

PEWeldBank PEWeldBank Individual Weld Report

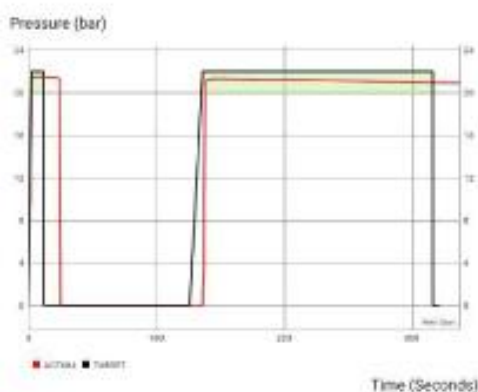
Date	Weld Number	Custom Weld Number	Start Time	Ambient Temp	Status
08-02-2023	2023020811192976	26	11:19	22.1° C	For Review

Project Details

Project Name	Job Number	Project Contact Details
DK version	Roco værksted	Test 98177977

Weld Details	Required	Actual	
P1 bead-up pressure	19.8-22.2	0.9-21.5	bar
t1 bead-up size	Until indication of bead	24.00	mm / Seconds
P2 heat soak pressure	0.0-0.0	0.0-0.0	bar
t2 heat soak time	110	110	Seconds
t3 heater plate removal time	≤4	≤4	Seconds
t4 time to achieve fusion jointing pressure	≤10	≤10	Seconds
P3 fusion jointing pressure	19.8-22.2	20.9-21.3	bar
t5 fusion jointing time (bead roll-over time)	≥03:00	03:00	Min:Sec

** Manual override has been enabled by the user



Welding Standard	
Standard name	Custom

Welding Company Details		
Name	Contact	Phone
Roco-plt A/S	John Rommerdahl	004598177977

Operator Details				
Operator	ID Number	DOB	Last Accredited	App Version
Kristian Andersen	Tester2	24-10-2020	-	1.6.9 (73)

Pipe / Fitting Details		METRIC (mm)					
Material	Manufacturer	Type	Shape	°n	SDR	°n	Batch No.
Spigot 1	Wavin PE100	PE100	Pipe	110	17	6.5	-
Spigot 2	Wavin PE100	PE100	Pipe	110	17	6.5	-

Machine Details					
Machine Brand	Model	Ram Size	Serial No.	Plant Id.	Calibration Date
Ritmo	Basic 160 V2	1.95 cm ²	165000151T / 165000151F / 165000151C	Roco-Pit A/S	18-05-2021

Sensor Details					
Brand		Model	Serial No.	Calibration Date	Firmware Version
PEWeldBank	Pressure	PWB-P133	30:AE:A4:F3:A6:4A	14-09-2021	V 1.3.7
PEWeldBank	Temperature	PWB-T102	30:AE:A4:F3:A8:BE	-	V 1.0.4

Asset Details		
Drawing Number	Spool Number	Line Number
-	-	-

GPS Coordinates at Time of Completed Weld	
Longitude	Latitude
0	0

Heater Plate Target (° C)		230-250
	Front	Back
Zone 1	231	232
Zone 2	235	231
Zone 3	235	236
Zone 4	236	234
Average	233.75	
Fixed Point Sensor	0	

At commencement of weld
Measured during Phase 1 and 2

Quality / Process Checklist

Is weld area protected?	Yes
Have the pipes been cleaned before placing in machine?	Yes
Are pipe ends covered?	Yes
Is pipe faced correctly?	Yes
Have pipe faces been cleaned?	Yes
Have pipe ends been checked for gap?	Yes
Is pipe aligned within 10% of wall thickness?	Yes

Alignment Photo



Finished Weld Photo



Sketch Pad

K 2

Statement

I, Kristian Andersen, agree that I completed this weld correctly and completed checklists honestly.

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