

Special Butt Welding Parameters for IP 4 HDPE ducts using PESTEC IP 4 Duct Butt Welding Equipment P 160 only

The given parameter are not valid for IP 4 PP ducts

The given parameters are suitable for IP 4 S PE and IP 4 M PE ducts both.

IP 4Duct Size	Adjusting Bead pressure using 220 °C	Adjusting Bead height	Heat up Pressure	Heat up time	Maximum Change time	Time to reach Full welding Pressure	Welding Pressure	Min. Cooling Time under welding pressure
	In N	In mm	In N	Sec	Sec	Sec	In N	in Minute
58/74	75	0,5	10	45	5	5	75	6
76/92	90	0,5	15	45	5	5	90	6
100/116	140	0,5	20	45	5	5	140	6
115/131	180	0,5	25	45	5	5	180	6
130/146	210	0,5	30	45	5	5	210	6
140/157	275	0,5	40	45	5	5	275	6

NOTE:

We would like to point that by using another brand and type of butt welding equipment, the given values have to be modified according to the individual butt welding equipment to be used.