

Technical Bulletin

Factory Approved 4" Butt Fusion- 14041503



June 29th, 2016

aquatechnik® has approved butt fusing SDR 11 4" PP-RCT 125 and PP-R Super 80 piping. Please note that it is still not recommended to butt fuse SDR 7.4 pipe at this diameter as the inner bead can impede the flow rate of the carried fluid in comparison.

Please find the information required to butt fuse SDR 11 4" PP-RCT 125 or PP-R Super 80 pipe below:

Butt Welding Bead Heights and Welding Times

Nominal Dia.	External Dia.	SDR	Bead Height		Heating Pressure		Heating Time	Max. transition time	Pressure build-up time	Cooling Time
in.	mm		in.	mm	psi	bar		seconds	seconds	min.
4	125	11	1/32	1	15	1	3 min 57 s	7	11	19

Welding Pressures by Manufacturer



Nominal Dia.	External Dia. mm	SDR	Acrobat 160	Dragon 160
in.	mm		psi	bar
4	125	11	101	11.0



Nominal Dia.	External Dia. mm	SDR	Roweld® P 160B	Roweld® P 250B & 355B	WI 4400	WI 4600
in.	mm		bar		bar	
4	125	11	11.5	6.5	17	8

Thank you for your cooperation in this matter. Please feel free to contact us if you require any additional information.