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Contents:

- 1 Scope of application
 - 2 General requirements
 - 3 Measures before the welding
 - 3.1 Prerequisites for the welding
 - 3.2 Cleaning
 - 3.2.1 Cleaning agents
 - 3.2.2 Cleaning of the heated tools
 - 3.2.3 Cleaning of the joining faces
 - 4 Heated tool butt welding of pipes, piping parts, fittings and panels
 - 4.1 Process description
 - 4.2 Preparation for the welding
 - 4.3 Execution of the welding
 - 5 Testing of the welded joints
 - 6 Standards, technical codes and guidelines which are also applicable
 - 7 Explanations
- Appendix: Processing instructions (short versions)
Welding record sheets

1 Scope of application

This technical code applies to the heated tool butt welding of panels according to DIN EN ISO 1163-1 for the fabrication of tanks and construction elements as well as of pipes and fittings which are made of PVC-U and serve to transport gases, liquids and solids.

Paying attention to the following instructions and on the basis of the practical experience, it may be assumed that panels according to ISO 11833-1, Group 2 and DIN 16927 as well as pipes and fittings according to DIN 8061 and DIN 8062 are suitable. If necessary, reference may be made to the data sheets of the suppliers of the semi-finished products – in cases of doubt, Works Certificate 2.1 according to DIN EN 10204.

2 General requirements

The quality of the welded joints is dependent on the qualification of the welders, on the suitability of the utilised machines and jigs as well as on the compliance with the technical codes for welding. The weld can be tested using non-destructive and/or destructive procedures.

The welding work must be monitored. The contracting parties must reach agreement on the type and scope of the monitoring. It is recommended to document the process data on welding record sheets (for a specimen, see the appendix) or on data carriers.

Within the framework of the quality assurance, it is recommended to manufacture and test trial welds in the given working conditions before commencing and during the welding work.

Every welder must be trained and must possess a valid qualification certificate. The planned area of application may determine the type of the qualification. DVS 2212-1 applies to the

heated tool butt welding of panels as well as to pipeline construction.

The machines and jigs used for the welding must comply with the requirements in DVS 2208-1.

3 Measures before the welding**3.1 Prerequisites for the welding**

The immediate welding area must be protected from unfavourable weathering influences (e. g. wind or the action of moisture). If suitable measures (e. g. preheating, tenting or heating) ensure conditions permissible for the welding, the work may be carried out at any outdoor temperature – provided that the dexterity of the welder is not hindered (see the explanations). If necessary, additional evidence must be provided by manufacturing trial welds in the specified conditions (see Section 5).

If the semi-finished product is heated non-uniformly due to solar radiation, the temperatures must be equalised by covering the area of the welding point in good time. It is necessary to avoid any draught-induced cooling during the welding operation. When pipes are welded, the pipe ends must be closed in addition.

The joining faces of the parts to be welded must not be scratched and must be free from contaminations (e. g. dirt, grease and chips).

3.2 Cleaning

For the manufacture of flawless welded joints, it is decisively important that not only the joining faces but also the tools and the heated tools are clean and free from grease.

3.2.1 Cleaning agents

The cleaning fluid or baths which have already been moistened with it in the factory and are kept in a flammable plastic box must consist of a solvent with 10% vaporisation, e. g. of 99 parts ethanol with a degree of purity of 99.8% and one part MEK (methyl ethyl ketone, denat. 100). Agents tested according to DVGW VP 603 comply with this stipulation. The use of spirit may lead to a quality reduction because of the water contained in it.

The paper for the cleaning must be clean, unused, absorbent, non-fraying and undyed.

3.2.2 Cleaning of the heated tools

The heated tools must be cleaned with a cleaning cloth or paper before every welding operation. No residues of cleaning agents or paper may remain on the heated tool. Ensure subsequent extraction.

3.2.3 Cleaning of the joining faces

Before the chip-producing machining of the joining faces, it must be ensured that the utilised tools and the workpieces are clean and free from grease beyond the welding area. If necessary, the cleaning must be carried out with a cleaning agent. Ensure subsequent extraction.

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

The joining faces must be machined immediately before the beginning of the welding.

Any chips must be removed without touching the joining faces.

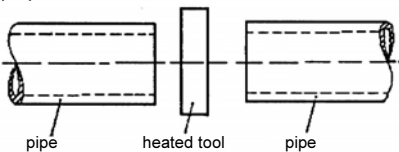
If the surface is soiled after the chip-producing machining (e. g. because of contact with the welder's hands), the welding faces must be treated with a cleaning agent if an additional chip-producing machining operation is not possible for process-related reasons.

4 Heated tool butt welding of pipes, piping parts, fittings and panels

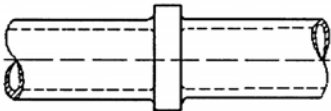
4.1 Process description

During heated tool butt welding, the faces of the parts to be welded are aligned to the heated tool under pressure (alignment), are subsequently heated up to the welding temperature at a reduced pressure (heating-up) and, when the heated tool has been removed (changeover), are joined together under pressure (joining). Figure 1 shows the principle of the process.

preparation



heating-up



welding joint

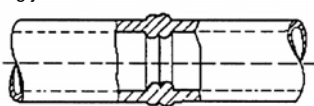


Figure 1. Principle of heated tool butt welding using the example of pipes.

4.2 Preparation for the welding

The heated tool temperature necessary for the welding must be checked before the beginning of the welding work. This is carried out, for example, with a quick-display temperature gauge for surface measurements with a contact area with an edge length of approx. 10 mm. The control measurement must be taken within the heated tool area corresponding to the semi-finished product. So that a thermal equilibrium can occur, the heated tool may be used, at the earliest, ten minutes after the nominal temperature has been reached.

For optimum welds, it is necessary to clean the heated tool according to Section 3.2.2 before every welding operation. The anti-adhesive coating or covering of the heated tool must be undamaged in the working area.

The respective joining forces or joining pressures must be stipulated for the machines to be used. These may refer, for example, to information from the manufacturer or to calculated or measured values. In the case of pipe welding, it is also necessary to read the movement force or movement pressure during the slow movement of the workpiece off the display instrument of the welding machine and to add this to the previously determined joining force or to the joining pressure. Preference should be

given to electronically controlled machines – if at all possible, with recording.

The nominal wall thicknesses of the parts to be welded must match in the joining region.

Pipes and fittings must be aligned axially before they are clamped in the welding machine. The easy longitudinal mobility of the part to be welded on must be ensured, for example, using adjustable dollies or a swinging suspension.

Immediately before the welding, the faces to be joined must be subjected to chip-producing machining with a clean and grease-free tool so that they have parallel faces in the clamped condition. The permissible gap widths under the alignment pressure are shown in Table 1.

Table 1. TMaximum gap widths between the machined welding faces.

Pipe outside diameter d mm	Gap width mm	Panel width mm
≤ 63	0.5	–
> 63 ... ≤ 110	1.0	≤ 1,500
> 110 ... ≤ 225	1.3	> 1,500 ≤ 2,000
> 225 ... ≤ 400	1.5	> 2,000 ≤ 3,000
–	2.0	> 2,300 ≤ 3,000

The misalignment must be checked at the same time as the gap width. The misalignment of the joining faces in relation to each other must not exceed the permissible dimension of 0.1 mm wall thickness on the outside of the pipe or on the panel. The objective must be a minimum misalignment. A larger misalignment results in a reduction in quality which restricts the load-bearing capacity of the joint. In this case, an evaluation may be carried out according to the DVS 2202-1 technical code, taking account of the requirements on the joint.

The machined welding faces must not be either soiled or touched by the welder's hands since another chip-producing machining operation would otherwise be necessary. An additional cleaning operation is not required and does not give rise to any improvement in quality. Any chips which have fallen into the pipe must be removed.

4.3 Execution of the welding

In the case of heated tool butt welding, the faces to be joined are heated up to the welding temperature using a heated tool and, when the heated tool has been removed, are joined together under pressure. The heated tool temperature is 230 ± 8°C. The step-by-step sequence of the welding operation is illustrated on Figure 2.

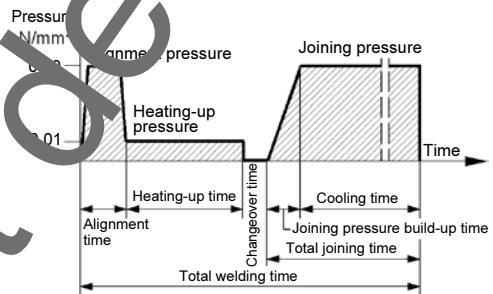


Figure 2. Process steps in heated tool butt welding.