

承插/对接/电熔全系列PE管件



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全系列PE管件

诸暨市高晖机械有限公司

ZHUJI GAOHUI MACHINERY CO., LTD.

(诸暨市长荣机械有限公司)

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企业简介 Company Profile>>>>

诸暨市高晖机械有限公司（原诸暨市长荣机械有限公司）成立于2002年3月13日，是一家专业生产HDPE给水管件的大型生产企业，位于浙江省诸暨市店口镇三江口工业园区内，占地50亩，交通便捷、地理位置优越，现已是投资兴业的一片热土。

我司在生产HDPE给水管件领域有着深厚的技术和丰富的经验；在PE给水管件制造领域中年生产用料达8000余吨，并拥有配套齐全的注塑设备，所有常规所需用到的规格一应俱全，是您各种工程项目理想的PE管材、PE管件配套供应商；（工程所需产品可配套也可单独供应将为您的项目大大降低工程造价）。另外我司也可根据公斤压力等级的不同为客户提供各种压力等级的PE管材、管件，产品价格在全国具有竞争优势！目前我司所生产的HDPE管件已在东南亚、南非等国家大面发展开拓。

诸暨市高晖机械有限公司目前拥有400-100000克电自动化控制的PE管件注塑机50台，专用模具1000余副，能生产直径20-1000MM的600余种规格热熔、电熔的承插及对接HDPE给水管件，一次成型管件最大可做到1000mm，法兰根最大可到1200mm；我司的检测设备齐全，各类产品定期开展耐压爆破试验、耐力开裂实验、纵向回缩率、拉力试验以及熔融指数等试验，从原材料到成品各个环节的质量全部符合国家标准。公司所生产的各类PE管材、PE管件经国家化学建筑材料测试中心检测，各项性能指标均符合GB15558.2-2005和GB13663-2000等标准要求，并且在行业内率先通过了ISO9001-2000国际标准质量体系认证、ISO9001-14000环境体系认证以及德国TUV认证等一系列资格认证。产品符合国标所有指标要求，保证质量，可通过国内、国际一切第三方权威机构检测。

公司始终坚持“以质量求生存、以信誉求发展”为经营方针，坚持以“为客户创造价值”为企业宗旨，热忱欢迎国内外客商来我司考察、指导，我司将以“过硬的质量、信誉、服务”与各界朋友真诚合作，共创未来！

Zhuji gaohui Machinery Co., Ltd. (formerly Zhuji Changrong Machinery Co., Ltd.) was established on March 13, 2002. It is a large-scale manufacturer specializing in the production of HDPE water supply pipe fittings. Located in Sanjiangkou Industrial Park, Diankou Town, Zhuji City, Zhejiang Province, it covers an area of 35000 M², has convenient transportation and superior geographical location, and is now a hot land for investment and industry.

Our company has profound technology and rich experience in the field of producing HDPE water supply pipe fittings; in the field of PE water supply pipe fittings manufacturing, the middle-aged production materials are more than 8000 tons, and we have a complete set of injection molding equipment, all the conventional specifications are available, and we are the ideal PE pipe and PE pipe fittings suppliers for your various projects; (the products required for the project can be matched or supplied separately Will greatly reduce the project cost for your project). In addition, we can also provide all kinds of PE pipes and pipe fittings according to different kilogram pressure grades. The product price has a competitive advantage in China! At present, HDPE pipe fittings produced by our company have been widely developed in Southeast Asia, South Africa and other countries. Zhuji City gaohui Machinery Co., Ltd. currently has 50 PE pipe injection molding machines with 400-100000 grams of electric automation control, more than 1000 special molds, and can produce more than 600 specifications of hot-melt, electric fusion socket and butt joint HDPE water supply pipe fittings with a diameter of 20-1000mm. The maximum length of one-time forming pipe fittings can be 1000mm, and the maximum length of flange root can be 1200mm.

Our company has complete testing equipment, and all kinds of products are carried out regularly. The quality of all links from raw materials to finished products meet the national standards through pressure blasting test, endurance cracking test, longitudinal shrinkage test, tensile test and melt index test. All kinds of PE pipes and pipe fittings produced by the company have been tested by the national chemical building materials testing center, and all performance indexes meet the requirements of gbt15558.2-2005 and gbt13663-2000 standards. In addition, the company has taken the lead in the industry in passing a series of qualification certificates such as ISO9001-2000 international standard quality system certification, ISO9001-14000 environmental system certification and German TUV certification. The products meet all the requirements of the national standard and guarantee the quality. They can be tested by all the third-party authorities at home and abroad.

The company always adheres to the management policy of "quality for survival, reputation for development" and the enterprise tenet of "creating value for customers". Warmly welcome domestic and foreign businessmen to visit and guide us. We will sincerely cooperate with friends from all walks of life with "excellent quality, reputation and service" to create a future together!

ZHUJI GAOHUI MACHINERY CO., LTD.




 承插直接
Socket Fusion Coupler

规格 Specifications(mm)	SDR11	订货编号 Item number
S20	✓	PE0001
S25	✓	PE0002
S32	✓	PE0003
S40	✓	PE0004
S50	✓	PE0005
S63	✓	PE0006
S75	✓	PE0007
S90	✓	PE0008
S110	✓	PE0009


 承插异径直接
Socket Fusion
Reducing Coupler

规格 Specifications(mm)	SDR11	订货编号 Item number
S25 × 20	✓	PE0010
S32 × 20	✓	PE0011
S32 × 25	✓	PE0012
S40 × 20	✓	PE0013
S40 × 25	✓	PE0014
S40 × 32	✓	PE0015
S50 × 20	✓	PE0016
S50 × 25	✓	PE0017
S50 × 32	✓	PE0018
S50 × 40	✓	PE0019
S63 × 20	✓	PE0020
S63 × 25	✓	PE0021
S63 × 32	✓	PE0022
S63 × 40	✓	PE0023
S63 × 50	✓	PE0024
S75 × 25	✓	PE0025
S75 × 32	✓	PE0026
S75 × 40	✓	PE0027
S75 × 50	✓	PE0028
S75 × 63	✓	PE0029
S90 × 25	✓	PE0030
S90 × 32	✓	PE0031
S90 × 40	✓	PE0032
S90 × 50	✓	PE0033
S90 × 63	✓	PE0034
S90 × 75	✓	PE0035
S110 × 25	✓	PE0036
S110 × 32	✓	PE0037
S110 × 40	✓	PE0038
S110 × 50	✓	PE0039
S110 × 63	✓	PE0040
S110 × 75	✓	PE0041
S110 × 90	✓	PE0042


 承插等径三通
Socket Fusion Tee

规格 Specifications(mm)	SDR11	订货编号 Item number
T20	✓	PE0043
T25	✓	PE0044
T32	✓	PE0045
T40	✓	PE0046
T50	✓	PE0047
T63	✓	PE0048
T75	✓	PE0049
T90	✓	PE0050
T110	✓	PE0051


 承插异径三通
Socket Fusion
Reducing Tee

规格 Specifications(mm)	SDR11	订货编号 Item number
T25 × 20	✓	PE0052
T32 × 20	✓	PE0053
T32 × 25	✓	PE0054
T40 × 20	✓	PE0055
T40 × 25	✓	PE0056
T40 × 32	✓	PE0057
T50 × 20	✓	PE0058
T50 × 25	✓	PE0059
T50 × 32	✓	PE0060
T50 × 40	✓	PE0061
T63 × 20	✓	PE0062
T63 × 25	✓	PE0063
T63 × 32	✓	PE0064
T63 × 40	✓	PE0065
T63 × 50	✓	PE0066
T75 × 25	✓	PE0067
T75 × 32	✓	PE0068
T75 × 40	✓	PE0069
T75 × 50	✓	PE0070
T75 × 63	✓	PE0071
T90 × 25	✓	PE0072
T90 × 32	✓	PE0073
T90 × 40	✓	PE0074
T90 × 50	✓	PE0075
T90 × 63	✓	PE0076
T90 × 75	✓	PE0077
T110 × 25	✓	PE0078
T110 × 32	✓	PE0079
T110 × 40	✓	PE0080
T110 × 50	✓	PE0081
T110 × 63	✓	PE0082
T110 × 75	✓	PE0083
T110 × 90	✓	PE0084


 承插90° 弯头
Socket Fusion Elbow 90°

规格 Specifications(mm)	SDR11	订货编号 Item number
L20	✓	PE0085
L25	✓	PE0086
L32	✓	PE0087
L40	✓	PE0088
L50	✓	PE0089
L63	✓	PE0090
L75	✓	PE0091
L90	✓	PE0092
L110	✓	PE0093


 承插45° 弯头
Socket Fusion Elbow 45°

规格 Specifications(mm)	SDR11	订货编号 Item number
L20	✓	PE0094
L25	✓	PE0095
L32	✓	PE0096
L40	✓	PE0097
L50	✓	PE0098
L63	✓	PE0099
L75	✓	PE0100
L90	✓	PE0101
L110	✓	PE0102


 承插管帽
Socket Fusion End Cap

规格 Specifications(mm)	SDR11	订货编号 Item number
D20	✓	PE0103
D25	✓	PE0104
D32	✓	PE0105
D40	✓	PE0106
D50	✓	PE0107
D63	✓	PE0108
D75	✓	PE0109
D90	✓	PE0110
D110	✓	PE0111


 承插法兰
Socket Fusion Flange

规格 Specifications(mm)	SDR11	订货编号 Item number
FL50	✓	PE0112
FL63	✓	PE0113
FL75	✓	PE0114
FL90	✓	PE0115
FL110	✓	PE0116


 对接等径三通
Butt Fusion Tee

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
T63		✓	✓	Pe0117
T75		✓	✓	PE0118
T90		✓	✓	PE0119
T110		✓	✓	PE0120
T125		✓	✓	PE0121
T140		✓	✓	PE0122
T160		✓	✓	PE0123
T180		✓	✓	PE0124
T200		✓	✓	PE0125
T225		✓	✓	PE0126
T250	✓	✓	✓	PE0127
T280		✓	✓	PE0128
T315	✓	✓	✓	PE0129
T355	✓		✓	PE0130
T400	✓		✓	PE0131
T450	✓		✓	PE0132
T500	✓		✓	PE0133
T560	✓		✓	PE0134
T630	✓		✓	PE0135
T710	✓			PE0136
T800	✓			PE0137


 对接45° 弯头
Butt Fusion Elbow 45°

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
L63		✓	✓	PE0138
L75		✓	✓	PE0139
L90		✓	✓	PE0140
L110		✓	✓	PE0141
L125		✓	✓	PE0142
L140		✓	✓	PE0143
L160		✓	✓	PE0144
L180		✓	✓	PE0145
L200		✓	✓	PE0146
L225		✓	✓	PE0147
L250	✓	✓	✓	PE0148
L280		✓	✓	PE0149
L315	✓	✓	✓	PE0150
L355	✓		✓	PE0151
L400	✓		✓	PE0152
L450	✓		✓	PE0153
L500	✓		✓	PE0154
L560	✓			PE0155
L630	✓		✓	PE0156
L710	✓			PE0157
L800	✓			PE0158


 对接90° 弯头
Butt Fusion
Elbow90°

 对接管帽
Butt Fusion
End Cap

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
L63		✓	✓	PE0159
L75		✓	✓	PE0160
L90		✓	✓	PE0161
L110		✓	✓	PE0162
L125		✓	✓	PE0163
L140		✓	✓	PE0164
L160		✓	✓	PE0165
L180		✓	✓	PE0166
L200		✓	✓	PE0167
L225		✓	✓	PE0168
L250	✓	✓	✓	PE0169
L280		✓	✓	PE0170
L315	✓	✓	✓	PE0171
L355	✓		✓	PE0172
L400	✓		✓	PE0173
L450	✓		✓	PE0174
L500	✓		✓	PE0175
L560	✓		✓	PE0176
L630	✓		✓	PE0177
L710	✓			PE0178
L800	✓			PE0179

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
D75		✓	✓	PE0180
D90		✓	✓	PE0181
D110		✓	✓	PE0182
D125		✓	✓	PE0183
D140		✓	✓	PE0184
D160		✓	✓	PE0185
D180		✓	✓	PE0186
D200		✓	✓	PE0187
D225		✓	✓	PE0188
D250		✓	✓	PE0189
D280		✓	✓	PE0190
D315		✓	✓	PE0191
D355	✓		✓	PE0192
D400	✓		✓	PE0193
D450	✓		✓	PE0194
D500	✓		✓	PE0195
D630	✓		✓	PE0196
D710	✓			PE0197
D800	✓			PE0198
D900	✓			PE0199
D1000	✓			PE0200


 对接等径四通
Butt Fusion
Cross Tee

 抢修节
Repair Clamp Saddle

 斜三通
Butt Fusion Y Tee

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
+63		✓	✓	PE0201
+75		✓	✓	PE0202
+90		✓	✓	PE0203
+110		✓	✓	PE0204
+125		✓	✓	PE0205
+140			✓	PE0206
+160		✓	✓	PE0207
+200		✓	✓	PE0208
+225		✓	✓	PE0209
+250		✓	✓	PE0210
+315	✓	✓	✓	PE0211
+355	✓			PE0212
+400	✓		✓	PE0213
+450	✓			PE0214
+500	✓			PE0215
+560	✓			PE0216
+630	✓			PE0217
+710	✓			PE0218
+800	✓			PE0219

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
40	✓		✓	PE0220
50	✓		✓	PE0221
63	✓		✓	PE0222
75	✓		✓	PE0223
90	✓		✓	PE0224
110	✓		✓	PE0225
125	✓		✓	PE0226
140	✓		✓	PE0227
160	✓		✓	PE0228
180	✓		✓	PE0229
200	✓		✓	PE0230
225	✓		✓	PE0231
250	✓		✓	PE0232
280	✓		✓	PE0233
315	✓		✓	PE0234
355	✓		✓	PE0235
400	✓		✓	PE0236

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
Y110		✓		PE0237
Y160		✓		PE0238



对接异径三通
Butt Fusion
Reducing tee

规格 Specifications(mm)	SDR17	SDR136	SDR11	订货编号 Item number
T400×250	✓		✓	PE0307
T400×315	✓		✓	PE0308
T400×355	✓		✓	PE0309
T450×110	✓		✓	PE0310
T450×160	✓		✓	PE0311
T450×200	✓		✓	PE0312
T450×250	✓		✓	PE0313
T450×315	✓		✓	PE0314
T450×355	✓		✓	PE0315
T450×400	✓		✓	PE0316
T500×110	✓		✓	PE0317
T500×160	✓		✓	PE0318
T500×200	✓		✓	PE0319
T500×250	✓		✓	PE0320
T500×315	✓		✓	PE0321
T500×400	✓		✓	PE0322
T500×450	✓		✓	PE0323
T560×110	✓		✓	PE0324
T560×160	✓		✓	PE0325
T560×200	✓		✓	PE0326
T560×250	✓		✓	PE0327
T560×315	✓		✓	PE0328
T560×400	✓		✓	PE0329
T560×450	✓		✓	PE0330
T560×500	✓		✓	PE0331
T630×110	✓		✓	PE0332
T630×160	✓		✓	PE0333
T630×200	✓		✓	PE0334
T630×250	✓		✓	PE0335
T630×315	✓		✓	PE0336
T630×400	✓		✓	PE0337
T630×450	✓		✓	PE0338
T630×500	✓		✓	PE0339
T710×110	✓			PE0340
T710×160	✓			PE0341
T710×200	✓			PE0342
T710×250	✓			PE0343
T710×315	✓			PE0344
T710×400	✓			PE0345
T710×500	✓			PE0346
T710×630	✓			PE0347
T800×110	✓			PE0348
T800×160	✓			PE0349
T800×200	✓			PE0350
T800×250	✓			PE0351
T800×315	✓			PE0352
T800×400	✓			PE0353
T800×500	✓			PE0354
T800×630	✓			PE0355

规格 Specifications(mm)	SDR17	SDR136	SDR11	订货编号 Item number
T75×50		✓	✓	PE0239
T75×63		✓	✓	PE0240
T90×40		✓	✓	PE0241
T90×50		✓	✓	PE0242
T90×63		✓	✓	PE0243
T90×75		✓	✓	PE0244
T110×40		✓	✓	PE0245
T110×50		✓	✓	PE0246
T110×63		✓	✓	PE0247
T110×75		✓	✓	PE0248
T110×90		✓	✓	PE0249
T125×50		✓	✓	PE0250
T125×63		✓	✓	PE0251
T125×75		✓	✓	PE0252
T125×90		✓	✓	PE0253
T125×110		✓	✓	PE0254
T140×63		✓	✓	PE0255
T140×75		✓	✓	PE0256
T140×90		✓	✓	PE0257
T140×110		✓	✓	PE0258
T140×125		✓	✓	PE0259
T160×50		✓	✓	PE0260
T160×63		✓	✓	PE0261
T160×75		✓	✓	PE0262
T160×90		✓	✓	PE0263
T160×110		✓	✓	PE0264
T160×125		✓	✓	PE0265
T160×140		✓	✓	PE0266
T180×90		✓	✓	PE0267
T180×110		✓	✓	PE0268
T180×125		✓	✓	PE0269
T180×140		✓	✓	PE0270
T180×160		✓	✓	PE0271
T200×50		✓	✓	PE0272

规格 Specifications(mm)	SDR17	SDR136	SDR11	订货编号 Item number
T200×63		✓	✓	Pe0273
T200×75		✓	✓	PE0274
T200×90		✓	✓	PE0275
T200×110		✓	✓	PE0276
T200×125		✓	✓	PE0277
T200×140		✓	✓	PE0278
T200×160		✓	✓	PE0279
T200×180		✓	✓	PE0280
T225×90		✓	✓	PE0281
T225×110		✓	✓	PE0282
T225×160		✓	✓	PE0283
T225×200		✓	✓	PE0284
T250×90		✓	✓	PE0285
T250×110	✓	✓	✓	PE0286
T250×160		✓	✓	PE0287
T250×200		✓	✓	PE0288
T280×110		✓	✓	PE0289
T280×160		✓	✓	PE0290
T280×200		✓	✓	PE0291
T280×250		✓	✓	PE0292
T315×90		✓	✓	PE0293
T315×110	✓	✓	✓	PE0294
T315×160	✓	✓	✓	PE0295
T315×200	✓	✓	✓	PE0296
T315×225		✓	✓	PE0297
T315×250	✓	✓	✓	PE0298
T355×110	✓		✓	PE0299
T355×160	✓		✓	PE0300
T355×200	✓		✓	PE0301
T355×250	✓		✓	PE0302
T355×315	✓		✓	PE0303
T400×110	✓		✓	PE0304
T400×160	✓		✓	PE0305
T400×200	✓		✓	PE0306



对接异径直接
Butt Fusion
Reducer

规格 Specifications(mm)	SDR17	SDR136	SDR11	订货编号 Item number
S75×50		✓	✓	PE0356
S75×63		✓	✓	PE0357
S90×40		✓	✓	PE0358
S90×50		✓	✓	PE0359
S90×63		✓	✓	PE0360
S90×75		✓	✓	PE0361
S110×40		✓	✓	PE0362
S110×50		✓	✓	PE0363
S110×63		✓	✓	PE0364
S110×75		✓	✓	PE0365
S110×90		✓	✓	PE0366
S125×50		✓	✓	PE0367
S125×63		✓	✓	PE0368
S125×75		✓	✓	PE0369
S125×90		✓	✓	PE0370
S125×110		✓	✓	PE0371
S140×63		✓	✓	PE0372
S140×75		✓	✓	PE0373
S140×90		✓	✓	PE0374
S140×110		✓	✓	PE0375
S140×125		✓	✓	PE0376
S160×63		✓	✓	PE0377
S160×75		✓	✓	PE0378
S160×90		✓	✓	PE0379
S160×110		✓	✓	PE0380
S160×125		✓	✓	PE0381
S160×140		✓	✓	PE0382
S180X63		✓	✓	PE0383
S180X75		✓	✓	PE0384

规格 Specifications(mm)	SDR17	SDR136	SDR11	订货编号 Item number
S180X90		✓	✓	Pe0385
S180×110		✓	✓	PE0386
S180×125		✓	✓	PE0387
S180×140		✓	✓	PE0388
S180×160		✓	✓	PE0389
S200×63		✓	✓	PE0390
S200×75		✓	✓	PE0391
S200×90		✓	✓	PE0392
S200×110		✓	✓	PE0393
S200×125		✓	✓	PE0394
S200X140		✓	✓	PE0395
S200×160		✓	✓	PE0396
S200×180		✓	✓	PE0397
S225×110		✓	✓	PE0398
S225×125		✓	✓	PE0399
S225×160		✓	✓	PE0400
S225×180		✓	✓	PE0401
S225×200		✓	✓	PE0402
S250×110		✓	✓	PE0403
S250×125		✓	✓	PE0404
S250×160		✓	✓	PE0405
S250X180		✓	✓	PE0406
S250×200		✓	✓	PE0407
S250×225		✓	✓	PE0408
S280×110		✓	✓	PE0409
S280×160		✓	✓	PE0410
S280×200		✓	✓	PE0411
S280×225		✓	✓	PE0412
S280×250		✓	✓	PE0413

规格 Specifications(mm)	SDR17	SDR136	SDR11	订货编号 Item number
S315×110		✓	✓	PE0414
S315×160		✓	✓	PE0415
S315×180		✓	✓	PE0416
S315×200		✓	✓	PE0417
S315×225		✓	✓	PE0418
S315×250		✓	✓	PE0419
S315×280		✓	✓	PE0420
S355×110	✓		✓	PE0421
S355×160	✓		✓	PE0422
S355×200	✓		✓	PE0423
S355×250	✓		✓	PE0424
S355×280	✓		✓	PE0425
S355×315	✓		✓	PE0426
S400×110	✓		✓	PE0427
S400×160	✓		✓	PE0428
S400×200	✓		✓	PE0429
S400×225	✓		✓	PE0430
S400×250	✓		✓	PE0431
S400×280	✓		✓	PE0432
S400×315	✓		✓	PE0433
S400×355	✓		✓	PE0434
S450×200	✓		✓	PE0435
S450×225	✓		✓	PE0436
S450×250	✓		✓	PE0437
S450×280	✓		✓	PE0438
S450×315	✓		✓	PE0439
S450×355	✓		✓	PE0440
S450×400	✓		✓	PE0441
S500×200	✓		✓	PE0442
S500×250	✓		✓	PE0443
S500×315	✓		✓	PE0444
S500×355	✓		✓	PE0445
S500×400	✓		✓	PE0446
S500×450	✓		✓	PE0447
S560×315	✓		✓	PE0448
S560×355	✓		✓	PE0449
S560×400	✓		✓	PE0450
S560×450	✓		✓	PE0451
S560×500	✓		✓	PE0452
S630×315	✓		✓	PE0453
S630×400	✓		✓	PE0454
S630×450	✓		✓	PE0455
S630×500	✓		✓	PE0456
S630×560	✓		✓	PE0457



对接法兰
Butt Fusion
Flange

规格 Specifications(mm)	SDR21	SDR17	SDR13.6	SDR11	订货编号 Item number
FL50			✓	✓	PE0458
FL63			✓	✓	PE0459
FL75			✓	✓	PE0460
FL90			✓	✓	PE0461
FL110			✓	✓	PE0462
FL125			✓	✓	PE0463
FL140			✓	✓	PE0464
FL160			✓	✓	PE0465
FL160 (short)			✓	✓	PE0466
FL180FL200			✓	✓	PE0467
FL200 (short)			✓	✓	PE0468
FL225			✓	✓	PE0469
FL250			✓	✓	PE0470
FL280			✓	✓	PE0471
FL315			✓	✓	PE0472
FL355		✓		✓	PE0473
FL400	✓	✓		✓	PE0474
FL450	✓	✓		✓	PE0475
FL500	✓	✓		✓	PE0476
FL560		✓		✓	PE0477
FL630		✓		✓	PE0478
FL710		✓			PE0479
FL800		✓			PE0480
FL900		✓			PE0481
FL1000		✓			PE0482
FL1200		✓			PE0483



对接异径四通
Butt Fusion
Reducing Cross
>>>>>

规格 Specifications(mm)	SDR17	SDR13.6	SDR11	订货编号 Item number
+90 × 63			✓	PE0484
+110 × 63		✓	✓	PE0485
+110 × 75		✓		PE0486
+110 × 90		✓		PE0487
+160 × 63		✓		PE0488
+160 × 75		✓	✓	PE0489
+160 × 90		✓	✓	PE0490
+160 × 110		✓	✓	PE0491
+200 × 110		✓		PE0492
+200 × 160		✓		PE0493
+225 × 110		✓		PE0494
+225 × 160		✓		PE0495
+225 × 200		✓		PE0496
+250 × 110		✓		PE0497
+250 × 160		✓		PE0498
+250 × 200		✓		PE0499
+315 × 110		✓		PE0500
+315 × 160		✓		PE0501
+315 × 200		✓		PE0502
+315 × 250		✓	✓	PE0503
+355 × 200	✓			PE0504
+400 × 110	✓			PE0505
+400 × 200	✓		✓	PE0506
+450 × 200	✓			PE0507
+450 × 315	✓			PE0508
+500 × 110	✓			PE0509
+500 × 160	✓			PE0510
+500 × 200	✓			PE0511
+500 × 250	✓			PE0512
+500 × 315	✓			PE0513
+500 × 400	✓			PE0514
+560 × 200	✓			PE0515
+560 × 315	✓			PE0516
+630 × 200	✓			PE0517
+630 × 315	✓			PE0518
+710 × 200	✓			PE0519
+710 × 315	✓			PE0520
+710 × 400	✓			PE0521
+710 × 500	✓			PE0522
+710 × 630	✓			PE0523
+800 × 200	✓			PE0524
+800 × 315	✓			PE0525
+800 × 400	✓			PE0526
+800 × 500	✓			PE0527
+800 × 630	✓			PE0528



PE 增口接
Add Pipe Connector >>>>>



PE 快接
Compression Coupler

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
Φ20	✓	✓	PE0529
Φ25	✓	✓	PE0530
Φ32	✓	✓	PE0531
Φ40	✓	✓	PE0532
Φ50	✓	✓	PE0533
Φ63	✓	✓	PE0534
Φ75	✓	✓	PE0535
Φ90	✓	✓	PE0536
Φ110	✓	✓	PE0537



转换接头 Conversion Tie-in

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
Φ20	✓	✓	PE0538
Φ25	✓	✓	PE0539
Φ32	✓	✓	PE0540

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
20x20	✓	✓	PE0541
25x20	✓	✓	PE0542
25x25	✓	✓	PE0543
32x25	✓	✓	PE0544
32x32	✓	✓	PE0545
40x25	✓	✓	PE0546
40x32	✓	✓	PE0547
50x25	✓	✓	PE0548
50x32	✓	✓	PE0549
63x32	✓	✓	PE0550
63x40	✓	✓	PE0551
63x50	✓	✓	PE0552
63x63	✓	✓	PE0553
75x32	✓	✓	PE0554
75x40	✓	✓	PE0555
75x50	✓	✓	PE0556
75x63	✓	✓	PE0557
75x75	✓	✓	PE0558
90x63	✓	✓	PE0559
90x75	✓	✓	PE0560
90x90	✓	✓	PE0561
110x50	✓	✓	PE0562
110x63	✓	✓	PE0563
110x75	✓	✓	PE0564
110x90	✓	✓	PE0565
110x110	✓	✓	PE0566
125x63	✓	✓	PE0567
125x90	✓	✓	PE0568
125x110	✓	✓	PE0569
140x63	✓	✓	PE0570
140x110	✓	✓	PE0571
160x90	✓	✓	PE0572
160x110	✓	✓	PE0573
160x160	✓	✓	PE0574
200x50	✓	✓	PE0575
200x63	✓	✓	PE0576
200x75	✓	✓	PE0577
200x90	✓	✓	PE0578
200x110	✓	✓	PE0579
200x160	✓	✓	PE0580
200x200	✓	✓	PE0581
225x110	✓	✓	PE0582
225x160	✓	✓	PE0583
250x110	✓	✓	PE0584
250x160	✓	✓	PE0585
250x200	✓	✓	PE0586
315x110	✓	✓	PE0587
315x160	✓	✓	PE0588
315x200	✓	✓	PE0589



内丝直接 Female Coupling

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
S20*1/2F	✓	✓	PE0590
S20*3/4F	✓	✓	PE0591
S25*1/2F	✓	✓	PE0592
S25*3/4F	✓	✓	PE0593
S32*1/2F	✓	✓	PE0594
S32*3/4F	✓	✓	PE0595
S32*1F	✓	✓	PE0596
S40*1-1/4F无角	✓	✓	PE0597
S40*1-1/4F六角	✓	✓	PE0598
S50*1-1/2F无角	✓	✓	PE0599
S50*1-1/2F六角	✓	✓	PE0600
S63*2F无角	✓	✓	PE0601
S63*2F六角	✓	✓	PE0602
S75*2-1/2F无角	✓	✓	PE0603
S75*2-1/2F六角	✓	✓	PE0604
S90*3F无角	✓	✓	PE0605
S90*3F六角	✓	✓	PE0606
S110*4F无角	✓	✓	PE0607
S110*4F六角	✓	✓	PE0608



外丝直接 Male Coupling

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
S20*1/2M	✓	✓	PE0609
S20*3/4M	✓	✓	PE0610
S25*1/2M	✓	✓	PE0611
S25*3/4M	✓	✓	PE0612
S32*1/2M	✓	✓	PE0613
S32*3/4M	✓	✓	PE0614
S32*1M	✓	✓	PE0615
S40*1-1/4M无角	✓	✓	PE0616
S40*1-1/4M六角	✓	✓	PE0617
S50*1-1/2M无角	✓	✓	PE0618
S50*1-1/2M六角	✓	✓	PE0619
S63*2M无角	✓	✓	PE0620
S63*2M六角	✓	✓	PE0621
S75*2-1/2M无角	✓	✓	PE0622
S75*2-1/2M六角	✓	✓	PE0623
S90*3M无角	✓	✓	PE0624
S90*3M六角	✓	✓	PE0625
S110*4M无角	✓	✓	PE0626
S110*4M六角	✓	✓	PE0627



Pe球阀
Ball Valve
>>>>>

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
Φ20	✓	✓	PE0628
Φ25	✓	✓	PE0629
Φ32	✓	✓	PE0630
Φ40	✓	✓	PE0631
Φ50	✓	✓	PE0632
Φ63	✓	✓	PE0633
Φ75	✓	✓	PE0634
Φ90	✓	✓	PE0635
Φ110	✓	✓	PE0636
Φ160	✓	✓	PE0637
Φ75对接	✓	✓	PE0638
Φ90对接	✓	✓	PE0639
Φ110对接	✓	✓	PE0640
Φ160对接	✓	✓	PE0641



内丝弯头 Female Elbow

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
L20 × 1/2F	✓	✓	PE0642
L25 × 1/2F	✓	✓	PE0643
L25 × 3/4F	✓	✓	PE0644
L32 × 1/2F	✓	✓	PE0645
L32 × 3/4F	✓	✓	PE0646
L32 × 1°F	✓	✓	PE0647
L40 × 1/2F	✓	✓	PE0648
L40 × 3/4F	✓	✓	PE0649
L40 × 1°F	✓	✓	PE0650
L40 × 1-1/4F	✓	✓	PE0651
L50 × 1/2F	✓	✓	PE0652
L50 × 3/4F	✓	✓	Pe0653
L50 × 1°F	✓	✓	PE0654
L50 × 1-1/2F	✓	✓	PE0655
L63 × 2°F	✓	✓	PE0656



外丝弯头 Male Elbow

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
L20 × 1/2M	✓	✓	PE0657
L25 × 1/2M	✓	✓	PE0658
L25 × 3/4M	✓	✓	PE0659
L32 × 1/2M	✓	✓	PE0660
L32 × 3/4M	✓	✓	PE0661
L32 × 1°M	✓	✓	PE0662
L40 × 1/2M	✓	✓	PE0663
L40 × 3/4M	✓	✓	PE0664
L40 × 1°M	✓	✓	PE0665
L40 × 1-1/4M	✓	✓	PE0666
L50 × 1/2M	✓	✓	PE0667
L50 × 3/4M	✓	✓	PE0668
L50 × 1°M	✓	✓	PE0669
L50 × 1-1/2M	✓	✓	PE0670
L63 × 2°M	✓	✓	PE0671



全塑活接 Fully Plastic Coupling

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
Φ20	✓	✓	PE0672
Φ25	✓	✓	PE0673
Φ32	✓	✓	PE0674
Φ40	✓	✓	PE0675
Φ50	✓	✓	PE0676
Φ63	✓	✓	PE0677



Pe截止阀
General Stop Valve

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
Φ20	✓	✓	PE0678
Φ25	✓	✓	PE0679
Φ32	✓	✓	PE0680
Φ40	✓	✓	PE0681
Φ50	✓	✓	PE0682
Φ63	✓	✓	PE0683
Φ75	✓	✓	PE0684
Φ90	✓	✓	PE0685
Φ110	✓	✓	PE0686
Φ75对接	✓	✓	PE0687
Φ90对接	✓	✓	PE0688
Φ110对接	✓	✓	PE0689



内丝直接 Female Tee

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
T20 × 1/2F	✓	✓	PE0690
T25 × 1/2F	✓	✓	PE0691
T25 × 3/4F	✓	✓	PE0692
T32 × 1/2F	✓	✓	PE0693
T32 × 3/4F	✓	✓	PE0694
T32 × 1"F	✓	✓	PE0695
T40 × 1/2F	✓	✓	PE0696
T40 × 3/4F	✓	✓	PE0697
T40 × 1F	✓	✓	PE0698
T40 × 1-1/4F	✓	✓	PE0699
T50 × 1/2F	✓	✓	PE0700
T50 × 3/4F	✓	✓	PE0701
T50 × 1"F	✓	✓	PE0702
T50 × 1-1/2F	✓	✓	PE0703
T63 × 2"F	✓	✓	PE0704



外丝直接 Male Tee

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
T20 × 1/2M	✓	✓	PE0705
T25 × 1/2M	✓	✓	PE0706
T25 × 3/4M	✓	✓	PE0707
T32 × 1/2M	✓	✓	PE0708
T32 × 3/4M	✓	✓	PE0709
T32 × 1"M	✓	✓	PE0710
T40 × 1/2M	✓	✓	PE0711
T40 × 3/4M	✓	✓	PE0712
T40 × 1"M	✓	✓	PE0713
T40 × 1-1/4M	✓	✓	PE0714
T50 × 1/2M	✓	✓	PE0715
T50 × 3/4M	✓	✓	PE0716
T50 × 1"M	✓	✓	PE0717
T50 × 1-1/2M	✓	✓	PE0718
T63 × 2"M	✓	✓	PE0719



内丝活接 Female Copper Coupling

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
Φ20	✓	✓	PE0720
Φ25	✓	✓	PE0721
Φ32	✓	✓	PE0722
Φ40	✓	✓	PE0723
Φ50	✓	✓	PE0724
Φ63	✓	✓	PE0725



外丝活接 Male Copper Coupling

规格 Specifications(mm)	SDR13.6	SDR11	订货编号 Item number
Φ20	✓	✓	PE0726
Φ25	✓	✓	PE0727
Φ32	✓	✓	PE0728
Φ40	✓	✓	PE0729
Φ50	✓	✓	PE0730
Φ63	✓	✓	PE0731

热熔焊接连接规程

承插式管材管件安装

INSTALLATION OF SOCKET-TYPE PIPE AND PIPE FITTINGS



一、检查管材表面质量，连接部位清洁无损，断口平整表面光滑无毛刺。测量承口深度，在管材表面作出标记。



二、管口用专用刮刀对管材连接部位表面进行处理，确保周边为新面层，口部宜进行倒角，坡口应为30°，表面坡口长度不大2.0mm。



三、对管件承口面用干布擦擦，清洁表面。



四、将管材、管件同时无旋转地插入加热器，对连接部位加热。



五、加热到预定时间，拔出管材、管件，快速平稳而均匀地将管材推入管件承口中，在承口周围形成凸缘环。管材、管件超过规定冷却时间后方可进行下一步操作。

对焊式管材管件安装

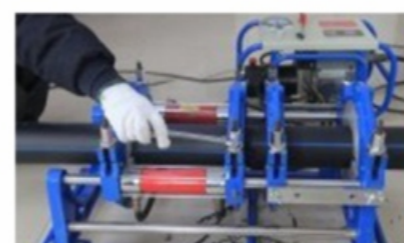
INSTALLATION OF PLASTIC-MAKING TO CONNECT PIPES



检查管材清理端面并紧固管材



铣刀铣削管端面



检查管端面错位和间隙



加热管材并观察最小卷边高度



管材熔接并冷却至规定时间
拿出管材，完成焊接


电熔直接
Electro Fusion Coupler

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
S25		✓	PE0763
S32		✓	PE0764
S40		✓	PE0765
S50		✓	PE0766
S63		✓	PE0767
S75		✓	PE0768
S90		✓	PE0769
S110		✓	PE0770
S125		✓	PE0771
S140		✓	PE0772
S160		✓	PE0773
S200		✓	PE0774
S225		✓	PE0775
S250		✓	PE0776
S280		✓	PE0777
S315	✓	✓	PE0778
S400	✓	✓	PE0779
S500	✓	✓	PE0780
S560	✓		PE0781
S630	✓	✓	PE0782
S710	✓		PE0783
S800	✓		PE0784


电熔45°弯头
Electro Fusion Elbow45°

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
L50		✓	PE0785
L63		✓	PE0786
L75		✓	PE0787
L90		✓	PE0788
L110		✓	PE0789
L125		✓	PE0790
L140		✓	PE0791
L160		✓	PE0792
L200		✓	PE0793
L225		✓	PE0794
L250		✓	PE0795
L315	✓	✓	PE0796
L355	✓	✓	PE0797
L400	✓	✓	PE0798
L450		✓	PE0799
L500	✓	✓	PE0800
L630	✓		PE0801


电熔90°弯头
Electro Fusion Elbow90°

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
L25		✓	PE0802
L32		✓	PE0803
L40		✓	PE0804
L50		✓	PE0805
L63		✓	PE0806
L75		✓	PE0807
L90		✓	PE0808
L110		✓	PE0809
L125		✓	PE0810
L140		✓	PE0811
L160		✓	PE0812
L200		✓	PE0813
L225		✓	PE0814
L250		✓	PE0815
L315	✓	✓	PE0816
L355	✓	✓	PE0817
L400	✓	✓	PE0818
L450		✓	PE0819
L500	✓	✓	PE0820
L630	✓		PE0821


电熔正三通
Electro Fusion Tee

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
T32		✓	PE0822
T40		✓	PE0823
T50		✓	PE0824
T63		✓	PE0825
T75		✓	PE0826
T90		✓	PE0827
T110		✓	PE0828
T125		✓	PE0829
T140		✓	PE0830
T160		✓	PE0831
T200		✓	PE0832
T225		✓	PE0833
T250		✓	PE0834
T315	✓	✓	PE0835
T355	✓	✓	PE0836
T400	✓	✓	PE0837
T450		✓	PE0838
T500	✓	✓	PE0839
T630	✓		PE0840




 电熔异径直接
Electro Fusion
Reducer

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
S32x25		✓	PE0841
S40x32		✓	PE0842
S50x32		✓	PE0843
S50x40		✓	PE0844
S63x32		✓	PE0845
S63x40		✓	PE0846
S63x50		✓	PE0847
S75x50		✓	PE0848
S75x63		✓	PE0849
S90x50		✓	PE0850
S90x63		✓	PE0851
S90x75		✓	PE0852
S110x50		✓	PE0853
S110x63		✓	PE0854
S110x75		✓	PE0855
S110x90		✓	PE0856
S125x75		✓	PE0857
S125x90		✓	PE0858
S125x110		✓	PE0859
S140x110		✓	PE0860
S160x50		✓	PE0861
S160x63		✓	PE0862
S160x75		✓	PE0863
S160x90		✓	PE0864
S160x110		✓	PE0865
S160x125		✓	PE0866
S160x140		✓	PE0867
S200x50		✓	PE0868
S200x63		✓	PE0869
S200x75		✓	PE0870
S200x90		✓	PE0871
S200x110		✓	PE0872
S200x125		✓	PE0873
S200x140		✓	PE0874
S200x160		✓	PE0875
S225x110		✓	PE0876
S225x160		✓	PE0877
S225x200		✓	PE0878


 电熔异径直接
Electro Fusion
Reducer

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
S250x110		✓	Pe0880
S250x160		✓	Pe0881
S250x200		✓	Pe0882
S250x225		✓	PE0883
S315x160		✓	Pe0884
S315x200		✓	Pe0885
S315x250		✓	Pe0886
S355x200	✓	✓	Pe0887
S355x250	✓	✓	PE0888
S355x315	✓	✓	Pe0889
S400x250	✓		Pe0890
S400x315	✓	✓	PE0891
S400x355		✓	Pe0892
S450x400	✓		Pe0893
S500x315	✓		PE0894
S500x400	✓	✓	PE0895


 电熔法兰
Electro Fusion Flange

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
FL50		✓	PE0896
FL63		✓	PE0897
FL75		✓	PE0898
FL90		✓	PE0899
FL110		✓	PE0900
FL125		✓	PE0901
FL140		✓	PE0902
FL160		✓	PE0903
FL200		✓	PE0904
FL225		✓	PE0905
FL250		✓	PE0906
FL280		✓	PE0907
FL315		✓	PE0908
FL355	✓	✓	PE0909
FL400	✓	✓	PE0910
FL450	✓		PE0911
FL500	✓		PE0912
FL560	✓		PE0913
FL630	✓		PE0914
FL710	✓		PE0915
FL800	✓		PE0916



电熔异径三通
Electro Fusion
Reducing Tee

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
T32x25		✓	PE0917
T40x32		✓	PE0918
T50x32		✓	PE0919
T50x40		✓	PE0920
T63x32		✓	PE0921
T63x40		✓	PE0922
T63x50		✓	PE0923
T75x50		✓	PE0924
T75x63		✓	PE0925
T90x50		✓	PE0926
T90x63		✓	PE0927
T90x75		✓	PE0928
T110x50		✓	PE0929
T110x63		✓	PE0930
T110x75		✓	PE0931
T110x90		✓	PE0932
T125x75		✓	PE0933
T125x90		✓	PE0934
T125x110		✓	PE0935
T140x90		✓	PE0936
T140x110		✓	PE0937
T160x50		✓	PE0938
T160x63		✓	PE0939
T160x75		✓	PE0940
T160x90		✓	PE0941
T160x110		✓	PE0942
T160x125		✓	PE0943
T160x140		✓	PE0944
T200x50		✓	PE0945
T200x63		✓	PE0946
T200x75		✓	PE0947
T200x90		✓	PE0948
T200x110		✓	PE0949
T200x125		✓	PE0950
T200x160		✓	PE0951
T225x90		✓	PE0952
T225x110		✓	PE0953
T225x160		✓	PE0954
T225x200		✓	PE0955



电熔异径三通
Electro Fusion
Reducing Tee

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
T250x75		✓	PE0956
T250x90		✓	PE0957
T250x110		✓	PE0958
T250x125		✓	PE0959
T250x160		✓	PE0960
T250x200		✓	PE0961
T315x90	✓	✓	PE0962
T315x110	✓	✓	PE0963
T315x125	✓	✓	PE0964
T315x160	✓	✓	PE0965
T315x200	✓	✓	PE0966
T315x250	✓	✓	PE0967
T355x110	✓	✓	PE0968
T355x160	✓	✓	PE0969
T355x200	✓	✓	PE0970
T355x250	✓	✓	PE0971
T355x315	✓	✓	PE0972
T400x110	✓	✓	PE0973
T400x160	✓	✓	PE0974
T400x200	✓	✓	PE0975
T400x250	✓	✓	PE0976
T400x315	✓	✓	PE0977
T450x250	✓	✓	PE0978
T450x315	✓	✓	PE0979
T450x400	✓	✓	PE0980
T500x110	✓	✓	PE0981
T500x160	✓	✓	PE0982
T500x200	✓	✓	PE0983
T500x250	✓	✓	PE0984
T500x315	✓	✓	PE0985
T500x400	✓	✓	PE0986
T630x110	✓		PE0987
T630x160	✓		PE0988
T630x200	✓		PE0989
T630x250	✓		PE0990
T630x315	✓		PE0991
T630x400	✓		PE0992
T630x500	✓		PE0993




电熔管帽
Electro Fusion End Cap

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
Φ63		✓	PE0994
Φ75		✓	PE0995
Φ90		✓	PE0996
Φ110		✓	PE0997
Φ160		✓	PE0998
Φ200		✓	PE0999
Φ250		✓	PE1000

规格 Specifications(mm)	SDR17	SDR11	订货编号 Item number
FL50		✓	PE1001
FL63		✓	PE1002
FL75		✓	PE1003
FL90		✓	PE1004
FL110		✓	PE1005
FL125		✓	PE1006
FL140		✓	PE1007
FL160		✓	PE1008
FL200 (8孔/12孔)		✓	PE1009
FL225 (8孔/12孔)		✓	PE1010
FL250	✓		PE1011
FL280	✓		PE1012
FL315	✓		PE1013
FL355	✓		PE1014
FL400	✓		PE1015
FL450	✓		PE1016
FL500	✓		PE1017
FL560	✓		PE1018
FL630	✓		PE1019
FL710	✓		PE1020
FL800	✓		PE1021


法兰片
Flange Plate

电熔焊接连接规程

一、操作过程

- 1、电熔管件应保护好包装，直到使用时方可拿出。在开始焊接前，管件内表面应保持干燥、清洁。
- 2、刮削管材焊接端面氧化层。采用适当的工具，如手动或机械刮刀进行这一操作。刮削时应沿管材或插口管件的整个外圆周进行刮削。当使用鞍形或鞍形三通时，要对焊接区域进行刮削。
- 3、用塑料管材切刀或带切削导向装置的细齿锯切断管材，必须确保其端面垂直于管材轴线。用小刀切除内、外部边缘的毛刺。
- 4、确保插入深度符合要求，可采用标记插入深度等方式加以解决，插入深度同管件的承口深度。
- 5、去除管材或插口端区域氧化层，并清洁焊接区域。
- 6、将管材或插口管件插入到电熔管件承口区域，检查管材或插口管件上的插入深度标记线，确保完全到位，使用对正夹具确保管材、管件的同心度，并防止在焊接过程中管材从电熔管件中受熔融料压力外移。
- 7、检查电熔管件上条码和工艺纸上对应的焊接时间是否一致，若一致可用条码自动扫描或按手动操作完成焊接。
- 8、在焊接过程中密切关注焊接进展情况，适当保持人身、设备与焊接件间的距离，防止由于不正当操作等原因造成的意外事故对人身和设备的损伤。

二、影响电熔连接接口质量的因素

1. 电压波动对接口质量的影响
给定的电熔管件内电阻丝电阻值一定，因此，电阻丝的发热功率完全取决于电源提供的电压，故焊口的质量会因电压波动影响加热功率而变坏。
2. 焊接时间对接口质量的影响
每个规格的电熔管件所需的热量范围都是固定的，过多或过少的热量都将对焊接质量产生致命的影响，而在焊接电压和管件电阻固定的前提下，焊接时间是管件发热量的唯一决定因素，因此必须准确控制焊接时间。
3. 环境温度对接口质量的影响
焊接过程中环境温度的变化，直接影响到焊接区的热传递条件，进而影响焊接的质量，因此焊机必须能监控环境温度，并能自动根据偏差结果对输出参数作相应调整。
4. 不良操作对焊接接口质量的影响
所谓不良操作，一方面指焊接时管材的刮削或清洗不符合规范（特别是承插口装配不到位，插口端部有较大斜度等），这就要求操作者必须具备一定的焊接知识。另一方面是输入焊接参数时发生的错误，这方面应通过焊机本身的设置来避免。

三、施工中应特别注意的事项

1. 切割管材时，端面必须与管材轴线垂直，不能有斜口。
2. 插入管材前，必须对管材和管件内、外表面进行清洁，不得带有泥沙、水等任何杂质。
3. 插入管材前，应刮掉管材和插口管件表面的氧化层，刮削时，应量出需刮削的区域，沿管材或插口管件的整个圆周均匀刮削。
4. 管材必须插到位，并使管材与管件保持平行，为了确保管材的穿插到位，需在插口端做好插入深度标志。
5. 焊接时应采用相配套的电熔焊机（交流电、39.5V）。
6. 合理掌握插口端氧化层的刮削量，严禁用重物敲击过量装配。
7. 焊接D110以上规格管件时必须在管材两端采用紧固夹具确保管材在焊接过程中受熔融料的压力而外移。



用记号笔标记刮削区域，刮削长度应在插入深度长10mm以上；



刮除管材表面氧化层，刮削深度0.1~0.2mm左右；



将刮削端插入至管件限位挡台，用固定夹具将两端的管材固定；



焊接时，确保焊机输入电压、时间与管件标识一致，也可直接扫描条形码进行焊接；



准备工作就绪后，按确认键，焊机将再次显示焊接参数，完全确认后，再按启动键开始焊接，焊接结束后会自动报警提示，焊接程序结束。