

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
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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

BUTT FUSION WELDING MACHINE PE80/PE100 DVS 2207-1						Bead Build Up		Heating		Change Over	Welding and Cooling		
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
BUTT FUSION WELDING MACHINE PE80/PE100 DVS 2207-1						Bead Build Up	Heating		Change Over	Welding and Cooling			
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
BUTT FUSION WELDING MACHINE PE80/PE100 DVS 2207-1						Bead Build Up		Heating		Change Over	Welding and Cooling		
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
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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

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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