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2 Requirements

The demanded mean value for the short-time tensile welding factor f_z according to Table 1 must be complied with for the specified welding processes.

1 Scope of application

This supplement is applicable in connection with the DVS 2203-1 technical code. The requirements for the tensile test according to DVS 2203-2 are indicated in this supplement.

Table 1. Minimum short-time tensile welding factor f_z .

Process		Short-time tensile welding factor f_z				
		PE 63 PE 80 PE 100	PP-H PP-R PP-B	PVC-U	PVC-C	PVDF
HS	Heated tool butt welding	0.9	0.9	0.9	0.8	0.9
IR	Non-contact heated tool butt welding	–	0.9 *	–	–	0.9
WF and WZ	Hot gas fan and string-bead welding	0.8	0.8	0.8	0.7	0.8
WE _{cont}	Hot gas extrusion welding, continuous	0.8	0.8	0.8	–	–
WE _{dis}	Hot gas extrusion welding, discontinuous	0.8	–	–	–	–

* Displacement-controlled for PP-H and pressure-controlled for all PPs

The prerequisites for the specified values were the command of the corresponding welding processes and the execution by qualified and certified personnel. The short-time tensile welding factors apply to the total loading time up to one hour. Corresponding proof is the prerequisite for the computation with higher welding factors than stipulated in the above table.

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DVS, Technical Committee, Working Group "Joining of Plastics"