



DTL-HDPE-TEM-0003

Poly Welding Parameters

DTL Health & Safety Management System

Doc No: DTL-HDPE-TEM-0003 **Version:** 1.0 — Apr 2026 **Review:** Apr 2027
Owner: Annelize Van Tonder

Purpose: Reference table of butt-fusion welding parameters by pipe size. Confirm against the manufacturer's procedure for the pipe in use.

Poly Welding Parameters

Pipe size	SDR	Heater temp (°C)	Heat-soak time	Fusion pressure	Cool time

Approved for issue

Tyson Knight — Director
27 May 2026

