

# Wefatherm PP-R Socket welding guide

This jointing technique is suitable for d16-63 mm

**01** Cut the pipe square using pipe cutter for plastic pipes. Remove the cutting chips.

**02** Mark the insertion depth with a gauge on the pipe. Align the position of the fitting with the aid of the auxiliary marking on the fitting and the continuous line on the pipe.

**03** Simultaneous insert the pipe and fitting into the heating sleeve, without turning.

**04** Heating-up time starts when the full insertion depth of the pipe is reached and fitting is pushed against the stop.

**05** At the end of the heating-up time, quickly remove the pipe and fitting from the sleeve and mandrel. And immediately push them together up to insertion depth marking is covered by the bead that has been formed.

**06** During the processing time keep the pipe and fitting in fixed position. The parts can still be aligned to each other during this phase but may not be rotated.

**07** After completion of the cooling time the joint can be fully loaded. This welding joint is an inseparable joint, the material of the fitting and pipe have melted together. Make sure to respect the cooling time.

Prepare the welding device according to the device manual. **Set the thermostat to 260°C.**

Pipe outside diameter (mm)	Welding depth (mm)	Heating-up time (sec)	Processing time (sec)	Cooling down time (min)
16	13	5	4	2
20	14	5	4	2
25	15	7	4	2
32	17	8	6	4
40	18	12	6	4
50	20	18	6	4
63	26	24	8	6
75	29	30	8	8
90	32	40	8	8
110	35	50	8	8
125	41	60	10	8

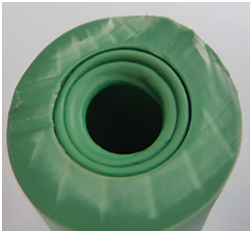
General guideline of socket welding DVS 2207 Part 11





# Typical Welding Errors

Do not insert the pipe too far into the fitting to prevent the internal diameter of the pipe being reduced. Do not rotate the pipe and fitting relative to each other.



Inserted too much



Welded wet



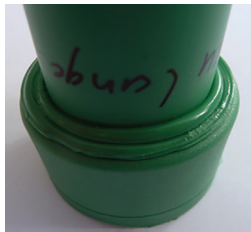
Inserted too little



Welded double



Under angle



Heated too long

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