egeplast

SLM® 3.0

Welding parameters for butt fusion jointing
WITHOUT cutting back the coating

egeplast

Content

As of: March 2025

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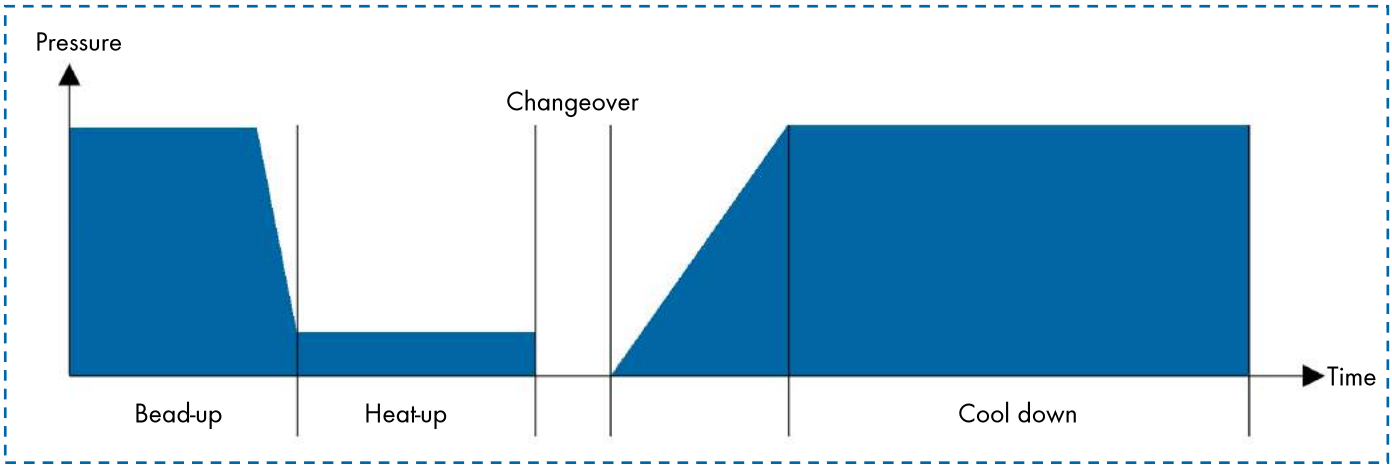
Hürner HST-160-H

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.

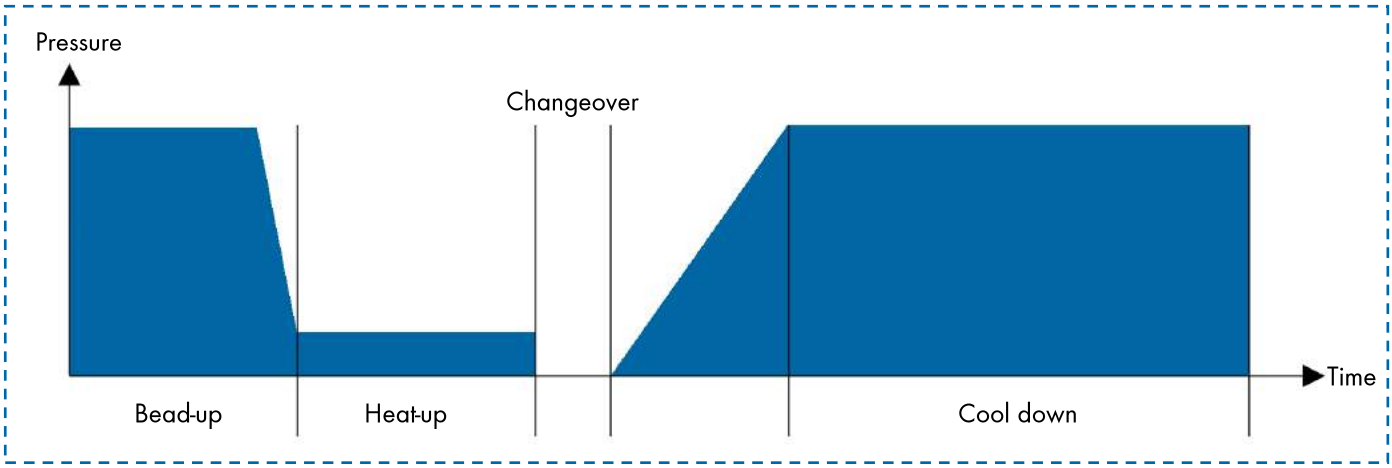
Hürner HST-160-H1

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.

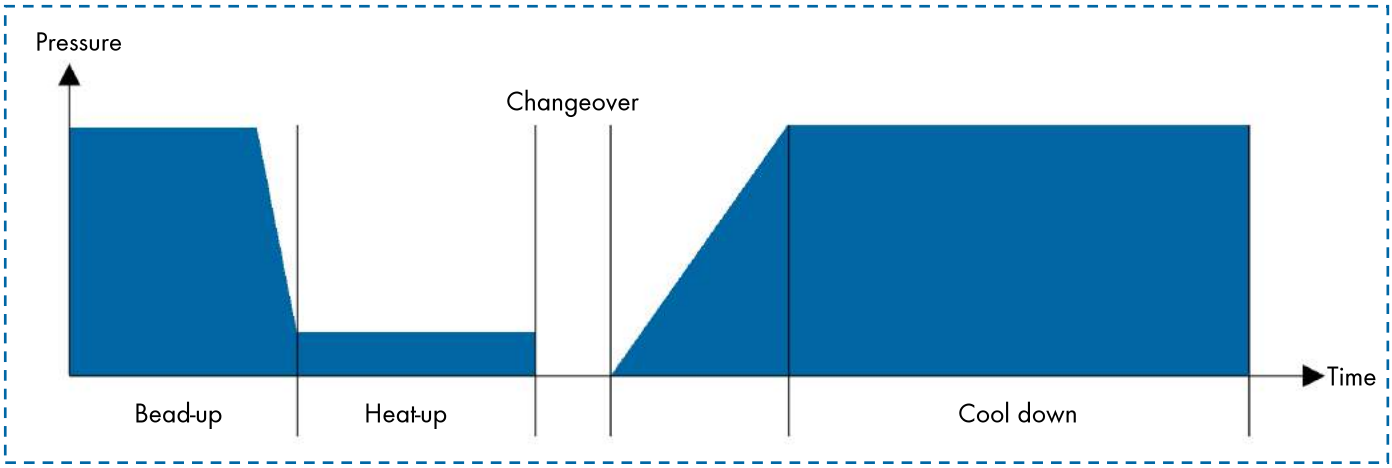
Hürner HST-200-H

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.

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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.

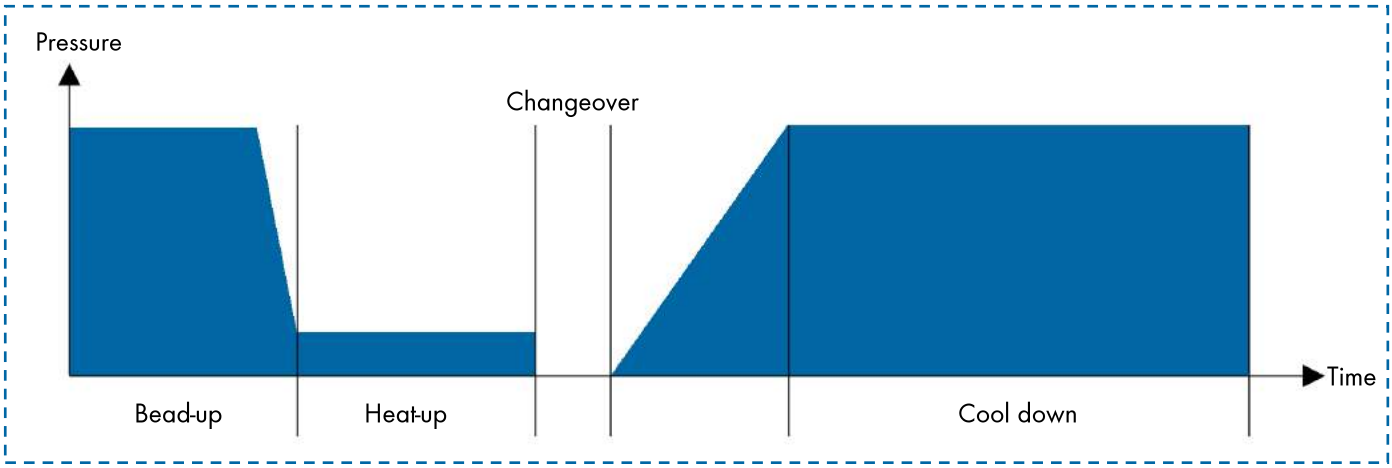
Hürner HST-250-H

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.

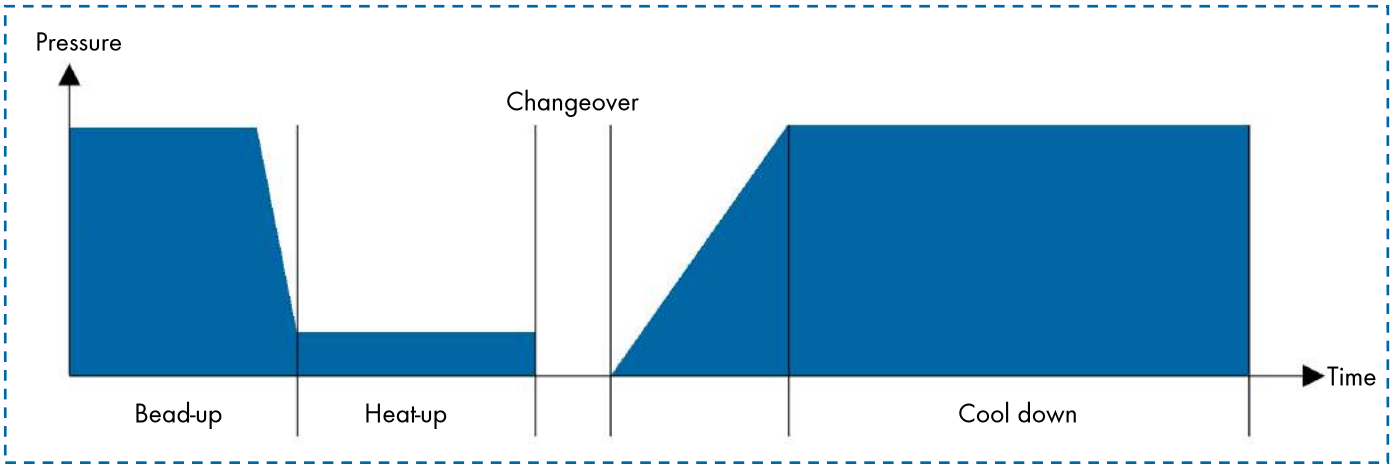
Hürner HST-315-H

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.

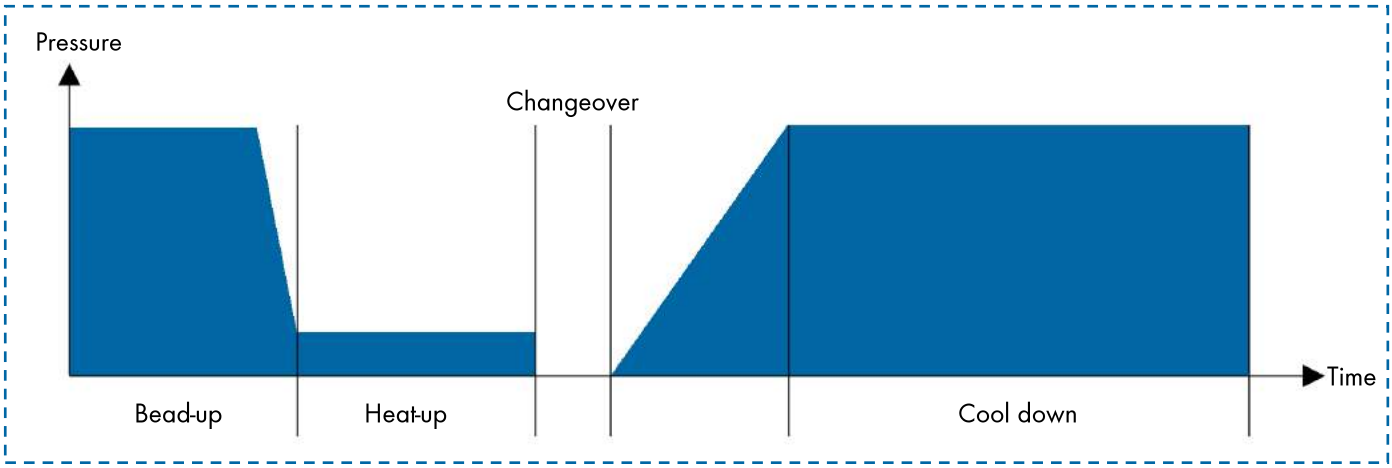
Hürner HST-355-H

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.

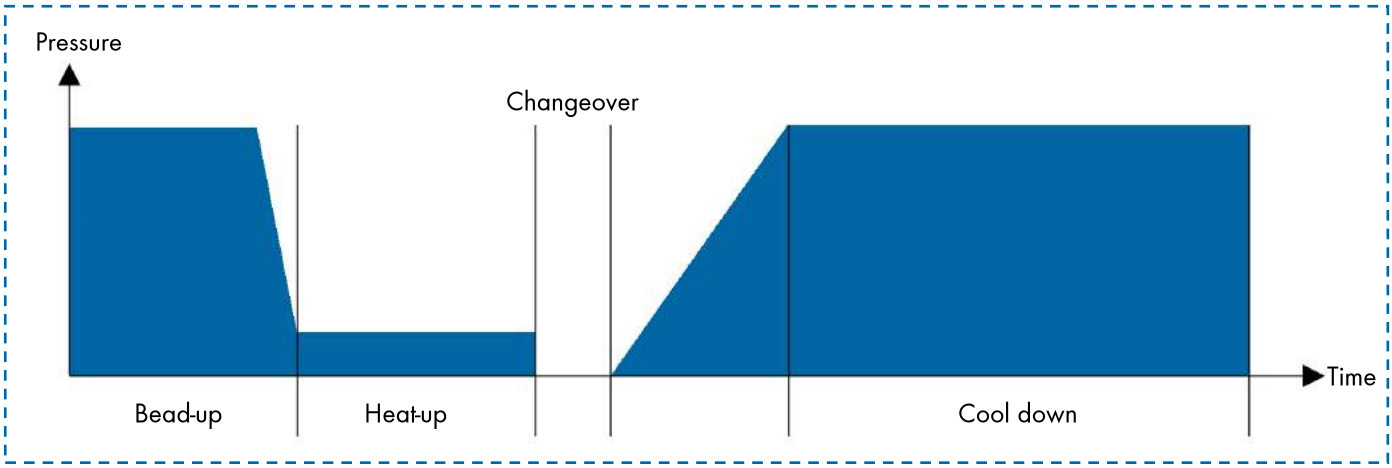
Hürner HST-500-O

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.

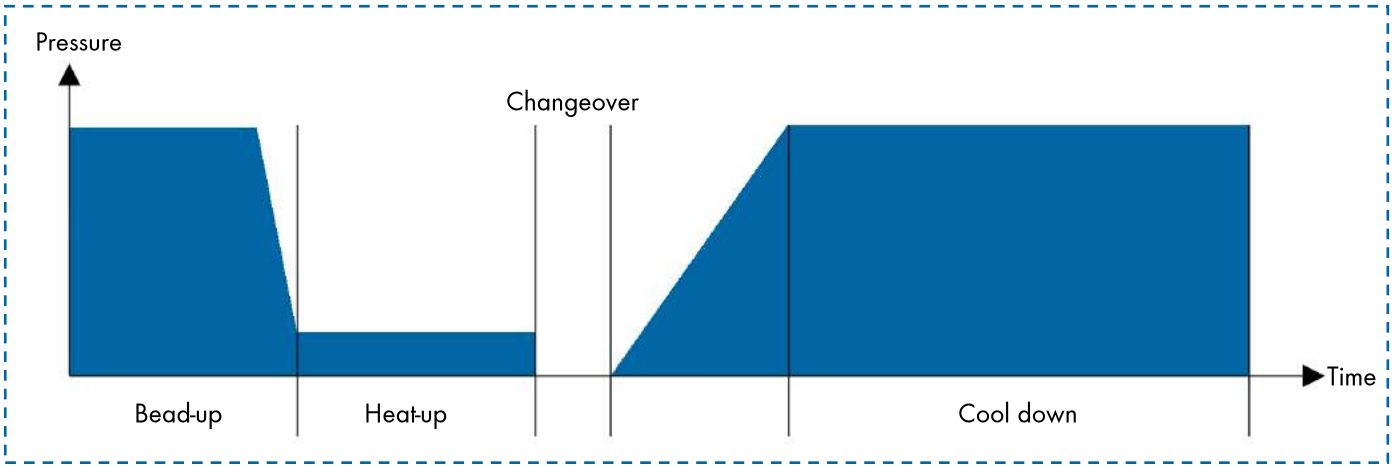
Hürner HST-630-O1

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.

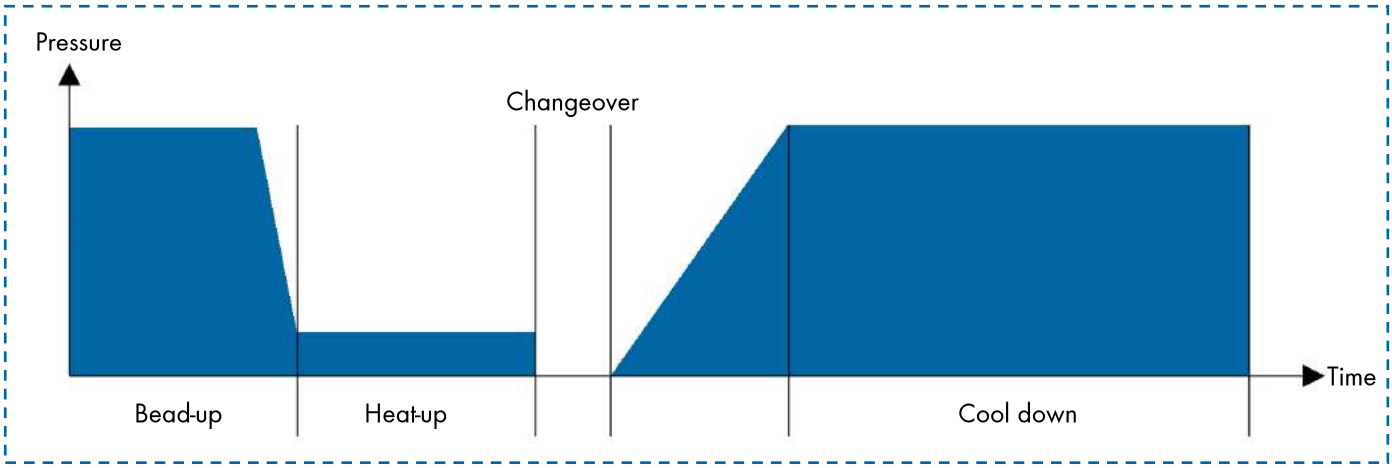
Hürner HST-800-O1

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.

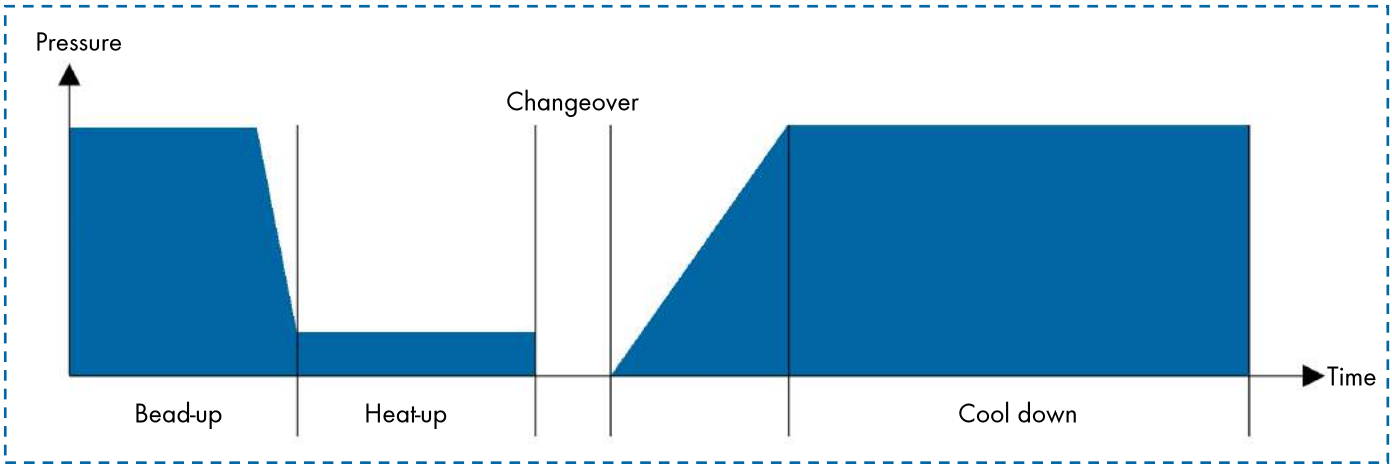
Widos 4400

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.

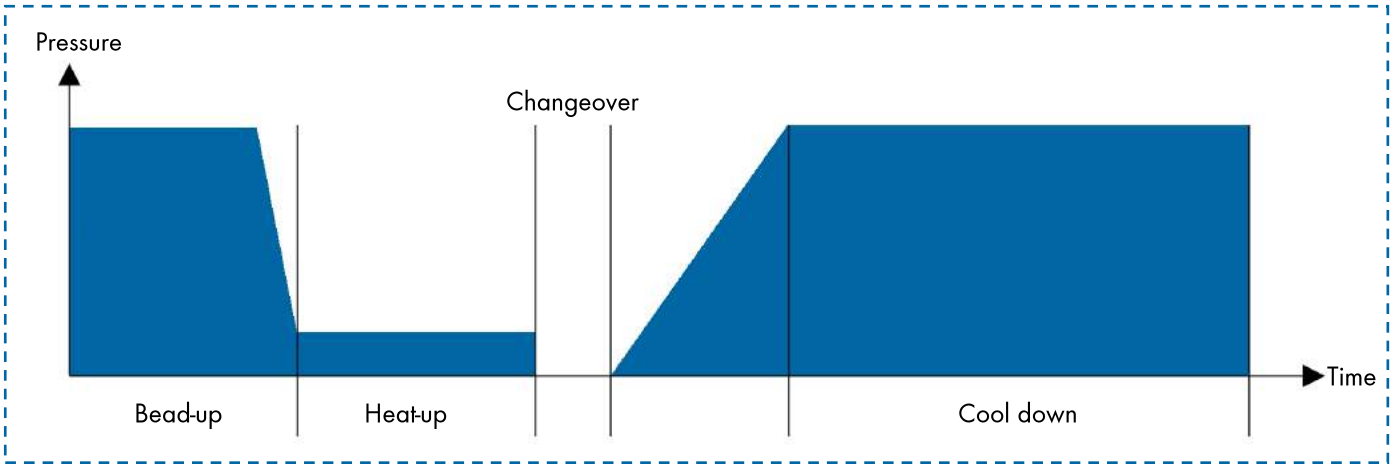
Widos 4600 — 4800

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.

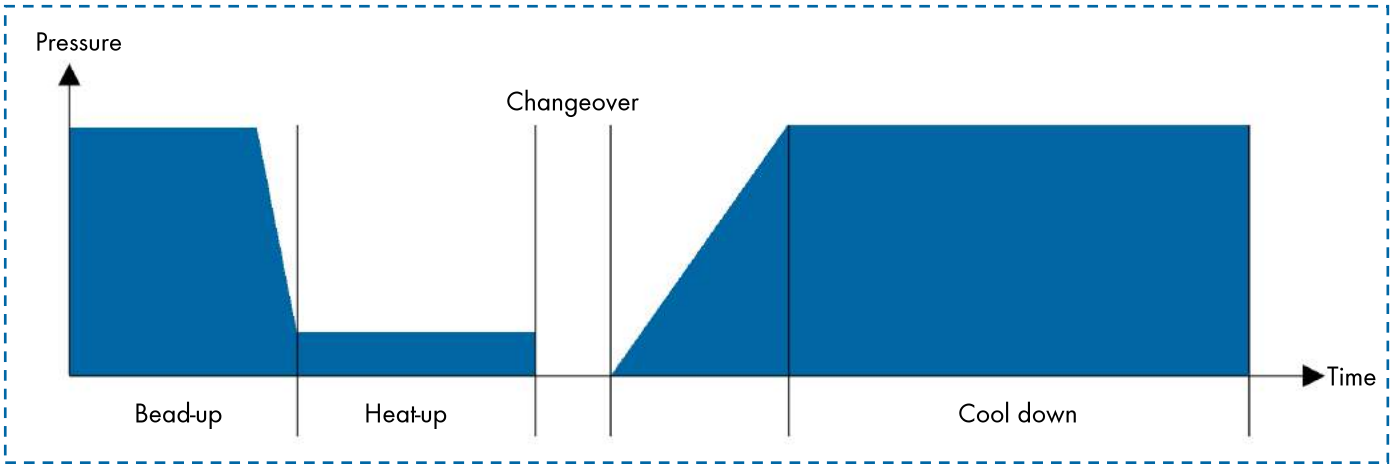
Widos 4900

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.

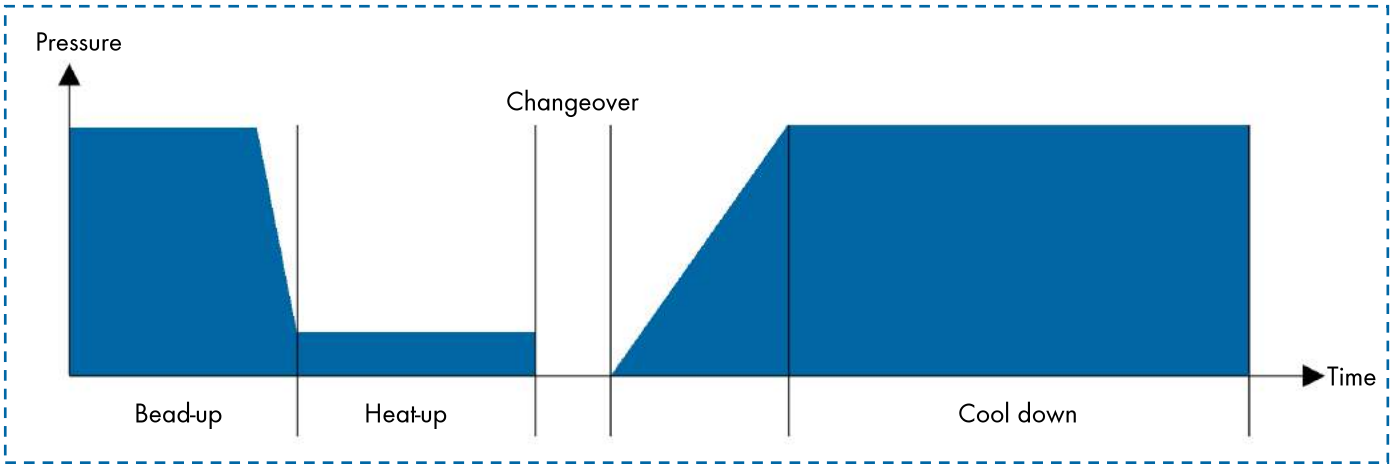
Widos 5100 — 5500

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.

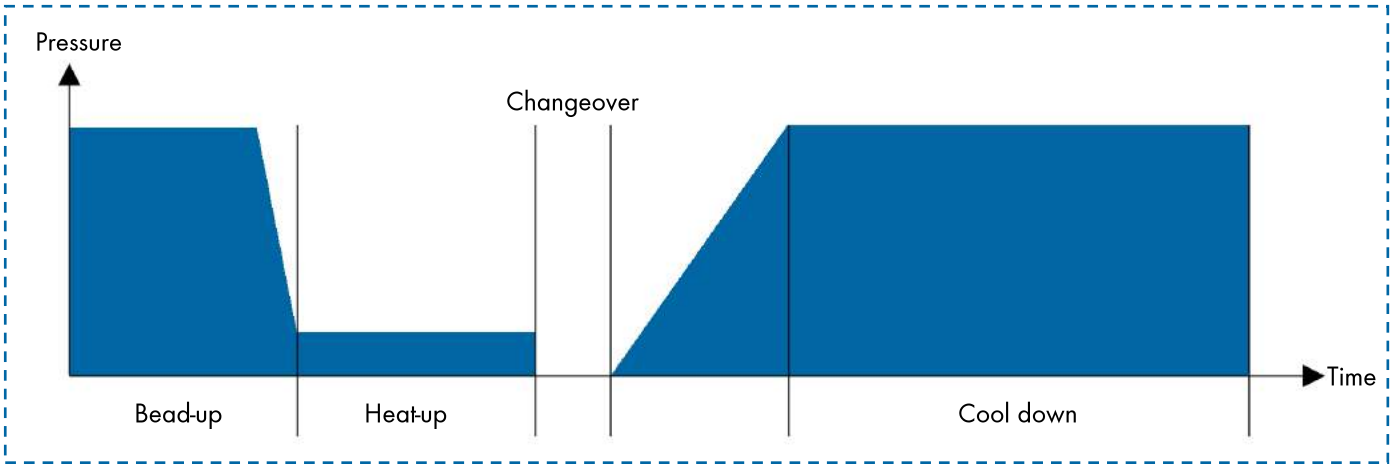
Widos 6100

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.

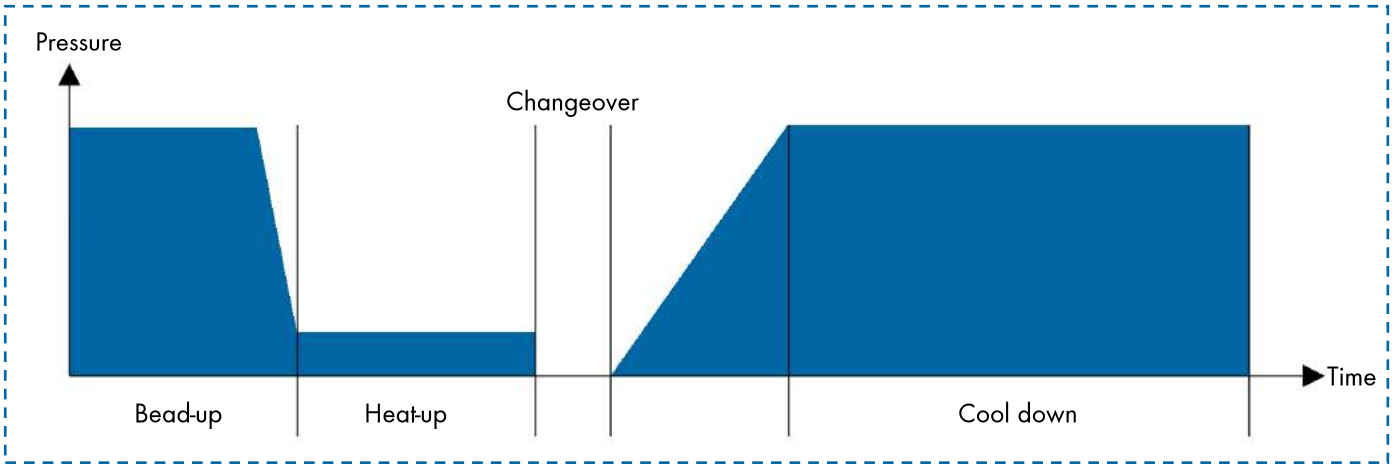
Widos 6100 Steel (since 6/2009)

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.

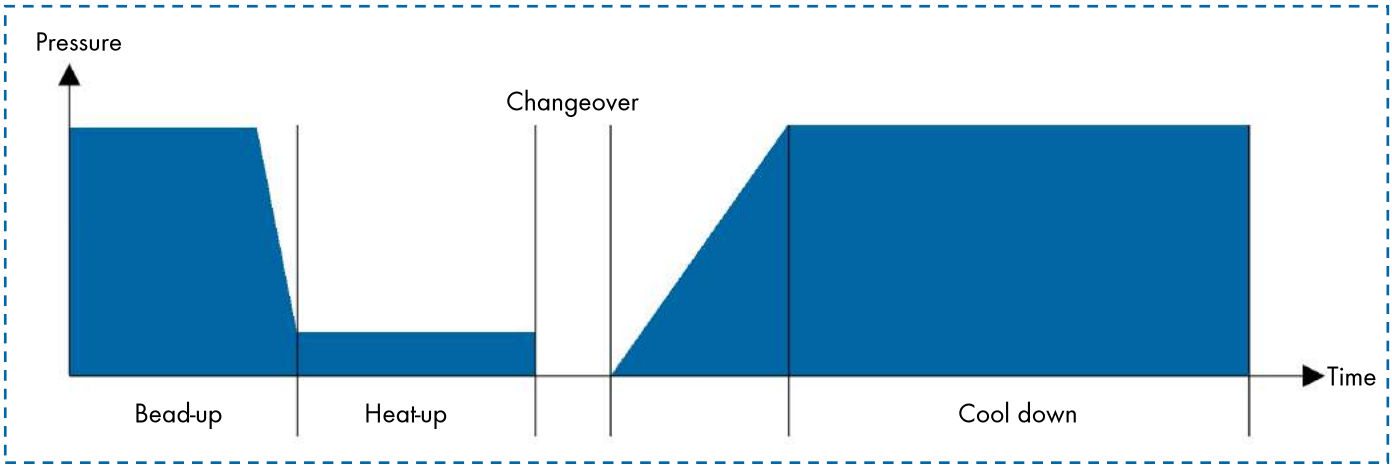
Widos 8000 (7/2000 to 5/2009) – 10000 (since 7/2000)

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.

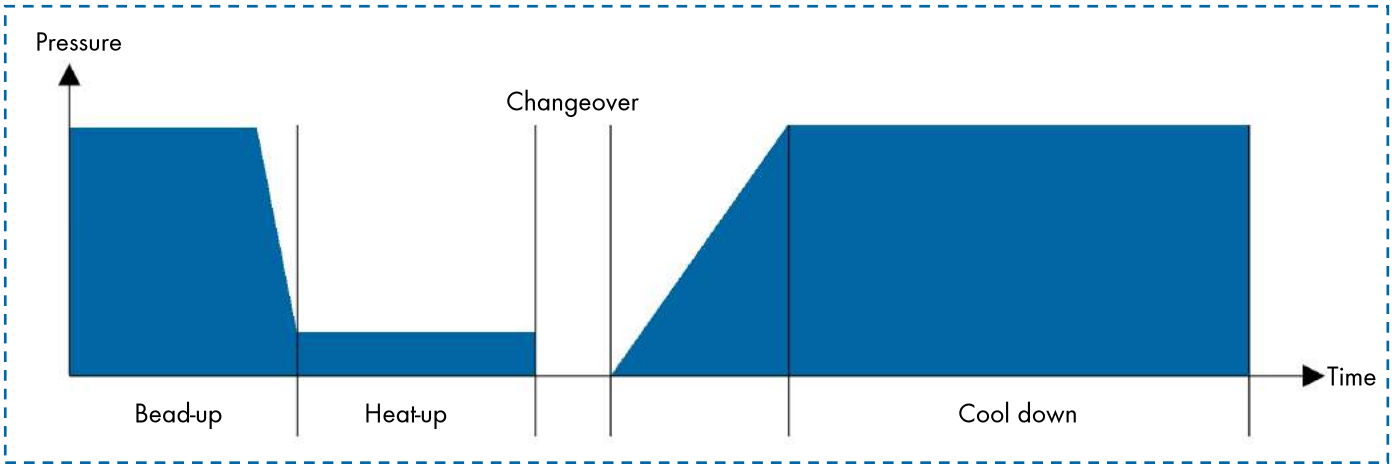
Widos 8000 (since 6/2009)

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.

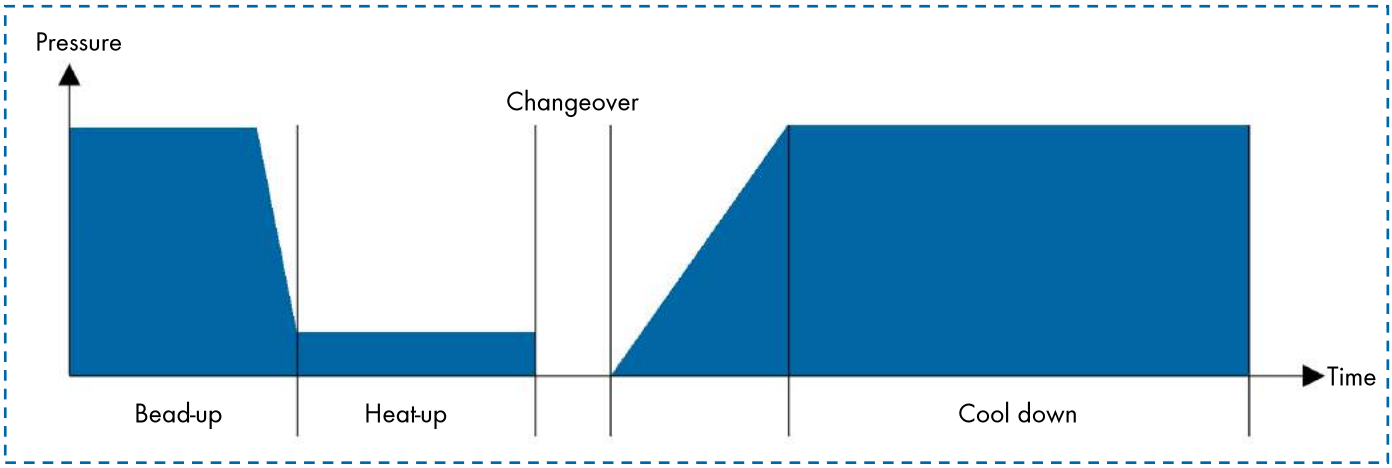
Georg Fischer GF TM 160 / GF TM 160 CNC

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 = 353 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	Pmax	t	t	t	P	t
50 mm	SDR 11	3.80 bar	1 mm	0.50 bar	61 s	6 s	6 s	3.80 bar	9 min
	SDR 9	4.30 bar	1.5 mm	0.50 bar	72 s	6 s	6 s	4.30 bar	10 min
	SDR 7.4	5.00 bar	1.5 mm	0.50 bar	85 s	7 s	7 s	5.00 bar	12 min
63 mm	SDR 17.6	4.20 bar	1 mm	0.50 bar	52 s	5 s	5 s	4.20 bar	7 min
	SDR 17	4.30 bar	1 mm	0.50 bar	54 s	5 s	5 s	4.30 bar	8 min
	SDR 13.6	5.00 bar	1 mm	0.50 bar	63 s	6 s	6 s	5.00 bar	9 min
	SDR 11	5.80 bar	1.5 mm	0.50 bar	75 s	6 s	6 s	5.80 bar	10 min
	SDR 9	6.70 bar	1.5 mm	0.50 bar	89 s	7 s	7 s	6.70 bar	12 min
	SDR 7.4	7.70 bar	1.5 mm	0.50 bar	104 s	7 s	7 s	7.70 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 Georg Fischer GF TM 160 / GF TM 160 CNC

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	Pmax	t	t	t	P	t
75 mm	SDR 17.6	5.70 bar	1 mm	1.00 bar	59 s	6 s	6 s	5.70 bar	8 min
	SDR 17	5.80 bar	1 mm	1.00 bar	61 s	6 s	6 s	5.80 bar	9 min
	SDR 13.6	6.80 bar	1.5 mm	1.00 bar	73 s	6 s	6 s	6.80 bar	10 min
	SDR 11	7.90 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	7.90 bar	12 min
	SDR 9	9.20 bar	1.5 mm	1.00 bar	102 s	7 s	7 s	9.20 bar	14 min
	SDR 7.4	10.70 bar	2 mm	1.00 bar	122 s	8 s	8 s	10.70 bar	16 min
90 mm	SDR 17.6	7.90 bar	1 mm	1.00 bar	69 s	6 s	6 s	7.90 bar	10 min
	SDR 17	8.20 bar	1.5 mm	1.00 bar	72 s	6 s	6 s	8.20 bar	10 min
	SDR 13.6	9.60 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	9.60 bar	12 min
	SDR 11	11.20 bar	1.5 mm	1.00 bar	101 s	7 s	7 s	11.20 bar	14 min
	SDR 9	13.10 bar	2 mm	1.00 bar	121 s	8 s	8 s	13.10 bar	16 min
	SDR 7.4	15.10 bar	2 mm	1.00 bar	144 s	9 s	9 s	15.10 bar	19 min
110 mm	SDR 17.6	11.90 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	11.90 bar	12 min
	SDR 17	12.30 bar	1.5 mm	1.00 bar	88 s	7 s	7 s	12.30 bar	12 min
	SDR 13.6	14.30 bar	1.5 mm	1.00 bar	104 s	7 s	7 s	14.30 bar	14 min
	SDR 11	16.70 bar	2 mm	1.10 bar	123 s	8 s	8 s	16.70 bar	16 min
	SDR 9	19.50 bar	2 mm	1.30 bar	148 s	9 s	9 s	19.50 bar	19 min
	SDR 7.4	22.70 bar	2 mm	1.50 bar	177 s	10 s	10 s	22.70 bar	23 min
125 mm	SDR 17.6	14.80 bar	1.5 mm	1.00 bar	93 s	7 s	7 s	14.80 bar	13 min
	SDR 17	15.30 bar	1.5 mm	1.00 bar	96 s	7 s	7 s	15.30 bar	13 min
	SDR 13.6	18.00 bar	1.5 mm	1.20 bar	115 s	8 s	8 s	18.00 bar	15 min
	SDR 11	21.20 bar	2 mm	1.40 bar	138 s	9 s	9 s	21.20 bar	18 min
	SDR 9	24.80 bar	2 mm	1.70 bar	166 s	9 s	10 s	24.80 bar	21 min
	SDR 7.4	28.80 bar	2.5 mm	1.90 bar	198 s	10 s	11 s	28.80 bar	25 min
140 mm	SDR 17.6	18.30 bar	1.5 mm	1.20 bar	103 s	7 s	7 s	18.30 bar	14 min
	SDR 17	18.80 bar	1.5 mm	1.30 bar	106 s	7 s	7 s	18.80 bar	14 min
	SDR 13.6	22.20 bar	2 mm	1.50 bar	127 s	8 s	8 s	22.20 bar	17 min
	SDR 11	26.10 bar	2 mm	1.70 bar	152 s	9 s	9 s	26.10 bar	20 min
	SDR 9	30.70 bar	2 mm	2.00 bar	183 s	10 s	11 s	30.70 bar	23 min
	SDR 7.4	35.80 bar	2.5 mm	2.40 bar	220 s	11 s	12 s	35.80 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.

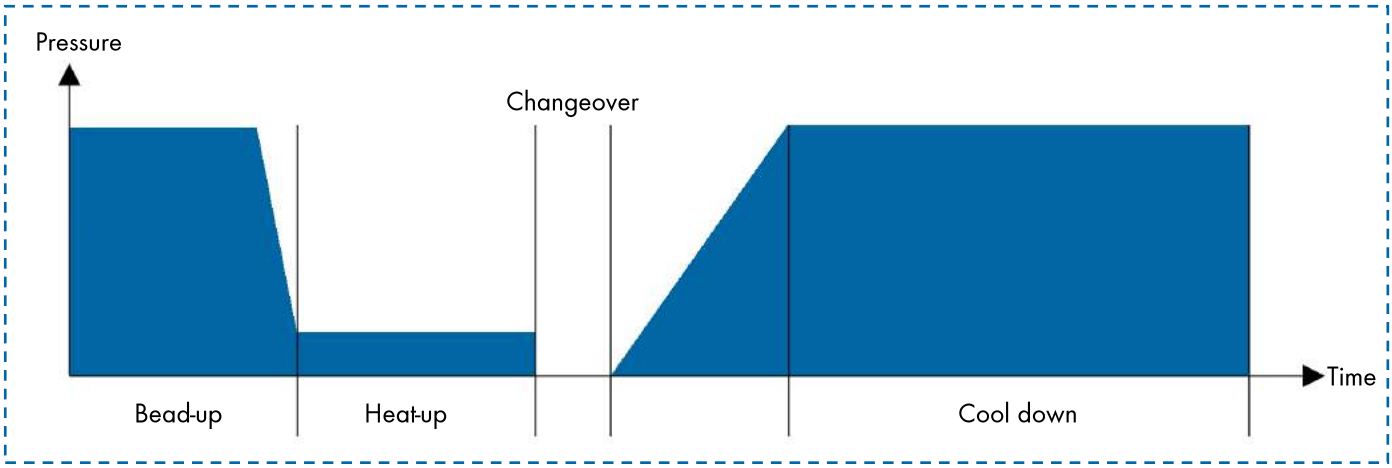
Georg Fischer GF TM 250 / GF TM 250 CNC

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 = 510 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	Pmax	t	t	t	P	t
75 mm	SDR 17.6	3.90 bar	1 mm	1.00 bar	59 s	6 s	6 s	3.90 bar	8 min
	SDR 17	4.00 bar	1 mm	1.00 bar	61 s	6 s	6 s	4.00 bar	9 min
	SDR 13.6	4.70 bar	1.5 mm	1.00 bar	73 s	6 s	6 s	4.70 bar	10 min
	SDR 11	5.50 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	5.50 bar	12 min
	SDR 9	6.40 bar	1.5 mm	1.00 bar	102 s	7 s	7 s	6.40 bar	14 min
	SDR 7.4	7.40 bar	2 mm	1.00 bar	122 s	8 s	8 s	7.40 bar	16 min
90 mm	SDR 17.6	5.50 bar	1 mm	1.00 bar	69 s	6 s	6 s	5.50 bar	10 min
	SDR 17	5.70 bar	1.5 mm	1.00 bar	72 s	6 s	6 s	5.70 bar	10 min
	SDR 13.6	6.60 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	6.60 bar	12 min
	SDR 11	7.70 bar	1.5 mm	1.00 bar	101 s	7 s	7 s	7.70 bar	14 min
	SDR 9	9.10 bar	2 mm	1.00 bar	121 s	8 s	8 s	9.10 bar	16 min
	SDR 7.4	10.50 bar	2 mm	1.00 bar	144 s	9 s	9 s	10.50 bar	19 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 Georg Fischer GF TM 250 / GF TM 250 CNC

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	Pmax	t	t	t	P	t
110 mm	SDR 17.6	8.20 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	8.20 bar	12 min
	SDR 17	8.50 bar	1.5 mm	1.00 bar	88 s	7 s	7 s	8.50 bar	12 min
	SDR 13.6	9.90 bar	1.5 mm	1.00 bar	104 s	7 s	7 s	9.90 bar	14 min
	SDR 11	11.50 bar	2 mm	1.00 bar	123 s	8 s	8 s	11.50 bar	16 min
	SDR 9	13.50 bar	2 mm	1.00 bar	148 s	9 s	9 s	13.50 bar	19 min
	SDR 7.4	15.70 bar	2 mm	1.00 bar	177 s	10 s	10 s	15.70 bar	22 min
125 mm	SDR 17.6	10.30 bar	1.5 mm	1.00 bar	93 s	7 s	7 s	10.30 bar	13 min
	SDR 17	10.60 bar	1.5 mm	1.00 bar	96 s	7 s	7 s	10.60 bar	13 min
	SDR 13.6	12.50 bar	1.5 mm	1.00 bar	115 s	8 s	8 s	12.50 bar	15 min
	SDR 11	14.70 bar	2 mm	1.00 bar	138 s	9 s	9 s	14.70 bar	18 min
	SDR 9	17.20 bar	2 mm	1.10 bar	166 s	9 s	10 s	17.20 bar	21 min
	SDR 7.4	20.00 bar	2.5 mm	1.30 bar	198 s	10 s	11 s	20.00 bar	25 min
140 mm	SDR 17.6	12.70 bar	1.5 mm	1.00 bar	103 s	7 s	7 s	12.70 bar	14 min
	SDR 17	13.00 bar	1.5 mm	1.00 bar	106 s	7 s	7 s	13.00 bar	14 min
	SDR 13.6	15.40 bar	2 mm	1.00 bar	127 s	8 s	8 s	15.40 bar	17 min
	SDR 11	18.00 bar	2 mm	1.20 bar	152 s	9 s	9 s	18.00 bar	20 min
	SDR 9	21.30 bar	2 mm	1.40 bar	183 s	10 s	11 s	21.30 bar	23 min
	SDR 7.4	24.80 bar	2.5 mm	1.70 bar	220 s	11 s	12 s	24.80 bar	27 min
160 mm	SDR 17.6	16.80 bar	1.5 mm	1.10 bar	119 s	8 s	8 s	16.80 bar	16 min
	SDR 17	17.40 bar	2 mm	1.20 bar	123 s	8 s	8 s	17.40 bar	16 min
	SDR 13.6	20.40 bar	2 mm	1.40 bar	147 s	9 s	9 s	20.40 bar	19 min
	SDR 11	24.00 bar	2 mm	1.60 bar	177 s	10 s	10 s	24.00 bar	22 min
	SDR 9	28.10 bar	2.5 mm	1.90 bar	211 s	11 s	12 s	28.10 bar	26 min
	SDR 7.4	32.70 bar	2.5 mm	2.20 bar	253 s	12 s	14 s	32.70 bar	31 min
180 mm	SDR 17.6	21.90 bar	2 mm	1.50 bar	137 s	8 s	9 s	21.90 bar	18 min
	SDR 17	22.60 bar	2 mm	1.50 bar	142 s	9 s	9 s	22.60 bar	19 min
	SDR 13.6	26.50 bar	2 mm	1.80 bar	170 s	9 s	10 s	26.50 bar	22 min
	SDR 11	31.00 bar	2.5 mm	2.10 bar	202 s	10 s	12 s	31.00 bar	25 min
	SDR 9	36.10 bar	2.5 mm	2.40 bar	241 s	11 s	13 s	36.10 bar	30 min
	SDR 7.4	41.90 bar	3 mm	2.80 bar	288 s	13 s	15 s	41.90 bar	35 min
200 mm	SDR 17.6	26.40 bar	2 mm	1.80 bar	150 s	9 s	9 s	26.40 bar	19 min
	SDR 17	27.30 bar	2 mm	1.80 bar	155 s	9 s	9 s	27.30 bar	20 min
	SDR 13.6	32.00 bar	2 mm	2.10 bar	184 s	10 s	11 s	32.00 bar	23 min
	SDR 11	37.60 bar	2.5 mm	2.50 bar	221 s	11 s	12 s	37.60 bar	27 min
	SDR 9	44.10 bar	3 mm	2.90 bar	265 s	12 s	14 s	44.10 bar	32 min
	SDR 7.4	51.20 bar	3 mm	3.40 bar	318 s	14 s	17 s	51.20 bar	39 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 Georg Fischer GF TM 250 / GF TM 250 CNC

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	Pmax	t	t	t	P	t
225 mm	SDR 17.6	32.60 bar	2 mm	2.20 bar	164 s	9 s	10 s	32.60 bar	21 min
	SDR 17	33.80 bar	2 mm	2.30 bar	171 s	9 s	10 s	33.80 bar	22 min
	SDR 13.6	39.80 bar	2.5 mm	2.70 bar	204 s	10 s	12 s	39.80 bar	26 min
	SDR 11	46.90 bar	2.5 mm	3.10 bar	245 s	12 s	13 s	46.90 bar	30 min
	SDR 9	55.00 bar	3 mm	3.70 bar	295 s	13 s	16 s	55.00 bar	36 min
	SDR 7.4	64.00 bar	3 mm	4.30 bar	353 s	15 s	18 s	64.00 bar	43 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.

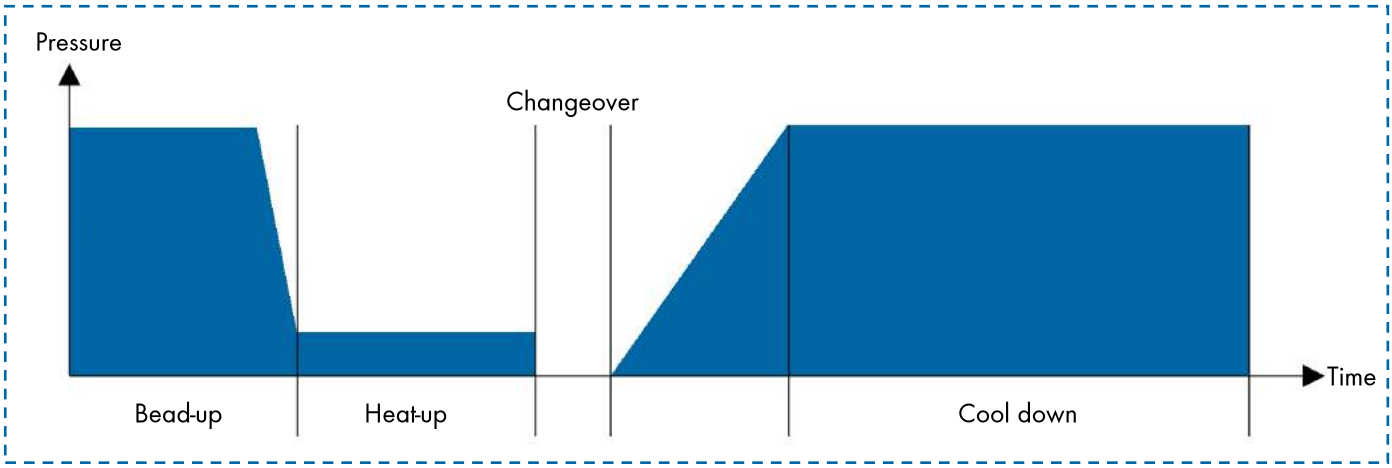
Georg Fischer GF TM 315 / GF TM 315 CNC

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 = 510 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	Pmax	t	t	t	P	t
90 mm	SDR 17.6	5.50 bar	1 mm	1.00 bar	69 s	6 s	6 s	5.50 bar	10 min
	SDR 17	5.70 bar	1.5 mm	1.00 bar	72 s	6 s	6 s	5.70 bar	10 min
	SDR 13.6	6.60 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	6.60 bar	12 min
	SDR 11	7.70 bar	1.5 mm	1.00 bar	101 s	7 s	7 s	7.70 bar	14 min
	SDR 9	9.10 bar	2 mm	1.00 bar	121 s	8 s	8 s	9.10 bar	16 min
	SDR 7.4	10.50 bar	2 mm	1.00 bar	144 s	9 s	9 s	10.50 bar	19 min
110 mm	SDR 17.6	8.20 bar	1.5 mm	1.00 bar	85 s	7 s	7 s	8.20 bar	12 min
	SDR 17	8.50 bar	1.5 mm	1.00 bar	88 s	7 s	7 s	8.50 bar	12 min
	SDR 13.6	9.90 bar	1.5 mm	1.00 bar	104 s	7 s	7 s	9.90 bar	14 min
	SDR 11	11.50 bar	2 mm	1.00 bar	123 s	8 s	8 s	11.50 bar	16 min
	SDR 9	13.50 bar	2 mm	1.00 bar	148 s	9 s	9 s	13.50 bar	19 min
	SDR 7.4	15.70 bar	2 mm	1.00 bar	177 s	10 s	10 s	15.70 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 Georg Fischer GF TM 315 / GF TM 315 CNC

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	Pmax	t	t	t	P	t
125 mm	SDR 17.6	10.30 bar	1.5 mm	1.00 bar	93 s	7 s	7 s	10.30 bar	13 min
	SDR 17	10.60 bar	1.5 mm	1.00 bar	96 s	7 s	7 s	10.60 bar	13 min
	SDR 13.6	12.50 bar	1.5 mm	1.00 bar	115 s	8 s	8 s	12.50 bar	15 min
	SDR 11	14.70 bar	2 mm	1.00 bar	138 s	9 s	9 s	14.70 bar	18 min
	SDR 9	17.20 bar	2 mm	1.10 bar	166 s	9 s	10 s	17.20 bar	21 min
	SDR 7.4	20.00 bar	2.5 mm	1.30 bar	198 s	10 s	11 s	20.00 bar	25 min
140 mm	SDR 17.6	12.70 bar	1.5 mm	1.00 bar	103 s	7 s	7 s	12.70 bar	14 min
	SDR 17	13.00 bar	1.5 mm	1.00 bar	106 s	7 s	7 s	13.00 bar	14 min
	SDR 13.6	15.40 bar	2 mm	1.00 bar	127 s	8 s	8 s	15.40 bar	17 min
	SDR 11	18.00 bar	2 mm	1.20 bar	152 s	9 s	9 s	18.00 bar	20 min
	SDR 9	21.30 bar	2 mm	1.40 bar	183 s	10 s	11 s	21.30 bar	23 min
	SDR 7.4	24.80 bar	2.5 mm	1.70 bar	220 s	11 s	12 s	24.80 bar	27 min
160 mm	SDR 17.6	16.80 bar	1.5 mm	1.10 bar	119 s	8 s	8 s	16.80 bar	16 min
	SDR 17	17.40 bar	2 mm	1.20 bar	123 s	8 s	8 s	17.40 bar	16 min
	SDR 13.6	20.40 bar	2 mm	1.40 bar	147 s	9 s	9 s	20.40 bar	19 min
	SDR 11	24.00 bar	2 mm	1.60 bar	177 s	10 s	10 s	24.00 bar	22 min
	SDR 9	28.10 bar	2.5 mm	1.90 bar	211 s	11 s	12 s	28.10 bar	26 min
	SDR 7.4	32.70 bar	2.5 mm	2.20 bar	253 s	12 s	14 s	32.70 bar	31 min
180 mm	SDR 17.6	21.90 bar	2 mm	1.50 bar	137 s	8 s	9 s	21.90 bar	18 min
	SDR 17	22.60 bar	2 mm	1.50 bar	142 s	9 s	9 s	22.60 bar	19 min
	SDR 13.6	26.50 bar	2 mm	1.80 bar	170 s	9 s	10 s	26.50 bar	22 min
	SDR 11	31.00 bar	2.5 mm	2.10 bar	202 s	10 s	12 s	31.00 bar	25 min
	SDR 9	36.10 bar	2.5 mm	2.40 bar	241 s	11 s	13 s	36.10 bar	30 min
	SDR 7.4	41.90 bar	3 mm	2.80 bar	288 s	13 s	15 s	41.90 bar	35 min
200 mm	SDR 17.6	26.40 bar	2 mm	1.80 bar	150 s	9 s	9 s	26.40 bar	19 min
	SDR 17	27.30 bar	2 mm	1.80 bar	155 s	9 s	9 s	27.30 bar	20 min
	SDR 13.6	32.00 bar	2 mm	2.10 bar	184 s	10 s	11 s	32.00 bar	23 min
	SDR 11	37.60 bar	2.5 mm	2.50 bar	221 s	11 s	12 s	37.60 bar	27 min
	SDR 9	44.10 bar	3 mm	2.90 bar	265 s	12 s	14 s	44.10 bar	32 min
	SDR 7.4	51.20 bar	3 mm	3.40 bar	318 s	14 s	17 s	51.20 bar	39 min
225 mm	SDR 17.6	32.60 bar	2 mm	2.20 bar	164 s	9 s	10 s	32.60 bar	21 min
	SDR 17	33.80 bar	2 mm	2.30 bar	171 s	9 s	10 s	33.80 bar	22 min
	SDR 13.6	39.80 bar	2.5 mm	2.70 bar	204 s	10 s	12 s	39.80 bar	26 min
	SDR 11	46.90 bar	2.5 mm	3.10 bar	245 s	12 s	13 s	46.90 bar	30 min
	SDR 9	55.00 bar	3 mm	3.70 bar	295 s	13 s	16 s	55.00 bar	36 min
	SDR 7.4	64.00 bar	3 mm	4.30 bar	353 s	15 s	18 s	64.00 bar	43 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 Georg Fischer GF TM 315 / GF TM 315 CNC

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	Pmax	t	t	t	P	t
250 mm	SDR 17.6	39.50 bar	2 mm	2.60 bar	179 s	10 s	11 s	39.50 bar	23 min
	SDR 17	40.70 bar	2 mm	2.70 bar	185 s	10 s	11 s	40.70 bar	23 min
	SDR 13.6	48.30 bar	2.5 mm	3.20 bar	223 s	11 s	12 s	48.30 bar	28 min
	SDR 11	56.90 bar	3 mm	3.80 bar	268 s	12 s	14 s	56.90 bar	33 min
	SDR 9	66.90 bar	3 mm	4.50 bar	323 s	14 s	17 s	66.90 bar	40 min
	SDR 7.4	78.20 bar	3.5 mm	5.20 bar	389 s	17 s	20 s	78.20 bar	47 min
280 mm	SDR 17.6	48.50 bar	2.5 mm	3.20 bar	197 s	10 s	11 s	48.50 bar	25 min
	SDR 17	50.20 bar	2.5 mm	3.30 bar	204 s	10 s	12 s	50.20 bar	26 min
	SDR 13.6	59.60 bar	2.5 mm	4.00 bar	246 s	12 s	13 s	59.60 bar	30 min
	SDR 11	70.40 bar	3 mm	4.70 bar	297 s	13 s	16 s	70.40 bar	36 min
	SDR 9	83.10 bar	3 mm	5.50 bar	359 s	16 s	18 s	83.10 bar	44 min
	SDR 7.4	97.20 bar	3.5 mm	6.50 bar	432 s	18 s	22 s	97.20 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.

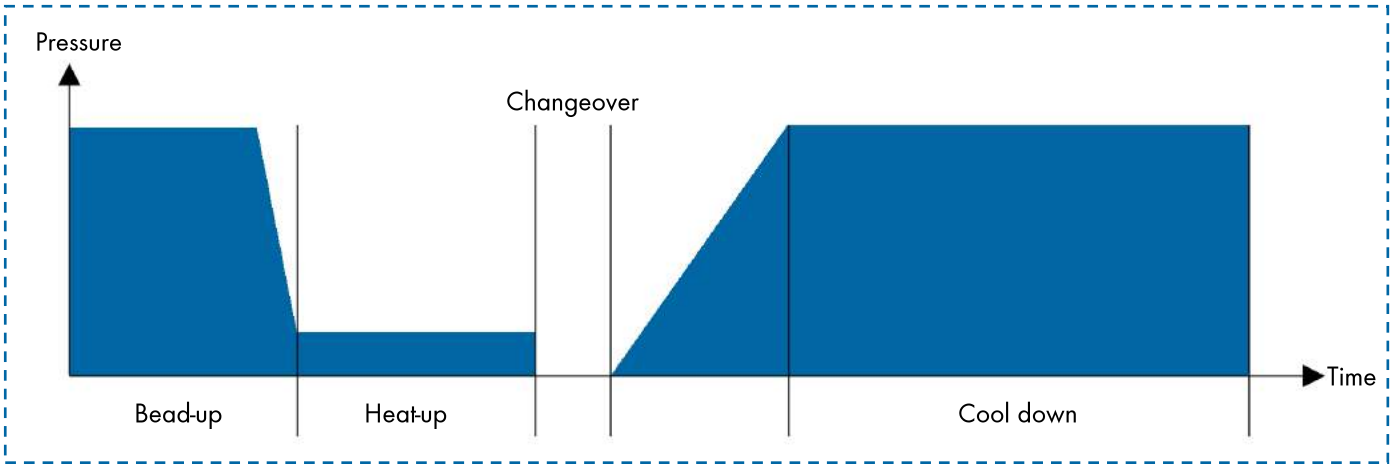
Georg Fischer GF 400 / GF 400 CNC

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 = 904 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	Pmax	t	t	t	P	t
125 mm	SDR 17.6	5.80 bar	1.5 mm	1.00 bar	93 s	7 s	7 s	5.80 bar	13 min
	SDR 17	6.00 bar	1.5 mm	1.00 bar	96 s	7 s	7 s	6.00 bar	13 min
	SDR 13.6	7.00 bar	1.5 mm	1.00 bar	115 s	8 s	8 s	7.00 bar	15 min
	SDR 11	8.30 bar	2 mm	1.00 bar	138 s	9 s	9 s	8.30 bar	18 min
	SDR 9	9.70 bar	2 mm	1.00 bar	166 s	9 s	10 s	9.70 bar	21 min
	SDR 7.4	11.30 bar	2.5 mm	1.00 bar	198 s	10 s	11 s	11.30 bar	25 min
140 mm	SDR 17.6	7.10 bar	1.5 mm	1.00 bar	103 s	7 s	7 s	7.10 bar	14 min
	SDR 17	7.30 bar	1.5 mm	1.00 bar	106 s	7 s	7 s	7.30 bar	14 min
	SDR 13.6	8.70 bar	2 mm	1.00 bar	127 s	8 s	8 s	8.70 bar	17 min
	SDR 11	10.20 bar	2 mm	1.00 bar	152 s	9 s	9 s	10.20 bar	20 min
	SDR 9	12.00 bar	2 mm	1.00 bar	183 s	10 s	11 s	12.00 bar	23 min
	SDR 7.4	14.00 bar	2.5 mm	1.00 bar	220 s	11 s	12 s	14.00 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.

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Continuation Georg Fischer GF 400 / GF 400 CNC

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	Pmax	t	t	t	P	t
160 mm	SDR 17.6	9.50 bar	1.5 mm	1.00 bar	119 s	8 s	8 s	9.50 bar	16 min
	SDR 17	9.80 bar	2 mm	1.00 bar	123 s	8 s	8 s	9.80 bar	16 min
	SDR 13.6	11.50 bar	2 mm	1.00 bar	147 s	9 s	9 s	11.50 bar	19 min
	SDR 11	13.60 bar	2 mm	1.00 bar	177 s	10 s	10 s	13.60 bar	22 min
	SDR 9	15.80 bar	2.5 mm	1.10 bar	211 s	11 s	12 s	15.80 bar	26 min
	SDR 7.4	18.40 bar	2.5 mm	1.20 bar	253 s	12 s	14 s	18.40 bar	31 min
180 mm	SDR 17.6	12.30 bar	2 mm	1.00 bar	137 s	8 s	9 s	12.30 bar	18 min
	SDR 17	12.70 bar	2 mm	1.00 bar	142 s	9 s	9 s	12.70 bar	19 min
	SDR 13.6	15.00 bar	2 mm	1.00 bar	170 s	9 s	10 s	15.00 bar	22 min
	SDR 11	17.50 bar	2.5 mm	1.20 bar	202 s	10 s	12 s	17.50 bar	25 min
	SDR 9	20.40 bar	2.5 mm	1.40 bar	241 s	11 s	13 s	20.40 bar	30 min
	SDR 7.4	23.70 bar	3 mm	1.60 bar	288 s	13 s	15 s	23.70 bar	35 min
200 mm	SDR 17.6	14.90 bar	2 mm	1.00 bar	150 s	9 s	9 s	14.90 bar	19 min
	SDR 17	15.40 bar	2 mm	1.00 bar	155 s	9 s	9 s	15.40 bar	20 min
	SDR 13.6	18.00 bar	2 mm	1.20 bar	184 s	10 s	11 s	18.00 bar	23 min
	SDR 11	21.20 bar	2.5 mm	1.40 bar	221 s	11 s	12 s	21.20 bar	27 min
	SDR 9	24.90 bar	3 mm	1.70 bar	265 s	12 s	14 s	24.90 bar	33 min
	SDR 7.4	28.90 bar	3 mm	1.90 bar	318 s	14 s	17 s	28.90 bar	39 min
225 mm	SDR 17.6	18.40 bar	2 mm	1.20 bar	164 s	9 s	10 s	18.40 bar	21 min
	SDR 17	19.10 bar	2 mm	1.30 bar	171 s	9 s	10 s	19.10 bar	22 min
	SDR 13.6	22.40 bar	2.5 mm	1.50 bar	204 s	10 s	12 s	22.40 bar	26 min
	SDR 11	26.40 bar	2.5 mm	1.80 bar	245 s	12 s	13 s	26.40 bar	30 min
	SDR 9	31.00 bar	3 mm	2.10 bar	295 s	13 s	16 s	31.00 bar	36 min
	SDR 7.4	36.10 bar	3 mm	2.40 bar	353 s	15 s	18 s	36.10 bar	43 min
250 mm	SDR 17.6	22.30 bar	2 mm	1.50 bar	179 s	10 s	11 s	22.30 bar	23 min
	SDR 17	23.00 bar	2 mm	1.50 bar	185 s	10 s	11 s	23.00 bar	23 min
	SDR 13.6	27.20 bar	2.5 mm	1.80 bar	223 s	10 s	12 s	27.20 bar	28 min
	SDR 11	32.10 bar	3 mm	2.10 bar	268 s	12 s	14 s	32.10 bar	33 min
	SDR 9	37.70 bar	3 mm	2.50 bar	323 s	14 s	17 s	37.70 bar	39 min
	SDR 7.4	44.10 bar	3.5 mm	2.90 bar	389 s	17 s	17 s	44.10 bar	47 min
280 mm	SDR 17.6	27.40 bar	2.5 mm	1.80 bar	197 s	10 s	11 s	27.40 bar	25 min
	SDR 17	28.30 bar	2.5 mm	1.90 bar	204 s	10 s	12 s	28.30 bar	26 min
	SDR 13.6	33.60 bar	2.5 mm	2.20 bar	246 s	12 s	13 s	33.60 bar	30 min
	SDR 11	39.70 bar	3 mm	2.60 bar	297 s	13 s	16 s	39.70 bar	36 min
	SDR 9	46.90 bar	3 mm	3.10 bar	359 s	16 s	18 s	46.90 bar	43 min
	SDR 7.4	54.80 bar	3.5 mm	3.70 bar	432 s	18 s	22 s	54.80 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.

Continuation Georg Fischer GF 400 / GF 400 CNC

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	Pmax	t	t	t	P	t
315 mm	SDR 17.6	34.50 bar	2.5 mm	2.30 bar	221 s	10 s	12 s	34.50 bar	28 min
	SDR 17	35.80 bar	2.5 mm	2.40 bar	229 s	11 s	12 s	35.80 bar	28 min
	SDR 13.6	42.50 bar	3 mm	2.80 bar	277 s	12 s	14 s	42.50 bar	34 min
	SDR 11	50.20 bar	3 mm	3.30 bar	333 s	14 s	17 s	50.20 bar	41 min
	SDR 9	58.30 bar	3.5 mm	3.90 bar	396 s	17 s	17 s	58.30 bar	48 min
	SDR 7.4	69.30 bar	3.5 mm	4.60 bar	486 s	19 s	21 s	69.30 bar	59 min
355 mm	SDR 17.6	43.00 bar	2.5 mm	2.90 bar	244 s	11 s	13 s	43.00 bar	30 min
	SDR 17	44.70 bar	2.5 mm	3.00 bar	255 s	11 s	13 s	44.70 bar	32 min
	SDR 13.6	53.10 bar	3 mm	3.50 bar	307 s	13 s	16 s	53.10 bar	38 min
	SDR 11	62.90 bar	3.5 mm	4.20 bar	371 s	16 s	16 s	62.90 bar	45 min
	SDR 9	74.40 bar	3.5 mm	5.00 bar	450 s	18 s	19 s	74.40 bar	54 min
	SDR 7.4	87.10 bar	4 mm	5.80 bar	542 s	21 s	22 s	87.10 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.

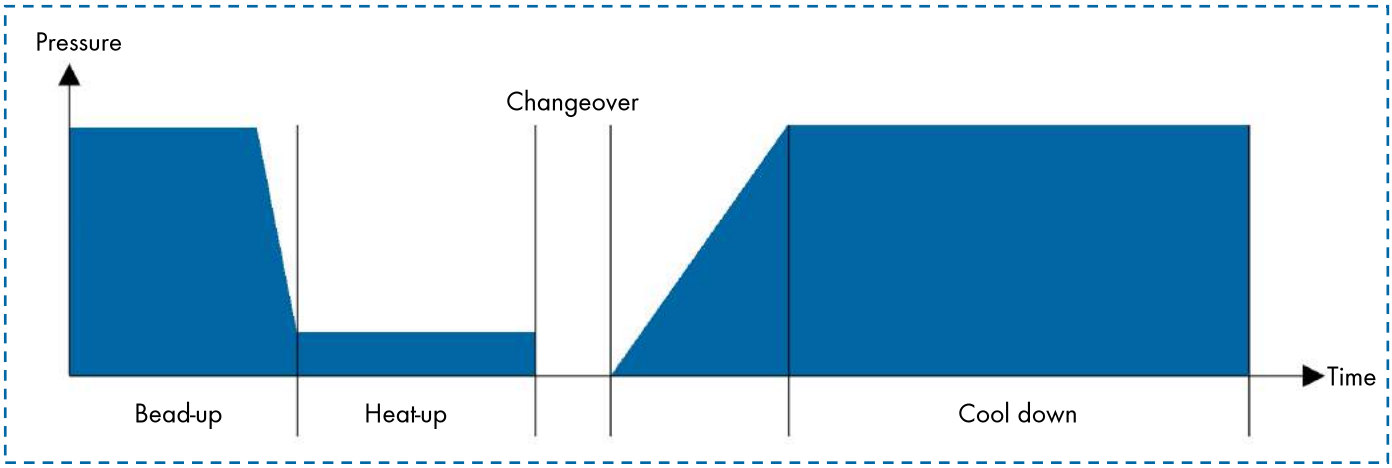
Georg Fischer GF 500 / GF 500 CNC

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 = 1413 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	Pmax	t	t	t	P	t
200 mm	SDR 17.6	9.50 bar	2 mm	1.00 bar	150 s	9 s	9 s	9.50 bar	19 min
	SDR 17	9.80 bar	2 mm	1.00 bar	155 s	9 s	9 s	9.80 bar	19 min
	SDR 13.6	11.50 bar	2 mm	1.00 bar	184 s	10 s	11 s	11.50 bar	23 min
	SDR 11	13.60 bar	2.5 mm	1.00 bar	221 s	11 s	12 s	13.60 bar	27 min
	SDR 9	15.90 bar	3 mm	1.10 bar	265 s	12 s	14 s	15.90 bar	32 min
	SDR 7.4	18.50 bar	3 mm	2.00 bar	318 s	14 s	17 s	18.50 bar	39 min
225 mm	SDR 17.6	11.80 bar	2 mm	1.00 bar	164 s	9 s	10 s	11.80 bar	21 min
	SDR 17	12.20 bar	2 mm	1.00 bar	171 s	9 s	10 s	12.20 bar	21 min
	SDR 13.6	14.40 bar	2.5 mm	1.00 bar	204 s	10 s	12 s	14.40 bar	26 min
	SDR 11	16.90 bar	2.5 mm	1.10 bar	245 s	12 s	13 s	16.90 bar	30 min
	SDR 9	19.80 bar	3 mm	1.30 bar	295 s	13 s	16 s	19.80 bar	36 min
	SDR 7.4	23.10 bar	3 mm	1.50 bar	353 s	15 s	18 s	23.10 bar	43 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 Georg Fischer GF 500 / GF 500 CNC

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	Pmax	t	t	t	P	t
250 mm	SDR 17.6	14.20 bar	2 mm	1.00 bar	179 s	10 s	11 s	14.20 bar	23 min
	SDR 17	14.70 bar	2 mm	1.00 bar	185 s	10 s	11 s	14.70 bar	24 min
	SDR 13.6	17.40 bar	2.5 mm	1.20 bar	223 s	11 s	12 s	17.40 bar	27 min
	SDR 11	20.50 bar	3 mm	1.40 bar	268 s	12 s	14 s	20.50 bar	33 min
	SDR 9	24.10 bar	3 mm	1.60 bar	323 s	14 s	17 s	24.10 bar	39 min
	SDR 7.4	28.20 bar	3.5 mm	1.90 bar	389 s	17 s	20 s	28.20 bar	47 min
280 mm	SDR 17.6	17.50 bar	2.5 mm	1.20 bar	197 s	10 s	11 s	17.50 bar	25 min
	SDR 17	18.10 bar	2.5 mm	1.20 bar	204 s	10 s	12 s	18.10 bar	26 min
	SDR 13.6	21.50 bar	2.5 mm	1.40 bar	246 s	12 s	13 s	21.50 bar	30 min
	SDR 11	25.40 bar	3 mm	1.70 bar	297 s	13 s	16 s	25.40 bar	36 min
	SDR 9	30.00 bar	3 mm	2.00 bar	359 s	16 s	18 s	30.00 bar	44 min
	SDR 7.4	35.10 bar	3.5 mm	2.30 bar	432 s	18 s	22 s	35.10 bar	52 min
315 mm	SDR 17.6	22.10 bar	2.5 mm	1.50 bar	221 s	11 s	12 s	22.10 bar	27 min
	SDR 17	22.90 bar	2.5 mm	1.50 bar	229 s	11 s	13 s	22.90 bar	28 min
	SDR 13.6	27.20 bar	3 mm	1.80 bar	277 s	13 s	15 s	27.20 bar	34 min
	SDR 11	32.10 bar	3 mm	2.10 bar	333 s	15 s	17 s	32.10 bar	41 min
	SDR 9	37.30 bar	3.5 mm	2.50 bar	396 s	17 s	20 s	37.30 bar	48 min
	SDR 7.4	44.30 bar	3.5 mm	3.00 bar	486 s	20 s	24 s	44.30 bar	58 min
355 mm	SDR 17.6	27.50 bar	2.5 mm	1.80 bar	244 s	12 s	13 s	27.50 bar	30 min
	SDR 17	28.60 bar	2.5 mm	1.90 bar	255 s	12 s	14 s	28.60 bar	31 min
	SDR 13.6	34.00 bar	3 mm	2.30 bar	307 s	14 s	16 s	34.00 bar	38 min
	SDR 11	40.30 bar	3.5 mm	2.70 bar	371 s	16 s	19 s	40.30 bar	45 min
	SDR 9	47.60 bar	3.5 mm	3.20 bar	450 s	18 s	23 s	47.60 bar	54 min
	SDR 7.4	55.70 bar	4 mm	3.70 bar	542 s	21 s	27 s	55.70 bar	64 min
400 mm	SDR 17.6	34.40 bar	3 mm	2.30 bar	271 s	12 s	15 s	34.40 bar	33 min
	SDR 17	35.60 bar	3 mm	2.40 bar	282 s	13 s	15 s	35.60 bar	34 min
	SDR 13.6	42.50 bar	3 mm	2.80 bar	342 s	15 s	18 s	42.50 bar	41 min
	SDR 11	50.60 bar	3.5 mm	3.40 bar	414 s	17 s	21 s	50.60 bar	50 min
	SDR 9	59.80 bar	4 mm	4.00 bar	502 s	20 s	25 s	59.80 bar	60 min
	SDR 7.4	70.20 bar	4 mm	4.70 bar	607 s	23 s	30 s	70.20 bar	70 min
450 mm	SDR 17.6	43.60 bar	3 mm	2.90 bar	305 s	14 s	16 s	43.60 bar	37 min
	SDR 17	45.20 bar	3 mm	3.00 bar	318 s	14 s	17 s	45.20 bar	39 min
	SDR 13.6	54.00 bar	3.5 mm	3.60 bar	385 s	16 s	20 s	54.00 bar	47 min
	SDR 11	64.10 bar	3.5 mm	4.30 bar	467 s	19 s	23 s	64.10 bar	56 min
	SDR 9	75.80 bar	4 mm	5.10 bar	566 s	22 s	28 s	75.80 bar	67 min
	SDR 7.4	88.90 bar	4 mm	5.90 bar	683 s	25 s	34 s	88.90 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.

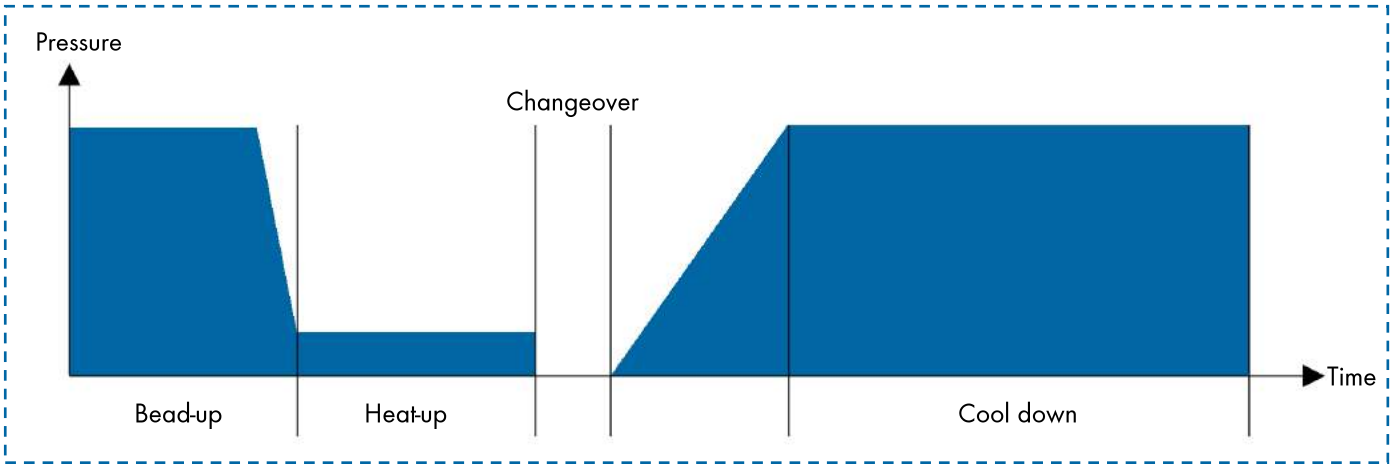
Georg Fischer GF 630 / GF 630 CNC

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 = 1413 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	Pmax	t	t	t	P	t
315 mm	SDR 17.6	22.10 bar	2.5 mm	1.50 bar	221 s	11 s	12 s	22.10 bar	27 min
	SDR 17	22.90 bar	2.5 mm	1.50 bar	229 s	11 s	13 s	22.90 bar	28 min
	SDR 13.6	27.20 bar	3 mm	1.80 bar	277 s	13 s	15 s	27.20 bar	34 min
	SDR 11	32.10 bar	3 mm	2.10 bar	333 s	15 s	17 s	32.10 bar	41 min
	SDR 9	37.30 bar	3.5 mm	2.50 bar	396 s	17 s	20 s	37.30 bar	48 min
	SDR 7.4	44.30 bar	3.5 mm	3.00 bar	486 s	20 s	24 s	44.30 bar	58 min
355 mm	SDR 17.6	27.50 bar	2.5 mm	1.80 bar	244 s	12 s	13 s	27.50 bar	30 min
	SDR 17	28.60 bar	2.5 mm	1.90 bar	255 s	12 s	14 s	28.60 bar	31 min
	SDR 13.6	34.00 bar	3 mm	2.30 bar	307 s	14 s	16 s	34.00 bar	38 min
	SDR 11	40.30 bar	3.5 mm	2.70 bar	371 s	16 s	19 s	40.30 bar	45 min
	SDR 9	47.60 bar	3.5 mm	3.20 bar	450 s	18 s	23 s	47.60 bar	54 min
	SDR 7.4	55.70 bar	4 mm	3.70 bar	542 s	21 s	27 s	55.70 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 Georg Fischer GF 630 / GF 630 CNC

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	Pmax	t	t	t	P	t
400 mm	SDR 17.6	34.40 bar	3 mm	2.30 bar	271 s	12 s	15 s	34.40 bar	33 min
	SDR 17	35.60 bar	3 mm	2.40 bar	282 s	13 s	15 s	35.60 bar	34 min
	SDR 13.6	42.50 bar	3 mm	2.80 bar	342 s	15 s	18 s	42.50 bar	41 min
	SDR 11	50.60 bar	3.5 mm	3.40 bar	414 s	17 s	21 s	50.60 bar	50 min
	SDR 9	59.80 bar	4 mm	4.00 bar	502 s	20 s	25 s	59.80 bar	60 min
	SDR 7.4	70.20 bar	4 mm	4.70 bar	607 s	23 s	30 s	70.20 bar	70 min
450 mm	SDR 17.6	43.60 bar	3 mm	2.90 bar	305 s	14 s	16 s	43.60 bar	37 min
	SDR 17	45.20 bar	3 mm	3.00 bar	318 s	14 s	17 s	45.20 bar	39 min
	SDR 13.6	54.00 bar	3.5 mm	3.60 bar	385 s	16 s	20 s	54.00 bar	47 min
	SDR 11	64.10 bar	3.5 mm	4.30 bar	467 s	19 s	23 s	64.10 bar	56 min
	SDR 9	75.80 bar	4 mm	5.10 bar	566 s	22 s	28 s	75.80 bar	67 min
	SDR 7.4	88.90 bar	4 mm	5.90 bar	683 s	25 s	34 s	88.90 bar	78 min
500 mm	SDR 17.6	53.00 bar	3 mm	3.50 bar	335 s	15 s	17 s	53.00 bar	41 min
	SDR 17	55.20 bar	3 mm	3.70 bar	349 s	15 s	18 s	55.20 bar	42 min
	SDR 13.6	65.90 bar	3.5 mm	4.40 bar	424 s	18 s	21 s	65.90 bar	51 min
	SDR 11	78.40 bar	4 mm	5.20 bar	514 s	20 s	26 s	78.40 bar	61 min
	SDR 9	92.80 bar	4 mm	6.20 bar	623 s	23 s	31 s	92.80 bar	72 min
560 mm	SDR 17.6	65.60 bar	3 mm	4.40 bar	370 s	16 s	19 s	65.60 bar	45 min
	SDR 17	68.30 bar	3.5 mm	4.60 bar	386 s	16 s	24 s	68.30 bar	47 min
	SDR 13.6	81.80 bar	3.5 mm	5.50 bar	470 s	19 s	24 s	81.80 bar	56 min
	SDR 11	97.40 bar	4 mm	6.50 bar	571 s	22 s	29 s	97.40 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.

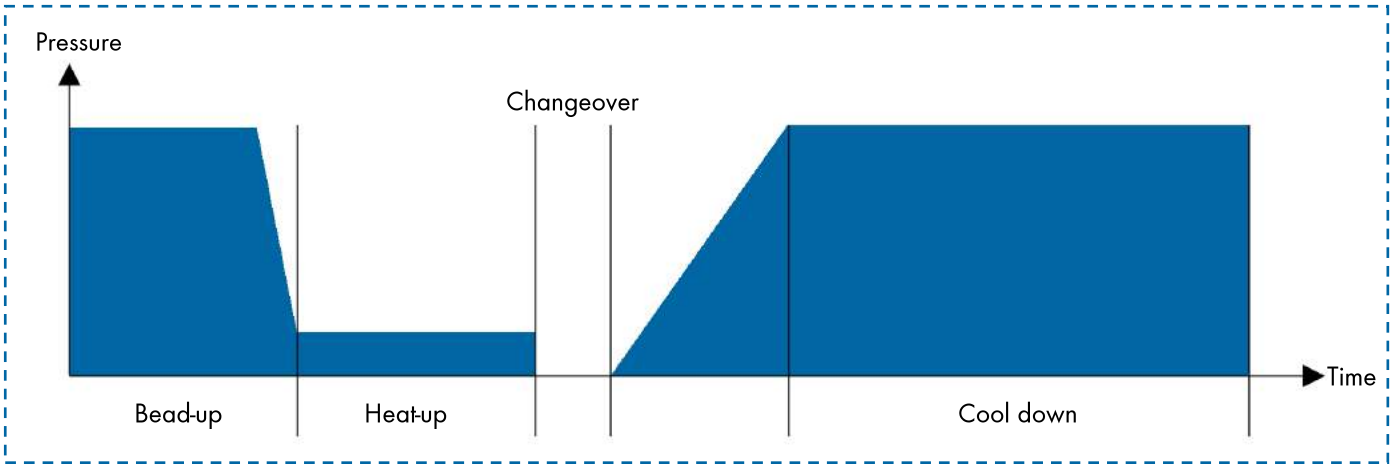
Georg Fischer GF 800

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 = 2356 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	Pmax	t	t	t	P	t
500 mm	SDR 17.6	31.30 bar	3 mm	2.10 bar	335 s	14 s	17 s	31.30 bar	40 min
	SDR 17	32.50 bar	3 mm	2.20 bar	349 s	15 s	18 s	32.50 bar	42 min
	SDR 13.6	38.80 bar	3.5 mm	2.60 bar	424 s	17 s	18 s	38.80 bar	51 min
	SDR 11	46.20 bar	4 mm	3.10 bar	514 s	20 s	20 s	46.20 bar	61 min
	SDR 9	54.70 bar	4 mm	3.70 bar	623 s	23 s	26 s	54.70 bar	72 min
560 mm	SDR 17.6	38.70 bar	3 mm	2.60 bar	370 s	16 s	19 s	38.70 bar	45 min
	SDR 17	40.20 bar	3.5 mm	2.70 bar	386 s	16 s	16 s	40.20 bar	46 min
	SDR 13.6	48.20 bar	3.5 mm	3.30 bar	470 s	19 s	20 s	48.20 bar	56 min
	SDR 11	57.40 bar	4 mm	3.90 bar	571 s	21 s	23 s	57.40 bar	67 min
630 mm	SDR 17.6	48.40 bar	3.5 mm	3.30 bar	412 s	17 s	17 s	48.40 bar	49 min
	SDR 17	50.40 bar	3.5 mm	3.40 bar	430 s	17 s	18 s	50.40 bar	51 min
	SDR 13.6	60.40 bar	4 mm	4.10 bar	524 s	20 s	21 s	60.40 bar	62 min
	SDR 11	72.10 bar	4 mm	4.90 bar	638 s	23 s	26 s	72.10 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.

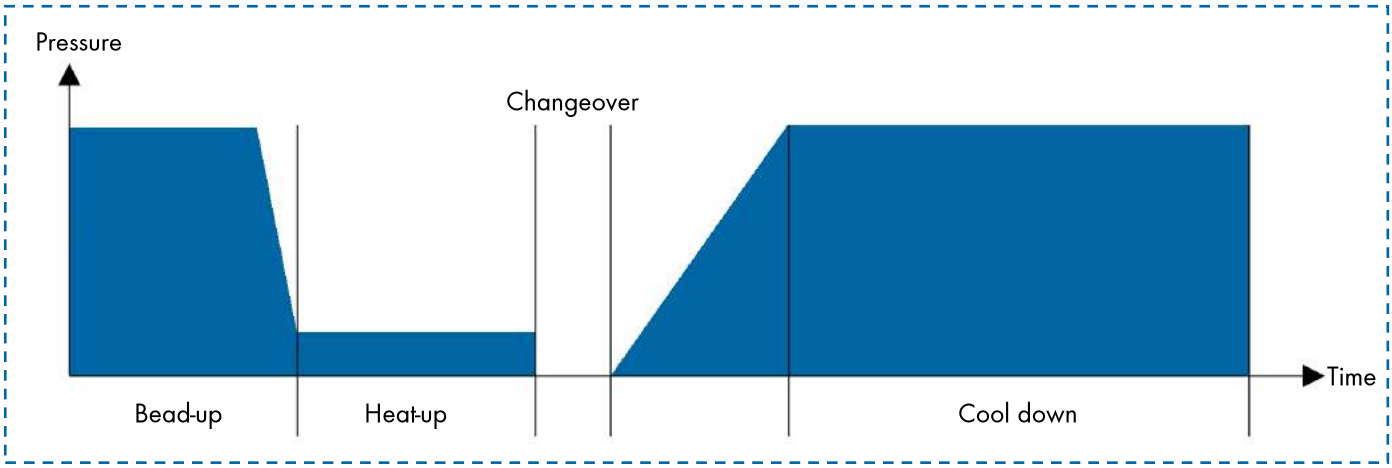
Rothenberger Roweld P 160 B

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.

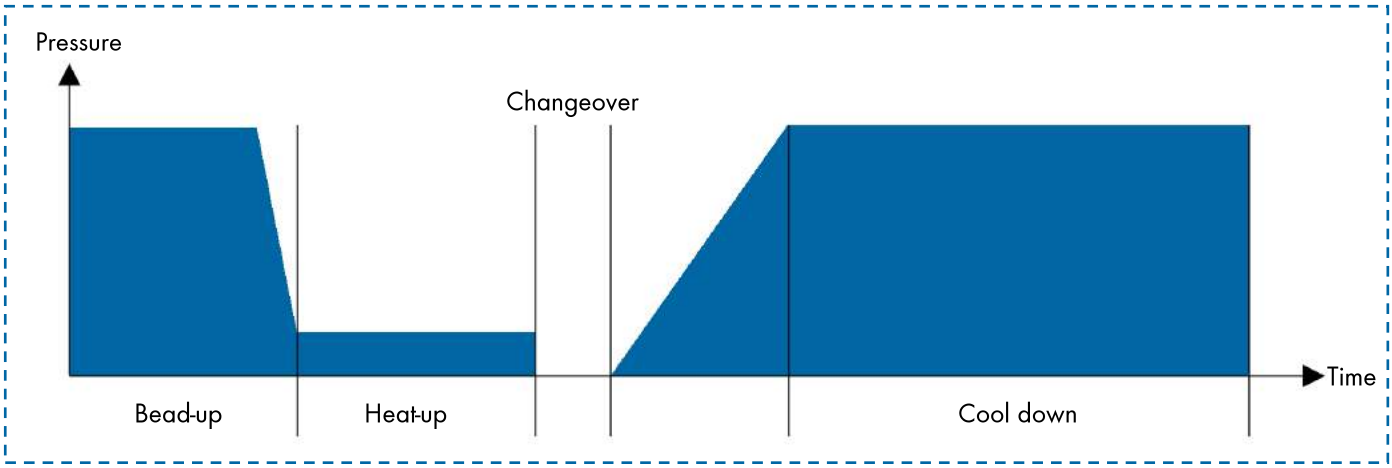
Rothenberger Roweld P 250 B

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.

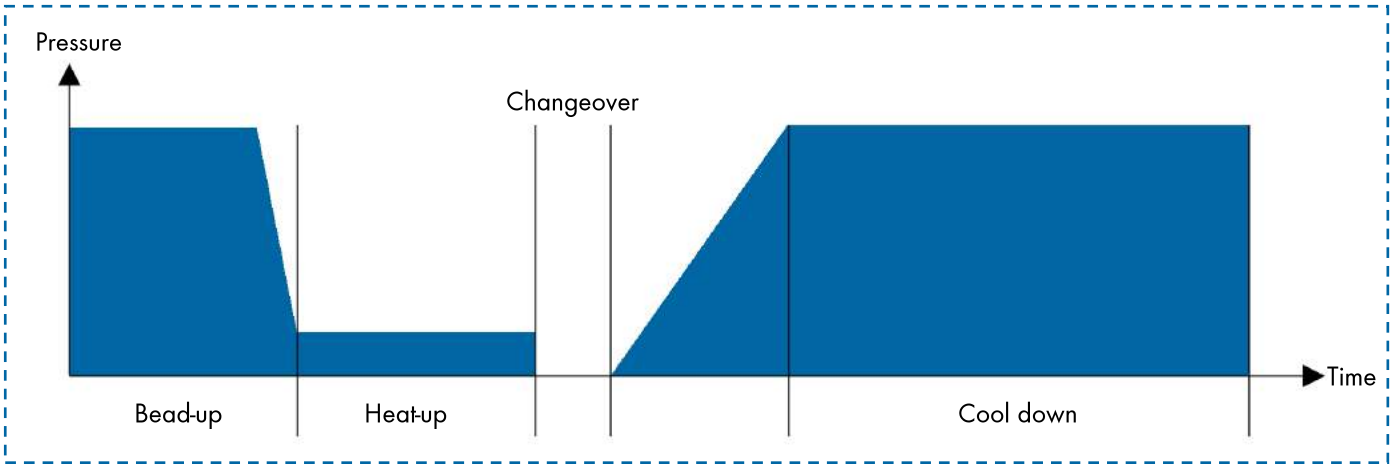
Rothenberger Roweld P 355 B

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.

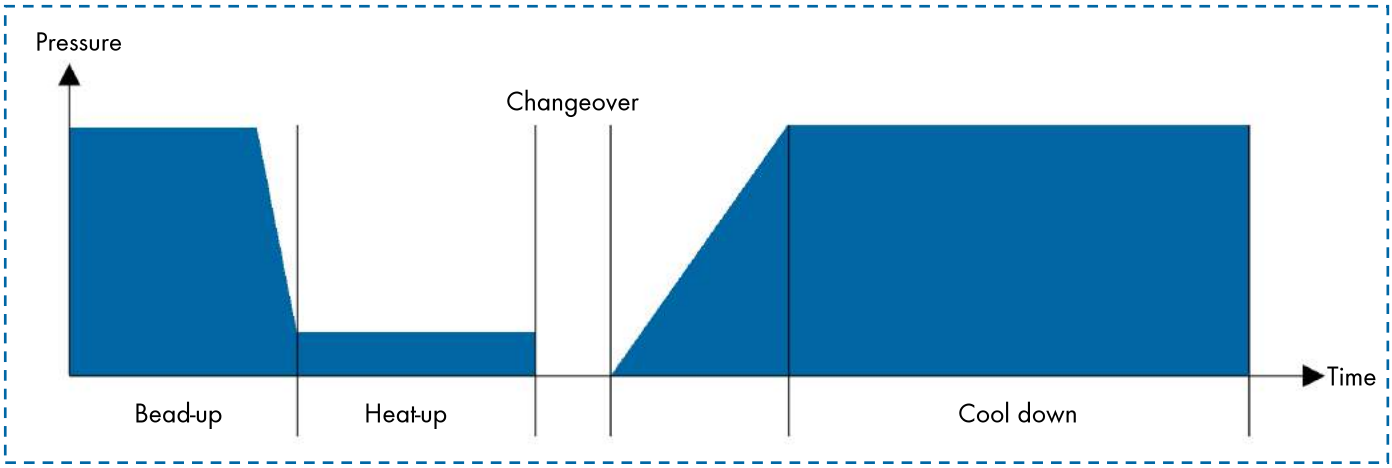
Rothenberger Roweld P 500 B

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.

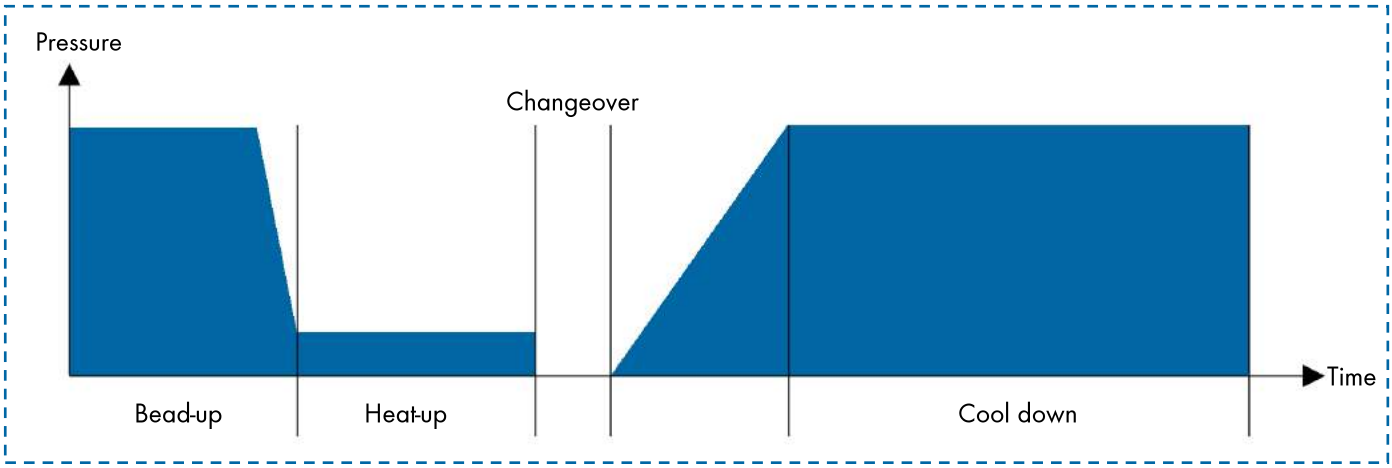
Rothenberger Roweld P 630 B

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.

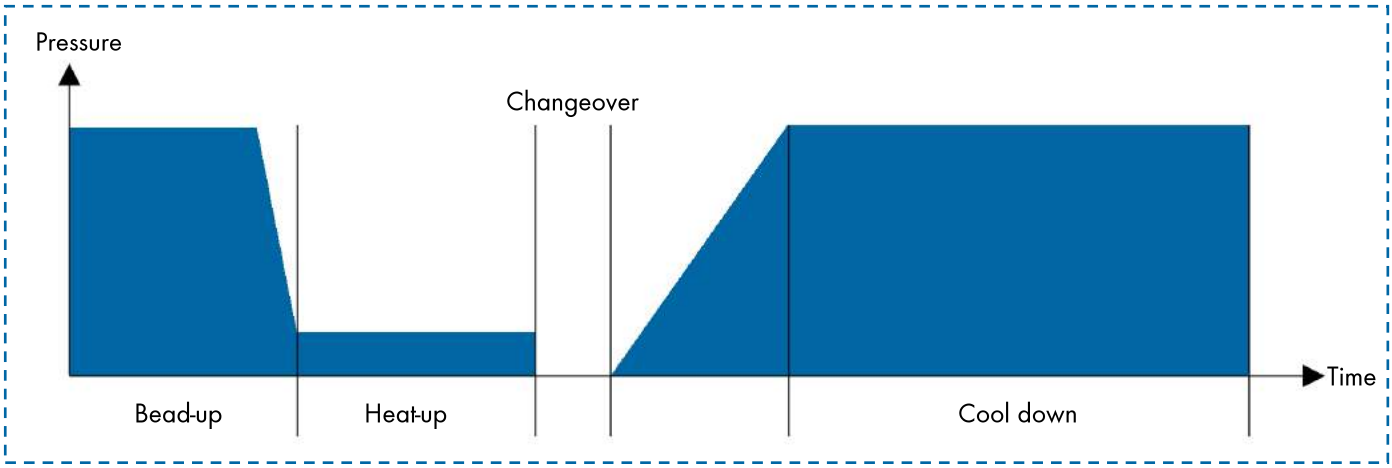
Rothenberger Roweld P 630 B plus

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.

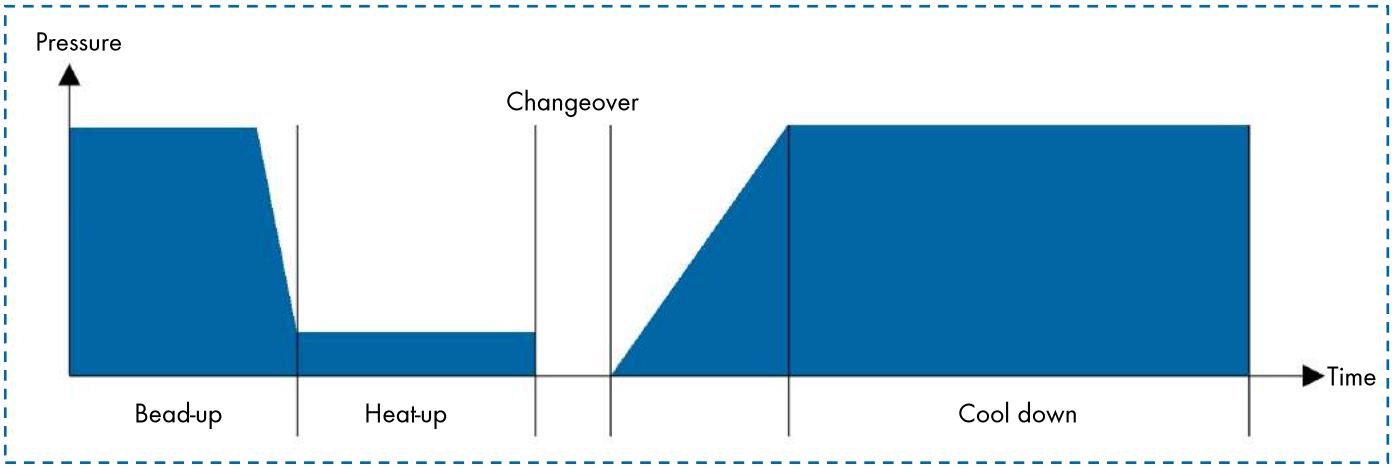
RITMO BASIC 250 (V0, V1)

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 = 589 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
90 mm	SDR 17.6	4.7 bar	1 mm	69 s	5 s	5 s	4.7 bar	9 min
	SDR 17	4.9 bar	1.5 mm	72 s	6 s	6 s	4.9 bar	10 min
	SDR 13.6	5.7 bar	1.5 mm	85 s	6 s	6 s	5.7 bar	11 min
	SDR 11	6.6 bar	1.5 mm	101 s	7 s	7 s	6.6 bar	13 min
	SDR 9	7.7 bar	2 mm	121 s	8 s	8 s	7.7 bar	16 min
	SDR 7.4	8.9 bar	2 mm	144 s	8 s	9 s	8.9 bar	18 min
110 mm	SDR 17.6	7.0 bar	1.5 mm	85 s	6 s	6 s	7.0 bar	11 min
	SDR 17	7.3 bar	1.5 mm	88 s	6 s	6 s	7.3 bar	12 min
	SDR 13.6	8.5 bar	1.5 mm	104 s	7 s	7 s	8.5 bar	14 min
	SDR 11	9.9 bar	2 mm	123 s	8 s	8 s	9.9 bar	16 min
	SDR 9	11.5 bar	2 mm	148 s	8 s	9 s	11.5 bar	19 min
	SDR 7.4	13.4 bar	2 mm	177 s	9 s	10 s	13.4 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 RITMO BASIC 250 (V0, V1)

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	8.8 bar	1.5 mm	93 s	6 s	6 s	8.8 bar	12 min
	SDR 17	9.0 bar	1.5 mm	96 s	7 s	7 s	9.0 bar	13 min
	SDR 13.6	10.6 bar	1.5 mm	115 s	7 s	7 s	10.6 bar	15 min
	SDR 11	12.5 bar	2 mm	138 s	8 s	8 s	12.5 bar	18 min
	SDR 9	14.6 bar	2 mm	166 s	9 s	9 s	14.6 bar	21 min
	SDR 7.4	17.0 bar	2.5 mm	198 s	10 s	11 s	17.0 bar	24 min
140 mm	SDR 17.6	10.8 bar	1.5 mm	103 s	7 s	7 s	10.8 bar	13 min
	SDR 17	11.1 bar	1.5 mm	106 s	7 s	7 s	11.1 bar	14 min
	SDR 13.6	13.1 bar	2 mm	127 s	8 s	8 s	13.1 bar	16 min
	SDR 11	15.4 bar	2 mm	152 s	8 s	9 s	15.4 bar	19 min
	SDR 9	18.1 bar	2 mm	183 s	9 s	10 s	18.1 bar	23 min
	SDR 7.4	21.1 bar	2.5 mm	220 s	10 s	12 s	21.1 bar	27 min
160 mm	SDR 17.6	14.3 bar	1.5 mm	119 s	7 s	7 s	14.3 bar	15 min
	SDR 17	14.8 bar	2 mm	123 s	8 s	8 s	14.8 bar	16 min
	SDR 13.6	17.4 bar	2 mm	147 s	8 s	9 s	17.4 bar	19 min
	SDR 11	20.5 bar	2 mm	177 s	9 s	10 s	20.5 bar	22 min
	SDR 9	23.9 bar	2.5 mm	211 s	10 s	11 s	23.9 bar	26 min
	SDR 7.4	27.8 bar	2.5 mm	253 s	11 s	13 s	27.8 bar	31 min
180 mm	SDR 17.6	18.6 bar	2 mm	137 s	8 s	8 s	18.6 bar	17 min
	SDR 17	19.2 bar	2 mm	142 s	8 s	8 s	19.2 bar	18 min
	SDR 13.6	22.6 bar	2 mm	170 s	9 s	10 s	22.6 bar	21 min
	SDR 11	26.4 bar	2.5 mm	202 s	10 s	11 s	26.4 bar	25 min
	SDR 9	30.7 bar	2.5 mm	241 s	11 s	13 s	30.7 bar	29 min
	SDR 7.4	35.7 bar	3 mm	288 s	13 s	15 s	35.7 bar	35 min
200 mm	SDR 17.6	22.5 bar	2 mm	150 s	8 s	9 s	22.5 bar	19 min
	SDR 17	23.2 bar	2 mm	155 s	8 s	9 s	23.2 bar	19 min
	SDR 13.6	27.2 bar	2 mm	184 s	9 s	10 s	27.2 bar	23 min
	SDR 11	32.0 bar	2.5 mm	221 s	10 s	12 s	32.0 bar	27 min
	SDR 9	37.5 bar	3 mm	265 s	12 s	14 s	37.5 bar	32 min
	SDR 7.4	43.6 bar	3 mm	318 s	14 s	16 s	43.6 bar	38 min
225 mm	SDR 17.6	27.7 bar	2 mm	164 s	9 s	9 s	27.7 bar	21 min
	SDR 17	28.7 bar	2 mm	171 s	9 s	10 s	28.7 bar	21 min
	SDR 13.6	33.8 bar	2.5 mm	204 s	10 s	11 s	33.8 bar	25 min
	SDR 11	39.9 bar	2.5 mm	245 s	11 s	13 s	39.9 bar	30 min
	SDR 9	46.8 bar	3 mm	295 s	13 s	15 s	46.8 bar	36 min
	SDR 7.4	54.4 bar	3 mm	353 s	15 s	18 s	54.4 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.

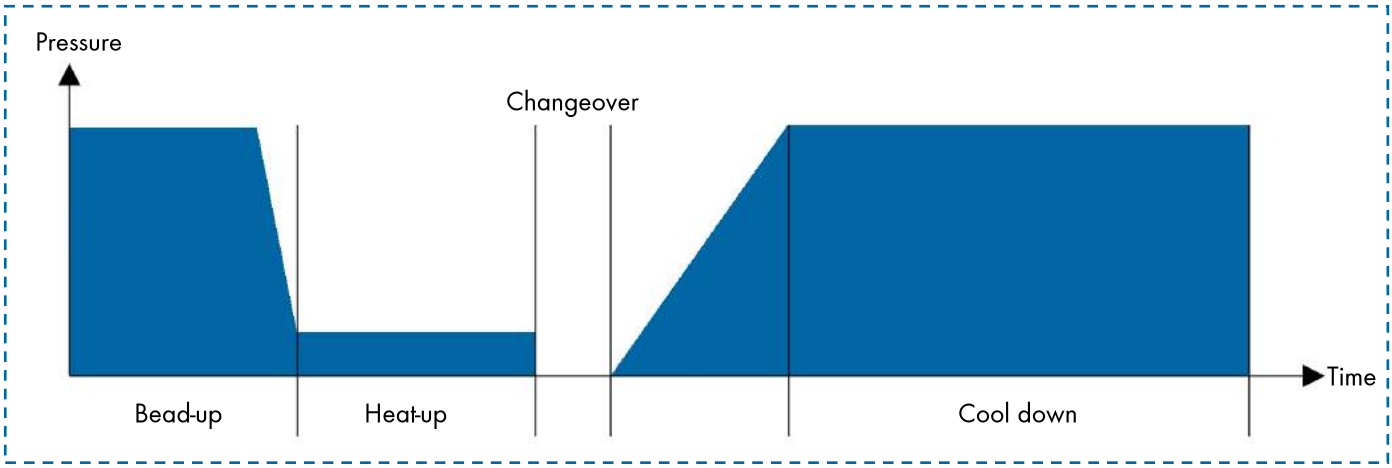
RITMO BASIC 315 (V0, V1)

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 = 668 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
OD 90 mm	SDR 17.6	4.1 bar	1 mm	69 s	5 s	5 s	4.1 bar	9 min
	SDR 17	4.3 bar	1.5 mm	72 s	6 s	6 s	4.3 bar	10 min
	SDR 13.6	5.0 bar	1.5 mm	85 s	6 s	6 s	5.0 bar	11 min
	SDR 11	5.9 bar	1.5 mm	101 s	7 s	7 s	5.9 bar	13 min
	SDR 9	6.8 bar	2 mm	121 s	8 s	8 s	6.8 bar	16 min
	SDR 7.4	7.9 bar	2 mm	144 s	8 s	9 s	7.9 bar	18 min
OD 110 mm	SDR 17.6	6.2 bar	1.5 mm	85 s	6 s	6 s	6.2 bar	11 min
	SDR 17	6.4 bar	1.5 mm	88 s	6 s	6 s	6.4 bar	12 min
	SDR 13.6	7.5 bar	1.5 mm	104 s	7 s	7 s	7.5 bar	14 min
	SDR 11	8.7 bar	2 mm	123 s	8 s	8 s	8.7 bar	16 min
	SDR 9	10.2 bar	2 mm	148 s	8 s	9 s	10.2 bar	19 min
	SDR 7.4	11.8 bar	2 mm	177 s	9 s	10 s	11.8 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 RITMO BASIC 315 (V0, V1)

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	7.7 bar	1.5 mm	93 s	6 s	6 s	7.7 bar	12 min
	SDR 17	8.0 bar	1.5 mm	96 s	7 s	7 s	8.0 bar	13 min
	SDR 13.6	9.4 bar	1.5 mm	115 s	7 s	7 s	9.4 bar	15 min
	SDR 11	11.0 bar	2 mm	138 s	8 s	8 s	11.0 bar	18 min
	SDR 9	12.9 bar	2 mm	166 s	9 s	9 s	12.9 bar	21 min
	SDR 7.4	15.0 bar	2.5 mm	198 s	10 s	11 s	15.0 bar	24 min
140 mm	SDR 17.6	9.5 bar	1.5 mm	103 s	7 s	7 s	9.5 bar	13 min
	SDR 17	9.8 bar	1.5 mm	106 s	7 s	7 s	9.8 bar	14 min
	SDR 13.6	11.5 bar	2 mm	127 s	8 s	8 s	11.5 bar	16 min
	SDR 11	13.6 bar	2 mm	152 s	8 s	9 s	13.6 bar	19 min
	SDR 9	16.0 bar	2 mm	183 s	9 s	10 s	16.0 bar	23 min
	SDR 7.4	18.6 bar	2.5 mm	220 s	10 s	12 s	18.6 bar	27 min
160 mm	SDR 17.6	12.7 bar	1.5 mm	119 s	7 s	7 s	12.7 bar	15 min
	SDR 17	13.0 bar	2 mm	123 s	8 s	8 s	13.0 bar	16 min
	SDR 13.6	15.3 bar	2 mm	147 s	8 s	9 s	15.3 bar	19 min
	SDR 11	18.0 bar	2 mm	177 s	9 s	10 s	18.0 bar	22 min
	SDR 9	21.1 bar	2.5 mm	211 s	10 s	11 s	21.1 bar	26 min
	SDR 7.4	24.5 bar	2.5 mm	253 s	11 s	13 s	24.5 bar	31 min
180 mm	SDR 17.6	16.4 bar	2 mm	137 s	8 s	8 s	16.4 bar	17 min
	SDR 17	17.0 bar	2 mm	142 s	8 s	8 s	17.0 bar	18 min
	SDR 13.6	19.9 bar	2 mm	170 s	9 s	10 s	19.9 bar	21 min
	SDR 11	23.3 bar	2.5 mm	202 s	10 s	11 s	23.3 bar	25 min
	SDR 9	27.1 bar	2.5 mm	241 s	11 s	13 s	27.1 bar	29 min
	SDR 7.4	31.5 bar	3 mm	288 s	13 s	15 s	31.5 bar	35 min
200 mm	SDR 17.6	19.9 bar	2 mm	150 s	8 s	9 s	19.9 bar	19 min
	SDR 17	20.5 bar	2 mm	155 s	8 s	9 s	20.5 bar	19 min
	SDR 13.6	24.0 bar	2 mm	184 s	9 s	10 s	24.0 bar	23 min
	SDR 11	28.2 bar	2.5 mm	221 s	10 s	12 s	28.2 bar	27 min
	SDR 9	33.0 bar	3 mm	265 s	12 s	14 s	33.0 bar	32 min
	SDR 7.4	38.4 bar	3 mm	318 s	14 s	16 s	38.4 bar	38 min
225 mm	SDR 17.6	24.5 bar	2 mm	164 s	9 s	9 s	24.5 bar	21 min
	SDR 17	25.4 bar	2 mm	171 s	9 s	10 s	25.4 bar	21 min
	SDR 13.6	29.9 bar	2.5 mm	204 s	10 s	11 s	29.9 bar	25 min
	SDR 11	35.1 bar	2.5 mm	245 s	11 s	13 s	35.1 bar	30 min
	SDR 9	41.2 bar	3 mm	295 s	13 s	15 s	41.2 bar	36 min
	SDR 7.4	48.0 bar	3 mm	353 s	15 s	18 s	48.0 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 RITMO BASIC 315 (V0, V1)

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	29.6 bar	2 mm	179 s	9 s	10 s	29.6 bar	22 min
	SDR 17	30.5 bar	2 mm	185 s	9 s	10 s	30.5 bar	23 min
	SDR 13.6	36.2 bar	2.5 mm	223 s	10 s	12 s	36.2 bar	27 min
	SDR 11	42.7 bar	3 mm	268 s	12 s	14 s	42.7 bar	32 min
	SDR 9	50.1 bar	3 mm	323 s	14 s	16 s	50.1 bar	39 min
	SDR 7.4	58.6 bar	3.5 mm	389 s	16 s	16 s	58.6 bar	47 min
280 mm	SDR 17.6	36.4 bar	2.5 mm	197 s	10 s	11 s	36.4 bar	24 min
	SDR 17	37.6 bar	2.5 mm	204 s	10 s	11 s	37.6 bar	25 min
	SDR 13.6	44.7 bar	2.5 mm	246 s	11 s	13 s	44.7 bar	30 min
	SDR 11	52.8 bar	3 mm	297 s	13 s	15 s	52.8 bar	36 min
	SDR 9	62.3 bar	3 mm	359 s	15 s	18 s	62.3 bar	43 min
	SDR 7.4	72.8 bar	3.5 mm	432 s	17 s	18 s	72.8 bar	52 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.

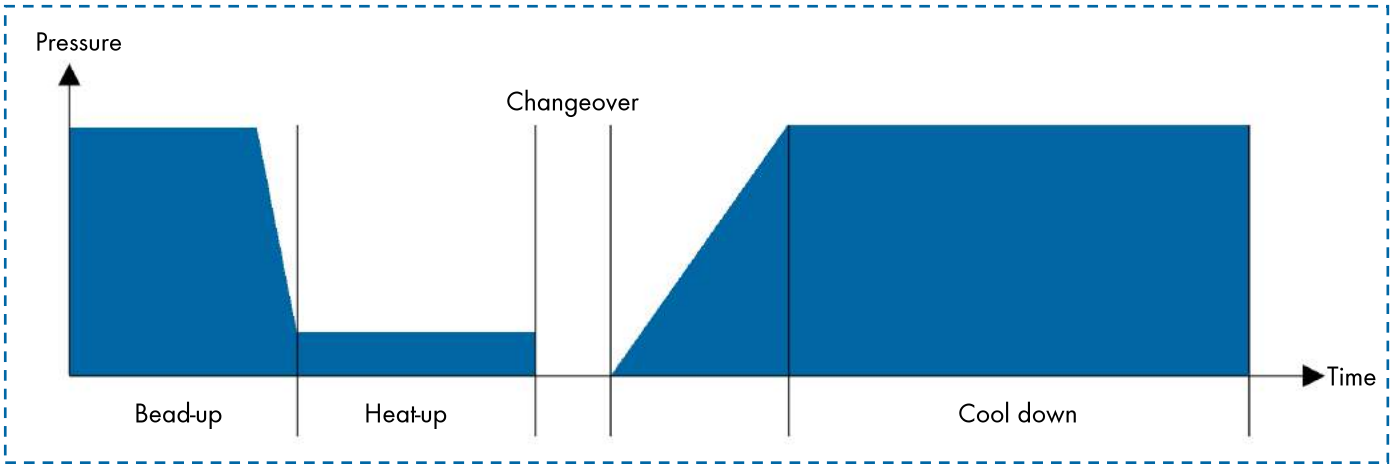
RITMO BASIC 355 (V0)

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 = 1413 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
125 mm	SDR 17.6	3.7 bar	1.5 mm	93 s	6 s	6 s	3.7 bar	12 min
	SDR 17	3.8 bar	1.5 mm	96 s	7 s	7 s	3.8 bar	13 min
	SDR 13.6	4.5 bar	1.5 mm	115 s	7 s	7 s	4.5 bar	15 min
	SDR 11	5.2 bar	2 mm	138 s	8 s	8 s	5.2 bar	18 min
	SDR 9	6.1 bar	2 mm	166 s	9 s	9 s	6.1 bar	21 min
	SDR 7.4	7.1 bar	2.5 mm	198 s	10 s	11 s	7.1 bar	24 min
140 mm	SDR 17.6	4.5 bar	1.5 mm	103 s	7 s	7 s	4.5 bar	13 min
	SDR 17	4.7 bar	1.5 mm	106 s	7 s	7 s	4.7 bar	14 min
	SDR 13.6	5.5 bar	2 mm	127 s	8 s	8 s	5.5 bar	16 min
	SDR 11	6.4 bar	2 mm	152 s	8 s	9 s	6.4 bar	19 min
	SDR 9	7.6 bar	2 mm	183 s	9 s	10 s	7.6 bar	23 min
	SDR 7.4	8.8 bar	2.5 mm	220 s	10 s	12 s	8.8 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.

Continuation RITMO BASIC 355 (V0)

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
160 mm	SDR 17.6	6.0 bar	1.5 mm	119 s	7 s	7 s	6.0 bar	15 min
	SDR 17	6.2 bar	2 mm	123 s	8 s	8 s	6.2 bar	16 min
	SDR 13.6	7.3 bar	2 mm	147 s	8 s	9 s	7.3 bar	19 min
	SDR 11	8.6 bar	2 mm	177 s	9 s	10 s	8.6 bar	22 min
	SDR 9	10.0 bar	2.5 mm	211 s	10 s	11 s	10.0 bar	26 min
	SDR 7.4	11.6 bar	2.5 mm	253 s	11 s	13 s	11.6 bar	31 min
180 mm	SDR 17.6	7.8 bar	2 mm	137 s	8 s	8 s	7.8 bar	17 min
	SDR 17	8.0 bar	2 mm	142 s	8 s	8 s	8.0 bar	18 min
	SDR 13.6	9.4 bar	2 mm	170 s	9 s	10 s	9.4 bar	21 min
	SDR 11	11.0 bar	2.5 mm	202 s	10 s	11 s	11.0 bar	25 min
	SDR 9	12.8 bar	2.5 mm	241 s	11 s	13 s	12.8 bar	29 min
	SDR 7.4	14.9 bar	3 mm	288 s	13 s	15 s	14.9 bar	35 min
200 mm	SDR 17.6	9.4 bar	2 mm	150 s	8 s	9 s	9.4 bar	19 min
	SDR 17	9.7 bar	2 mm	155 s	8 s	9 s	9.7 bar	19 min
	SDR 13.6	11.4 bar	2 mm	184 s	9 s	10 s	11.4 bar	23 min
	SDR 11	13.4 bar	2.5 mm	221 s	10 s	12 s	13.4 bar	27 min
	SDR 9	15.6 bar	3 mm	265 s	12 s	14 s	15.6 bar	32 min
	SDR 7.4	18.2 bar	3 mm	318 s	14 s	16 s	18.2 bar	38 min
225 mm	SDR 17.6	11.6 bar	2 mm	164 s	9 s	9 s	11.6 bar	21 min
	SDR 17	12.0 bar	2 mm	171 s	9 s	10 s	12.0 bar	21 min
	SDR 13.6	14.1 bar	2.5 mm	204 s	10 s	11 s	14.1 bar	25 min
	SDR 11	16.6 bar	2.5 mm	245 s	11 s	13 s	16.6 bar	30 min
	SDR 9	19.5 bar	3 mm	295 s	13 s	15 s	19.5 bar	36 min
	SDR 7.4	22.7 bar	3 mm	353 s	15 s	18 s	22.7 bar	42 min
250 mm	SDR 17.6	14.0 bar	2 mm	179 s	9 s	10 s	14.0 bar	22 min
	SDR 17	14.5 bar	2 mm	185 s	9 s	10 s	14.5 bar	23 min
	SDR 13.6	17.1 bar	2.5 mm	223 s	10 s	12 s	17.1 bar	27 min
	SDR 11	20.2 bar	3 mm	268 s	12 s	14 s	20.2 bar	32 min
	SDR 9	23.7 bar	3 mm	323 s	14 s	16 s	23.7 bar	39 min
	SDR 7.4	27.7 bar	3.5 mm	389 s	16 s	16 s	27.7 bar	47 min
280 mm	SDR 17.6	17.2 bar	2.5 mm	197 s	10 s	11 s	17.2 bar	24 min
	SDR 17	17.8 bar	2.5 mm	204 s	10 s	11 s	17.8 bar	25 min
	SDR 13.6	21.1 bar	2.5 mm	246 s	11 s	13 s	21.1 bar	30 min
	SDR 11	25.0 bar	3 mm	297 s	13 s	15 s	25.0 bar	36 min
	SDR 9	29.5 bar	3 mm	359 s	15 s	18 s	29.5 bar	43 min
	SDR 7.4	34.5 bar	3.5 mm	432 s	17 s	18 s	34.5 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.

Continuation RITMO BASIC 315 (V0)

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	21.7 bar	2.5 mm	221 s	10 s	12 s	21.7 bar	27 min
	SDR 17	22.5 bar	2.5 mm	229 s	11 s	12 s	22.5 bar	28 min
	SDR 13.6	26.7 bar	3 mm	277 s	12 s	14 s	26.7 bar	33 min
	SDR 11	31.5 bar	3 mm	333 s	14 s	17 s	31.5 bar	40 min
	SDR 9	37.2 bar	3.5 mm	403 s	17 s	17 s	37.2 bar	48 min
	SDR 7.4	43.5 bar	3.5 mm	486 s	19 s	21 s	43.5 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.

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