



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

PLASTIC WELDING

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!

		HD-PE (mm)						LD-PE (mm)					PVC (mm)						
		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
Combi wedge	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. 700 N	560° C 3.5 m/min. 100% Air vol. 800 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. 100% Air vol.	560° C 1.5 m/min. 100% Air vol. 750 N
TWINNY T7	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.	560° C 1.0 m/min. 100% Air vol.

														Steel wedge required					
Wedge	90 mm	COMET 700	400° C 5.0 m/min. 700 N	400° C 4.5 m/min. 900 N	400° C 4.0 m/min. 900 N	400° C 3.5 m/min. 1000 N				350° C 5.5 m/min. 700 N	380° C 5.0 m/min. 750 N	380° C 4.5 m/min. 800 N		400° C 4.0 m/min. 550 N	400° C 3.2 m/min. 600 N	400° C 3.0 m/min. 650 N	400° C 2.7 m/min. 700 N	400° C 2.5 m/min. 750 N	
			60 mm	400° C 5.0 m/min. 600 N	400° C 4.5 m/min. 700 N	400° C 3.5 m/min. 800 N	400° C 3.0 m/min. 900 N			300° C 5.0 m/min. 650 N	350° C 4.5 m/min. 700 N	380° C 4.0 m/min. 750 N	380° C 3.5 m/min. 800 N		400° C 3.0 m/min. 550 N	400° C 2.7 m/min. 600 N	400° C 2.5 m/min. 650 N	400° C 2.3 m/min. 700 N	400° C 2.0 m/min. 750 N
COMET 500	60 mm	400° C 4.0 m/min. max. pressure	400° C 3.5 m/min. max. pressure	400° C 3.0 m/min. max. pressure	400° C 2.5 m/min. max. pressure			300° C 4.5 m/min. ¼ pressure	350° C 4.0 m/min. ¼ pressure	380° C 3.5 m/min. ¼ pressure	380° C 3.0 m/min. ¼ pressure		400° C 3.0 m/min. ½ pressure	400° C 2.7 m/min. ½ pressure	400° C 2.5 m/min. ½ pressure	400° C 2.3 m/min. ½ pressure	400° C 2.0 m/min. ½ pressure		
GEOSTAR G7	230 V/2800 W		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							
GEOSTAR G5	230 V/2800 W		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 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 3.2 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	
GEOSTAR G5	120 V/1800 W		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 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	

Leister PW GEO Welding Parameters for Welders V-2022_Metric