Asahitec™ - Socket Fusion Parameters

VALVES • ACTUATORS • HIGH PURITY PIPING • INDUSTRIAL PIPING • ENVIRONMENTAL PIPING • WET PROCESS SOLUTIONS

Size		Heat Soak Time (sec)	Insertion Depth (in)	Changeover (sec)	Cooling (sec)
mm	inches				
20	1/2	5	0.57	4	2
25	3/4	7	0.63		
32	1	8	0.71	6	4
40	1-1/4	12	0.81		
50	1-1/2	18	0.93		
63	2	24	1.08	8	6
75	2-1/2	30	1.18		
90	3	40	1.30	10	8
110	4	50	1.46		
125	4-1/2	60	1.57		

Notes:

1. DVS2207-11, Process A, Type A inserts.
2. These values are for a room temperature of 68°F (20°C). If room temperature is <41°F (5°C), please contact Asahi/ America for new values.

Asahitec™ Socket Welding Process

1) Create acceptable working conditions. Ensure a safe and isothermal environment.
2) Secure the pair of heater inserts onto the welder.
3) Plug in and turn on welding equipment to 500°F (<10 min to reach temperature)
4) Cut pipe faces at right angles and remove burrs.
5) Use isopropyl alcohol and a non-fraying cloth to clean the pipe and fitting surfaces.
6) Mark the insertion depth, note the heat soaks time, & checks the working area of the heater inserts with a calibrated thermocouple.
7) Simultaneously push the fitting and pipe into the heated inserts. Don't push past the noted insertion depth. Do not let the pipe end bottom out on the heater.
8) Wait for the prescribed heat soak time and then quickly pull the pieces off, without twisting, and immediately push them together. Stop when the melt bead starts to cover the marked insertion depth.
9) Let the joint cool down for the recommended time, before any mechanical loads are applied to the piece.