | 66 min |
| | SDR 7.4 | 39.3 bar | 4 mm | 683 s | 24 s | 29 s | 39.3 bar | 78 min |
| 500 mm | SDR 17.6 | 23.5 bar | 3 mm | 335 s | 14 s | 17 s | 23.5 bar | 40 min |
| | SDR 17 | 24.4 bar | 3 mm | 349 s | 15 s | 18 s | 24.4 bar | 42 min |
| | SDR 13.6 | 29.1 bar | 3.5 mm | 424 s | 17 s | 18 s | 29.1 bar | 51 min |
| | SDR 11 | 34.7 bar | 4 mm | 514 s | 20 s | 20 s | 34.7 bar | 61 min |
| | SDR 9 | 41.0 bar | 4 mm | 623 s | 23 s | 26 s | 41.0 bar | 72 min |
| 560 mm | SDR 17.6 | 29.0 bar | 3 mm | 370 s | 16 s | 19 s | 29.0 bar | 45 min |
| | SDR 17 | 30.2 bar | 3.5 mm | 386 s | 16 s | 16 s | 30.2 bar | 46 min |
| | SDR 13.6 | 36.2 bar | 3.5 mm | 470 s | 19 s | 20 s | 36.2 bar | 56 min |
| | SDR 11 | 43.0 bar | 4 mm | 571 s | 21 s | 23 s | 43.0 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.

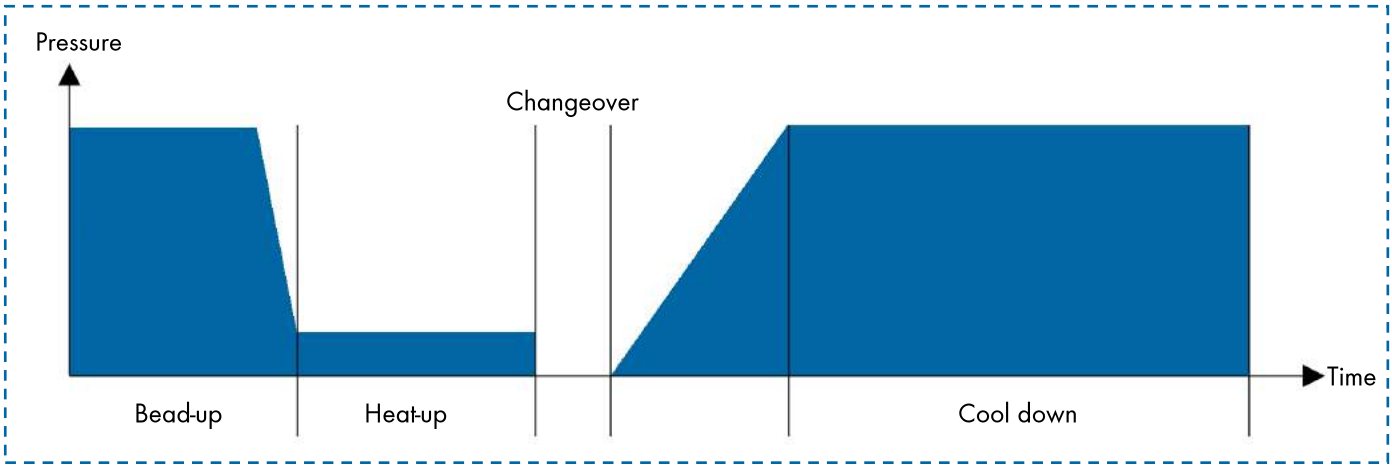
# Hürner HST-800-O1

## 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 = 36.50 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 |
| 500 mm | SDR 17.6 | 20.2 bar | 3 mm | 335 s | 14 s | 17 s | 20.2 bar | 40 min |
| | SDR 17 | 21.0 bar | 3 mm | 349 s | 15 s | 18 s | 21.0 bar | 42 min |
| | SDR 13.6 | 25.1 bar | 3.5 mm | 424 s | 17 s | 18 s | 25.1 bar | 51 min |
| | SDR 11 | 29.8 bar | 4 mm | 514 s | 20 s | 20 s | 29.8 bar | 61 min |
| | SDR 9 | 35.3 bar | 4 mm | 623 s | 23 s | 26 s | 35.3 bar | 72 min |
| 560 mm | SDR 17.6 | 25.0 bar | 3 mm | 370 s | 16 s | 19 s | 25.0 bar | 45 min |
| | SDR 17 | 26.0 bar | 3.5 mm | 386 s | 16 s | 16 s | 26.0 bar | 46 min |
| | SDR 13.6 | 31.1 bar | 3.5 mm | 470 s | 19 s | 20 s | 31.1 bar | 56 min |
| | SDR 11 | 37.0 bar | 4 mm | 571 s | 21 s | 23 s | 37.0 bar | 67 min |
| 630 mm | SDR 17.6 | 31.3 bar | 3.5 mm | 412 s | 17 s | 17 s | 31.3 bar | 49 min |
| | SDR 17 | 32.5 bar | 3.5 mm | 430 s | 17 s | 18 s | 32.5 bar | 51 min |
| | SDR 13.6 | 39.0 bar | 4 mm | 524 s | 20 s | 21 s | 39.0 bar | 62 min |
| | SDR 11 | 46.5 bar | 4 mm | 638 s | 23 s | 26 s | 46.5 bar | 73 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.

Information, sources and background details regarding our sustainability management can be found on our website at www.egeplast.de/en/sustainability

egeplast

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