

Productivity Package Welding Parameters

CURRENT AS OF
09/05/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Air-Pro® (PE)	10" (250mm) SDR11	296	2.5 mm	Almost Zero	227 seconds	11 seconds	296	21.2 min
Air-Pro® (PE)	12" (315mm) SDR11	466	3 mm	Almost Zero	286 seconds	13 seconds	466	26.4 min
Asahitec™ Solid Wall (PP-RCT)	10" (250mm) SDR11	198	1.5 mm	Almost Zero	240 seconds	10 seconds	198	21.2 min
Asahitec™ Solid Wall (PP-RCT)	12" (315mm) SDR11	311	2 mm	Almost Zero	293 seconds	12 seconds	311	26.4 min
Asahitec™ Solid Wall (PP-RCT)	14" (355mm) SDR11	393	2 mm	Almost Zero	322 seconds	13 seconds	393	29.6 min
Asahitec™ Solid Wall (PP-RCT)	16" (400mm) SDR11	500	2 mm	Almost Zero	356 seconds	14 seconds	500	33.4 min
Asahitec™ Solid Wall (PP-RCT)	18" (450mm) SDR11	645	2.5 mm	Almost Zero	388 seconds	15 seconds	645	37.6 min
Asahitec™ Solid Wall (PP-RCT)	20" (500mm) SDR11	790	2.5 mm	Almost Zero	420 seconds	16 seconds	790	41.9 min
Chem Proline® (PE)	10" (250mm) SDR11	134	2.5 mm	Almost Zero	227 seconds	11 seconds	775	21.2 min
Chem Proline® (PE)	12" (315mm) SDR11	212	3 mm	Almost Zero	286 seconds	13 seconds	1218	26.4 min
Climatec™ (PP-RCT)	10" (250mm) SDR17	351	1 mm	Almost Zero	163 seconds	8 seconds	351	14.4 min
Climatec™ (PP-RCT)	12" (315mm) SDR17	554	1 mm	Almost Zero	203 seconds	9 seconds	554	17.8 min
Climatec™ (PP-RCT)	14" (355mm) SDR17	264	1.5 mm	Almost Zero	225 seconds	10 seconds	264	19.8 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

The weldment must cool for a minimum time of 60 seconds under full force before it may be set aside to finish cooling for the complete time according to the Cooling Time column. The removed piece should be handled carefully and set down with minimal strain on the weld for the remainder of the cooling time.

Productivity Package Welding Parameters

CURRENT AS OF
09/05/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Climatec™ (PP-RCT)	16" (400mm) SDR17	335	1.5 mm	Almost Zero	250 seconds	10 seconds	335	22.0 min
Climatec™ (PP-RCT)	18" (450mm) SDR17	442	2 mm	Almost Zero	277 seconds	11 seconds	442	24.6 min
Climatec™ (PP-RCT)	20" (500mm) SDR17	544	2 mm	Almost Zero	302 seconds	12 seconds	544	27.4 min
Proline® PRO150 (PP)	10" (250mm) SDR11	198	1.5 mm	Almost Zero	240 seconds	10 seconds	198	21.2 min
Proline® PRO150 (PP)	12" (315mm) SDR11	311	2 mm	Almost Zero	293 seconds	12 seconds	311	26.4 min
Proline® PRO150 (PP)	14" (355mm) SDR11	393	2 mm	Almost Zero	322 seconds	13 seconds	393	29.6 min
Proline® PRO150 (PP)	16" (400mm) SDR11	500	2 mm	Almost Zero	356 seconds	14 seconds	500	33.4 min
Proline® PRO150 (PP)	18" (450mm) SDR11	645	2.5 mm	Almost Zero	388 seconds	15 seconds	645	37.6 min
Proline® PRO150 (PP)	20" (500mm) SDR11	790	3 mm	Almost Zero	420 seconds	16 seconds	790	41.9 min
Proline® PRO150 (PP)	22" (560mm) SDR11	998	3 mm	Almost Zero	455 seconds	17 seconds	998	46.9 min
Proline® PRO150 (PP)	24" (630mm) SDR11	1247	3 mm	Almost Zero	485 seconds	19 seconds	1247	52.6 min
Proline® PRO90 (PP)	10" (250mm) SDR17	127	1 mm	Almost Zero	157 seconds	8 seconds	127	13.5 min
Proline® PRO90 (PP)	12" (315mm) SDR17.6	205	1 mm	Almost Zero	195 seconds	9 seconds	205	17 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

The weldment must cool for a minimum time of 60 seconds under full force before it may be set aside to finish cooling for the complete time according to the Cooling Time column. The removed piece should be handled carefully and set down with minimal strain on the weld for the remainder of the cooling time.

Productivity Package Welding Parameters

CURRENT AS OF
09/05/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Proline® PRO90 (PP)	14" (355mm) SDR17.6	255	1.5 mm	Almost Zero	201 seconds	10 seconds	255	18.6 min
Proline® PRO90 (PP)	16" (400mm) SDR17.6	340	1.5 mm	Almost Zero	240 seconds	10 seconds	340	21.1 min
Proline® PRO90 (PP)	18" (450mm) SDR17.6	340	1.5 mm	Almost Zero	266 seconds	11 seconds	340	23.3 min
Proline® PRO90 (PP)	20" (500mm) SDR17.6	425	2 mm	Almost Zero	291 seconds	12 seconds	425	26.1 min
Proline® PRO90 (PP)	22" (560mm) SDR17.6	527	2 mm	Almost Zero	318 seconds	13 seconds	527	29.1 min
Proline® PRO90 (PP)	24" (630mm) SDR17.6	662	2 mm	Almost Zero	351 seconds	13 seconds	662	32.5 min
Proline® PRO45 (PP)	10" (250mm) SDR33	71	1 mm	Almost Zero	89 seconds	6 seconds	71	8.1 min
Proline® PRO45 (PP)	12" (315mm) SDR33	113	1 mm	Almost Zero	110 seconds	7 seconds	113	9.9 min
Proline® PRO45 (PP)	14" (355mm) SDR33	153	1 mm	Almost Zero	123 seconds	7 seconds	153	11.0 min
Proline® PRO45 (PP)	16" (400mm) SDR33	187	1 mm	Almost Zero	138 seconds	7 seconds	187	12.3 min
Proline® PRO45 (PP)	18" (450mm) SDR33	238	1 mm	Almost Zero	153 seconds	8 seconds	238	13.6 min
Proline® PRO45 (PP)	20" (500mm) SDR33	289	1 mm	Almost Zero	168 seconds	8 seconds	289	14.8 min
Proline® PRO45 (PP)	22" (560mm) SDR33	353	1 mm	Almost Zero	188 seconds	8 seconds	353	16.5 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

The weldment must cool for a minimum time of 60 seconds under full force before it may be set aside to finish cooling for the complete time according to the Cooling Time column. The removed piece should be handled carefully and set down with minimal strain on the weld for the remainder of the cooling time.

Productivity Package Welding Parameters

CURRENT AS OF
09/05/2023

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Proline® PRO45 (PP)	24" (630mm) SDR33	457	1.5 mm	Almost Zero	209 seconds	9 seconds	457	18.3 min
Watertec™ (PP-RCT)	10" (250mm) SDR11	198	1.5 mm	Almost Zero	240 seconds	10 seconds	198	21.2 min
Watertec™ (PP-RCT)	12" (315mm) SDR11	311	2 mm	Almost Zero	293 seconds	12 seconds	311	26.4 min
Watertec™ (PP-RCT)	14" (355mm) SDR11	393	2 mm	Almost Zero	322 seconds	13 seconds	393	29.6 min
Watertec™ (PP-RCT)	16" (400mm) SDR11	500	2 mm	Almost Zero	356 seconds	14 seconds	500	33.4 min
Watertec™ (PP-RCT)	18" (450mm) SDR11	645	2.5 mm	Almost Zero	388 seconds	15 seconds	645	37.6 min
Watertec™ (PP-RCT)	20" (500mm) SDR11	790	3 mm	Almost Zero	420 seconds	16 seconds	790	41.9 min

Welding Temperatures

PP: 393°F - 410°F (200°C - 210°C)
 PE: 420°F - 446°F (215°C - 230°C)
 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

The weldment must cool for a minimum time of 60 seconds under full force before it may be set aside to finish cooling for the complete time according to the Cooling Time column. The removed piece should be handled carefully and set down with minimal strain on the weld for the remainder of the cooling time.