PE 100

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **41** | PE 100 | (PN | 4) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 15,4 | 4,5 | 2,0 | 154 | 9 | 10 | 18 | 21 |
| **710** | 17,3 | 5,7 | 2,0 | 173 | 10 | 11 | 21 | 24 |
| **800** | 19,5 | 7,3 | 2,5 | 195 | 10 | 12 | 23 | 27 |
| **900** | 22,0 | 9,2 | 2,5 | 220 | 11 | 13 | 26 | 30 |
| **1000** | 24,4 | 11,3 | 2,5 | 244 | 12 | 14 | 29 | 34 |
| **1200** | 29,3 | 16,3 | 3,0 | 293 | 13 | 16 | 35 | 40 |
| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **33** | PE 100 | (PN | 5) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 19,1 | 5,6 | 2,5 | 191 | 10 | 12 | 23 | 26 |
| **710** | 21,5 | 7,1 | 2,5 | 215 | 11 | 13 | 26 | 30 |
| **800** | 24,2 | 9,0 | 2,5 | 242 | 11 | 14 | 29 | 33 |
| **900** | 27,3 | 11,3 | 3,0 | 273 | 12 | 15 | 33 | 38 |
| **1000** | 30,3 | 14,0 | 3,0 | 303 | 14 | 16 | 36 | 42 |
| **1200** | 36,4 | 20,1 | 3,0 | 364 | 16 | 19 | 44 | 50 |
| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **26** | PE 100 | (PN | 6) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 24,2 | 7,0 | 2,5 | 242 | 11 | 14 | 29 | 33 |
| **710** | 27,3 | 8,9 | 3,0 | 273 | 12 | 15 | 33 | 38 |
| **800** | 30,8 | 11,3 | 3,0 | 308 | 14 | 17 | 37 | 42 |
| **900** | 34,6 | 14,3 | 3,0 | 346 | 15 | 18 | 42 | 48 |
| **1000** | 38,5 | 17,6 | 3,5 | 385 | 16 | 20 | 46 | 53 |
| **1200** | 46,2 | 25,4 | 3,5 | 462 | 19 | 24 | 55 | 64 |

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **21** | PE 100 | (PN | 8) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 30,0 | 8,6 | 3,0 | 300 | 13 | 16 | 36 | 41 |
| **710** | 33,8 | 10,9 | 3,0 | 338 | 15 | 18 | 41 | 47 |
| **800** | 38,1 | 13,8 | 3,5 | 381 | 16 | 20 | 46 | 53 |
| **900** | 42,9 | 17,5 | 3,5 | 429 | 18 | 22 | 51 | 59 |
| **1000** | 47,6 | 21,6 | 3,5 | 476 | 19 | 24 | 57 | 66 |
| **1200** | 57,1 | 31,1 | 4,0 | 571 | 22 | 29 | 69 | 79 |

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **17** | PE 100 | (PN | 10) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 37,1 | 10,5 | 3,5 | 371 | 16 | 20 | 44 | 51 |
| **710** | 41,8 | 13,3 | 3,5 | 418 | 17 | 22 | 50 | 58 |
| **800** | 47,1 | 16,9 | 3,5 | 471 | 19 | 24 | 56 | 65 |
| **900** | 52,9 | 21,4 | 4,0 | 529 | 21 | 27 | 64 | 73 |
| **1000** | 58,8 | 26,4 | 4,0 | 588 | 22 | 30 | 71 | 81 |
| **1200** | 70,6 | 38,0 | 4,0 | 706 | 25 | 35 | 85 | 97 |

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **13,6** | PE 100 | (PN | 12,5) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 46,3 | 12,9 | 3,5 | 463 | 19 | 24 | 56 | 64 |
| **710** | 52,2 | 16,4 | 4,0 | 522 | 21 | 27 | 63 | 72 |
| **800** | 58,8 | 20,8 | 4,0 | 588 | 22 | 30 | 71 | 81 |
| **900** | 66,2 | 26,3 | 4,0 | 662 | 24 | 34 | 79 | 91 |
| **1000** | 73,5 |  |  |  |  |  |  |  |
| **1200** | 88,2 |  |  |  |  |  |  |  |

PE 80

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **41** | PE 80 | (PN | 3,2) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 15,4 | 4,5 | 2,0 | 154 | 9 | 10 | 18 | 21 |
| **710** | 17,3 | 5,7 | 2,0 | 173 | 10 | 11 | 21 | 24 |
| **800** | 19,5 | 7,3 | 2,5 | 195 | 10 | 12 | 23 | 27 |
| **900** | 22,0 | 9,2 | 2,5 | 220 | 11 | 13 | 26 | 30 |
| **1000** | 24,4 | 11,3 | 2,5 | 244 | 12 | 14 | 29 | 34 |
| **1200** | 29,3 | 16,3 | 3,0 | 293 | 13 | 16 | 35 | 40 |

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **33** | PE 80 | (PN | 4) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 19,1 | 5,6 | 2,5 | 191 | 10 | 12 | 23 | 26 |
| **710** | 21,5 | 7,1 | 2,5 | 215 | 11 | 13 | 26 | 30 |
| **800** | 24,2 | 9,0 | 2,5 | 242 | 11 | 14 | 29 | 33 |
| **900** | 27,3 | 11,3 | 3,0 | 273 | 12 | 15 | 33 | 38 |
| **1000** | 30,3 | 14,0 | 3,0 | 303 | 14 | 16 | 36 | 42 |
| **1200** | 36,4 | 20,1 | 3,0 | 364 | 16 | 19 | 44 | 50 |

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **26** | PE 80 | (PN | 5) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 24,2 | 7,0 | 2,5 | 242 | 11 | 14 | 29 | 33 |
| **710** | 27,3 | 8,9 | 3,0 | 273 | 12 | 15 | 33 | 38 |
| **800** | 30,8 | 11,3 | 3,0 | 308 | 14 | 17 | 37 | 42 |
| **900** | 34,6 | 14,3 | 3,0 | 346 | 15 | 18 | 42 | 48 |
| **1000** | 38,5 | 17,6 | 3,5 | 385 | 16 | 20 | 46 | 53 |
| **1200** | 46,2 | 25,4 | 3,5 | 462 | 19 | 24 | 55 | 64 |

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **21** | PE 80 | (PN | 6) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 30,0 | 8,6 | 3,0 | 300 | 13 | 16 | 36 | 41 |
| **710** | 33,8 | 10,9 | 3,0 | 338 | 15 | 18 | 41 | 47 |
| **800** | 38,1 | 13,8 | 3,5 | 381 | 16 | 20 | 46 | 53 |
| **900** | 42,9 | 17,5 | 3,5 | 429 | 18 | 22 | 51 | 59 |
| **1000** | 47,6 | 21,6 | 3,5 | 476 | 19 | 24 | 57 | 66 |
| **1200** | 57,1 | 31,1 | 4,0 | 571 | 22 | 29 | 69 | 79 |

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| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **17** | PE 80 | (PN | 8) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 37,1 | 10,5 | 3,5 | 371 | 16 | 20 | 44 | 51 |
| **710** | 41,8 | 13,3 | 3,5 | 418 | 17 | 22 | 50 | 58 |
| **800** | 47,1 | 16,9 | 3,5 | 471 | 19 | 24 | 56 | 65 |
| **900** | 52,9 | 21,4 | 4,0 | 529 | 21 | 27 | 64 | 73 |
| **1000** | 58,8 | 26,4 | 4,0 | 588 | 22 | 30 | 71 | 81 |
| **1200** | 70,6 | 38,0 | 4,0 | 706 | 25 | 35 | 85 | 97 |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **C1200** |  |  |  |  |  |  |  |  |
| **SDR** | **13,6** | PE 80 | (PN | 10) |  |  |  |  |
| **Диаметр** | **Толщина** | **Давление** | **Высота** | **Время** | **Время** | **Время** | **Время** | **Общее** |
| **трубы** | **стенки** | **сварки** | **грата** | **нагрева** | **технологич.** | **увеличения** | **охлаждения** | **время** |
| **(OD)** | **(s)** | **P1=P5** | **(буртика)** | **(t2)** | **паузы (t3)** | **давления** | **(t5)** |  |
|  |  |  |  |  |  | **(t4)** |  |  |
| **мм** | **мм** | **бар** | **мм** | **сек.** | **сек.** | **сек.** | **мин.** | **мин.** |
| **630** | 46,3 | 12,9 | 3,5 | 463 | 19 | 24 | 56 | 64 |
| **710** | 52,2 | 16,4 | 4,0 | 522 | 21 | 27 | 63 | 72 |
| **800** | 58,8 | 20,8 | 4,0 | 588 | 22 | 30 | 71 | 81 |
| **900** | 66,2 | 26,3 | 4,0 | 662 | 24 | 34 | 79 | 91 |
| **1000** | 73,5 |  |  |  |  |  |  |  |
| **1200** | 88,2 |  |  |  |  |  |  |  |