

ELECTRICALLY WELDED JOINTS FOR DISTRICT HEATING



Electrically welded joint is used to reproduce the outer casing pipe and create a sealed joint of pipe segments in the technology of pre-insulated pipes.

Electrically welded joint of Termogum production is made of HDPE pipe cut lengthwise and equipped with a heating element. **Heating element is permanently mounted in the joint material** in a way that seals the interior space of the joint. The application of Termogum joint does not require using tapes, as it provides complete tightness of the preinsulated pipes connection.



Shape

Termogum electrically welded joint has a shape that facilitates comfortable and reliable installation, because it is **formed in the shape of the letter "C"** to allow easier closure of the joint space, keeping it in the proper position and clamping the outer casing of pre-insulated pipe sections.

Compliance with standards

Termogum's sleeves and joints are compatible with all standard outer casing tubes made according to PN EN 253. All sleeves and joints produced by Termogum meet the requirements of PN EN 489 and stress corrosion test.

Welding process

During the welding process, the jacket material the outer casing pipe and the joint is melted along the heating element. **Penetration and mixing of the material in the weld area provides an excellent seal and inability to penetrate by external factors.**

In addition, in Termogum's welded joints occur **heat shrinking effect** as a result of which the material of the joint also shrinks around the outer casing pipe under the influence of temperature pressing harder preinsulated pipe. With **heat shrinking effect** created insulation is perfectly tight.

In the welding process, temperature and pressure of welded surfaces are one of the most important preconditions for high quality welds of plastics. Therefore Termogum solution provides the required pressure through the belt astringents, as well as installed thermocouple monitors reaching the proper temperature of the weld.

For installation of the welding joint in the technology of Termogum it is possible to use a **standard welding machine, which allows continuous operation for 30 minutes at a current of 120- 130 Amperes.**

Thermocouple nickel-chromium, embedded permanently in the joint material, provides independent control of pipes' connection temperature, thereby carrying out welding of the joint always in the same conditions, regardless of external conditions. Such independence from





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external factors and atmospheric conditions ensures quality and repeatability of pre-insulated pipe joints.

Storage

Proper storage temperature for joints is max. 40° C. They should be protected from moisture, extreme temperatures and sunlight. There is advisable not to drop or drag joints on the ground, as it may lead to serious damage to the joints.



CATALOGUE

Joint type	Diameter of outer casing of preinsulated pipe (mm)
TMZE-110	110
TMZE-125	125
TMZE-140	140
TMZE-160	160
TMZE-180	180
TMZE-200	200
TMZE-225	225
TMZE-250	250
TMZE-280	280
TMZE-315	315
TMZE-355	355
TMZE-400	400
TMZE-450	450
TMZE-500	500
TMZE-560	560
TMZE-630	630
TMZE-710	710
TMZE-800	800
TMZE-900	900
TMZE-1000	1000
TMZE-1100	1100
TMZE-1200	1200

Electrically welded joints are supplied in the length of 700 mm. There is a possibility of delivery joints in other required lengths.

