



PLASTIC WELDING

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

Please note: The indicated welding parameter may vary depending on the ambient temperature and the material configuration. Test welds need to be done and the parameter aligned accordingly! Leister takes no responsibility for poor quality welding!

Wedge			HD-PE							LD-PE					PVC, Attention: Steel wedge only!							
			0.3	0.5	1.0	1.5	2.0	2.5	3.0	0.3	0.5	1.0	1.5	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								
		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							350° C 2.0 m/min 400 N				
<b>ASTRO</b>						420° C 4.5 m/min 1250 N	420° C 4.0 m/min 1500 N	420° C 3.0 m/min 1500 N	420° C 2.0 m/min 1500 N													
<b>GEOSTAR G7</b> 230 V / 2800 W					380° C 9.0 m/min 1000 N	400° C 8.0 m/min 1250 N	400° C 6.0 m/min 1500 N	400° C 4.0 m/min 1500 N	400° C 2.5 m/min 1500 N				360° C 7.0 m/min 1000 N	360° C 6.0 m/min 1000 N	360° C 5.0 m/min 1250 N							
<b>GEOSTAR G5</b> 230 V / 2800 W					380° C 6.0 m/min 1000 N	400° C 5.0 m/min 1250 N	400° C 3.0 m/min 1500 N	400° C 2.0 m/min 1500 N	400° C 1.5 m/min 1500 N				360° C 6.0 m/min 800 N	360° C 5.0 m/min 1000 N	360° C 3.0 m/min 1000 N	360° C 2.0 m/min 1250 N		400° C 3.5 m/min 650 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 800 N
<b>GEOSTAR G5</b> 120 V / 1800 W					360° C 5.0 m/min 1000 N	400° C 3.5 m/min 1250 N	400° C 2.6 m/min 1500 N	400° C 1.6 m/min 1500 N	400° C 1.2 m/min 1500 N				360° C 5.0 m/min 800 N	360° C 3.5 m/min 1000 N	360° C 2.5 m/min 1000 N	360° C 1.5 m/min 1250 N		400° C 3.5 m/min 650 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 800 N
<b>Combi Wedge</b>																						
<b>TWINNY S</b>	Short	450° C 3.5 m/min 400 N	500° C 3.0 m/min 500 N	500° C 2.0 m/min 800 N						480° C 3.5 m/min 400 N	500° C 3.0 m/min 500 N	500° C 2.0 m/min 600 N			500° C 2.5 m/min 400 N	550° C 2.5 m/min 500 N	600° C 2.5 m/min 600 N					
	Long				550° C 2.0 m/min 800 N	550° C 1.8 m/min 1000 N							500° C 2.5 m/min 600 N	550° C 2.0 m/min 700 N				550° C 2.5 m/min 600 N	580° C 2.5 m/min 700 N	600° C 2.0 m/min 800 N		
<b>TWINNY T</b>	Short	420° C 3.2 m/min 400 N	500° C 3.0 m/min 500 N	500° C 2.0 m/min 800 N						450° C 3.2 m/min 400 N	500° C 3.0 m/min 500 N	500° C 2.0 m/min 600 N			500° C 2.5 m/min 400 N	550° C 2.5 m/min 500 N	560° C 2.3 m/min 600 N					
	Long				550° C 2.0 m/min 800 N	550° C 1.8 m/min 1000 N							500° C 2.5 m/min 600 N	550° C 2.0 m/min 700 N				550° C 2.5 m/min 600 N	550° C 2.5 m/min 800 N	560° C 2.0 m/min 1000 N		