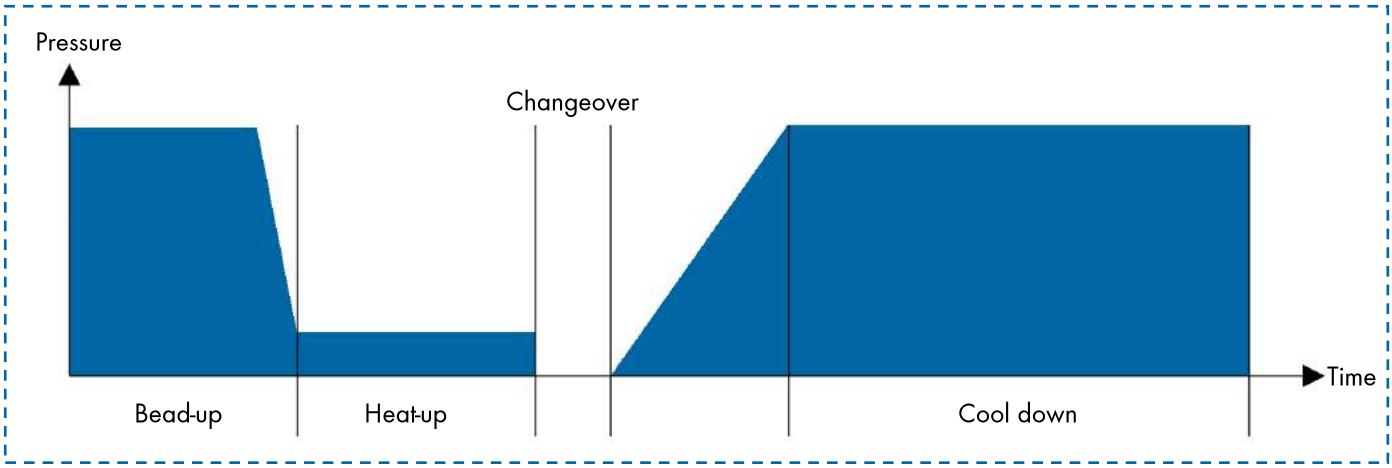
RITMO BASIC 250 (V0, V1)

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.

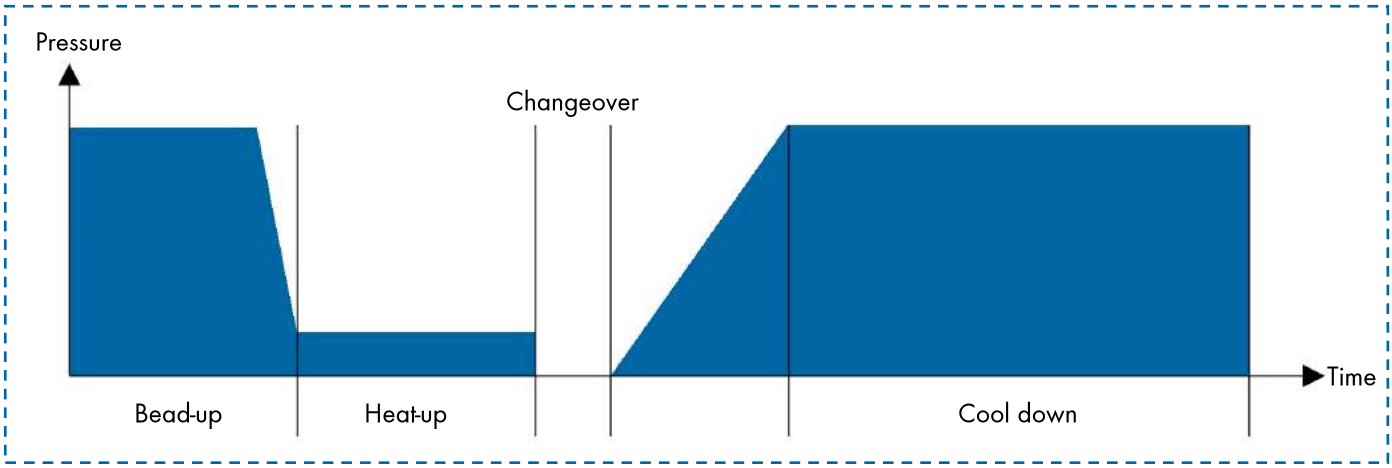
RITMO BASIC 315 (V0, V1)

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.

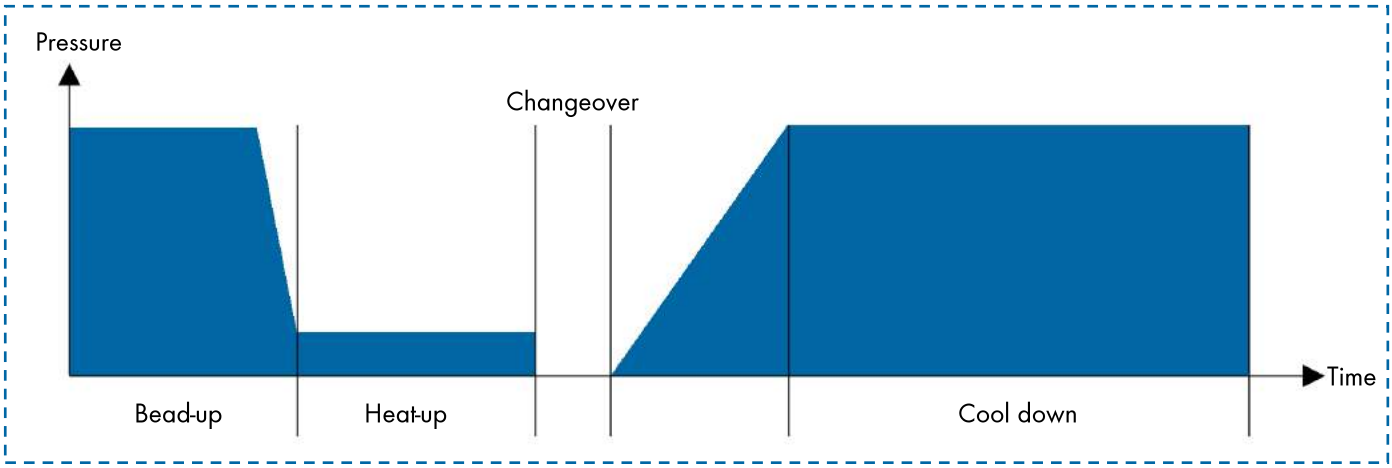
RITMO BASIC 355 (V0)

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.