

DVGW registration number DV-8606BO0315 + DV-8611BO0316  
DVGW test mark for gas EN 1555 and water EN 12201 corresponds to GW 335/B2

## 1. Intended use / product description:



HA-WELD® welding clamps are to be used for welding on PE pipes according to DIN 8074. The drilling saddle made of polyethylene (PE 100) is melted and welded at the connecting surfaces (outer pipe surface and inner surface of the heating coil drilling saddle) with the aid of the resistance wires (invisible heating coil) integrated in the saddle. The metal connections integrated in the upper part of the saddle are used to accommodate valves/service valves or further pipelines or a drilling T-piece.

**Medium:** Water/Gas

**Max. operating pressure:** Gas: 10 bar  
Potable water: 16 bar

**Material:** Top and bottom heat part: PE 100  
Thread insert: stainless steel  
ZAK®-insert: brass

When laying the pipes and during installation, it is necessary to refer to and comply with applicable standards and regulations, accident prevention regulations and regulations from trade associations. The installation of the HA-WELD welding clamp as well as the production of the electrofusion connection may only be carried out by qualified personnel.

## 2. Assembly

### 2.1 Storage

Store articles in the shade. Solar radiation in combination with the film packaging can strongly heat the article. This changes the winding resistance. This can then lead to welding errors.

Caution! Only use welding machines approved by the manufacturer for the welding parameters used (Table T.1, page 4). (see DVS2207, part 1.5.2) The sequence of operations described must be observed.

### 2.2 Fundamentals

The quality of the welding is decisively determined by the careful implementation of the preparatory work. The drilling saddle can be used for SDR 11.17 and 17.6 (for Ø63 only SDR 11.9). Only similar materials can be welded. Here, the materials PE 80 and PE 100 can be regarded as identical and can therefore be welded together.

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### Alignment

Align the upper part of the drilling saddle on the pipeline and mark the welding zone (the pipe surface covered by the saddle) with a suitable pin.

2



### Clean welding zone

According to DVS 2207-1, the pipe surface must be completely and evenly cleaned of the oxide layer in the marked area of the welding zone immediately before installation using a rotary peeling tool (the use of manual scrapers is only permitted in exceptional cases).



#### Caution!

**If the oxide layer is not completely removed, a leaky or defective welded joint may occur.**

**At least 0.2 mm must be completely removed.**

This should result in an even surface without any recesses or scratches on the pipe surface. Sanding, filing or cleaning with solvent is not sufficient and is not permitted. The surface treated in this way must be protected from dirt and grease (such as hand cream, oily cloths, etc.), run-off water and rainwater or frost formation.

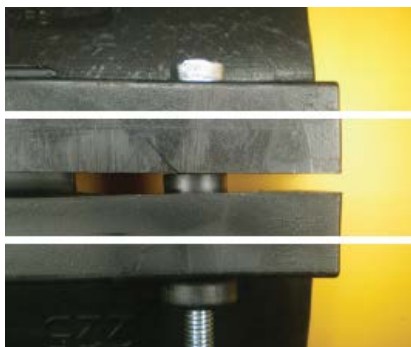
3



### Cleaning

The pipe surfaces to be welded and the inner surfaces of the drilling saddles must be absolutely clean, dry and free of grease. Immediately before assembly (after scraping) the welding surfaces are to be cleaned with 99.9% ethanol (or Tangit KS/Tangit KS cloths) and exclusively with absorbent, non-fibrous and undyed paper. It must be ensured that no dirt from the edge area gets onto the welding surface. The cleaner must have completely evaporated before welding.

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### Assembly of the drilling saddle

Place the upper part with the branch on the cleaned pipe surface and align. Snap the lower part with the clamping hooks into the upper part with the first locking. Remove the screws from the retaining holes and insert them into the holes provided for this purpose. Tighten all four screws evenly by hand. Check the installation position again and tighten the screws evenly as far as possible using a suitable tool. Visually check the contact surface of the saddle on the pipe. The saddle must fit exactly on the pipe in the crown area. Welding should take place immediately after assembly.



**Caution: For lateral assembly, make sure that the bar code is visible upwards for welding. During assembly, make sure that the inner surface of the drilling saddle is not damaged.**



### Welding the drilling saddle

Connect the contacts (version according to EN 1555-3 type A) to the welding machine. Make sure that the contacts are clean and dry, if necessary clean them beforehand. The welding parameters are contained in a bar code which is placed on the side of the saddle. The parameters are read into the welding machine via the stylus (observe the operating instructions of the welding machine). The attached traceability code can also be read with the stylus. Start welding. The data on the display of the welding machine must be compared with the saddle data (see Table T.1). If the barcode is not readable, the parameters can also be entered manually.

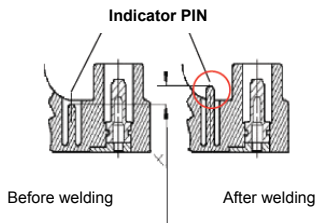


**Caution:** For general safety reasons, keep a distance of 1 m from the welding point during the welding process. Welding while media is leaking is not permitted. The welding process must not be interrupted. Welding with pipe materials other than PE 80/100 is not possible. The welding may only be carried out at ambient temperatures between 0°C and +45°C. Temperature differences between pipe and drilling saddle must be avoided.

**Caution:** If the cooling time is not observed, the saddle may be separated from the pipe in the welding plane. The lower half of the saddle must not be dismantled or loosened during this time.

### Review

After completion of the welding process, check whether the welding has been carried out correctly: no error indication on the display of the welding machine (observe operating instructions of the welding machine)



### Indicator Pin

The indicator pin only indicates that welding has been carried out. A statement about the achieved quality is not given. Depending on the gap between saddle and pipe, the outlet height may vary. The correct welding sequence is only indicated by the welding machine.

### Labelling

The welding point must be marked captively with a suitable marking (e.g. SNOWMAN SILVER MARKER) with the position from the installation plan. The welding must be documented with the protocol of the welding machine.








### Welding defect

If a welding fault (winding short circuit) is indicated on the welding machine, the welding must be rejected. If no pipe penetration (drilling) has yet taken place, the saddle piece can remain on the pipe, but must be permanently marked as defective welding. At a new position, the assembly and welding must be repeated.



**It is not allowed to use the used drilling saddle for repeat welding.**

## T.1 Welding parameter

Pipe Ø	welding stress	resistor	weld time	cool-down period	No. for barcode Code Interleaved 2 of 5 with checksum
63mm	10 V	0,40 Ω	110 sec.	20 min.	 080123330633100405110556
90mm	18 V	0,90 Ω	210 sec.	30 min.	 080123340903180905210555
110mm	20 V	0,90 Ω	225 sec.	30 min.	 080123341103200905225559
125mm	20 V	0,90 Ω	225 sec.	30 min.	 080123341253200905225553
160mm	20 V	0,90 Ω	225 sec.	30 min.	 080123341603200905225554
180mm	20 V	0,90 Ω	225 sec.	30 min.	 080123341803200905225552
225mm	20 V	0,90 Ω	225 sec.	30 min.	 080123342253200905225550

## 3. Service and maintenance

The HA-WELD welding clamp is maintenance-free.

## 4. Commissioning and pressure testing

After successful welding, a pressure test must be carried out in an open pipe trench in accordance with DVGW regulations, observing the specified minimum cooling time.

[Should you have questions or need further information, please contact:](#)

Hawle Armaturen GmbH  
- Application Engineering -  
Liegnitzer Str. 6  
83395 Freilassing  
Telephone: +49 8654 6303-0  
Fax: +49 8654 6303-222  
Email: [info@hawle.de](mailto:info@hawle.de)  
Website: [www.hawle.de](http://www.hawle.de)