

GSC ENERGY PRO

Fusion Pressures

Butt Fusion

IPS Size	DR	McElroy #28	McElroy #412	McElroy #618
6"	11	211	172	103
	15.5	162	134	83
8"	11	337	271	152
	15.5	254	206	120
10"	11	N/A	404	221
	15.5	N/A	303	170
12"	11	N/A	556	299
	15.5	N/A	414	226

Service Saddle

NOTE:
0.75" IPS outlet Service Saddles require the same pressures and times as the base configuration remains the same for both outlet sizes.

Main x Branch (IPS)	Pressure for Melt Pattern psi	Fusion Pressure psi
1.25" x 1.00"	150 - 175	60 - 80
1.50" x 1.00"	150 - 175	70 - 90
2.00" x 1.00"	150 - 175	70 - 90
3.00" x 1.00"	175 - 200	80 - 100
4.00" x 1.00"	175 - 200	80 - 100

Branch Saddle

NOTE:
1.25" IPS outlet Branch Saddles require the same pressures and times as the base configuration remains the same for both outlet sizes.

Main x Branch (IPS)	Pressure for Melt Pattern psi	Fusion Pressure psi
2.00" x 2.00"	140 - 160	140 - 160
3.00" x 2.00"	140 - 160	140 - 160
4.00" x 2.00"	160 - 180	160 - 180
4.00" x 3.00"	350 - 380	350 - 380
6.00" x 2.00"	175 - 190	175 - 190
6.00" x 3.00"	380 - 410	380 - 410
6.00" x 4.00"	630 - 680	630 - 680
8.00" x 2.00"	180 - 210	180 - 210
8.00" x 3.00"	410 - 450	410 - 450
8.00" x 4.00"	680 - 730	680 - 730
8.00" x 6.00"	1450 - 1575	1450 - 1575
10.00" x 3.00"	410 - 450	410 - 450
10.00" x 4.00"	680 - 730	680 - 730
10.00" x 6.00"	1450 - 1575	1450 - 1575
12.00" x 6.00"	1450 - 1575	1450 - 1575



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