

## WELDING PARAMETERS

Cylinder 100.48 cm <sup>2</sup>			WP1600A BUTT FUSION WELDING MACHINE 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.
1000	30.3	33	0.5	220	220	13.8	3.0	0.9	303	16	16	13.8	45
1000	38.5	26	0.5	220	220	17.3	3.5	1.2	385	20	20	17.3	60
1000	47.6	21	0.5	220	220	21.3	3.5	1.4	476	20	20	21.3	60
1000	58.8	17	1.0	220	220	26.0	4.0	1.7	588	25	25	26.0	80
1000	73.5	13.6	1.0	220	220	31.9	4.5	2.1	735	30	30	31.9	100
1200	36.4	33	0.5	220	220	19.8	3.0	1.3	364	16	16	19.8	45
1200	46.2	26	0.5	220	220	25.0	3.5	1.7	462	20	20	25.0	60
1400	42.4	33	0.5	220	220	27.0	3.5	1.8	424	18	20	27.0	50
1400	53.8	26	1.0	220	220	34.0	4.0	2.3	538	20	25	34.0	55
1600	48.5	33	0.5	220	220	35.3	4.0	2.4	485	20	25	35.3	55

[www.Rotengaran.ir](http://www.Rotengaran.ir)

1600	61.5	26	1.0	220	220	44.4	4.0	3.0	615	22	30	44.4	60
------	------	----	-----	-----	-----	------	-----	-----	-----	----	----	------	----