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2 Requirements

The established tensile creep welding factor f_s must satisfy the requirements according to Table 1.

1 Scope of application

This supplement is applicable in connection with the DVS 2203-1 technical code. The requirements for the tensile creep test according to the DVS 2203-4 technical code are indicated in this supplement.

Table 1. Minimum tensile creep welding factor f_s .

Process		Tensile creep welding factor f_s				
		PE 63 PE 80 PE 100	PP-H PP-R PP-B	PVC-U	PVC-C	PVDF
HS	Heated tool butt welding	0.8	0.8	0.6	0.6	0.8
IR	Non-contact heated tool butt welding	0.7	0.8	–	–	0.8
WF, WZ	Hot gas fan and string-bead welding	0.4	0.4	0.4	0.4	0.4
WE _{cont}	Hot gas extrusion welding, continuous	0.6	0.6	0.6	–	–
WE _{dis}	Hot gas extrusion welding, discontinuous	0.4	–	–	–	–

The prerequisites for the specified values are the command of the corresponding welding processes and the execution by qualified and certified personnel. The prerequisite for computation with higher welding factors than stipulated in the above table is corresponding proof.

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DVS, Technical Committee Working Group "Joining of Plastics"