





Plastic Welding

Part 7: Testing



We know how.

Part 7: Testing

- Make a test weld
- Visual Check of the welding
- Fill up the welded container with water
-  **NEVER TEST WITH COMPRESSED AIR!** 

Part 7: Testing

Destructive Test Methods:

- tensile test DVS 2203-2
- impact-tensile test DVS 2203-3
- long-time tensile test DVS 2203-4
- technological bending test DVS 2203-5

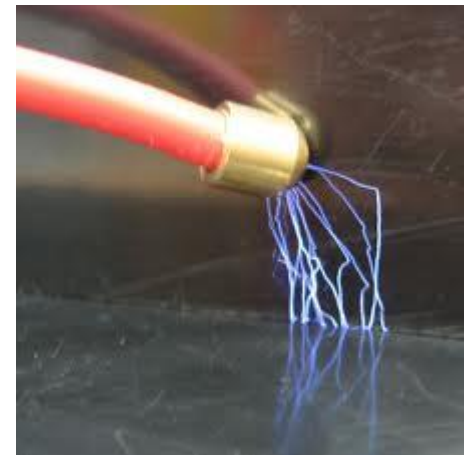
Part 7: Testing

Non-Destructive Test (Visual Check)

Welding Procedure	Appearance of Seam
Pendulum Welding and Draw Welding	<ul style="list-style-type: none">• building of bead• notches• seam covering• penetrate welding of roots• offset• extension and compression• mistake in seam cross section
Extrusion Welding	<ul style="list-style-type: none">• seam covering• notches and seam surface• mistake in seam cross section• min. melting depth of 0.5mm (check it during the welding process by insertion)

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Sparktest Leakage



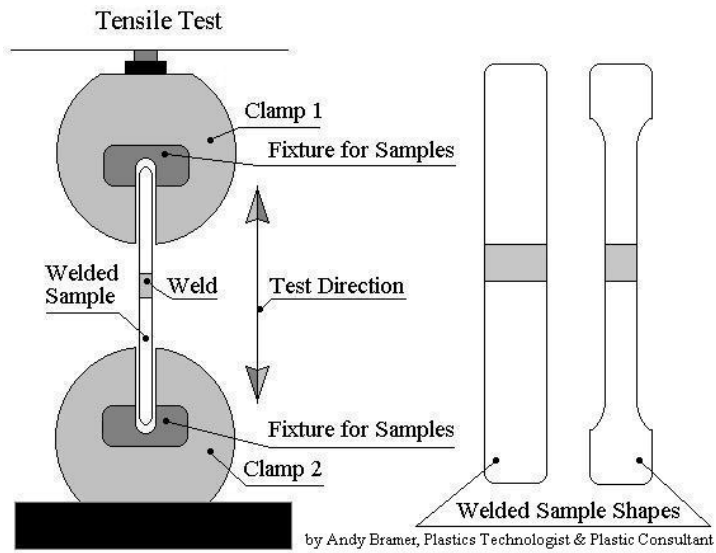
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Vakuüm bell



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Tensile test

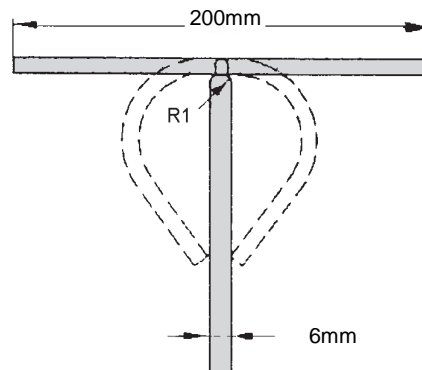


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Work shop bending test

This method for the technical bending test is a simple test adapted for carrying out in the workshop. Because of the forces involved this method is limited to test thicknesses of ≤ 10 mm.

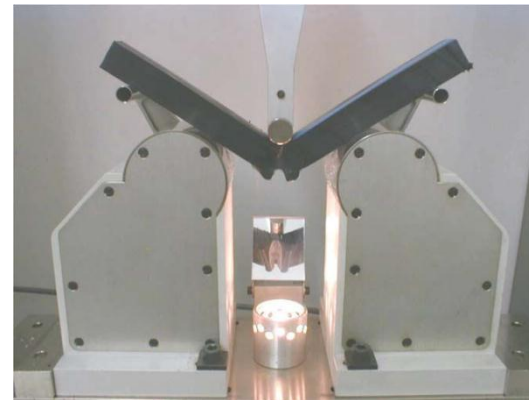
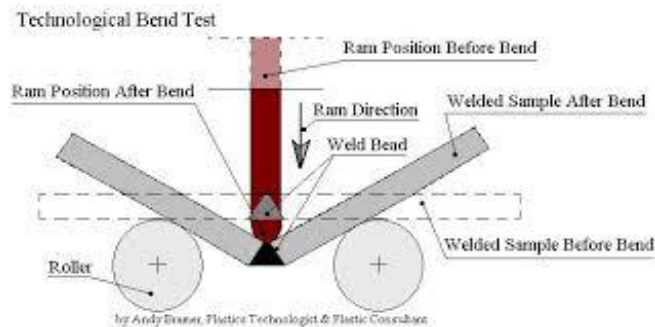
The test piece with the finished weld seam is bent over a rounded 6 mm thick rod in one quick movement (see figure) until it breaks or the free ends of the test piece touch the rod.



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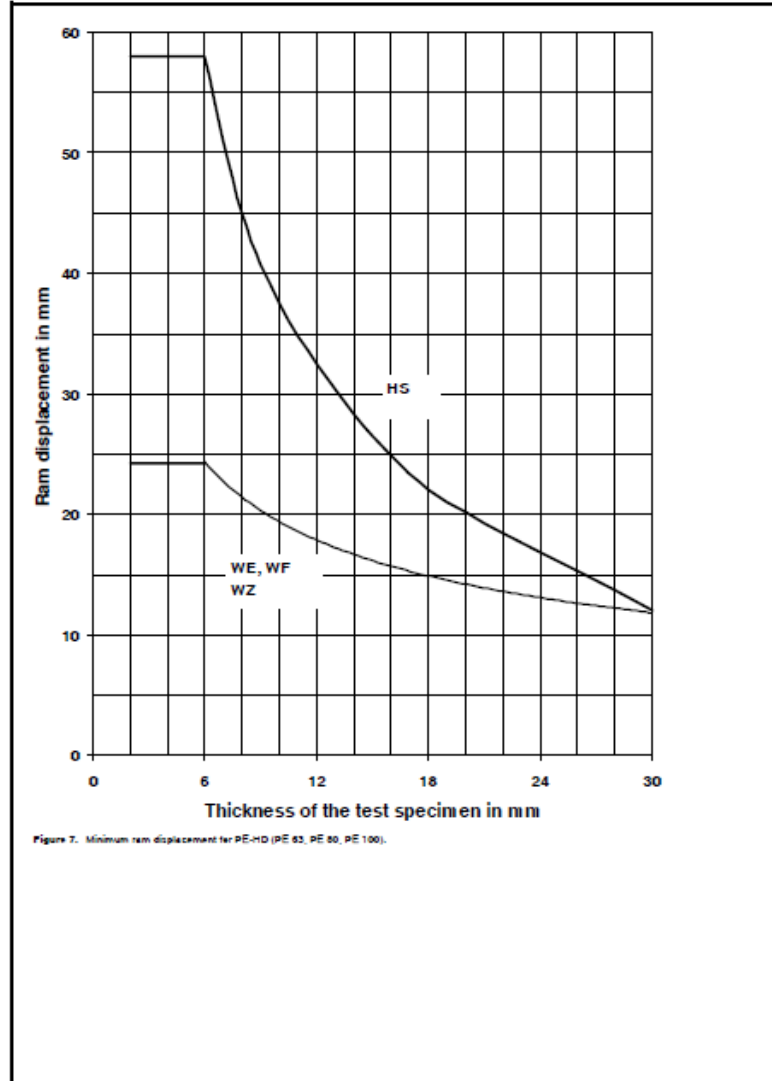
Bending test

- The weld reinforcement is not processed on the tension side.
- It is measured reached bending angle / bending path at rupture or scar of the weld test.
- Reviewed the smallest value of 6 individual values is. If the minimum value of max. Not amount to 2 samples, each with 2 spare samples from the same specimen and the same situation can be verified. All data verified samples must achieve the minimum value.

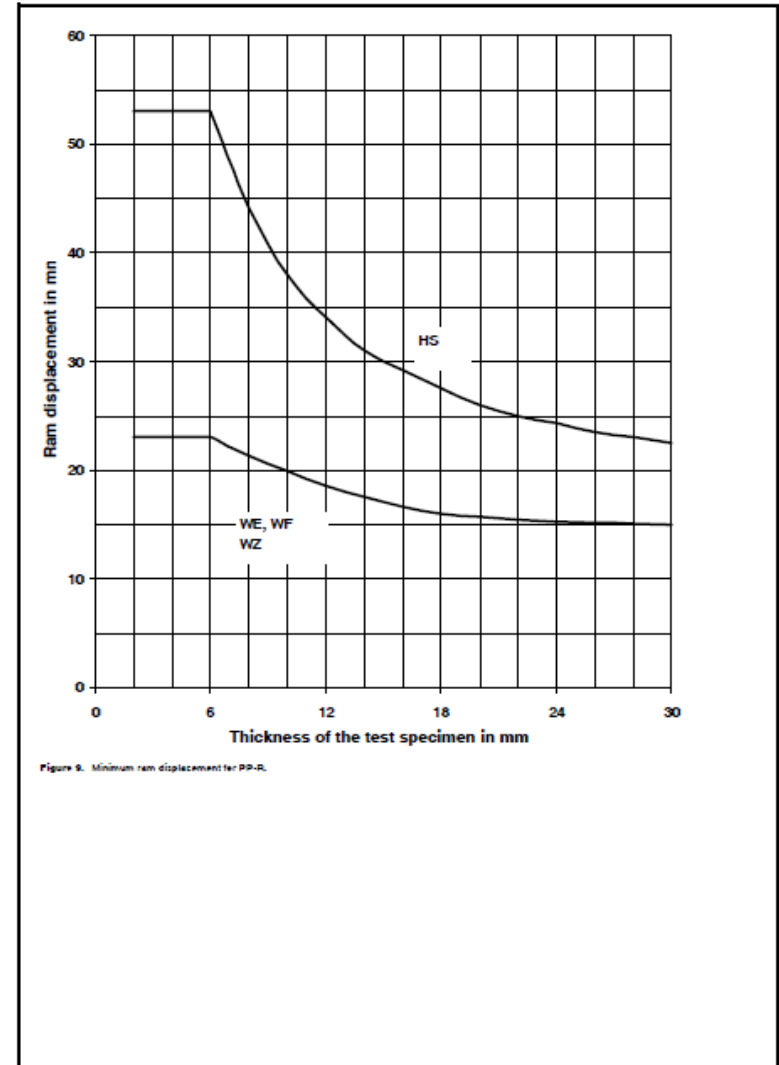


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Free hand bending test

