

Technical Code DVS 2225-6

Joining of Lining Membranes Made of Polymer Materials – Site Testing

Requirements for welding machines and devices

Technical Committee of the DVS
Working Group W4 „Joining Plastics“
Subgroup W4.7 „Plastic foils and membranes“

This publication has been drawn up by a group of experienced specialists working in an honorary capacity and its consideration is recommended. The user should always check to what extent the contents are applicable to his particular case and whether the version on hand is still valid. No liability can be accepted by the DVS – Deutscher Verband für Schweißen und verwandte Verfahren e.V., and those participating in the drawing up of the document.

Content:

1.	Scope	3
2.	Lining membranes	3
3.	Forms of weld	3
4.	Welding process	3
5.	General requirements	4
6.	Requirements for welding machines	5
6.1.	Basic machine	5
6.2.	Temperature conditioning system	6
6.2.1.	Heating wedge dimension	7
6.2.2.	Wedge heating with hot gas	7
6.2.3.	Wedge heating with electrical resistance	8
6.3.	Pressing system	8
6.4.	Drive system	9
6.5.	Display, control and monitoring elements	9
7.	Requirements for welding devices	10
7.1.	Extrusion welding devices	10
7.1.1.	Pre-heating system	10
7.1.2.	Plasticising system	11
7.1.3.	Welding shoe	11
7.2.	Hot-gas welding devices	12
8.	References	12
9.	Appendix 1: Test report for weld extruder	14
10.	Appendix 2: Test report for heated wedge welding machines	15

Voransicht des Regelwerkes