

2.2 Electrofusion coupling



Available from Ø 40 to 315mm.

Connection properties

- a Simple, reliable joint.
- b Rigid, non-removable.
- c Tension-resistant.

Application

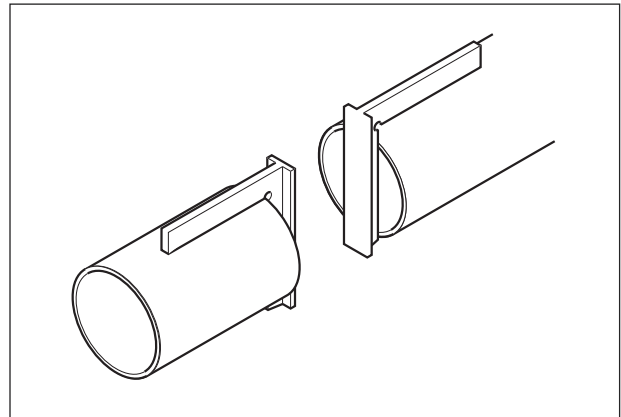
On-site welding, slip coupling for adding fittings or repairing sections.

The heat required to make the joint comes from flowing a constant electrical current through the embedded heater wires within the fitting. The pressure required to make the joint is obtained from the shrinking of the fitting under welding conditions. The shrinking does not alter the internal bore of the joint because the ends and the centre of the fitting are deliberately kept cold during the welding process.

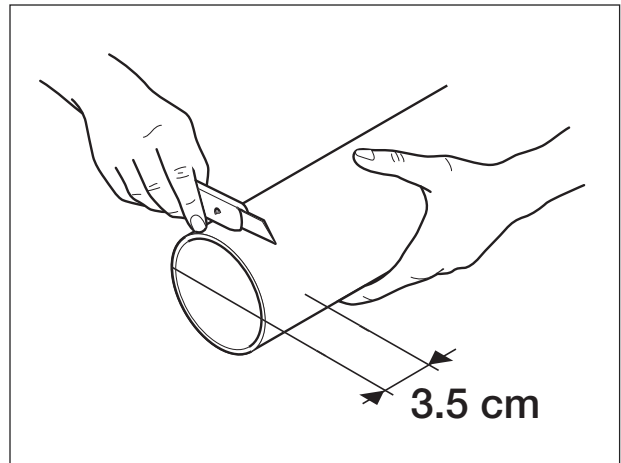
The joint obtained is simple, quick and strong once made. The heater wires remain encased in the HDPE so there is no chance of corrosion. The use of original Geberit equipment and fittings is essential to ensure a good weld is made.

Preparation for electrofusion

Cut the pipe square.



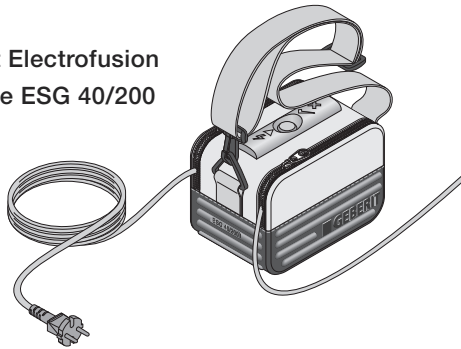
Dry, clean and scrape welding ends. Scraping or abrading of the pipe surface in the area to be fused is necessary to remove oxide layer and ensure an effective weld.



Remove burr. Welding ends must remain dry during the whole welding process. Mark 30mm insertion depth of the electrofusion coupling on the pipe with a grease pencil.

2.2.1 Electrofusion coupling
(for pipes Ø 40 to 160mm)

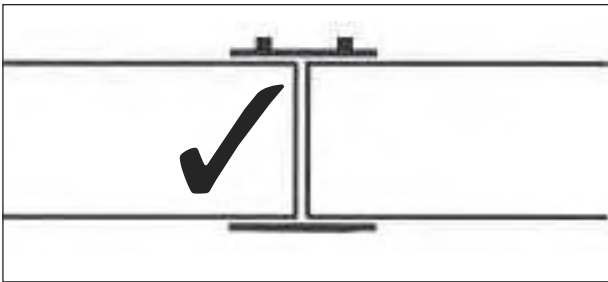
Geberit Electrofusion machine ESG 40/200



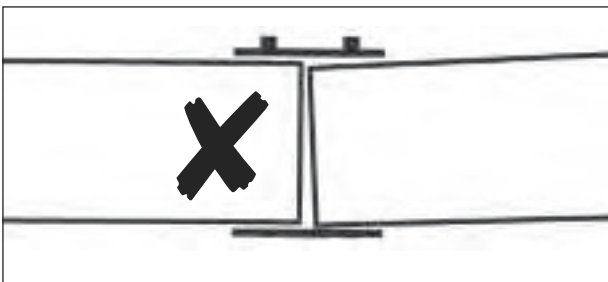
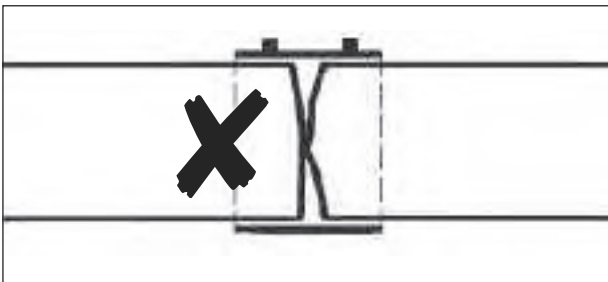
Electrofusion sleeve coupling



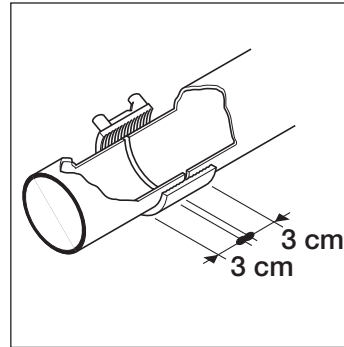
Correct



Incorrect



A Geberit Electrofusion machine ESG 40/200 (240v or 115v) must be used.



1 Insert pipe or fitting ends into the sleeve coupling up to insertion depth mark.



2 Connect electrofusion machine, start welding procedure. Welding time approximately 70 – 90 seconds.



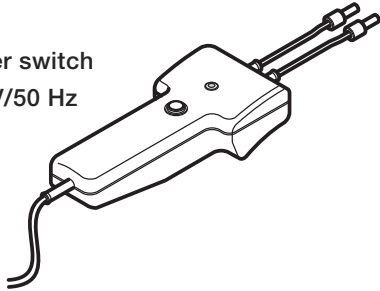
3 After the 'end' indicator has turned on, remove the connection cable. The protruding yellow indicator shows whether the welding process was performed correctly.



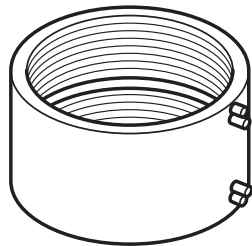
4 If required for sake of appearance, the electrical connector socket on electrofusion sleeves (diameters Ø 40 to 160mm) can be removed after the end of installation work.

2.2.2 Electrofusion coupling (for pipes Ø 200 to 315mm)

Geberit starter switch
ESG-T2 230 V/50 Hz



Electrofusion
coupling



Note:

The same coupling cannot be welded twice since the built-in thermo fuses shut off automatically after the necessary welding temperature has been reached.

A Geberit starter switch ESG – T2 must be used.



1 Dry, clean, scrape or abrade welding ends to full insertion depth. Remove burr. Welding ends must remain dry during the whole welding process.



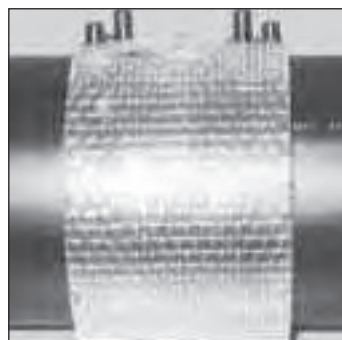
2 Mark insertion length 75mm with a grease pencil.



3 Mount centering rings to ensure proper welding.



4 Insert pipe or fitting ends into the electrofusion coupling to full insertion depth mark. Connect start switch cable. Press start button briefly. Working temperature: -10°C - +40°C. Welding time: approximately 5 to 7 minutes at 20°C. Check indicator window on coupling has changed from white to black



5 Wait for at least 15 minutes after weld has been completed before removing the centering rings. Do not remove the plastic sheet insulation until the coupling has completely cooled down.