



### Socket fusion heating times table

Pipe diameter			Welding depth inch	Heating time in sec.		Welding time sec.	Cooling time min.
ND (inch)	OD (mm)	Actual OD (inch)		above 40 °F	below 40 °F		
A	B	C	D	E	F	G	H
½"	20	0.79	9/16"	5	8	4	2
¾"	25	0.98	5/8"	7	11	4	2
1"	32	1.26	1 1/16"	8	12	6	4
1 ¼"	40	1.57	¾"	12	18	6	4
1 ½"	50	1.97	13/16"	18	27	6	4
2"	63	2.48	15/16"	24	36	8	6
2 ½"	75	2.95	1"	30	45	8	8
3"	90	3.54	1 1/8"	40	60	8	8
3 ½"	110	4.33	1 5/16"	50	75	10	8
4"	125	4.92	1 9/16"	60	90	10	8

### Butt welding heating and cooling times (6" - 12")

Dimension		Heating	Welding (Fusion)		Cooling
ND (OD mm)	SDR		Heating time	Max. transition time	
6" (160 x 9.1)	17.6	3 min. 24 sec.	6 sec.	9 sec.	15 min.
6" (160 x 14.6)	11	4 min. 37 sec.	8 sec.	13 sec.	24 min.
6" (160 x 21.9)	7.4	6 min. 1 sec.	10 sec.	19 sec.	34 min.
8" (200 x 11.4)	17.6	3 min. 57 sec.	7 sec.	11 sec.	19 min.
8" (200 x 18.2)	11	5 min. 20 sec.	9 sec.	16 sec.	29 min.
8" (200 x 27.4)	7.4	6 min. 52 sec.	11 sec.	23 sec.	42 min.
10" (250 x 14.2)	17.6	4 min. 32 sec.	8 sec.	13 sec.	23 min.
10" (250 x 22.7)	11	6 min. 8 sec.	10 sec.	20 sec.	35 min.
10" (250 x 34.2)	7.4	7 min. 46 sec.	13 sec.	30 sec.	52 min.
12" (315 x 17.9)	17.6	5 min. 17 sec.	9 sec.	16 sec.	28 min.
12" (315 x 28.6)	11	7 min.	12 sec.	24 sec.	44 min.
12" (315 x 43.1)	7.4	8 min. 40 sec.	15 sec.	37 sec.	62 min.
14" (355 x 20.1)	17.6	5 min. 41 sec.	9 sec.	18 sec.	32 min.
14" (355 x 32.2)	11	7 min. 28 sec.	13 sec.	28 sec.	48 min.
14" (355 x 48.0)	7.4	9 min. 25 sec.	17 sec.	42 sec.	70 min.
16" (400 x 22.7)	17.6	6 min. 7 sec.	10 sec.	20 sec.	35 min.
16" (400 x 36.3)	11	8 min.	14 sec.	31 sec.	54 min.
18" (450 x 25.5)	17.6	6 min. 35 sec.	11 sec.	22 sec.	39 min.
18" (450 x 40.9)	11	8 min. 28 sec.	15 sec.	36 sec.	59 min.
20" (500 x 28.4)	17.6	6 min. 59 sec.	12 sec.	24 sec.	43 min.
22" (560 x 31.7)	17.6	7 min. 24 sec.	12 sec.	27 sec.	48 min.
24" (630 x 35.7)	17.6	7 min. 55 sec.	14 sec.	31 sec.	53 min.