

Socket Fusion Weld Times

PIPE Ø (mm)	Heating Time		Weld Together Time	Cooling Time
	@ 20°C amb.	< +5°C amb.		
16	5 sec	10 sec	4 sec	2 min
20	5 sec	10 sec	4 sec	2 min
25	7 sec	14 sec	4 sec	2 min
32	8 sec	16 sec	6 sec	4 min
40	12 sec	24 sec	6 sec	4 min
50	18 sec	36 sec	6 sec	4 min
63	24 sec	48 sec	8 sec	6 min
75	30 sec	60 sec	8 sec	6 min
90	40 sec	80 sec	10 sec	8 min
110	50 sec	100 sec	10 sec	8 min
125	60 sec	120 sec	10 sec	8 min
Weld-in Saddles	30 sec for all sizes	45 sec For all sizes	6 sec	6 min

Points to Note:

- It is essential to observe the above welding times.
- Pipes and fittings from 75mm to 125mm should only be welded with a bench socket fusion machine.
- The welder temperature should always be checked prior to welding.
 - Socket Fusion Welders - 260°C
- Cold Welds. These are largely caused by...
 - Welder temperature not being achieved.
 - Wind cooling the tool down.
 - Lengthened 'weld together time'.
 - Loose mandrels
 - Disregard of 'heating time'.

If you have any questions – please phone the team @ UPG on 0800 473 100

PN16 PP-RCT/Climatec Pipe Support Spacing's (cm)

Diameter mm	Spans L in cm to T°C						
	20°C	30°C	40°C	50°C	60°C	70°C	80°C
20 SDR7.4	100	90	85	85	80	70	65
25 SDR7.4	105	100	95	90	85	80	75
32 SDR9	120	115	110	105	100	95	90
40 SDR11	120	115	110	105	100	95	90
50 SDR11	140	135	130	125	120	115	110
63 SDR11	150	145	140	135	130	125	120
75 SDR11	165	160	155	150	145	140	130
90 SDR11	175	170	165	160	155	150	135
110 SDR11	185	180	175	165	160	155	145
125 SDR11	205	195	190	180	170	160	150
160 SDR11	220	210	205	195	185	175	165

PN16 PP-RCT/Solid Wall Pipe Support Spacing's (cm)

Diameter mm	Spans L in cm to T°C				
	20°C	30°C	40°C	50°C	60°C
20 SDR9	60	55	50	45	40
25 SDR9	75	70	65	60	55
32 SDR11	95	85	75	70	65
40 SDR11	100	95	90	85	75
50 SDR11	120	115	105	100	90
63 SDR11	140	130	120	110	100
75 SDR11	150	145	135	125	115
90 SDR11	160	155	150	145	130
110 SDR11	180	170	160	155	140
125 SDR11	190	185	175	165	150
160 SDR11	200	195	185	175	160
200 SDR11	245	235	225	215	205
225 SDR11	260	250	240	230	210
250 SDR11	275	265	255	245	235
315 SDR11	290	280	270	260	250