



PLASTIC WELDING

## Useful welding parameter for HD-PE, LD-PE and PVC Membranes

Please note: The final welding parameter will vary depending on the ambient temperature and the material quality. Test welds need to be carried out. All Pressure values are cold settings before heating. These tables are to be used as a guide only. Leister takes no responsibility for poor quality welding!

Wedge	HD-PE							LD-PE				PVC								
	0.3	0.5	1.0	1.5	2.0	2.5	3.0	0.3	0.5	1.0	2.0	0.8	1.0	1.5	2.0	2.5	3.0			
<b>COMET</b>	Copper 95 mm			380° C 3.2 m/min. 600 N	420° C 3.0 m/min. 800 N	420° C 2.8 m/min. 1000 N	420° C 2.5 m/min. 1000 N					400° C 3.2 m/min. 600 N	400° C 3.0 m/min. 800 N							
	Copper 70 mm			380° C 2.5 m/min. 600 N	420° C 2.5 m/min. 800 N	420° C 2.2 m/min. 1000 N	420° C 2.0 m/min. 1000 N					400° C 2.8 m/min. 600 N	400° C 2.5 m/min. 800 N							
	Copper 50 mm		380° C 2.3 m/min. 500 N	420° C 2.2 m/min. 600 N	420° C 2.0 m/min. 800 N					380° C 2.5 m/min. 500 N	420° C 2.5 m/min. 600 N									
	Steel 70 mm																400° C 2.8 m/min. 700 N	420° C 2.5 m/min. 800 N	420° C 2.4 m/min. 1000 N	
	Steel 50 mm													400° C 2.8 m/min. 600 N	420° C 2.5 m/min. 600 N					
	Steel 20 mm	400° C 2.0 m/min. 400 N	420° C 1.5 m/min. 500 N																	350° C 2.0 m/min. 500 N
<b>GEOSTAR G7</b>	230V / 2800W			380° C 7.0 m/min. 900 N	400° C 6.0 m/min. 1050 N	400° C 5.0 m/min. 1200 N	400° C 3.5 m/min. 1300 N	400° C 2.5 m/min. 1400 N					380° C 7.0 m/min. 900 N	380° C 6.0 m/min. 1050 N	380° C 5.0 m/min. 1200 N					
<b>GEOSTAR G5</b>	230V / 2800W			380° C 3.6 m/min. 900 N	400° C 3.0 m/min. 1050 N	400° C 2.5 m/min. 1200 N	400° C 1.8 m/min. 1300 N	400° C 1.3 m/min. 1400 N			380° C 4.5 m/min. 750 N	380° C 3.5 m/min. 900 N	380° C 3.0 m/min. 1050 N	380° C 2.5 m/min. 1200 N		400° C 3.5 m/min. 600 N	400° C 3.0 m/min. 700 N	400° C 3.0 m/min. 750 N	400° C 2.7 m/min. 800 N	400° C 2.5 m/min. 850 N
	120V / 1800W			380° C 3.5 m/min. 900 N	400° C 2.9 m/min. 1050 N	400° C 2.4 m/min. 1200 N	400° C 1.6 m/min. 1300 N	400° C 1.2 m/min. 1400 N			380° C 4.0 m/min. 750 N	380° C 3.0 m/min. 900 N	380° C 2.5 m/min. 1050 N	380° C 2.0 m/min. 1200 N		400° C 3.5 m/min. 600 N	400° C 3.2 m/min. 700 N	400° C 3.0 m/min. 750 N	400° C 2.7 m/min. 800 N	400° C 2.5 m/min. 850 N
<b>Combi Wedge</b>																				
<b>TWINNY T7</b>	Short	400° C 7.0 m/min. 70% Air Vol. 400 N	500° C 6.0 m/min. 80% Air Vol. 600 N	560° C 3.0 m/min. 100% Air Vol. 750 N	560° C 2.2 m/min. 100% Air Vol. 800 N					400° C 7.0 m/min. 70% Air Vol. 400 N	500° C 6.0 m/min. 80% Air Vol. 500 N	560° C 3.0 m/min. 100% Air Vol. 600 N	560° C 2.5 m/min. 100% Air Vol. 700 N	560° C 2.0 m/min. 100% Air Vol. 800 N	500° C 5.5 m/min. 80% Air Vol. 300 N	560° C 4.0 m/min. 100% Air Vol. 400 N	560° C 3.0 m/min. 100% Air Vol. 500 N	560° C 2.0 m/min. 100% Air Vol. 600 N	560° C 1.5 m/min. 100% Air Vol. 650 N	560° C 1.2 m/min. 100% Air Vol. 750 N
	Long			560° C 4.0 m/min. 100% Air Vol. 750 N	560° C 3.0 m/min. 100% Air Vol. 800 N	560° C 2.5 m/min. 100% Air Vol. 850 N							560° C 4.5 m/min. 100% Air Vol. 600 N	560° C 3.5 m/min. 100% Air Vol. 700 N	560° C 3.0 m/min. 100% Air Vol. 800 N		560° C 5.0 m/min. 100% Air Vol. 400 N	560° C 4.0 m/min. 100% Air Vol. 500 N	560° C 3.0 m/min. 100% Air Vol. 600 N	560° C 2.0 m/min. 100% Air Vol. 650 N
<b>TWINNY T5</b>	Short	400° C 5.5 m/min. 70% Air Vol.	500° C 4.5 m/min. 80% Air Vol.	560° C 2.5 m/min. 100% Air Vol.	560° C 1.5 m/min. 100% Air Vol.					400° C 5.5 m/min. 70% Air Vol.	500° C 4.5 m/min. 80% Air Vol.	560° C 2.5 m/min. 100% Air Vol.	560° C 2.0 m/min. 100% Air Vol.	560° C 1.5 m/min. 100% Air Vol.	500° C 4.5 m/min. 80% Air Vol.	560° C 3.5 m/min. 100% Air Vol.	560° C 2.5 m/min. 100% Air Vol.	560° C 1.8 m/min. 100% Air Vol.	560° C 1.2 m/min. 100% Air Vol.	560° C 0.8 m/min. 100% Air Vol.
	Long			560° C 3.0 m/min. 100% Air Vol.	560° C 2.0 m/min. 100% Air Vol.	560° C 1.5 m/min. 100% Air Vol.							560° C 3.5 m/min. 100% Air Vol.	560° C 2.5 m/min. 100% Air Vol.	560° C 2.0 m/min. 100% Air Vol.		560° C 4.0 m/min. 100% Air Vol.	560° C 3.0 m/min. 100% Air Vol.	560° C 2.0 m/min. 100% Air Vol.	560° C 1.5 m/min. 100% Air Vol.

Leister PW GEO Welding Parameters for Welders V-2020\_Metric