

EDOBURG

PE Piping Systems

About Edoburg

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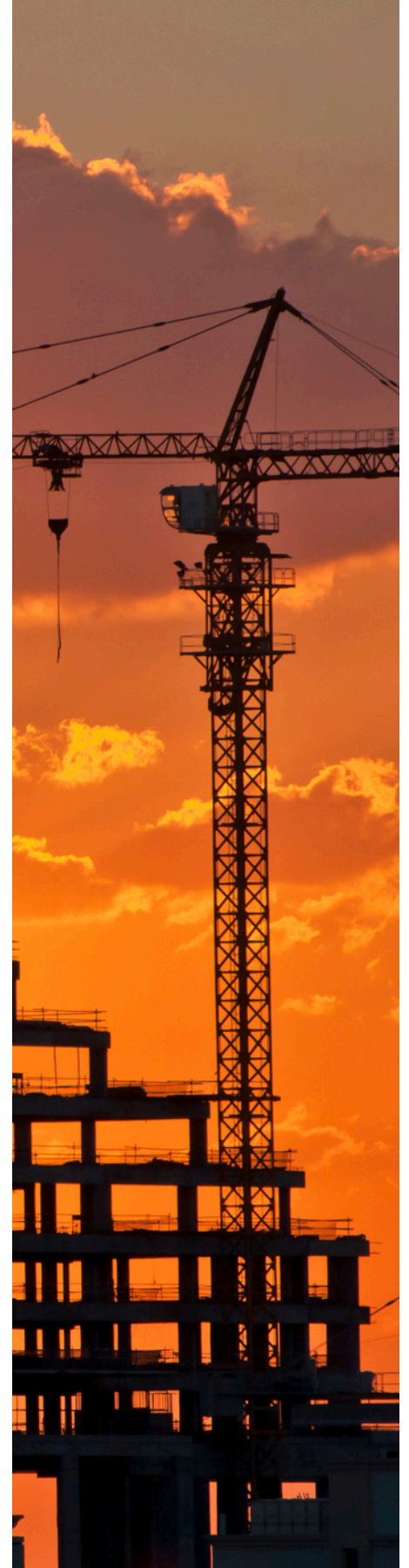
Our product portfolio spans over 10,000 SKUs across a wide range of categories including plastic piping systems, thermoplastic and composite pipelines, metal pipes and sections, drainage and utility systems, industrial components, and specialized engineered solutions for global projects.

All Edoburg-supplied products are manufactured in audited facilities and conform to international standards such as ASTM, CSA, ISO, IS, AS/NZS, and EN, depending on the target market. Each order is backed by full documentation support — including batch test reports, packing lists, Certificates of Origin, and private labelling when required.

We operate with export-ready processes, offering mixed container loads, low or no minimum order quantity, and market-specific packaging and compliance labelling. Our systems are designed to meet the expectations of professional buyers who require traceability, repeatability, and standardization across multiple geographies.

With clients across North America, Europe, the Middle East, Africa, and Asia-Pacific, Edoburg is positioned as a dependable global supplier — combining technical competence with structured commercial execution.

We don't just deliver material. **We supply what builds.**



EDOBURG

SUPPLY WHAT BUILDS



Properties and Technical Sheet

PE Pressure Piping Systems

Standard:

- IS 4984 – High-Density Polyethylene (PE 63, PE 80, PE 100) Pipes for Water Supply
- ISO 4427 – Polyethylene (PE 80, PE 100) Pipes for Water Supply – Specifications
- AS/NZS 4130 – Polyethylene (PE) Pipes for Pressure Applications
- BS EN 12201-2 – Plastics Piping Systems for Water Supply – Polyethylene Pipes
- DIN 8074 – Polyethylene (PE) Pipes – Dimensions

Manufacturing Origin: India

Product Type	Nominal Size (DN)	Outer Diameter (mm)	Pressure Rating	Standard Length	End Type
PE 63 Pressure Pipes	DN 16 – DN 1000	16 – 1000	PN 2.5 to PN 16	6 m / 12 m (Coils up to DN 110)	Plain End
PE 80 Pressure Pipes	DN 16 – DN 1200	16 – 1200	PN 2.5 to PN 20	6 m / 12 m (Coils up to DN 125)	Plain End
PE 100 Pressure Pipes	DN 16 – DN 2000	16 – 2000	PN 2.5 to PN 25	6 m / 12 m (Coils up to DN 125)	Plain End
PE Fittings (Moulded / Fabricated)	DN 16 – DN 1200	As per matching OD	As per pipe rating	-	Plain End / Electrofusion / Butt Fusion Ends

Material Properties

Property	Value / Description
Base Material	Polyethylene (PE 63, PE 80, PE 100 – High-Density Grades)
Density	0.940 – 0.960 g/cm ³
Vicat Softening Point	Not applicable (PE is non-thermosetting; softens gradually)
Maximum Operating Temperature	40°C continuous (short-term peaks up to 60°C)
Thermal Expansion Coefficient	-0.20 mm/m/°C
Flame Resistance	Does not support combustion – melts away from flame
UV Resistance	High with carbon black content ≥ 2% (UV-stabilised)
Chemical Resistance	Excellent – suitable for acids, bases, salts, many organic substances
Surface Finish	Smooth internal bore – low friction losses (Hazen-Williams C-factor ~150)
Colour	Black with blue stripes (potable water), solid black (industrial), other colours on request
Pressure Range	PN 2.5 to PN 25 (depending on material grade, size, and SDR)

Dimensions & Pressure Rating Chart for HDPE pipes (PE 63) as per IS:4984

OD	PN 2.5		PN 4		PN 6		PN 8		PN 10		PN 12.5		PN 16	
DN	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
20	-	-	-	-	-	-	-	-	2.3	2.8	2.8	3.3	3.4	4
25	-	-	-	-	-	-	2.3	2.8	2.8	3.3	3.4	4	4.2	4.9
32	-	-	-	-	2.3	2.8	3	3.5	3.6	4.2	4.4	5.1	5.4	6.2
40	-	-	2	2.4	2.8	3.3	3.7	4.3	4.5	5.2	5.5	6.3	6.7	7.6
50	-	-	2.4	2.9	3.5	4.1	4.6	5.3	5.6	6.4	6.8	7.7	8.4	9.5
63	2	2.4	3	3.5	4.4	5.1	5.8	6.6	7	7.9	8.6	9.7	10.5	11.8
75	2.3	2.8	3.6	4.2	5.3	6.1	6.9	7.8	8.4	9.5	10.2	11.5	12.5	14
90	2.8	3.3	4.3	5	6.3	7.2	8.2	9.3	10	11.2	12.2	13.7	15	16.7
110	3.4	4	5.3	6.1	7.7	8.7	10	11.2	12.3	13.8	14.9	16.6	18.4	20.5
125	3.8	4.4	6	6.8	8.8	9.8	11.4	12.8	13.9	15.5	16.9	18.8	20.9	23.2
140	4.3	5	6.7	7.6	9.8	11	12.8	14.3	15.6	17.4	19	21.1	23.4	26
160	4.9	5.6	7.7	8.7	11.2	12.6	14.6	16.3	17.8	19.8	21.7	21.4	26.7	29.6
180	5.5	6.3	8.6	9.7	12.6	14.1	16.4	18.3	20	22.2	24.4	27.1	30	33.2
200	6.1	7	9.6	10.8	14	15.6	18.2	20.63	22.3	24.8	27.1	30.4	33.4	37
225	3.9	7.8	10.8	12.4	15.7	17.5	20.5	22.8	25	27.7	30.5	33.8	37.5	41.5
250	7.6	8.6	12	13.4	17.5	19.5	22.8	25.3	27.8	30.8	33.8	37.4	41.4	46.1
280	8.5	9.6	12.4	15	19.6	21.8	25.8	28.3	31.2	34.6	37.9	41.9	46.7	51.6
315	9.6	10.8	15	16.7	22	24.4	28.7	31.8	35	38.7	42.6	14.1	52.5	58
355	10.8	12.1	17	18.9	24.8	27.5	32.3	35.8	39.5	43.7	48	53	59.2	65.4
400	12.2	14.3	19.1	22.2	28	32.4	36.4	42.1	44.5	51.4	54.1	62.5	-	-
450	13.7	16	21.5	25	31.4	36.4	41	47.4	50	57.7	-	-	-	-
500	15.2	17.7	23.9	27.7	34.9	40	45.5	52.6	55.6	64.2	-	-	-	-
560	17	19.8	26.7	31	39.1	45.2	51	58.9	-	-	-	-	-	-
630	19.1	22.2	30	34.7	44	50.8	57.3	66.1	-	-	-	-	-	-
710	21.6	25.1	33.9	39.2	49.6	57.3	-	-	-	-	-	-	-	-
800	24.3	28.2	38.1	44.1	55.9	64.5	-	-	-	-	-	-	-	-

Dimensions & Pressure Rating Chart for HDPE pipes (PE 80) as per IS:4984

OD	PN 2.5		PN 4		PN 6		PN 8		PN 10		PN 12.5		PN 16	
DN	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
20	-	-	-	-	-	-	-	-	-	-	2.3	2.8	2.8	3.3
25	-	-	-	-	-	-	-	-	2.3	2.8	2.8	3.3	3.5	4.1
32	-	-	-	-	-	-	2.4	2.9	3	3.5	3.6	4.2	4.5	5.2
40	-	-	-	-	2.3	2.8	3	3.5	3.7	4.3	4.5	5.2	5.6	6.4
50	-	-	2.3	2.8	2.9	3.4	3.8	4.4	4.6	5.3	5.6	6.4	6.9	7.8
63	-	-	2.5	3	3.6	4.2	4.7	5.4	5.8	6.6	7	7.9	8.9	9.8
75	-	-	2.9	3.4	4.3	5	5.6	6.4	6.9	7.8	8.4	9.5	10.4	11.7
90	2.3	2.8	3.5	4.1	5.1	5.9	6.7	7.6	8.2	9.3	10	11.2	12.5	14
110	2.7	3.2	4.3	5	6.3	7.2	8.2	9	10	11.2	12.3	13.8	15.2	17
125	3.1	3.7	4.9	5.6	7.1	8.1	9.3	10.5	11.4	12.8	13.9	15.5	17.3	19.3
140	3.5	4.1	5.4	6.2	8	9	10.4	11.7	12.8	14.3	15.6	17.4	19.4	21.6
160	4	4.6	6.2	7.1	9.1	10.3	11.9	13.3	14.6	16.3	17.8	19.8	22.1	24.6
180	4.4	5.1	7	7.9	10.2	11.5	13.4	15	16.4	18.3	20	22.2	24.9	27.6
200	4.9	5.6	7.7	8.7	11.4	12.8	14.9	16.6	18.2	20.3	22.3	24.8	27.6	30.6
225	5.5	6.3	8.7	9.8	12.8	14.3	16.7	18.6	20.5	22.8	25	27.7	31.1	34.5
250	6.1	7	9.7	10.9	14.2	15.9	18.6	20.7	22.8	25.3	27.8	30.8	34.5	38.2
280	6.9	7.8	10.8	12.1	15.9	17.7	20.8	23.1	25.5	28.3	31.2	34.6	38.7	42.5
315	7.7	8.7	12.2	13.7	17.9	19.9	23.4	26	28.7	31.8	35	38.7	43.5	48.1
355	8.7	9.8	13.7	15.3	20.1	22.4	26.3	29.2	32.3	35.8	39.5	43.7	49	54.1
400	9.8	11.5	15.4	18	22.7	26.4	29.7	34.4	36.4	42.1	44.5	51.4	55.2	63.7
450	11	12.9	17.4	20.3	25.5	29.6	33.4	38.7	41	47.4	50	27.7	-	-
500	12.2	14.3	19.3	22.4	28.4	32.9	37.1	42.9	45.5	52.6	55.6	64.2	-	-
560	13.7	16	21.6	25.1	31.7	36.7	41.5	48	51	58.9	-	-	-	-
630	15.4	18	24.3	28.2	35.7	41.3	46.7	54	57.3	66.1	-	-	-	-
710	17.4	20.3	27.4	31.8	40.2	46.5	52.6	60.7	-	-	-	-	-	-
800	19.6	22.8	30.8	35.7	45.3	52.3	-	-	-	-	-	-	-	-

Dimensions & Pressure Rating Chart for HDPE pipes (PE 100) as per IS:4984

OD	PN 6		PN 8		PN 10		PN 12.5		PN 16	
DN	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
20	-	-	-	-	-	-	-	-	2.3	2.8
25	-	-	-	-	-	-	2.3	2.8	2.9	3.4
32	-	-	-	-	2.4	2.9	2.9	3.4	3.7	4.3
40	-	-	2.4	2.9	3	3.5	3.7	4.3	4.6	5.3
50	2.3	2.8	3	3.5	3.7	4.3	4.6	5.3	5.7	6.5
63	2.9	3.4	3.8	4.4	4.7	5.4	5.7	6.5	7.1	8.1
75	3.5	4.1	4.5	5.2	5.6	6.4	6.8	7.7	8.5	9.6
90	4.1	4.8	5.4	6.2	6.7	7.6	8.2	9.5	10.2	11.5
110	5	5.7	6.6	7.5	8.1	9.2	10	11.2	12.4	13.9
125	5.7	6.5	7.2	8.5	9.2	10.4	11.3	12.7	14.1	15.8
140	6.4	7.3	8.4	9.5	10.3	11.6	12.7	14.2	15.8	17.6
160	7.3	8.3	9.6	10.8	11.8	13.2	14.5	16.2	18.1	20.2
180	8.2	9.3	10.8	12.1	13.3	14.9	16.3	18.2	20.3	22.6
200	9.1	10.3	12	13.4	14.8	16.5	18.1	20.2	22.6	25.1
225	10.3	11.6	13.5	15.1	16.6	18.5	20.4	22.7	25.4	28.2
250	11.4	12.8	15	16.7	18.4	20.5	22.6	25.1	28.2	31.3
280	12.8	14.3	16.8	18.7	20.6	22.9	25.3	28.1	31.6	35
315	14.4	16.1	18.9	21	23.2	25.8	28.5	31.6	35.5	39.3
355	16.2	18.1	21.2	23.6	26.2	29.1	32.1	35.6	40	44.2
400	18.2	21.2	23.9	27.7	29.5	34.2	36.2	41.9	45.1	52.1
450	20.2	23.8	26.9	31.2	33.1	38.3	40.7	47.1	50.8	58.7
500	22.8	26.5	29.9	34.6	36.8	42.6	45.2	52.2	56.4	65.1
560	25.5	29.6	33.5	38.8	41.2	47.6	50.6	58.4	-	-
630	28.7	33.3	37.7	43.6	46.4	53.6	56.9	65.7	-	-
710	32.3	37.4	42.4	49	52.3	60.4	-	-	-	-
800	36.4	42.1	47.8	55.2	58.9	68	-	-	-	-

Dimensions & Pressure Rating Chart for HDPE pipes (PE 100) as per ISO:4427

OD	PN 4 (SDR 41)		PN 6 (SDR 26)		PN 8 (SDR 21)		PN 10 (SDR 17)		PN 12.5 (SDR 13.6)		PN 16 (SDR 11)	
DN	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
20	-	-	-	-	-	-	-	-	-	-	2	2.3
25	-	-	-	-	-	-	-	-	2	2.3	2.3	2.7
32	-	-	-	-	-	-	2	2.3	2.4	2.8	3	3.4
40	-	-	-	-	2	2.3	2.4	2.8	3	3.5	3.7	4.2
50	-	-	2	2.3	2.4	2.8	3	3.4	3.7	4.2	4.6	5.2
63	-	-	2.5	2.9	3	3.4	3.8	4.3	4.7	5.3	5.8	6.5
75	-	-	2.9	3.3	3.6	4.1	4.5	5.1	5.6	6.3	6.8	7.6
90	-	-	3.5	4	4.3	4.9	5.4	6.1	6.7	7.5	8.2	9.2
110	-	-	4.2	4.8	5.3	6	6.6	7.4	8.1	9.1	10	11.1
125	-	-	4.8	5.4	6	6.7	7.4	8.3	9.2	10.3	11.4	12.7
140	-	-	5.4	6.1	6.7	7.5	8.3	9.3	10.3	11.5	12.7	14.1
160	-	-	6.2	7	7.7	8.6	9.5	10.6	11.8	13.1	14.6	16.2
180	-	-	6.9	7.7	8.6	9.6	10.7	11.9	13.3	14.3	16.4	18.2
200	-	-	7.7	8.6	9.6	10.7	11.9	13.2	14.7	16.3	18.2	20.2
225	-	-	8.6	9.6	10.8	12	13.4	14.9	16.6	18.4	20.5	22.7
250	-	-	9.6	10.7	11.9	13.2	14.8	16.4	18.4	20.4	22.7	25.1
280	-	-	10.7	11.9	13.4	14.9	16.6	18.4	20.6	22.8	25.4	28.1
315	7.7	8.6	12.1	13.5	15	16.6	18.7	20.7	23.2	25.7	28.6	31.6
355	8.7	9.7	13.6	15.1	16.9	18.7	21.1	23.4	26.1	28.9	32.2	35.6
400	9.8	10.9	15.3	17	19.1	21.2	23.7	26.2	29.4	32.5	36.3	40.1
450	11	12.2	17.2	19.1	21.5	23.8	26.7	29.5	33.1	36.6	40.9	45.1

Dimensions & Pressure Rating Chart for HDPE pipes (PE 80) as per ISO:4427

OD	PN 5 (SDR 26)		PN 6 (SDR 21)		PN 8 (SDR 17)		PN 10 (SDR 13.6)		PN 12.5 (SDR 11)		PN 16 (SDR 9)	
DN	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
20	-	-	-	-	-	-	-	-	2	2.3	2.3	2.7
25	-	-	-	-	-	-	2	2.3	2.3	2.7	3	3.4
32	-	-	-	-	2	2.3	2.4	2.8	3	3.4	3.6	4.1
40	-	-	2	2.3	2.4	2.8	3	3.5	3.7	4.2	4.5	5.1
50	2	2.3	2.4	2.8	3	3.4	3.7	4.2	4.6	5.2	5.6	6.3
63	2.5	2.9	3	3.4	3.8	4.3	4.7	5.3	5.8	6.5	7.1	8
75	2.9	3.3	3.6	4.1	4.5	5.1	5.6	6.3	6.8	7.6	8.4	9.4
90	3.5	4	4.3	4.9	5.4	6.1	6.7	7.5	8.2	9.2	10.1	11.3
110	4.2	4.8	5.3	6	6.6	7.4	8.1	9.1	10	11.1	12.3	13.7
125	4.8	5.4	6	6.7	7.4	8.3	9.2	10.3	11.4	12.7	14	15.6
140	5.4	6.1	6.7	7.5	8.3	9.3	10.3	11.5	12.7	14.1	15.7	17.4
160	6.2	7	7.7	8.6	9.5	10.6	11.8	13.1	14.6	16.2	17.9	19.8

Note: Blue MDPE Pipes (PE80) for drinking water purpose are also made available in SDR 21, SDR11 and SDR 9 in 20 to 160mm sizes.

Dimensions & Pressure Rating Chart for HDPE pipes as per AS/NZS 4130

OD	SDR 41		SDR 33		SDR 26		SDR 21		SDR 17		SDR 13.6		SDR 11		SDR 9	
DN	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
20	-	-	-	-	-	-	-	-	-	-	1.6	1.9	1.9	2.2	2.3	2.7
25	-	-	-	-	-	-	-	-	1.6	1.9	1.9	2.2	2.3	2.7	2.8	3.2
32	-	-	-	-	-	-	1.6	1.9	1.9	2.2	2.4	2.8	2.9	3.4	3.6	4.1
40	-	-	-	-	-	-	1.9	2.2	2.4	2.8	3	3.4	3.7	4.2	4.5	5.1
50	-	-	-	-	-	-	2.4	2.8	3	3.4	3.7	4.2	4.6	5.2	5.6	6.3
63	-	-	-	-	2.4	2.8	3	3.4	3.8	4.3	4.7	5.3	5.8	6.5	7.1	8
75	-	-	2.3	2.7	2.9	3.3	3.6	4.1	4.5	5.1	5.5	6.2	6.8	7.6	8.4	9.4
90	-	-	2.8	3.2	3.5	4	4.3	4.9	5.4	6.1	6.6	7.4	8.2	9.2	10.1	11.3
110	2.7	3.1	3.4	3.9	4.3	4.9	5.3	6	6.6	7.4	8.1	9.1	10	11.1	12.3	13.7
125	3.1	3.6	3.9	4.4	4.8	5.4	6	6.7	7.4	8.3	9.2	10.3	11.4	12.7	14	15.5
140	3.5	4	4.3	4.9	5.4	6.1	6.7	7.5	8.3	9.3	10.3	11.5	12.7	14.1	15.7	17.4
160	4	4.5	4.9	5.5	6.2	7	7.7	8.6	9.5	10.6	11.8	13.1	14.6	16.2	17.9	19.8
180	4.4	5	5.5	6.2	6.9	7.7	8.6	9.6	10.7	11.9	13.3	14.8	16.4	18.2	20.1	22.3
200	4.9	5.5	6.2	7	7.7	8.6	9.6	10.7	11.9	13.2	14.7	16.3	18.2	20.2	22.4	24.8
225	5.5	6.2	6.9	7.7	8.6	9.6	10.8	12	13.4	14.9	16.6	18.4	20.5	22.7	25.1	27.8
250	6.2	7	7.7	8.6	9.6	10.7	11.9	13.2	14.8	16.4	18.4	20.4	22.7	25.1	27.9	30.8
280	6.9	7.7	8.6	9.6	10.7	11.9	13.4	14.9	16.6	18.4	20.6	22.8	25.4	28.1	31.3	34.6
315	7.7	8.6	9.7	10.8	12.1	13.5	15	16.6	18.7	20.7	23.2	25.7	28.6	31.6	35.2	38.9
355	8.7	9.7	10.9	12.1	13.6	15.1	16.9	18.7	21.1	23.4	26.1	28.9	32.2	35.6	39.6	43.7
400	9.8	10.9	12.3	13.7	15.3	17	19.1	21.2	23.7	26.2	29.4	32.5	36.3	40.1	44.7	49.3
450	11	12.2	13.8	15.3	17.2	19.1	21.5	23.8	26.7	29.5	33.1	36.6	40.9	45.1	50.2	55.4

Dimensions & Pressure Rating Chart for HDPE pipes as per BS EN 12201-2

Grade	PIPE SERIES																	
	S 2.5		S 3.2		S 4		S 5		S 6.3		S 8		S 10		S 12.5		S 16	
	SDR 6		SDR 7.4		SDR 9		SDR 11		SDR 13.6		SDR 17		SDR 21		SDR 26		SDR 33	
	Nominal pressure, PN in bar																	
PE 80	PN 25		PN 20		PN 16		PN 12.5		PN 10		PN 8		PN 6		PN 5		PN 4	
PE 100	-		PN 25		PN 20		PN 16		PN 12.5		PN 10		PN 8		PN 6		PN 5	
Nominal Dia.	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
16	3	3.4	2.3	2.7	2	2.3	--	--	--	--	--	--	--	--	--	--	--	--
20	3.4	3.9	3	3.4	2.3	2.7	2	2.3	--	--	--	--	--	--	--	--	--	--
25	4.2	4.8	3.5	4	3	3.4	2.3	2.7	2	2.3	--	--	--	--	--	--	--	--
32	5.4	6.1	4.4	5	3.6	4.1	3	3.4	2.4	2.8	2	2.3	--	--	--	--	--	--
40	6.7	7.5	5.5	6.2	4.5	5.1	3.7	4.2	3	3.5	2.4	2.8	2	2.3	--	--	--	--
50	8.3	9.3	6.9	7.7	5.6	6.3	4.6	5.2	3.7	4.2	3	3.4	2.4	2.8	2	2.3	--	--
63	10.5	11.7	8.6	9.6	7.1	8	5.8	6.5	4.7	5.3	3.8	4.3	3	3.4	2.5	2.9	--	--
75	12.5	13.9	10.3	11.5	8.4	9.4	6.8	7.6	5.6	6.3	4.5	5.1	3.6	4.1	2.9	3.3	--	--
90	15	16.7	12.3	13.7	10.1	11.3	8.2	9.2	6.7	7.5	5.4	6.1	4.3	4.9	3.5	4	--	--
110	18.3	20.3	15.1	16.8	12.3	13.7	10	11.1	8.1	9.1	6.6	7.4	5.3	6	4.2	4.8	--	--
125	20.8	23	17.1	19	14	15.6	11.4	12.7	9.2	10.3	7.4	8.3	6	6.7	4.8	5.4	--	--
140	23.3	25.8	19.2	21.3	15.7	17.4	12.7	14.1	10.3	11.5	8.3	9.3	6.7	7.5	5.4	6.1	--	--
160	26.6	29.4	21.9	24.2	17.9	19.8	14.6	16.2	11.8	13.1	9.5	10.6	7.7	8.6	6.2	7	--	--
180	29.9	33	24.6	27.2	20.1	22.3	16.4	18.2	13.3	14.8	10.7	11.9	8.6	9.6	6.9	7.7	--	--
200	33.2	36.7	27.4	30.3	22.4	24.8	18.2	20.2	14.7	16.3	11.9	13.2	9.6	10.7	7.7	8.6	--	--
225	37.4	41.3	30.8	34	25.2	27.9	20.5	22.7	16.6	18.4	13.4	14.9	10.8	12	8.6	9.6	--	--
250	41.5	45.8	34.2	37.8	27.9	30.8	22.7	25.1	18.4	20.4	14.8	16.4	11.9	13.2	9.6	10.7	--	--
280	46.5	51.3	38.3	42.3	31.3	34.6	25.4	28.1	20.6	22.8	16.6	18.4	13.4	14.9	10.7	11.9	--	--
315	52.3	57.7	43.1	47.6	35.2	38.9	28.6	31.6	23.2	25.7	18.7	20.7	15	16.6	12.1	13.5	9.7	10.8

Dimensions & Pressure Rating Chart for HDPE pipes as per DIN:8074

Outside Diameter	Pipe Series	Pipe Series	Pipe Series	Pipe Series	Pipe Series	Pipe Series	Pipe Series	Pipe Series	Pipe Series	Pipe Series	Pipe Series
	12.5	10.5	10	8.3	8	6.3	5	4	3.2	2.5	2
20	--	--	--	--	--	1.8	1.9	2.3	2.8	3.4	4.1
25	--	--	--	--	1.8	1.9	2.3	2.8	3.5	4.2	5.1
32	--	--	--	1.8	1.9	2.4	2.9	3.6	4.4	5.4	6.5
40	1.8	1.9	1.9	2.3	2.4	3	3.7	4.5	5.5	6.7	8.1
50	2	2.3	2.4	2.9	3	3.7	4.6	5.6	6.9	8.3	10.1
63	2.5	2.9	3	3.6	3.8	4.7	5.8	7.1	8.6	10.5	12.7
75	2.9	3.5	3.6	4.3	4.5	5.6	6.8	8.4	10.3	12.5	15.1
90	3.5	4.1	4.3	5.1	5.4	6.7	8.2	10.1	12.3	15	18.1
110	4.2	5	5.3	6.3	6.6	8.1	10	12.3	15.1	18.3	22.1

Butt-Welding (Procedure)

Check the Wall Alignment and Gap

The alignment of the two parts should be checked at the same time. A possible misalignment on the outside must not exceed 10% of the thickness of the wall. If this limit is exceeded, a better clamping position is to be sought by rotating the pipe. In such a case, however, the surface must be re-planed. Important - The welding surfaces must be planed immediately prior to the jointing.

Once it has attained the fusion temperature, position the heating element in the butt-welding machine. Press the parts to be joined against the heating element with the force required for equalization until the entire circumference of each of the jointing faces rests completely against it and a bead has formed. Reduce the equalization pressure almost to zero. The heating time listed in the table below is measured from this moment.

Leave parts in the butt-welding jointing machine at welding pressure until the end of the cooling period. Once the heating period has elapsed, remove the parts from heating element, which should then be removed without touching the jointing surfaces and push the parts together immediately. The change over time must not exceed the value listed in the table. Pay particular attention during jointing that the parts be moved together swiftly until the surface are about to touch. Then they should be moved together so that they are in contact along the entire circumference. Next the pressure should be increased rapidly to the present jointing within the period of time specified in the table below. This pressure must be necessary, especially shortly after the jointing pressure has been attained. The jointing parts must stay in the welding machine under jointing pressure until the end of the cooling period specified in the table.

Welding bead checks

A bead should form around the entire circumference of the pipe. Jointing of two-lip point should be above the pipe circumference means always being positive.

Handling and Storage

Proper Handling of Pipes



- **Impact Prevention:** Avoid dropping, dragging, or throwing pipes during handling. Sudden impact may cause stress fractures or joint damage.
- **Lifting Guidelines:** Use padded pipe tongs, wide slings, or fork protectors. Chains, hooks, or bare forks may gouge or scar the pipe surface.
- **Inspection on Delivery:** Check all PE pipes and fittings on arrival for cracks, warping, or joint-end damage due to transit or handling.

Storage of Pipes

PE Pipes and Fittings must be stored in a dry, shaded, and well-ventilated location. If outdoor storage is unavoidable, the following best practices must be observed to maintain product performance and installation safety:



- **UV Protection:** Shield from direct sunlight using UV-resistant tarpaulin or sheeting. Ensure ventilation is maintained to prevent heat buildup.
- **Flat Surface Storage:** Pipes must rest on a flat, stable surface. Uneven storage areas may lead to sagging, ovality, or misalignment of sockets.
- **Stacking Alignment:** When stacking, alternate spigot and socket ends to distribute load evenly and avoid deformation of socket geometry.
- **Stacking Height Limit:** Do not exceed recommended stack heights. Excessive weight can distort pipe roundness and compromise sealing surfaces.
- **Rack Spacing:** When using pipe racks, provide support at intervals of not more than 900 mm (3 ft) to prevent bending or bowing.
- **Inspection on Delivery:** Inspect all pipes and fittings immediately upon receipt. Check for any damage, deformation, or cracks—especially at the joint ends.

Note: Improper handling may affect joint integrity and project safety. Always follow local code.



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