



*Heating elements procedure
(butt welding)*

WELDING PROCEDURES GUIDE

Welding is a special process that must be performed by qualified personnel. Expertises is an individual characteristic that is reached through knowledge plus the necessary ability to carry out the planned activities.

Plastitalia S.p.A. strongly encourages its customers to operate according to the following principles:

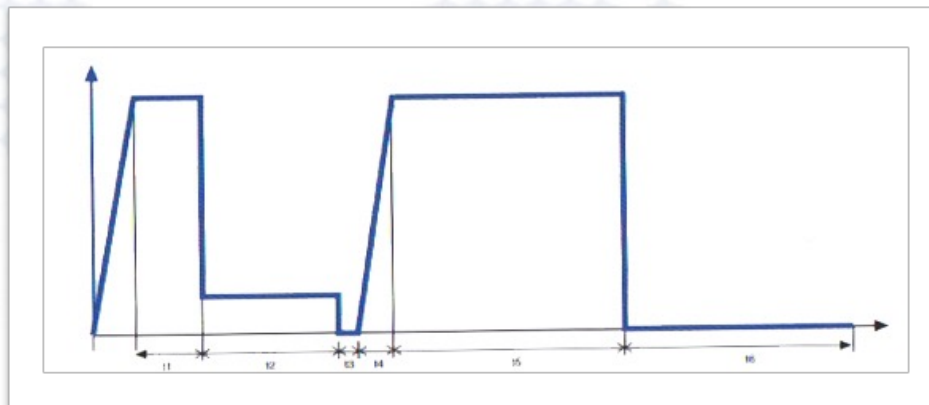
- The materials used, pipes and fittings, must comply with the applicable product standards;*
- The personnel operating the welding must be adequately informed and trained;*
- The equipment used must be appropriate to carry out the proposed works, well maintained and complying with product standards (if any);*
- Welding operations must be carried out in reliable conditions required by applicable law.*

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the chart reproduce below (source UNI 10520) represents the welding cycle divided into 6 different phases. This welding cycle is recognized as valid all over the world.

However, the welding parameters may vary slightly from country to country in order to take into account the local aspects, among which in the first instance, the environmental conditions (heat, cold, rain, etc...)

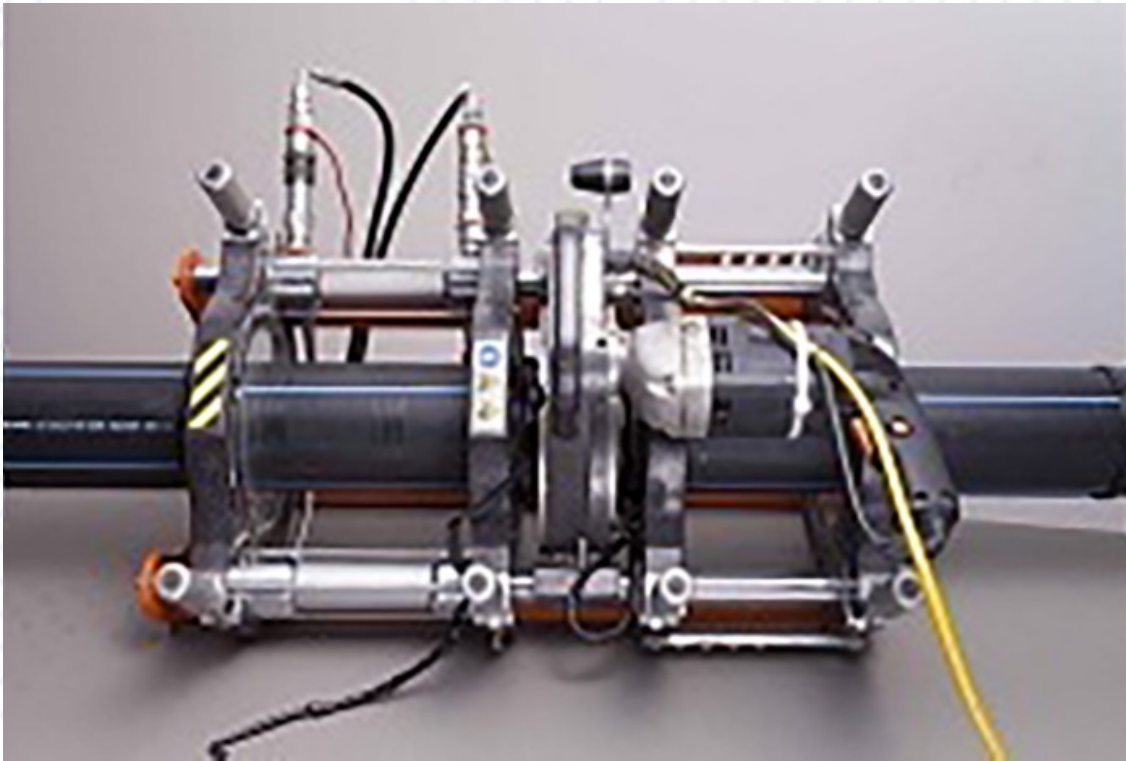
Most applied refer to the standards: ISO 21307, ASTM F2620 and UNI 10520; technical documents most followed are: DVS 2207-1, POP03, WIS 4-32-08, etc.



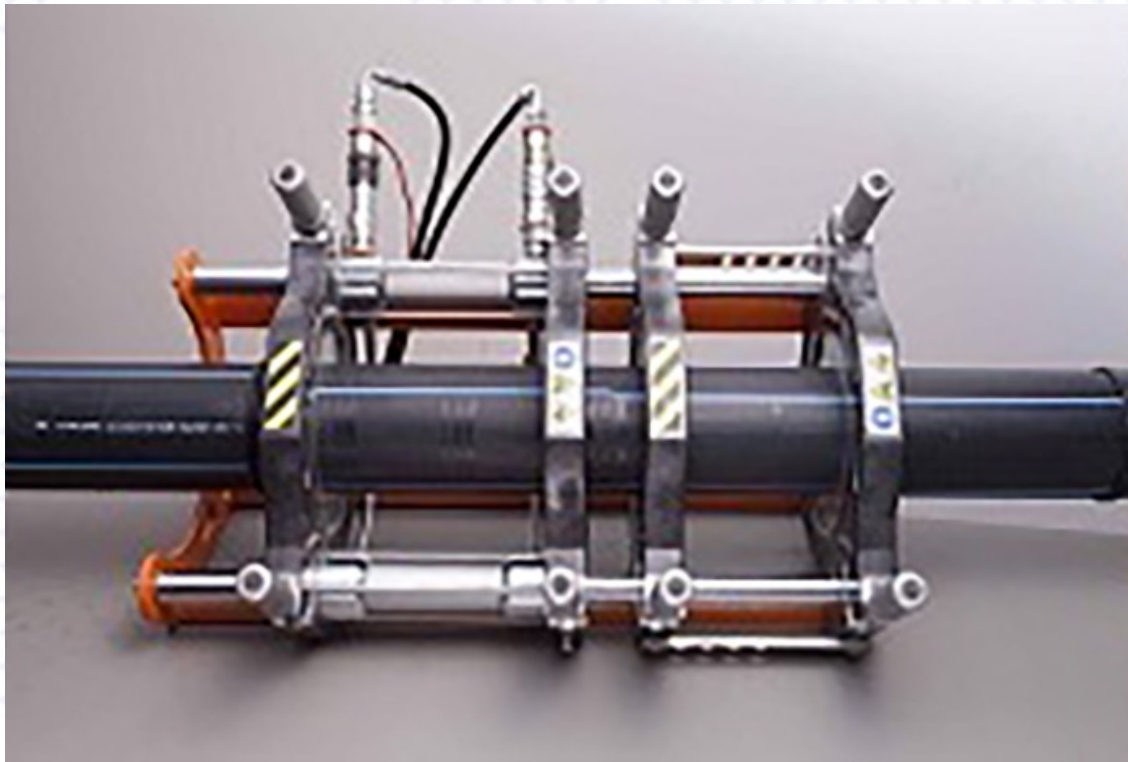
Place the elements to be welded into the machine.



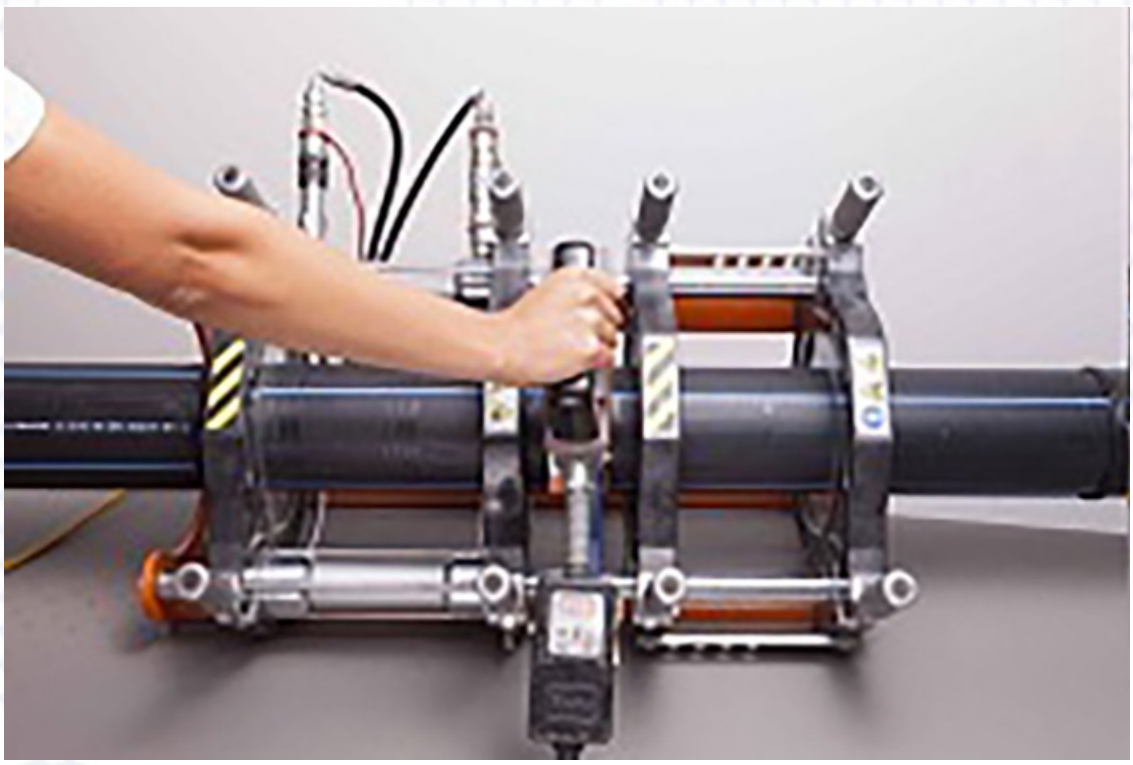
*Mill the parts to be welded and
check the alignment.*



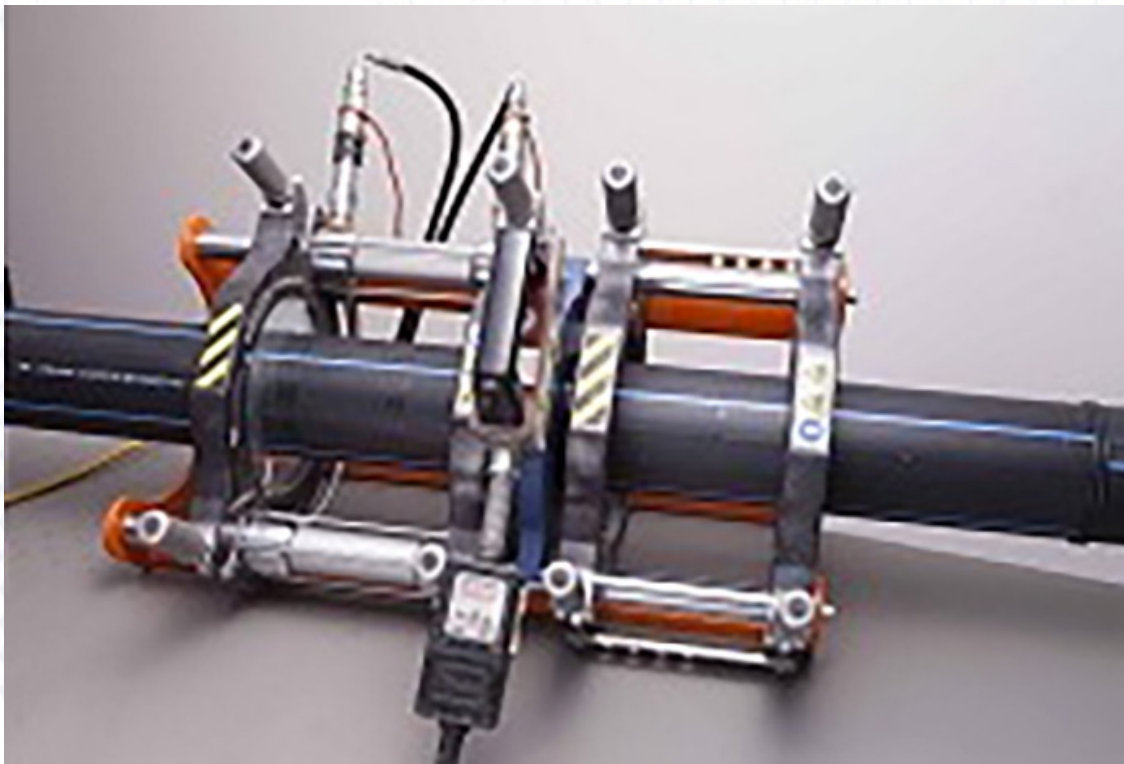
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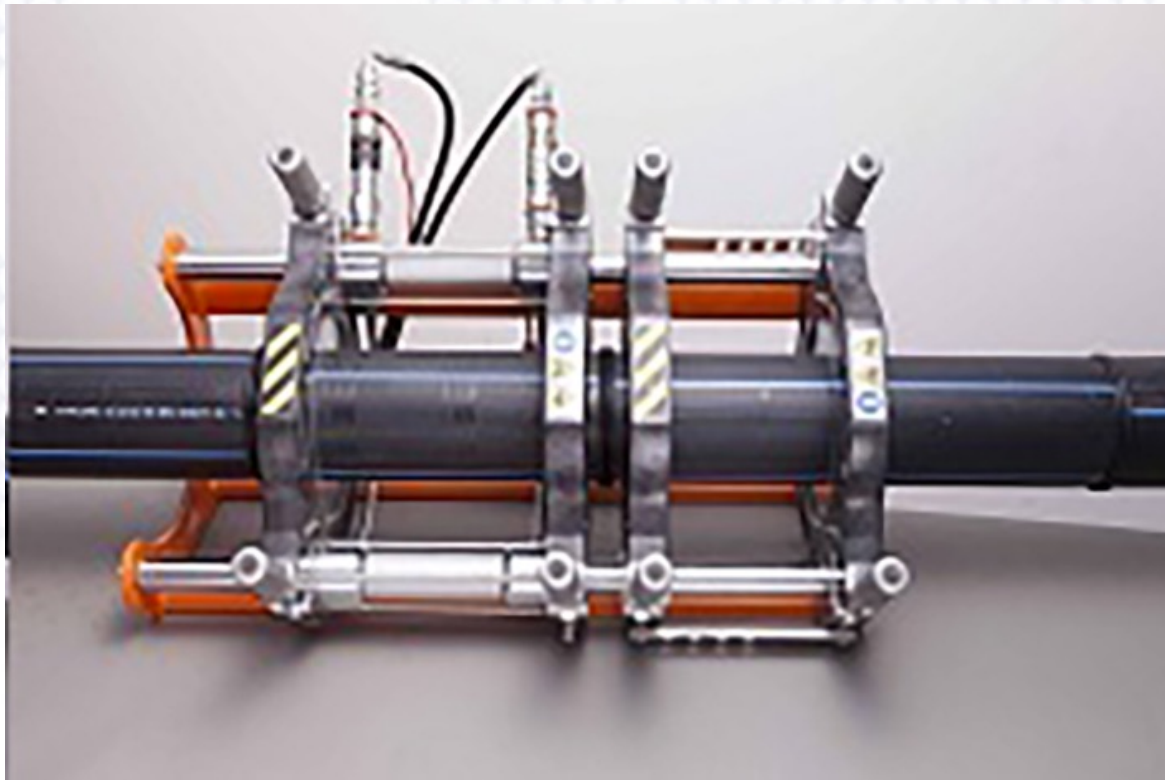
Preheating



Heating



Welding with element in pressure





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