

WELDING PARAMETERS

BUTT FUSION WELDING MACHINE PE80/PE100 DVS 2207-1						Bead Build Up		Heating		Change Over	Welding and Cooling		
OD	Thickness	SDR	Align Offset	Temp. °C	Temp. °C	P1	Bead	P2	T2	T3	T4	P5	T5
mm	mm		mm	(PE80)	(PE100)	Bar	mm	Bar	Sec.	Sec.	Sec.	Bar	Min.
63	5.7	11	0.5	220	220	2.47	1	0.33	57	6	6	2.47	9
63	3.6	17.6	0.5	220	220	1.6	0.5	0.21	36	5	5	1.60	7
63	4.6	13.6	0.5	220	220	2.03	1	0.27	46	5	6	2.03	8
63	3.7	17	0.5	220	220	1.65	0.5	0.22	37	5	5	1.65	7
63	3.0	21	0.5	220	220	1.35	0.5	0.18	30	5	5	1.35	6
63	2.4	26	0.5	220	220	1.10	0.5	0.15	19	5	5	1.10	5
63	1.9	33	0.5	220	220	0.88	0.5	0.88	19	5	5	0.88	5
75	6.8	11	0.5	220	220	3.50	1	0.47	68	6	7	3.5	10
75	4.3	17.6	0.5	220	220	2.27	0.5	0.30	43	5	6	2.27	7
75	5.5	13.6	0.5	220	220	2.88	1	0.38	55	5	6	2.88	9
75	4.4	17	0.5	220	220	2.34	0.5	0.31	44	5	6	2.34	7
75	3.6	21	0.5	220	220	1.92	0.5	0.26	36	5	5	1.92	7
75	2.9	26	0.5	220	220	1.57	0.5	0.21	29	5	5	1.57	6
75	2.3	33	0.5	220	220	1.24	0.5	1.24	23	5	5	1.24	5
90	3.46	26	0.5	220	220	0.7	0.5	0	45	5	5	0.7	6

90	4.29	21	0.5	220	220	0.9	0.5	0.1	45	5	5	0.9	6
90	5.11	17.6	0.5	220	220	1	1	0.1	51	5	5	1	7
90	5.29	17	0.5	220	220	1.1	1	0.1	53	5	5	1.1	7
90	6.62	13.6	0.5	220	220	1.3	1	0.1	66	6	6	1.3	9
90	8.18	11	0.5	220	220	1.6	1.5	0.1	82	6	6	1.6	11
90	10	9	0.5	220	220	1.9	1.5	0.1	100	7	7	1.9	14
90	12.16	7.4	0.5	220	220	2.2	2	0.1	122	8	8	2.2	16
110	4.23	26	0.5	220	220	1.1	0.5	0.1	45	5	5	1.1	6
110	5.24	21	0.5	220	220	1.3	1	0.1	52	5	5	1.3	7
110	6.25	17.6	0.5	220	220	1.5	1	0.1	63	6	6	1.5	9
110	6.47	17	0.5	220	220	1.6	1	0.1	65	6	6	1.6	9
110	8.09	13.6	0.5	220	220	1.9	1.5	0.1	81	6	6	1.9	11
110	10	11	0.5	220	220	2.4	1.5	0.2	100	7	7	2.4	14
110	12.22	9	0.5	220	220	2.8	2	0.2	122	8	8	2.8	16
110	14.86	7.4	0.5	220	220	3.3	2	0.2	149	9	9	3.3	19
125	4.81	26	0.5	220	220	1.4	1	0.1	48	5	5	1.4	6
125	5.95	21	0.5	220	220	1.7	1	0.1	60	6	6	1.7	8
125	7.1	17.6	0.5	220	220	2	1.5	0.1	71	6	6	2	10
125	7.35	17	0.5	220	220	2	1.5	0.1	74	6	6	2	10
125	9.19	13.6	0.5	220	220	2.5	1.5	0.2	92	7	7	2.5	13

125	11.36	11	0.5	220	220	3	1.5	0.2	114	8	8	3	15
125	13.89	9	0.5	220	220	3.6	2	0.2	139	9	9	3.6	18
125	16.89	7.4	0.5	220	220	4.3	2	0.3	169	9	10	4.3	22
140	5.38	26	0.5	220	220	1.7	1	0.1	54	5	5	1.7	7
140	6.67	21	0.5	220	220	2.1	1	0.1	67	6	6	2.1	9
140	7.95	17.6	0.5	220	220	2.5	1.5	0.2	80	6	6	2.5	11
140	8.24	17	0.5	220	220	2.6	1.5	0.2	82	6	6	2.6	11
140	10.29	13.6	0.5	220	220	3.1	1.5	0.2	103	7	7	3.1	14
140	12.73	11	0.5	220	220	3.8	2	0.3	127	8	8	3.8	17
140	15.56	9	0.5	220	220	4.6	2	0.3	156	9	10	4.6	20
140	18.92	7.4	0.5	220	220	5.4	2	0.4	189	10	11	5.4	24
160	6.15	26	0.5	220	220	2.2	1	0.1	62	6	6	2.2	9
160	7.62	21	0.5	220	220	2.7	1.5	0.2	76	6	6	2.7	11
160	9.09	17.6	0.5	220	220	3.2	1.5	0.2	91	7	7	3.2	13
160	9.41	17	0.5	220	220	3.3	1.5	0.2	94	7	7	3.3	13
160	11.76	13.6	0.5	220	220	4.1	1.5	0.3	118	8	8	4.1	16
160	14.55	11	0.5	220	220	5	2	0.3	146	9	9	5	19
160	17.78	9	0.5	220	220	6	2	0.4	178	10	10	6	23
160	21.62	7.4	0.5	220	220	7	2.5	0.5	216	11	12	7	27
180	6.92	26	0.5	220	220	2.8	1	0.2	69	6	6	2.8	10

180	8.57	21	0.5	220	220	3.5	1.5	0.2	86	7	7	3.5	12
180	10.23	17.6	0.5	220	220	4.1	1.5	0.3	102	7	7	4.1	14
180	10.59	17	0.5	220	220	4.2	1.5	0.3	106	7	7	4.2	14
180	13.24	13.6	0.5	220	220	5.2	2	0.3	132	8	9	5.2	17
180	16.36	11	0.5	220	220	6.3	2	0.4	164	9	10	6.3	21
180	20	9	0.5	220	220	7.5	2.5	0.5	200	10	11	7.5	25
180	24.32	7.4	0.5	220	220	8.9	2.5	0.6	243	12	13	8.9	30
200	7.69	26	0.5	220	220	3.5	1.5	0.2	77	6	6	3.5	11
200	9.52	21	0.5	220	220	4.3	1.5	0.3	95	7	7	4.3	13
200	11.36	17.6	0.5	220	220	5	1.5	0.3	114	8	8	5	15
200	11.76	17	0.5	220	220	5.2	1.5	0.3	118	8	8	5.2	16
200	14.71	13.6	0.5	220	220	6.4	2	0.4	147	9	9	6.4	19
200	18.18	11	0.5	220	220	7.8	2	0.5	182	10	11	7.8	23
200	22.22	9	0.5	220	220	9.3	2.5	0.6	222	11	12	9.3	28
200	27.03	7.4	0.5	220	220	11	3	0.7	270	12	14	11	33
225	8.65	26	0.5	220	220	4.4	1.5	0.3	87	7	7	4.4	12
225	10.71	21	0.5	220	220	5.4	1.5	0.4	107	7	7	5.4	14
225	12.78	17.6	0.5	220	220	6.4	2	0.4	128	8	8	6.4	17
225	13.24	17	0.5	220	220	6.6	2	0.4	132	8	9	6.6	17
225	16.54	13.6	0.5	220	220	8.1	2	0.5	165	9	10	8.1	21

225	20.45	11	0.5	220	220	9.8	2.5	0.7	205	10	12	9.8	26
225	25	9	0.5	220	220	11.8	2.5	0.8	250	12	14	11.8	31
225	30.41	7.4	0.5	220	220	13.9	3	0.9	304	14	16	13.9	37
250	9.62	26	0.5	220	220	5.4	1.5	0.4	96	7	7	5.4	13
250	11.9	21	0.5	220	220	6.7	1.5	0.4	119	8	8	6.7	16
250	14.2	17.6	0.5	220	220	7.9	2	0.5	142	9	9	7.9	19
250	14.71	17	0.5	220	220	8.1	2	0.5	147	9	9	8.1	19
250	18.38	13.6	0.5	220	220	10	2	0.7	184	10	11	10	23
250	22.73	11	0.5	220	220	12.2	2.5	0.8	227	11	13	12.2	28
250	27.78	9	0.5	220	220	14.5	3	1	278	13	15	14.5	34
250	33.78	7.4	0.5	220	220	17.2	3	1.1	338	15	18	17.2	41
280	10.77	26	0.5	220	220	6.8	1.5	0.5	108	8	8	6.8	15
280	13.33	21	0.5	220	220	8.4	2	0.6	133	8	9	8.4	18
280	15.91	17.6	0.5	220	220	9.9	2	0.7	159	9	10	9.9	20
280	16.47	17	0.5	220	220	10.2	2	0.7	165	9	10	10.2	21
280	20.59	13.6	0.5	220	220	12.6	2.5	0.8	206	10	12	12.6	26
280	25.45	11	0.5	220	220	15.2	2.5	1	255	12	14	15.2	31
280	31.11	9	0.5	220	220	18.2	3	1.2	311	14	16	18.2	38
280	37.84	7.4	0.5	220	220	21.6	3.5	1.4	378	16	19	21.6	46
315	12.12	26	0.5	220	220	8.6	2	0.6	121	8	8	8.6	16

315	15	21	0.5	220	220	10.6	2	0.7	150	9	9	10.6	19
315	17.9	17.6	0.5	220	220	12.5	2	0.8	179	10	11	12.5	23
315	18.53	17	0.5	220	220	12.9	2	0.9	185	10	11	12.9	23
315	23.16	13.6	0.5	220	220	15.9	2.5	1.1	232	11	13	15.9	29
315	28.64	11	0.5	220	220	19.3	3	1.3	286	13	15	19.3	35
315	35	9	0.5	220	220	23.1	3	1.5	350	15	18	23.1	43
315	42.57	7.4	0.5	220	220	27.3	3.5	1.8	426	18	22	27.3	51
355	13.6	26	0.5	220	220	10.9	2.0	0.7	136	10	10	10.9	16
355	16.9	21	0.5	220	220	13.4	2.0	0.9	169	10	10	13.4	18
355	20.17	17.6	0.5	220	220	15.9	2.5	1.1	202	12	12	15.9	24
355	20.9	17	0.5	220	220	16.4	2.5	1.1	209	12	12	16.4	24
355	26	13.6	0.5	220	220	20.1	2.5	1.3	260	12	14	20.1	32
355	32.2	11	0.5	220	220	24.5	3.0	1.6	322	16	16	24.5	36
355	39.4	9	0.5	220	220	29.3	3.5	2.0	394	18	20	29.3	45
355	48	7.4	0.5	220	220	34.7	3.5	2.3	480	20	24	34.7	52
400	15.38	26	0.5	220	220	12.4	2.0	0.8	154	10	10	12.4	18
400	19.00	21	0.5	220	220	15.2	2.0	1.0	190	10	11	15.2	24
400	22.70	17.6	0.5	220	220	18.0	2.5	1.2	227	12	13	18.0	26
400	23.50	17	0.5	220	220	18.6	2.5	1.2	235	12	13	18.6	26
400	29.40	13.6	0.5	220	220	22.9	3.0	1.5	294	14	16	22.9	32

400	36.36	11	0.5	220	220	27.8	3.0	1.9	364	16	19	27.8	45
400	44.40	9	0.5	220	220	33.2	3.5	2.2	444	18	22	33.2	50
400	54.05	7.4	0.5	220	220	39.4	4.0	2.6	541	20	26	39.4	60
450	17.3	26	0.5	220	220	15.8	2.0	1.1	173	10	11	15.8	18
450	21.4	21	0.5	220	220	19.3	2.5	1.3	214	10	13	19.3	26
450	25.56	17.6	0.5	220	220	22.8	2.5	1.5	256	12	14	22.8	32
450	26.47	17	0.5	220	220	23.6	3.0	1.6	265	14	14	23.6	32
450	33.08	13.6	0.5	220	220	29.0	3.5	1.9	331	16	16	29.0	36
450	40.9	11	0.5	220	220	35.2	3.5	2.3	409	18	20	35.2	45
450	50	9	0.5	220	220	42.1	4.0	2.8	500	20	25	42.1	61
450	60.8	7.4	0.5	220	220	49.8	4.0	3.3	608	22	28	49.8	70
500	19.2	26	0.5	220	220	19.4	2.0	1.3	192	10	11	19.4	24
500	23.8	21	0.5	220	220	23.9	2.5	1.6	238	10	13	23.9	28
500	28.4	17.6	0.5	220	220	28.2	3.0	1.9	284	12	14	28.2	34
500	29.4	17	0.5	220	220	29.1	3.0	1.9	294	14	14	29.1	34
500	36.7	13.6	0.5	220	220	35.8	3.5	2.4	367	16	16	35.8	38
500	45.5	11	0.5	220	220	43.5	3.5	2.9	455	18	20	43.5	45
500	55.5	9	0.5	220	220	51.9	4.0	3.5	555	22	25	51.9	61
560	21.5	26	0.5	220	220	20.1	2.5	1.3	215	10	12	20.1	26
560	26.7	21	0.5	220	220	24.7	2.5	1.6	267	12	13	24.7	32

560	31.8	17.6	0.5	220	220	29.2	3.0	1.9	318	14	14	29.2	36
560	33	17	0.5	220	220	30.2	3.0	2.0	330	14	14	30.2	36
560	41.2	13.6	0.5	220	220	37.1	3.5	2.5	412	18	16	37.1	45
560	51	11	0.5	220	220	45.1	4.0	3.0	510	20	20	45.1	60
560	62	9	0.5	220	220	53.7	4.0	3.6	620	24	25	53.7	70
630	21.5	26	0.5	220	220	22.7	2.5	1.5	215	10	12	22.7	26
630	26.7	21	0.5	220	220	28.0	2.5	1.9	267	12	13	28.0	32
630	31.8	17.6	0.5	220	220	33.1	3.0	2.2	318	14	14	33.1	36
630	33	17	0.5	220	220	34.2	3.0	2.3	330	14	14	34.2	36
630	41.2	13.6	0.5	220	220	42.2	3.5	2.8	412	18	16	42.2	45
630	51	11	0.5	220	220	51.3	4.0	3.4	510	20	20	51.3	60
630	62	9	0.5	220	220	61.2	4.0	4.1	620	24	25	61.2	70
710	21.5	33	0.5	220	220	15.2	2.5	1.0	215	12	12	15.2	32
710	27.3	26	0.5	220	220	19.1	3.0	1.3	273	14	14	19.1	45
710	33.8	21	0.5	220	220	23.4	3.0	1.6	338	16	16	23.4	45
710	41.8	17	0.5	220	220	28.6	3.5	1.9	418	20	20	28.6	60
710	52.2	13.6	0.5	220	220	35.2	4.0	2.3	522	25	25	35.2	80
710	64.5	11	0.5	220	220	42.7	4.0	2.8	645	25	25	42.7	80
800	24.2	33	0.5	220	220	19.3	2.5	1.3	242	12	12	19.3	32
800	30.8	26	0.5	220	220	24.3	3.0	1.6	308	16	16	24.3	45

800	38.1	21	0.5	220	220	29.8	3.5	2.0	381	20	20	29.8	60
800	47.1	17	0.5	220	220	36.3	3.5	2.4	471	20	20	36.3	60
800	58.8	13.6	0.5	220	220	44.7	4.0	3.0	588	25	25	44.7	80
800	72.7	11	0.5	220	220	54.2	4.5	3.6	727	30	30	54.2	100
900	27.3	33	0.5	220	220	24.4	3.0	1.6	273	16	16	24.4	45
900	34.6	26	0.5	220	220	30.7	3.0	2.0	346	16	16	30.7	45
900	42.9	21	0.5	220	220	37.7	3.5	2.5	429	20	20	37.7	60
900	52.9	17	0.5	220	220	46.0	4.0	3.1	529	25	25	46.0	80
900	66.2	13.6	0.5	220	220	56.6	4.0	3.8	662	25	25	56.6	80
900	81.8	11	0.5	220	220	68.6	4.5	4.6	818	30	30	68.6	100
1000	30.3	33	0.5	220	220	30.1	3.0	2.0	303	16	16	30.1	45
1000	38.5	26	0.5	220	220	37.9	3.5	2.5	385	20	20	37.9	60
1000	47.6	21	0.5	220	220	46.5	3.5	3.1	476	20	20	46.5	60
1000	58.8	17	0.5	220	220	56.8	4.0	3.8	588	25	25	56.8	80
1000	73.5	13.6	0.5	220	220	69.8	4.5	4.7	735	30	30	69.8	100
1000	90.9	11	0.5	220	220	84.7	5.0	5.6	909	35	35	84.7	120
1100	33.3	33	0.5	220	220	36.5	3.0	2.4	333	16	16	36.5	45
1100	42.3	26	0.5	220	220	45.9	3.5	3.1	423	20	20	45.9	60
1200	36.4	33	0.5	220	220	43.4	3.0	2.9	364	16	16	43.4	45
1200	46.2	26	0.5	220	220	54.6	3.5	3.6	462	20	20	54.6	60