

AG 51 møte 18 september 2007

- Borås
- PE 100+ Prosjekt
 - "Store rør"

Svanesund Rör



Pipelife



Pipelife har sertifiserte sveisere og sertifisert utstyr for sveising av alle dimensjoner PE rør.

ISO/DIS 21307

ISO DRAFT INTERNATIONAL STANDARD ISO/DIS 21307
ISO/TC 136/SC 4 Secretariat: NEN
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Plastics pipes and fittings — Butt fusion joining procedures for polyethylene (PE) pipes and fittings used in the construction of gas and water distribution systems

Tubes et raccords en matières plastiques — Procédure d'assemblage par soudage bout à bout de tubes et raccords en polyéthylène (PE) utilisés pour la construction de systèmes de distribution de gaz et d'eau

ICS: 29.040.20; 29.040.42; 75.200

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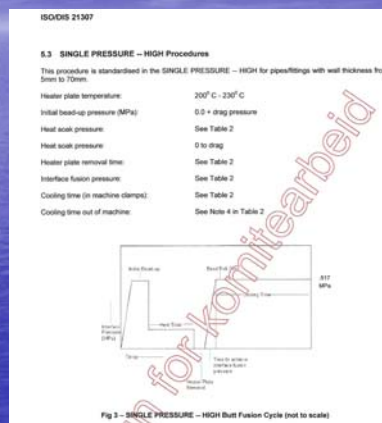
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Single Pressure – High Procedures



Dual Pressure – Low procedures

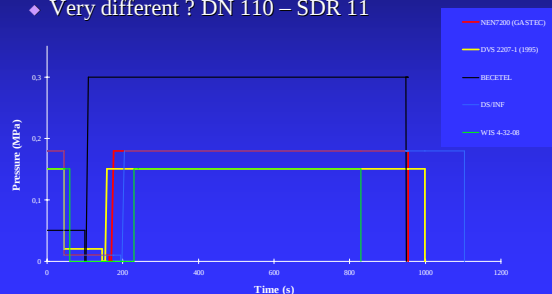


Hvilke parametere bruker du ?

Butt Fusion Jointing of PE Systems

■ Fusion procedure – A multitude of procedures

- ◆ Very different ? DN 110 – SDR 11



Hvilke testmetoder bruker du ?

- Korttidstester ihht. SS-EN-12201 og SS-EN 1555 ?
- Hvordan verifisere langtidshållfasthet på stumsvets ?

PE100+ Prosjektet

- Sveiseparametere som angitt tidligere:
 - Singel Pressure – Low Procedures
 - Singel Pressure – High Procedures ($e=5-70$ mm)
 - Dual Pressure (not recommended for PE80 - after 10 seconds, reduce the pressure to $1/6^{\text{th}}$ of cooling pressure)
- Følgende prioriteres:
 - 2 ulike korttidstestmetoder for stumsvets
 - UK Wis test
 - DVS test
 - 1 langtidstestmetode også for stumsvets

Konklusjon

- Svetsning ansees ikke som et stort problem, og man har derfor nedprioritert svetsningen til fordel for:
- Verifisere hållfastheten, (kort-lang), i håp om harmoniserte test- metoder i Europa.