

Vejledende Skyllletider

Volume		Skylletid ved 8 L/min						
Diameter	Længde mm	PPM 10	PPM 25	PPM 50	PPM 75	PPM 100	PPM 200	PPM 500
Ø21,3	100	3s	-	-	-	-	-	-
Ø21,3	1000	27s	25s	23s	21s	21s	19s	17s
Ø48,3	100	14s	13s	12s	11s	11s	10s	8s
Ø48,3	1000	2m 16s	2m 4s	1m 55s	1m 50s	1m 45	1m 35s	1m 23s
Ø60,3	100	21s	20s	18s	17s	17s	15s	13s
Ø60,3	1000	3m 33s	3m 14s	2m 59s	2m 50s	2m 44s	2m 29s	2m 10s
Ø88,9	100	46s	42s	39s	37s	36s	33s	28s
Ø88,9	1000	7m 44s	7m 1s	6m 29s	6m 10s	5m 56s	5m 24s	4m 42s
Ø101,6	100	1m 1s	55s	51s	48s	47s	43s	37s
Ø101,6	1000	10m 5s	9m 10s	8m 27s	8m 3s	7m 45s	7m 3s	6m 7s
Ø114,3	100	1m 17s	1m 10s	1m 4s	1m 1s	59s	54s	47s
Ø114,3	1000	12m 46s	11m 35s	10m 42s	10m 11s	9m 49s	8m 55s	7m 44s
Ø139,7	100	1m 55s	1m 44s	1m 36s	1m 31s	1m 28s	1m 20s	1m 10s
Ø139,7	1000	19m 4s	17m 19s	15m 59s	15m 13s	14m 40s	13m 20s	11m 34s
Ø168,3	100	1m 54s	1m 44s	1m 36s	1m 31s	1m 28s	1m 20s	1m 10s
Ø168,3	1000	19m 4s	17m 19s	15m 59s	15m 13s	14m 39s	13m 20s	11m 34s
Ø219,1	100	4m 42s	4m 16s	3m 56s	3m 45s	3m 36s	3m 17s	2m 51s
Ø219,1	1000	46m 54s	42m 35s	39m 19s	37m 25s	36m 3s	32m 47s	28m 28s
Ø325	100	10m 19s	9m 22s	8m 39s	8m 14s	7m 56s	7m 13s	6m 16s
Ø325	1000	1t 43m 12s	1t 33m 42s	1t 26m 31s	1t 22m 19s	1t 19m 20s	1t 12m 8s	1t 2m 38s
Ø350	100	11m 58s	10m 52s	10 m 2s	9m 33s	9m 12s	8m 22s	7m 16s
Ø350	1000	1t 59m 42s	1t 48m 40s	1t 40m 20s	1t 35m 28s	1t 32m	1t 23m 40s	1t 12m 39s
Ø400	100	15m 38s	14m 12	13m 6s	12m 28s	12m 1s	10m 56s	9m 29s
Ø400	1000	2t 36m 20s	2t 21m 56s	2t 11m 3s	2t 4m 41s	2t 0m 10s	1t 49m 16s	1t 34m 53s
Ø450	100	19m 47s	17m 58s	16m 35s	15m 47s	15m 12s	13m 50s	12m
Ø450	1000	3t 17m 51s	2t 59m 38s	2t 45m 51s	2t 37m 48s	2t 32m 5s	2t 18m 18s	2t 0m 5s
Ø500	100	24m 26m	22m 11s	20m 29s	19m 29s	18m 47s	17m 4s	14m 50s
Ø500	1000	4t 4m 16s	3t 41m 47s	3t 24m 46s	3t 14m 49s	3t 7m 45s	2t 50m 44s	2t 28m 15s
Ø600	100	35m 10s	31m 56s	29m 29s	28m 3s	27m 2s	24m 35s	21m 21s
Ø600	1000	5t 51m 45s	5t 19m 22s	4t 54m 52s	4t 40m 32s	4t 30m 22s	4t 5m 52s	3t 33m 29s
Ø700	100	47m 53s	43m 28s	40m 8s	38m 11s	36m 48s	33m 28s	29m 3s
Ø700	1000	7t 58m 46s	7t 14m 41s	6t 41m 20s	6t 21m 50s	6t 8m	5t 34m 39s	4t 50m 34s
Ø800	100	1t 2m 32s	56m 46s	52m 25s	49m 52s	48m 4s	43m 43s	37m 37s
Ø800	1000	10t 25m 19s	9t 27m 45s	8t 44m 12s	8t 18m 43s	8t 0m 39s	7t 17m 6s	6t 19m 31s

*Fordobles liter/min halveres skylletiden. Fordobles længden (volumen) fordobles skylletiden.

Alle beregninger er afrundet, diameter er indvendige diameter.

Husk at tilføre Formier i bunden og Argon i toppen.

Efterfølgende bør svejsningerne køles til håndlun inden baggas tages fra.

Bemærk tiderne er vejledende.

