Electrofusion welded fittings ES16

Supreme

The electrofusion welded fitting package “ES16” is a limited package of PE electrofusion welded fittings for PE100 pipes. These economically attractive electrofusion welded fittings have a moulded-in heater coil that ensures welding of the fitting to the PE pipe as soon as voltage is applied. This results in a high-quality joint.

APPLICATION

High-quality PE joints for gas and water transport (without certification)

CHARACTERISTICS

- Economically attractive electrofusion welded fittings from 32 to 200 mm diameter
- Most common fittings as both sockets and elbows
- Extremely simple welding process by connecting a welding transformer to the fittings (by means of a GF welding unit)
- Packed with a printed bar code sticker per product
- Also for combination with fittings from the ELGEF- and ELGEF+ package
- Welding unit and other equipment can be hired or purchased separately from Netafim

TECHNICAL DATA

Socket sizes	: 63 - 200 mm
Elbow sizes	: 32 - 200 mm
Max. pressure	: 16 bar
Max. temperature	: 60°C (with decreasing max. pressure)
Material	: PE100
Connection	: 4 mm
Special feature	: removable center stop with sockets

INSTALLATION & MAINTENANCE

External fixing is necessary for these fittings during welding.

Welding procedure

Electrofusion welded joints can be easily made by following a few basic rules. 80% of the quality of the joint made is determined by closely following these rules.

1. Start the welding process by inspecting the welding machine and the materials to be welded.
2. Remove any coarse soiling and shorten the pipe at an angle using a pipe cutter or saw.
3. Clean the pipe section to be welded with a dry cloth and then manually scrape 0.2 mm off the surface layer. Use a rotary scraper for this. Never use sandpaper or emery cloth.
4. Degrease the welding zone immediately before assembly using a cleaning cloth or suitable PE cleaning agent (use non-linting, non-pigmented paper).
5. Mark the insertion depth on the pipe.
6. Only now take the fitting out of the packaging. Important: If the welding surface of the fitting has been touched by hand, this must also be cleaned using a cleaning cloth.
7. Push the fitting over the pipe up to the mark or stop. With all diameters, position the pipe with fitting in the fixing clamp and tighten securely.
8. Connect the plugs of the welding device to the fittings using the 4 mm adapter plugs.
9. Read in the welding data from the bar code sticker on the product and check the data on the display. Start the welding process and monitor the welding progress. Record on the pipe the time at which the clamps can be removed again (after welding and cooling time). During welding, the welding indicators on the fitting pop up to indicate that the welding process has started.
10. When the cooling time has expired, the welding clamps can be removed and the fitting is ready for use.