

Acrobat 250

Welding Parameters

CURRENT AS OF
12/19/2024

Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Air-Pro® (PE)	3" (90mm) SDR7	9.0 bar	2 mm	Almost Zero	123 seconds	8 seconds	9.0 bar	12.3 min
Air-Pro® (PE)	4" (110mm) SDR7	13.0 bar	2 mm	Almost Zero	151 seconds	9 seconds	13.0 bar	14.7 min
Air-Pro® (PE)	6" (160mm) SDR11	20.0 bar	2 mm	Almost Zero	146 seconds	9 seconds	20.0 bar	14.2 min
Air-Pro® (PE)	8" (200mm) SDR11	30.0 bar	2 mm	Almost Zero	182 seconds	10 seconds	30.0 bar	17.3 min
Air-Pro® (PE)	10" (250mm) SDR11	47.0 bar	2.5 mm	Almost Zero	227 seconds	11 seconds	47.0 bar	21.2 min
Chem Proline® (PE)	3" (90mm) SDR11	7.0 bar	1.5 mm	Almost Zero	82 seconds	6 seconds	7.0 bar	8.6 min
Chem Proline® (PE)	4" (110mm) SDR11	10.0 bar	1.5 mm	Almost Zero	100 seconds	7 seconds	10.0 bar	10.2 min
Chem Proline® (PE)	6" (160mm) SDR11	20.0 bar	2 mm	Almost Zero	146 seconds	9 seconds	20.0 bar	14.2 min
Chem Proline® (PE)	8" (200mm) SDR11	30.0 bar	2 mm	Almost Zero	182 seconds	10 seconds	30.0 bar	17.3 min
Chem Proline® (PE)	10" (250mm) SDR11	47.0 bar	2.5 mm	Almost Zero	227 seconds	11 seconds	47.0 bar	21.2 min
Proline® PRO150 (PP)	2-1/2" (75mm) SDR11	3.0 bar	0.5 mm	Almost Zero	79 seconds	6 seconds	3.0 bar	7.3 min
Proline® PRO150 (PP)	3" (90mm) SDR11	5.0 bar	1 mm	Almost Zero	94 seconds	6 seconds	5.0 bar	8.6 min
Proline® PRO150 (PP)	4" (110mm) SDR11	7.0 bar	1 mm	Almost Zero	113 seconds	7 seconds	7.0 bar	10.2 min



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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)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

Acrobat 250

Welding Parameters

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Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Proline® PRO150 (PP)	4-1/2" (125mm) SDR11	8.0 bar	1 mm	Almost Zero	129 seconds	7 seconds	8.0 bar	11.5 min
Proline® PRO150 (PP)	5" (140mm) SDR11	10.0 bar	1 mm	Almost Zero	142 seconds	7 seconds	10.0 bar	12.6 min
Proline® PRO150 (PP)	6" (160mm) SDR11	13.0 bar	1 mm	Almost Zero	161 seconds	8 seconds	13.0 bar	14.2 min
Proline® PRO150 (PP)	7" (180mm) SDR11	17.0 bar	1 mm	Almost Zero	180 seconds	8 seconds	17.0 bar	15.8 min
Proline® PRO150 (PP)	8" (200mm) SDR11	20.0 bar	1 mm	Almost Zero	198 seconds	9 seconds	20.0 bar	17.3 min
Proline® PRO150 (PP)	9" (225mm) SDR11	26.0 bar	1.5 mm	Almost Zero	220 seconds	9 seconds	26.0 bar	19.3 min
Proline® PRO150 (PP)	10" (250mm) SDR11	32.0 bar	1.5 mm	Almost Zero	240 seconds	10 seconds	32.0 bar	21.2 min
Proline® PRO90 (PP)	2-1/2" (75mm) SDR17.6	2.0 bar	0.5 mm	Almost Zero	51 seconds	5 seconds	2.0 bar	5.0 min
Proline® PRO90 (PP)	3" (90mm) SDR17.6	3.0 bar	0.5 mm	Almost Zero	60 seconds	5 seconds	3.0 bar	5.4 min
Proline® PRO90 (PP)	4" (110mm) SDR17.6	4.0 bar	0.5 mm	Almost Zero	73 seconds	6 seconds	4.0 bar	6.5 min
Proline® PRO90 (PP)	4-1/2" (125mm) SDR17.6	6.0 bar	1 mm	Almost Zero	82 seconds	6 seconds	6.0 bar	7.4 min
Proline® PRO90 (PP)	5" (140mm) SDR17.6	7.0 bar	1 mm	Almost Zero	92 seconds	6 seconds	7.0 bar	8.2 min
Proline® PRO90 (PP)	6" (160mm) SDR17.6	9.0 bar	1 mm	Almost Zero	104 seconds	6 seconds	9.0 bar	9.2 min



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 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Welding Parameters

CURRENT AS OF
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Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Proline® PRO90 (PP)	7" (180mm) SDR17.6	11.0 bar	1 mm	Almost Zero	116 seconds	7 seconds	11.0 bar	10.2 min
Proline® PRO90 (PP)	8" (200mm) SDR17.6	13.0 bar	1 mm	Almost Zero	129 seconds	7 seconds	13.0 bar	11.3 min
Proline® PRO90 (PP)	9" (225mm) SDR17.6	17.0 bar	1 mm	Almost Zero	143 seconds	7 seconds	17.0 bar	12.4 min
Proline® PRO90 (PP)	10" (250mm) SDR17.6	21.0 bar	1 mm	Almost Zero	157 seconds	8 seconds	21.0 bar	13.5 min
Proline® PRO45 (PP)	4" (110mm) SDR33	3.0 bar	0.5 mm	Almost Zero	40 seconds	5 seconds	3.0 bar	5.0 min
Proline® PRO45 (PP)	4-1/2" (125mm) SDR33	3.0 bar	0.5 mm	Almost Zero	46 seconds	5 seconds	3.0 bar	5.0 min
Proline® PRO45 (PP)	5" (140mm) SDR33	4.0 bar	0.5 mm	Almost Zero	51 seconds	5 seconds	4.0 bar	5.0 min
Proline® PRO45 (PP)	6" (160mm) SDR33	5.0 bar	0.5 mm	Almost Zero	57 seconds	5 seconds	5.0 bar	5.4 min
Proline® PRO45 (PP)	7" (180mm) SDR33	6.0 bar	0.5 mm	Almost Zero	64 seconds	5 seconds	6.0 bar	6.0 min
Proline® PRO45 (PP)	8" (200mm) SDR33	8.0 bar	0.5 mm	Almost Zero	72 seconds	6 seconds	8.0 bar	6.7 min
Proline® PRO45 (PP)	9" (225mm) SDR33	10.0 bar	0.5 mm	Almost Zero	80 seconds	6 seconds	10.0 bar	7.4 min
Proline® PRO45 (PP)	10" (250mm) SDR33	12.0 bar	1 mm	Almost Zero	89 seconds	6 seconds	12.0 bar	8.1 min
Super Proline® (PVDF)	2-1/2" (75mm) SDR21	2.0 bar	0.5 mm	Almost Zero	76 seconds	3 seconds	2.0 bar	6.5 min



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 PVDF: 436°F - 446°F (225°C - 230°C)
 ECTFE: 527°F - 536°F (275°C - 280°C)

A reduction in the cooling time of up to 50%, i.e. removal of the welded part from the welding machine, is permitted in the following circumstances:

- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Welding Parameters

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Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Super Proline® (PVDF)	3" (90mm) SDR21	3.0 bar	0.5 mm	Almost Zero	83 seconds	3 seconds	3.0 bar	7.0 min
Super Proline® (PVDF)	4" (110mm) SDR21	4.0 bar	0.5 mm	Almost Zero	93 seconds	3 seconds	4.0 bar	8.5 min
Super Proline® (PVDF)	6" (160mm) SDR21	8.0 bar	0.7 mm	Almost Zero	117 seconds	4 seconds	8.0 bar	11.0 min
Super Proline® (PVDF)	8" (200mm) SDR21	12.0 bar	1 mm	Almost Zero	136 seconds	4 seconds	12.0 bar	13.5 min
Super Proline® (PVDF)	10" (250mm) SDR21	18.0 bar	1.1 mm	Almost Zero	159 seconds	4 seconds	18.0 bar	16.5 min
Super Proline® (PVDF)	2-1/2" (75mm) SDR33	2.0 bar	0.5 mm	Almost Zero	63 seconds	3 seconds	2.0 bar	5.0 min
Super Proline® (PVDF)	3" (90mm) SDR33	2.0 bar	0.5 mm	Almost Zero	68 seconds	3 seconds	2.0 bar	5.5 min
Super Proline® (PVDF)	4" (110mm) SDR33	3.0 bar	0.5 mm	Almost Zero	74 seconds	3 seconds	3.0 bar	6.0 min
Super Proline® (PVDF)	6" (160mm) SDR33	5.0 bar	0.5 mm	Almost Zero	89 seconds	3 seconds	5.0 bar	8.0 min
Super Proline® (PVDF)	8" (200mm) SDR33	8.0 bar	0.6 mm	Almost Zero	102 seconds	4 seconds	8.0 bar	9.5 min
Super Proline® (PVDF)	10" (250mm) SDR33	12.0 bar	0.7 mm	Almost Zero	117 seconds	4 seconds	12.0 bar	11.0 min
Duo-Pro® PRO150X150 (PP)	2" X 4" (63mm X 110mm) SDR11X11	9.0 bar	1 mm	Almost Zero	113 seconds	5 seconds	9.0 bar	10.2
Duo-Pro® PRO150X150 (PP)	3" X 6" (90mm X 160mm) SDR11X11	18.0 bar	1 mm	Almost Zero	161 seconds	8 seconds	18.0 bar	14.2 min



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- the joint connection was created under workshop conditions and
- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint

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Product Line & Material	Pipe Size	Initial Melt Pressure	Bead Height	Melt Pressure	Heatsoak Time	Changeover Time	Welding Pressure	Cooling Time
Duo-Pro® PRO150X150 (PP)	4" X 8" (110mm X 200mm) SDR11X11	27.0 bar	1 mm	Almost Zero	198 seconds	9 seconds	27.0 bar	17.3 min
Duo-Pro® PRO150X150 (PP)	6" X 10" (160mm X 250mm) SDR11X11	45.0 bar	1.5 mm	Almost Zero	240 seconds	10 seconds	45.0 bar	21.2 min
Duo-Pro® PRO150X150 (PP)	2" X 6" (63mm X 160mm) SDR11X11	15.4 bar	1 mm	Almost Zero	161 seconds	8 seconds	15.4 bar	14.2 min
Duo-Pro® PRO150X45 (PP)	3" X 6" (90mm X 160mm) SDR11X33	10.0 bar	0.5 mm	Almost Zero	94 seconds	6 seconds	10.0 bar	8.6 min
Duo-Pro® PRO150X45 (PP)	4" X 8" (110mm X 200mm) SDR11X33	15.0 bar	0.5 mm	Almost Zero	113 seconds	7 seconds	15.0 bar	10.2 min
Duo-Pro® PRO150X45 (PP)	6" X 10" (160mm X 250mm) SDR11X33	25.0 bar	1 mm	Almost Zero	161 seconds	8 seconds	25.0 bar	14.2 min
Duo-Pro® PRO150X45 (PP)	2" X 6" (63mm X 160mm) SDR11X33	7.4 bar	0.5 mm	Almost Zero	68 seconds	6 seconds	7.4 bar	6.3 min
Duo-Pro® PRO45X45 (PP)	4" X 8" (110mm X 200mm) SDR33X33	11.0 bar	0.5 mm	Almost Zero	72 seconds	6 seconds	11.0 bar	6.7 min
Duo-Pro® PRO45X45 (PP)	6" X 10" (160mm X 250mm) SDR33X33	17.0 bar	1 mm	Almost Zero	89 seconds	6 seconds	17.0 bar	6.7 min
Duo-Pro® PVDFXPVDF (PVDF)	2" X 4" (63mm X 110mm) SDR21X33	4.1 bar	0.5 mm	Almost Zero	74 seconds	3 seconds	4.1 bar	6.0 min
Duo-Pro® PVDFXPVDF (PVDF)	3" X 6" (90mm X 160mm) SDR33X33	7.0 bar	0.5 mm	Almost Zero	89 seconds	3 seconds	7.0 bar	8.0 min
Duo-Pro® PVDFXPVDF (PVDF)	4" X 8" (110mm X 200mm) SDR33X33	11.0 bar	0.6 mm	Almost Zero	102 seconds	4 seconds	11.0 bar	9.5 min
Duo-Pro® PVDFXPVDF (PVDF)	6" X 10" (160mm X 250mm) SDR33X33	17.0 bar	0.7 mm	Almost Zero	117 seconds	4 seconds	17.0 bar	11.0 min



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Duo-Pro® PVDFXPVDF (PVDF)	2" X 6" (63mm X 160mm) SDR21X33	6.4 bar	0.5 mm	Almost Zero	89 seconds	3 seconds	6.4 bar	8.0 min
Fluidlok (IPS) (PE)	3" X 6" SDR11X17	13.6 bar	mm	Almost Zero	65 seconds	5 seconds	13.6 bar	10.0 min
Fluidlok (IPS) (PE)	4" X 8" SDR11X17	23.8 bar	mm	Almost Zero	86 seconds	5 seconds	23.8 bar	12.0 min
Fluidlok (IPS) (PE)	6" X 10" SDR11X17	39.7 bar	mm	Almost Zero	105 seconds	6 seconds	39.7 bar	14.0 min
Poly-Flo® PE100RC (PE)	2" X 3" (63mm X 90mm) SDR11X17	5.6 bar	1 mm	Almost Zero	35 seconds	5 seconds	5.6 bar	8.0 min
Poly-Flo® PE100RC (PE)	4" X 6" (110mm X 160mm) SDR11X17	19.1 bar	1.5 mm	Almost Zero	80 seconds	7 seconds	19.1 bar	14.0 min
Poly-Flo® PPR (PP)	2" X 3" (63mm X 90mm) SDR11X17	5.1 bar	0.5 mm	Almost Zero	80 seconds	6 seconds	5.1 bar	9.0 min
Poly-Flo® PPR (PP)	4" X 6" (110mm X 160mm) SDR11X17	15.8 bar	1 mm	Almost Zero	150 seconds	7 seconds	15.8 bar	17.0 min



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- the removal of the part from the welding machine and its temporary storage until the complete cooling time according to the Cooling Time column causes negligible loading of the joint