



PLASTIC WELDING

F. Jannone AG
Offizieller Vertriebspartner





Shrimp Farm HDPE 0.5 mm



Tunnel PVC 2.5 mm



Water Reservoir HDPE 2.0 mm



Civil Engineering / Tunneling / Landfills

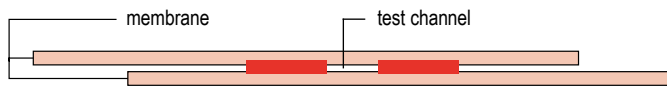
Product overview wedge welder	72
Product overview extrusion welder	73
GEOSTAR G7 / GEOSTAR G5	74 / 75
GEOSTAR G7 LQS / GEOSTAR G5 LQS	74 / 75
LQS - Leister Quality System	76 / 77
COMET / COMET USB	78 / 79
TWINNY T7 / TWINNY T5	80 / 81
TWINNY S	82
UNIDRIVE 500	83
WELDPLAST S6	84
WELDPLAST S4	85
WELDPLAST S2 / S2 TPO	86
FUSION 3 / FUSION 3C	87 / 88
EXAMO F300 USB / F600 USB	89
Vacuum test system	90
Compressed air testing system	91

Hot Air Tools

TRIAC ST	12 – 15
TRIAC AT	13 – 15
ELECTRON ST	16 / 17
General accessories	36 / 37

Possibilities of welding seams








Overlap seam with test channel



Overlap seam without test channel



Product overview wedge welders for Civil Engineering / Tunnelling / Landfills

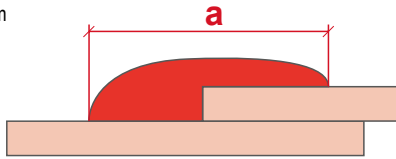
							
Device type	GEOSTAR G7 / G7 LQS	GEOSTAR G5 / G5 LQS	COMET	TWINNY T7	TWINNY T5	TWINNY S	UNIDRIVE 500
Voltage V~	230	230	230	230	120 / 230	120 / 230	120 / 230
Max. Power W	2800	2800	1500 / 1200	3450	1800 / 3450	1900 / 2900	2300
Temperature °C	80 – 460	80 – 460	80 – 420	560	560	80 – 600	20 – 600
Speed m/min	0.8 – 12	0.8 – 12	0.8 – 3.2	0.8 – 8	0.8 – 8	0.2 – 2.5 (4.0/6.0 ¹)	0.5 – 5
Max. Welding pressure N	1500	1500	1000	1000	1000	1000 (500)	
Weld seam width mm	2 × 15	2 × 15	2 × 15	2 × 15	2 × 15	2 × 15	15 / 30 / 40
Max. overlap mm	150	150	125	125	125	125	
Data recording	- / ✓	- / ✓	- / ✓	- / ✓			
Digital display	✓	✓	✓	✓	✓		✓
Size (L × W × H) mm	482 × 278 × 269	482 × 278 × 269	295 × 250 × 245	323 × 360 × 259	323 × 360 × 259	350 × 390 × 270	297 × 173 × 275
Weight kg	17.7	16.4	7.5	10.5	9.9	6.5 – 6.9	4
Conformity mark	CE	CE	CE	CE	CE	CE	CE
Protection class	⚡	⚡	⚡	⚡	⚡	⚡	⚡
Welding technologies							
Hot-wedge welding	✓	✓	✓				
Combi-wedge welding				✓	✓	✓	✓
Applications							
HDPE, LDPE, TPO, FPO, PP	1.0 – 3.0 mm	0.8 – 3.0 mm	0.5 – 2.5 mm	0.5 – 2.5 mm	0.5 – 2.5 mm	0.5 – 2.5 mm	0.5 – 2.5 mm
PVC, CSPE, EIA	-	0.8 – 3.0 mm *(steel wedge only)	0.5 – 3.0 mm *(steel wedge only)	0.5 – 3.0 mm	0.5 – 3.0 mm	0.5 – 3.0 mm	0.5 – 3.0 mm
Catalog page	 74 / 75	74 / 75	78 / 79	80 / 81	80 / 81	82	83

¹ For details, see page 82

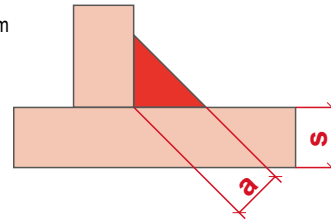
Attention these are Leister recommendations only, depending upon material specifications the possible min. thicknesses may vary.
For more information please contact your Leister Distributor.

* Please note PVC, CSPE and all Chlorinated products are only to be welded with steel wedges.







Overlap seam



Fillet welding seam



Product comparison

	Digitally regulated extrusion welders			Air heated extrusion welders	
					
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	FUSION 3	FUSION 3C
Output (HDPE) kg/hr	3.9 – 6	1.5 – 4	0.6 – 2.3	1.8 – 3.6	1.8 – 3.6
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	HD-PE, PP	HD-PE, PP
Wall thickness mm	15 – 40	8 – 35	4 – 20	8 – 25	8 – 25
Welding rod Ø mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5
Weight kg	14	8.7	5.8	7.2	6.9
Length mm	821	560	450	690	588
Voltage V~	230	230	230	230	230
Screw extruder	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	✓✓	✓
Brushless blower	yes	yes	yes	no	no
Remarks	1	1	1	2	2
Catalog page	 84	85	86	87 / 88	87 / 88

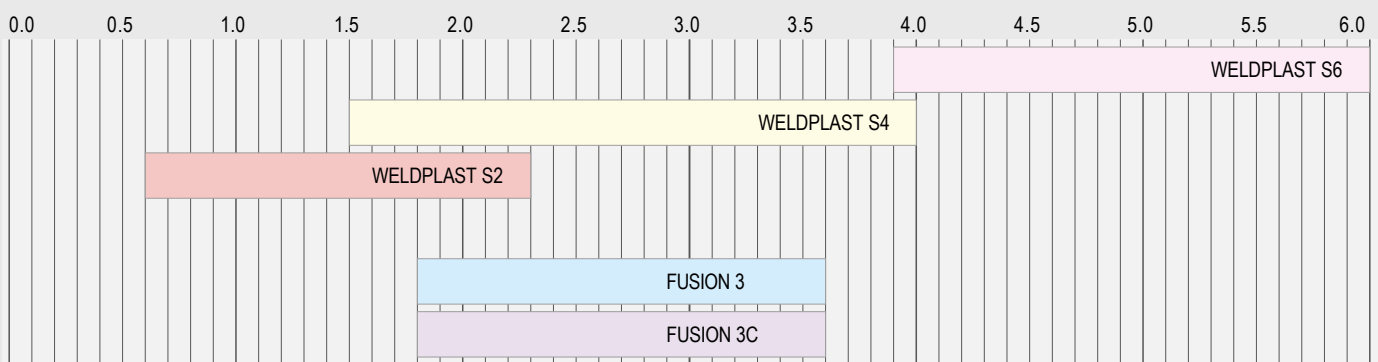
✓✓ very suitable

✓ suitable

1: Air and plast temperatures are shown via a display and can be separately and freely adjusted.

2: The air temperature is adjusted by means of a potentiometer (rotary dial). The heating of the plastic mass is performed by the pre-heating air.

Overview of Extrusion Welders Output (kg/hr)



GEOSTAR G5 and GEOSTAR G7 – Faster, lighter, smarter

Wedge welding redefined: Leister's new GEOSTAR welders change the civil engineering landscape. This mid-size, lightweight welder boasts a robust, cast aluminum frame for quality welding of geomembranes. The GEOSTAR also features a unique digital display with all key weld parameters: heat, speed, pressure and supply voltage. The new design makes field servicing a cinch—wedge can be removed and replaced in under a minute. include: easy loading

Wedge welders

GEOSTAR G7/ G7 LQS, G5/ G5 LQS



- Welding speed up to 12 m/min
- G7 Longer wedge allows for welding up to 45% faster than the G5
- High heating capacity / heating power
- Digital display of weld pressure
- Integrated voltage display
- Wedge replacement in less than one minute
- Adjustable chassis height

Technical data		GEOSTAR G7 / G7 LQS
Voltage	V~	220 – 240
Frequency	Hz	50 / 60
Power	W	2800
Max. heating temperature	°C	460
Welding wedge	mm	130 × 50
Max. overlap	mm	150
Max. welding force	N	1500
Weld width with test channel	mm	2 × 15
Drive speed*1	m/min	0.8 – 12 Level 1: 0.8 – 7 Level 2: 1.5 – 12
Dimensions (L × W × H)	mm	482 × 278 × 269
Weight	kg	17.7
Materials		HD-PE 1.0 – 3.0 mm PP, LD-PE, TPO, FPO additional materials upon request
Mark of conformity		CE
Protection Class I		⊕

*1: Conversion of gear 1–2 using position change of sprocket wheels

Article No.

- 151.035 GEOSTAR G7, 230V / 2800W, Roller width 50 mm, copper wedge with test channel, with Euro plug
- 155.152 GEOSTAR G7 LQS data recording, 230 V / 2800 W, copper wedge with test channel, with Euro plug

Scope of delivery: Automatic welder, transport box, 3 pcs. Allen keys, cleaning brush, Quick guide

Technical data		GEOSTAR G5 / G5 LQS
Voltage	V~	220 – 240
Frequency	Hz	50 / 60
Power	W	2800
Max. heating temperature	°C	460
Welding wedge	mm	90 × 50
Max. overlap	mm	150
Max. welding force	N	1500
Weld width with test channel	mm	2 × 15
Drive speed*1	m/min	0.8 – 12 Level 1: 0.8 – 6 Level 2: 1.5 – 12
Dimensions (L × W × H)	mm	482 × 278 × 269
Weight	kg	16.4
Materials		HD-PE 0.8 – 3.0 mm PP, LD-PE, TPO, FPO, PVC-P*2, CSPE*2, EIA*2 additional materials upon request
Mark of conformity		CE
Protection Class I		⊕

*2: Requires steel wedge

Article No.

- 151.683 GEOSTAR G5, 230V / 2800W, Roller width 50 mm, copper wedge with test channel, with Euro plug
- 156.135 GEOSTAR G5 LQS data recording, 230 V / 2800 W, copper wedge with test channel, with Euro plug

Scope of delivery: Automatic welder, transport box, 3 pcs. Allen keys, cleaning brush, Quick guide

of material, natural flow of material through the machine and innovative handle ergonomics for easy carry and rest positions. The GEOSTAR is available in two performance classes: the standard GEOSTARG5 and extended-wedge GEOSTARG7.



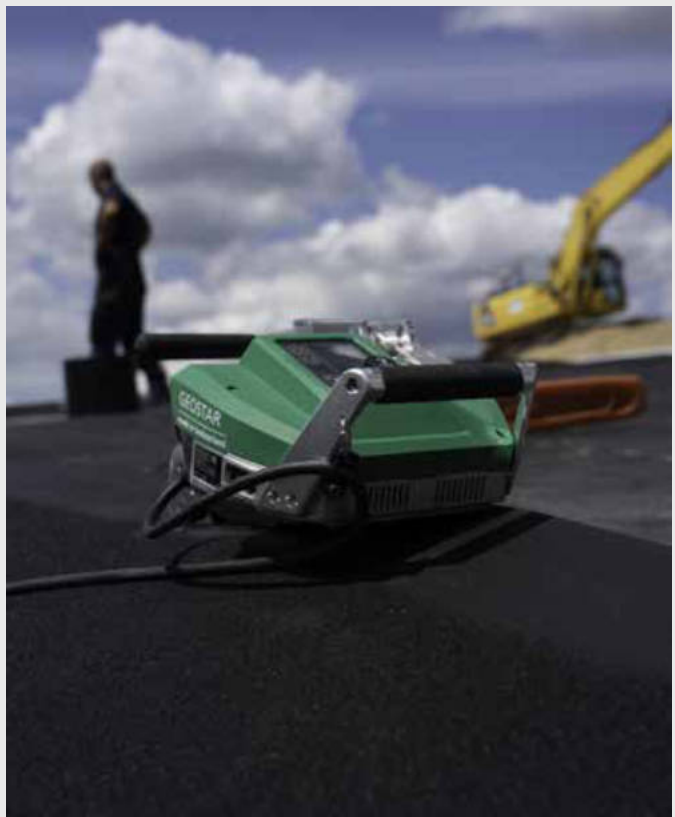
The GEOSTAR easily welds 240 m without difficulty in a single pass during a field test (South Africa)..

Accessories

GEOSTAR G7/ G7 LQS, G5/ G5 LQS

	148.489 Wedge Kit GEOSTAR G7, 130 × 50 mm, 230V/2500W, copper wedge with test channel
	151.684 Wedge Kit GEOSTAR G5, 90 × 50 mm, 230V/2500W, copper wedge with test channel
	153.557 stainless steel wedge with test channel 90 × 50mm, 230V/2500W
	149.174 Wedge-Kit GEOSTAR G5, 90 × 50 mm 120V/1600W, copper wedge with test channel
	153.560 stainless steel wedge with test channel 90 × 50 mm 120V/1600W Other wedges on request
	153.361 Drive roll D50 mm × 50 (75) mm; Traction Step, Steel, pointed knurled, with test channel
	Drive roll D50 mm × 50 mm;
	153.338 Steel, sharp edge knurled, with test channel
	153.359 Steel, blunt edge knurled, with test channel Other rollers on request
	155.568 50mm straight profile Roller w/screw
	154.272 78mm Silicone Rollers w/screw
	154.676 50mm Silicone Rollers w/screw
	146.204 Prefabrication wagon for Geostar
	146.346 Side support for Prefabrication wagon (4 pieces required)
	151.847 Brass brush

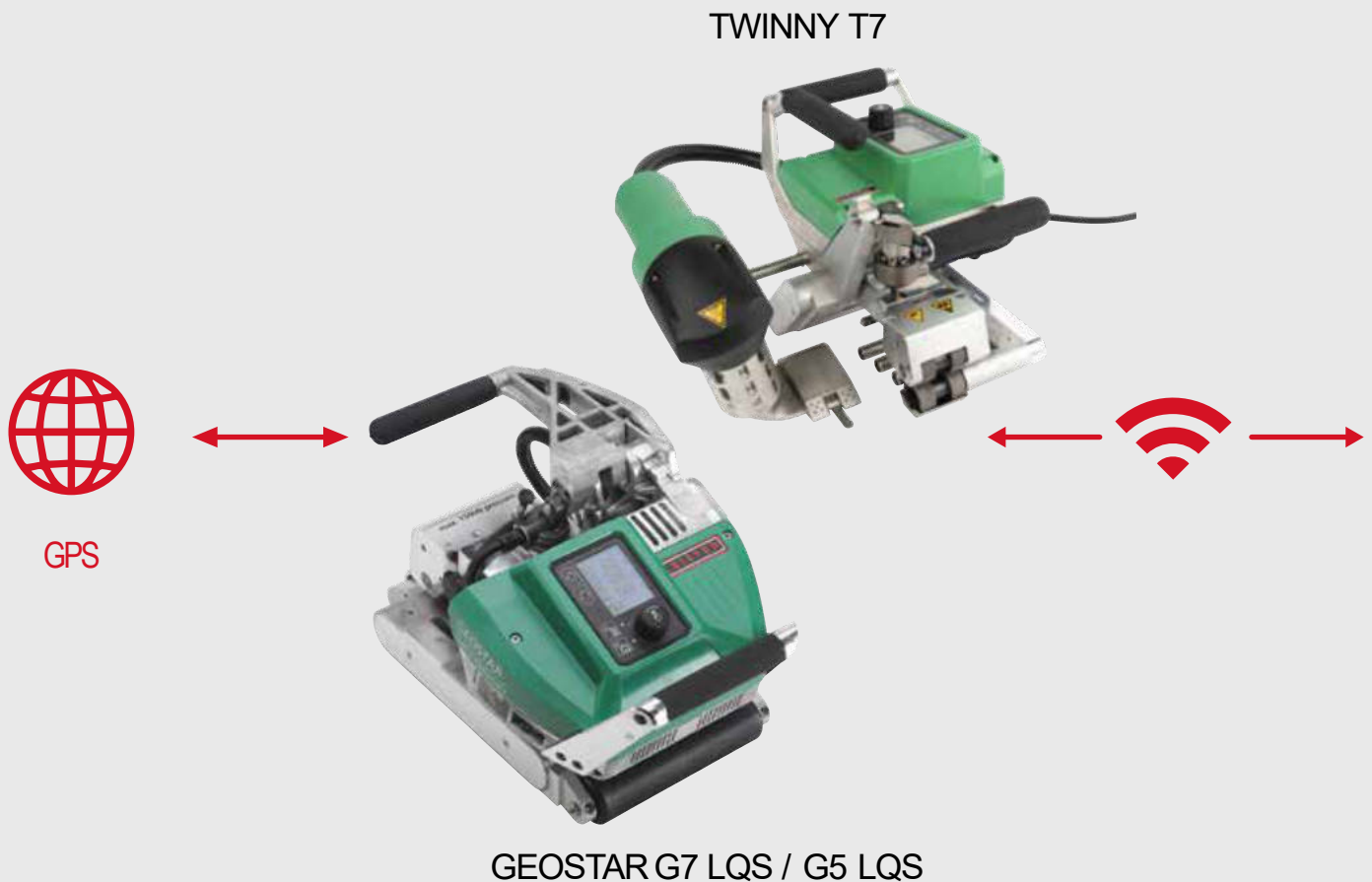
For further accessories see www.leister.com/geostar





LQS – Leister Quality System

The Leister Quality System (LQS) allows you to compile full quality documentation for all aspects of your welding work. You can document every welding seam as a table, graphic or even with GPS coordinates. The Leister Quality System provides all the advantages of state of the art technology, helping installers enhance on site QC/QA and installation standards overall.



Pinpoint precision
By activating the GPS function, you can assign the welding seams precisely to the relevant location (for GPS and GLONASS format).



LQS

- Activatable data recording
- Welding parameter monitoring via alarm function
- Data storage for 10,000 welds



Wireless data transfer
After the welding process, the data can be transferred conveniently via WiFi. The transfer process only takes a few seconds.



GEOSTARLQS in field operation.



Data evaluation on mobile devices
The data is evaluated digitally via the LQS app. This app can be downloaded free of charge from the Windows or Android Store. The LQS menus are extremely easy to navigate and are adapted to users' needs.



Data cloud
The data cloud opens up lots of extra possibilities:

- Cloud function can be switched on/off
- External data backup
- Unit management
- User management
- Decentralized access of welding data for remote team members



Welding report
The LQS app can be used to produce records in all standard forms:

- Welding report
- Tables and graphics
- pdf and csv format

COMET / COMET USB: The highflyers

This compact, heavy-duty welding machine is in use worldwide. The small powerhouse is specially designed for the demands of landfill sites, mines and tunnels. Documentation made simple: The COMET USB memory system is designed for use on construction sites. Because this compact hot-wedge welding machine records all relevant welding parameters, data transfer is mere child's play.

Wedge welder

COMET



- Lightweight and compact
- Digital display of temperature and velocity
- Closed loop control of temperature and drive
- Easy and user-friendly

Technical Data

Voltage	V~	230
Power	W	1500 / 1200
Temperature	°C	80 – 420
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 × 15, with test channel
Material thickness	mm	0.5 – 3
Size (L × B × H)	mm	295 × 250 × 245
Weight	kg	7.5
Conformity mark	CE	
Protection class I	⊕	

Article No.

107.547	COMET, with wedge 50 mm for PE, 230 V / 1200 W *
107.538	COMET, with wedge 70 mm for PE, 230 V / 1500 W *
145.893	COMET, with wedge 95 mm for PE, 230 V / 1850 W *
107.558	COMET, with wedge 50 mm for PVC, 230 V / 1200 W *
107.553	COMET, with 50mm wedge for PE, 120 V / 1200 W *
107.539	COMET, with 70mm wedge for PE, 120 V / 1500 W *

* with test channel, EUROplug

Included with purchase: Welder, quick guide, guide-bar short, storage case

Wedge welder

COMET USB



- Digital display of welding pressure
- Complete recording of all relevant welding parameters
- USB memory system designed for use on construction sites
- Convenient data transfer

Technical Data

Voltage	V~	230
Power	W	1500 / 1200
Temperature	°C	80 – 420
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 × 15, with test channel
Material thickness	mm	0.5 – 3
Size (L × B × H)	mm	295 × 250 × 245
Weight	kg	7.5
Conformity mark	CE	
Protection class I	⊕	

Article No.

137.626	COMETUSB, with wedge 50 mm for PE, 230 V / 1200 W *
138.088	COMETUSB, with wedge 70 mm for PE, 230 V / 1500 W *

* with test channel, EUROplug

Included with purchase: Welder, quick guide, guide-bar short, memorystick, storage case






Comet operating in the tunnel ...



... or on a landfill site.

Accessories COMET / COMET USB

	112.974	Extremely light cross handle 145 gram, material: aluminum
	129.224	Guide-bar, complete
	144.416	USB memory stick



Perfectly protected in the storage case.
126.448
(included with purchase)

	100.327	Driving roller 50 mm, steel, sharp edge knurled, with test channel
	100.328	Driving roller 50 mm, steel, sharp edge knurled, without test channel
	100.329	Driving roller 50 mm, steel, blunt edge knurled, with test channel
	100.330	Driving roller 50 mm, steel, blunt edge knurled, without test channel
	100.331	Driving roller 50 mm, silicon, with test channel
	100.332	Driving roller 50 mm, silicon, without test channel

Roles are compatible with COMET and TWINNY T and S welding machines.

Fields of application COMET / COMET USB

Power	1850 W		1500 W		1200 W	
Type of material	Wedge	Material thickness	Wedge	Material thickness	Wedge	Material thickness
PE-HD, PE-C, PP	95 mm copper	1.5 – 3.0 mm	70 mm copper	1.0 – 2.5 mm	50 mm copper	0.5 – 1.5 mm
PE-LD	95 mm copper	1.5 – 3.0 mm	70 mm copper	1.0 – 2.5 mm	50 mm copper	0.5 – 1.5 mm
PVC-P			70 mm steel	2.0 – 3.0 mm	50 mm steel	1.0 – 2.0 mm

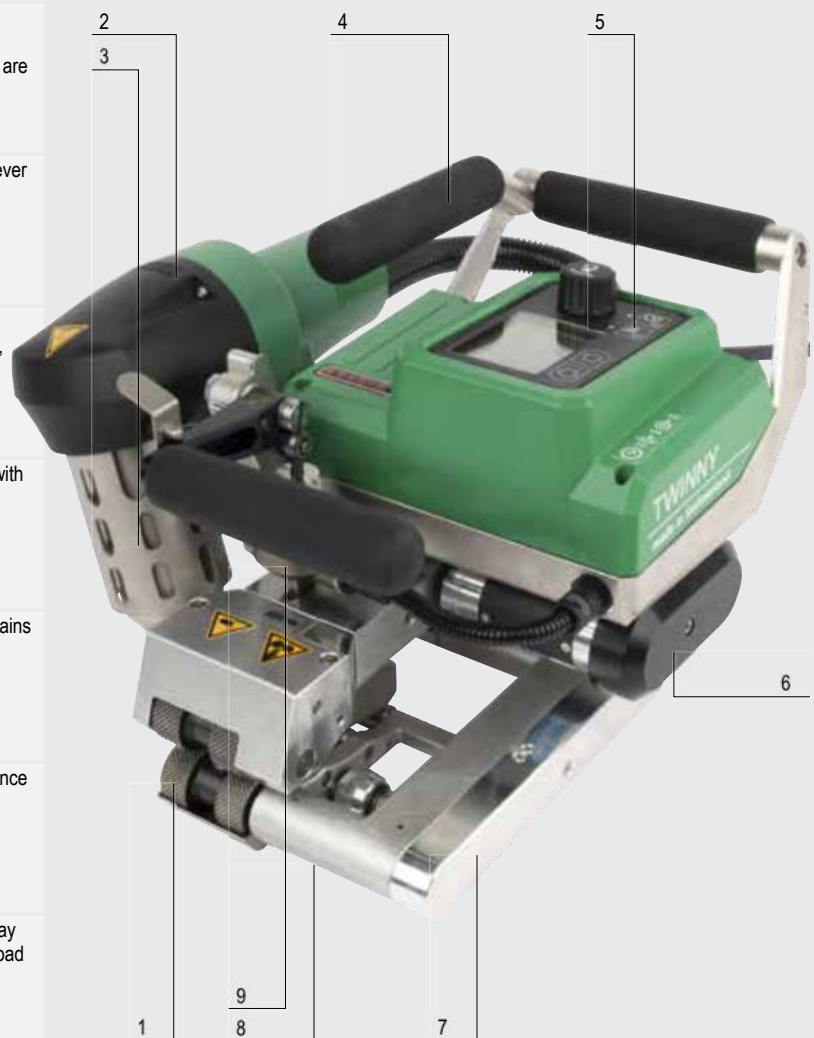
Plug and weld – TWINNY T7 und TWINNY T5

If you want to weld thin or thick geomembranes (0.5 to 2.5 mm) 20-100 mls quickly, easily and safely, the TWINNY T7 or TWINNY T5 are your go-to automatic welders. Both tools are well-rounded, thanks to their practical design and intuitive operation. The TWINNY T7 comes equipped with highly-efficient data recording ability thanks to the LQS function, GPS, Wi-Fi and connection to the myLeister app are guaranteed. Plug and weld – TWINNY T7 and T5.

Hot-air welder

TWINNY T7/T5

1		quick drive speed of 0.8 to 8 m/min
2		T7: brushless blower motor significantly greater air volume
3		dry and clean the hot air dries moisture in no time at all, while dust and sand are blown away
4		Optimum handling thanks to clever grip options
5		a. T7: Communication module myLeister with WiFi, GPS, LQS, voltmeter, e-Drive b. T5: Basic functions with digital accuracy
6		Gearbox and motor separated with service-friendly timing belt
7		Reinforced double-row drive chains
8		Field kit for more ground clearance
9		a. T7: digital joining force display b. T5: Force module with overload protection





Display TWINNY T7



Display TWINNY T5

Hot-air welder

TWINNY T7/T5



- powerful: 3300 watts, enabling more heating power
- sustainable: TWINNY T7 and T5 are durable and easy to service

Technical data		TWINNY T7	TWINNY T5
Voltage	V~	230	230 / 120
Frequency	Hz	50 / 60	50 / 60
Power	W	3450	3450 (1800 @ 120V)
Max. Temperature	°C	560	560
Blower Motor	rpm	Maintenance free Brushless Motor max. 18'000	Brushed Motor max. 12'000
Air volume	%	45 – 100	
Max. Overlap	mm	125	
Max. Welding pressure	N	1000	
Drive speed	m/min	0.8 – 8	
LQS, WIFI, GPS		Yes	No
Digital Pressure display		Yes	No
Digital Voltage display		Yes	No
Audible / Visual Alarms		Yes	No
Welding pressure overload protection		Visual and acoustical warning	Mechanical
Size(L × W × H)	mm	350 × 360 × 260	
Weight	kg	10.5	9.9
Conformity		CE	
Protection class		⚡	

Accessories TWINNY T7/T5

	155.629	Combi-wedge long, 50 mm, with test channel
	155.630	Combi-wedge long, 50 mm, without test channel
	155.634	Combi-wedge short, 50 mm, with test channel
	155.637	Combi-wedge short, 50 mm, without test channel
	159.135	Long handle complete
	164.025	Indoor roller kit

Article No.:

CEE blue plug	164.198	164.197	TWINNYT7 230 V / 3450 W CWLw/TC Ro50 mm sharp Field kit
Euro plug	164.215	164.214	TWINNYT7 230 V / 3450 W CWSw/TC Ro50 mm sharp Field kit
	164.217	164.216	TWINNYT7 230 V / 3450 W CWLwo/TC Ro50 mm blunt Field kit
	164.219	164.218	TWINNYT7 230 V / 3450 W CWSwo/TC Ro50 mm blunt Field kit
	164.221	164.220	TWINNYT7 230 V / 3450 W CWSwo/TCRo 50 mm SiliconeIndoor kit
	164.223	164.222	TWINNYT5 230 V / 3450 W CWLw/TC Ro50 mm sharp Field kit
	164.225	164.224	TWINNYT5 230 V / 3450 W CWSw/TC Ro50 mm sharp Field kit
	164.227	164.226	TWINNYT5 230 V / 3450 W CWLwo/TC Ro50 mm blunt Field kit
	164.229	164.228	TWINNYT5 230 V / 3450 W CWSwo/TC Ro50 mm blunt Field kit
	164.231	164.230	TWINNYT5 230 V / 3450 W CWSwo/TCRo 50 mm SiliconeIndoor kit
CEE yellow plug	164.232		TWINNY T5 120 V / 1800 W CWSw/TC Ro 50 mm sharp Field kit
	164.233		TWINNY T5 120 V / 1800 W CWSwo/TC Ro 50 mm blunt Field kit

CWL = Combi wedge long / CWS=Combi wedge short / W/TC = with Test channel / wo/TC = without Test Channel / Ro = Roller width

Scope of delivery: Machine, storage case, cleaning brush, Instruction manual

TWINNY S: Perfect weight

This lightweight tool is optimized for overhead welding and is ideal for thin materials used in civil engineering and tunnel construction. Leister offers a choice between replaceable combi-wedges with or without test channel.



TWINNY T, with convenient cross-handle, at work overhead welding in a tunnel.

Combi-wedge welder

TWINNY S



- Simple operation
- Lightweight
- High welding speed
- Stepless adjustment of temperature and drive
- Perfect welding result even in harsh environmental conditions thanks to hot-air system.

Technical Data

Voltage	V~	120 / 230
Power	W	2900 / 1900
Temperature	°C	20 – 600
Max. overlap	mm	125
Speed		
drive 256:1	m/min	0.8 – 2.5
drive 144:1		1.4 – 4
Welding pressure	N	1000 / 500 (256:1 / 144:1)
Size (L × W × H)	mm	350 × 390 × 270
Weight	kg	6.5 – 6.9
Conformity mark		CE
Protection class II		□

Article No.

- 119.031 TWINNYS for tunnel construction, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
- 119.039 TWINNYS for tunnel construction, drive 256:1, 120 V / 1900 W, with test channel, combi-wedge long, w/o plug

Included with purchase:

Tunneling version: Welder, quick guide, guide-bar short, storage case

Accessories TWINNY S

	112.974	Extremely light cross handle 145 gram, material: aluminum
	100.517 100.518	Combi-wedge short 50 mm, with test channel 50 mm, without test channel
	100.525 100.526	Combi-wedge long, complete 50 mm, with test channel 50 mm, without test channel, slotted, perforated
	126.448	Storage case (included with purchase)
	101.905 101.910 101.913	230 V / 2750 W heating element, TWINNY S 230 V / 2100 W heating element, TWINNY S 120 V / 1800 W heating element, TWINNY S

See COMET for roles.

UNIDRIVE 500: safe and economical – everywhere

Guided by two ergonomic handles, you can achieve the ideal pressure to ensure high-quality welding results. Changing direction – via key combination and dual drive, it couldn't be easier!




The perfect choice for welding joint sealing tape.

Semi-automatic hot-air welder

UNIDRIVE 500



- Safe: Constant parameters and reliable quality – even with undervoltage
- Fast: Up to three times faster than manual welding
- Customized: Reversible drive allows for welding in either direction
- Practical: Compact and lightweight semi-automatic hot-air welder: 4.5 kg, 30 cm high
- Economical: Maintenance-free, brushless motors

Technical data		UNIDRIVE500	UNIDRIVE500	UNIDRIVE500
Voltage	V~	100	120	230
Power	W	1500	1800	2200
Temperature	°C	100 – 560		
Air volume	%	45 – 100		
Speed	m/min	0.7 – 4.5		
Emission	L _{pA} (dB)	70 (K= 3 dB)		
Size(L × H × B)	mm	297 × 173 × 275		
Weight	kg	4.5		
Conformity mark		CE		
Protection class I				
Article No.:				
163.144	UNIDRIVE500, 40 mm, 220-240 V / 2200 W, Europlug, Silicone rollers			
163.146	UNIDRIVE500, 40 mm, 220-240 V / 2200 W, CEE3 pol. blue, Silicone rollers			
163.148	UNIDRIVE500, 40 mm, 100-120 V / 1800 W, UK plug, Silicone rollers			
163.149	UNIDRIVE500, 40 mm, 100 V / 1500 W, JP plug, Silicone rollers			
163.150	UNIDRIVE500, 30 mm, 220-240 V / 2200 W, EU plug, Silicone rollers			
163.151	UNIDRIVE500, 40 mm, 220-240 V / 2200 W, CEE3 pol. blue, Steel rollers			
163.152	UNIDRIVE500, 15 mm, 220-240 V / 2200 W, CEE3 pol. blue, Steel rollers			
Included with purchase: Welding machine, device case, hex key, quick guide				

Accessories UNIDRIVE 500

	164.586	Overlap welding nozzle
	164.576	15 mm
	164.403	30 mm
	163.930	40 mm
		Pressure roller, steel 15 mm
	163.357	
		Pressure roller steel 40 mm
	162.551	
		Support wheel, silicone
	161.156	
		Silicone rubber roller 40 mm
	159.911	
		Wheel for silicon rubber roller 40 mm
	151.847	
		Brass brush
	164.605	
	156.531	Storage case UNIDRIVE500 Carrying strap for Leister case
	145.582	
	165.176	Heating elements 230 V / 2200 W
	165.179	Heating elements 120 V / 2100 W Heating elements 100 V / 1600 W

WELDPLAST S6: The workhorse

WELDPLAST S6 is the world's highest rated handheld extrusion welder. With an output of 6 kg/h, it is surprisingly maneuverable. It features a brushless, preheat motor, multifunction display and comfortable ergo-grip, making the S6 Leister's flagship extrusion welder.



WELDPLAST S6, Gold Mine Mexico.

Digitally regulated extrusion welder

WELDPLAST S6



- 6 kg output per hour
- Highest possible preheating capacity
- Adjustable control wheel
- Maintenance-free hot-air blower
- Multifunctional display

Technical Data

Voltage	V~	230
Power	W	4600
Material		PE /PP
Welding rod	mm	Ø 4 – 5
Output	kg/h	3.9 – 6.0
Size (L × W × H)	mm	821 × 116 × 240
Weight	kg	14
Conformity mark		CE
Protection class I		⊕

Article No.

134.318 Extrusion Welder WELDPLASTS6, 230 V / 4600 W, with CEE32A plug

Included with purchase: WELDPLAST S6, overlap welding shoe, storage case

Accessories WELDPLAST S6

	146.239	Welding shoe complete
	146.240	54 × 40 × 52 mm blank welding shoe
	146.241	25 mm overlap
	146.706	35 mm overlap
	146.242	35 mm overlap
	145.899	40 mm overlap
	146.245	20 mm V-seam
	146.246	25 mm V-seam
	146.247	30 mm V-seam
	146.232	20 mm fillet weld seam (a = 14 mm*)
	146.233	25 mm fillet weld seam (a = 17.5 mm*)
	146.234	30 mm fillet weld seam (a = 21 mm*)
	146.230	Corner seam Ø 14 mm
	146.218	Corner seam Ø 20 mm
		* a = welding seam thickness
	117.055	35 mm preheat nozzle, large
	136.859	50 mm preheat nozzle, XL large
	117.790	Side hot-air guide (Position 9h/3h)
	116.367	Ultra strong storage case WELDPLAST S6 (included with purchase)
	149.744	Insulation sleeve

General accessories



WELDPLAST S4

The WELDPLAST S4 is the first extrusion welder of its kind with brushless, maintenance-free motor for generating preheated air. Output of up to four kilograms per hour is made possible thanks to the S4's powerful drive system.



The powerful WELDPLAST S4 at work.

Digitally regulated extrusion welder

WELDPLAST S4



- Compact housing design reduces noise and guarantees optimal cooling for the electronics and drive.
- Microprocessor to regulate the welding process and to monitor the tool
- Menu with function programs
- Dual-sided twist-free wire intake
- Maintenance-free blower

Technical Data

Voltage	V~	230
Power	W	3680
Material		PE /PP
Welding rod	mm	Ø 3 – 4 / Ø 4 – 5
Output	kg/h	1.5 – 4.0
Size (L × W × H)	mm	560 × 110 × 300
Weight	kg	8.7
Conformity mark		CE
Protection class I		⊕

Article No.

146.812	WELDPLASTS4, 230 V / 3680 W, 4–5 mm, top hot-air guide, overlap welding shoe 40 mm, preheat nozzle large, with Euro plug, storage case
116.948	WELDPLASTS4, 230 V / 3680 W, 3–4 mm, side hot-air guide, blank welding shoe, preheat nozzle large, medium and small, with Euro plug, storage case

Accessories WELDPLAST S4

		Welding shoe complete
		146.239 54 × 40 × 52 mm blank welding shoe
		146.240 74 × 50 × 58 mm blank welding shoe
		146.241 25 mm overlap
		146.706 30 mm overlap
		146.242 35 mm overlap
		145.899 40 mm overlap
		146.243 12 mm V-seam
		146.244 15 mm V-seam
		146.245 20 mm V-seam
		146.246 25 mm V-seam
		146.247 30 mm V-seam
		146.525 12 mm fillet weld seam (a = 8.5 mm*)
		146.231 15 mm fillet weld seam (a = 10 mm*)
		146.232 20 mm fillet weld seam (a = 14 mm*)
		146.233 25 mm fillet weld seam (a = 17.5 mm*)
		146.234 30 mm fillet weld seam (a = 21 mm*)
		146.230 Corner seam Ø 14 mm
		146.218 Corner seam Ø 20 mm
		* a = welding seam thickness
		144.904 45° angled adapter
		145.704 90° angled adapter
		Caution: You must use welding shoes with an integrated air guide for this
		117.064 Side hot-air guide
		117.065 Top hot-air guide
		preheat nozzle
		117.053 small, 20 mm
		117.518 medium, 25 mm
		141.177 large, 35 mm
		136.231 Pre-heat reflector
		149.723 Insulation sleeve

WELDPLAST S2: The masterpiece

The WELDPLASTS2 is a compact, ergonomically designed workhorse. The handy size extruder puts out two kilograms per hour and can even weld TPO materials without difficulty.



The robust WELDPLAST S2 welding a patch in a tunneling application.

Digitally regulated extrusion welder

WELDPLAST S2 / S2 TPO



- Maintenance-free blower
- Perfect weld seam quality
- Multifunctional display
- Ergonomic and handy
- Successfully operated worldwide

Technical Data

Voltage	V~	230
Power	W	3000
Material standard version		PE /PP
Welding rod	mm	Ø 3 – Ø 4
Output Ø 3 mm	kg/h	PE: 0.6 – 1.3 PP: 0.5 – 1.2
Output Ø 4 mm	kg/h	PE: 1.0 – 2.3 PP: 0.9 – 2.0
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Protection class I		⊕

Article No.

127.215 WELDPLASTS2, 230 V / 3000 W, with Euro plug
Included with purchase: WELDPLASTS2, blank welding shoe, storage case
136.602 WELDPLASTS2, 230 V / 3000 W, TPO, with Euro plug
Included with purchase: WELDPLAST S2, UBL-blank welding shoe, storage case

Accessories WELDPLAST S2 / S2 TPO

	145.945	Welding shoe complete
	145.946	45 x 30 x 54 mm blank welding shoe
	145.896	25 mm overlap
	145.947	30 mm overlap
	145.897	35 mm overlap
	145.915	8 / 10 mm V-seam
	145.907	12 mm V-seam
	145.903	15 mm V-seam
	145.909	20 mm V-seam
	145.944	8 / 10 mm fillet weld (a = 7 mm*)
	145.815	12 mm fillet weld (a = 8.5*)
	145.812	15 mm fillet weld (a = 10*)
	145.940	20 mm fillet weld (a = 14 mm*)
	146.645	Corner outside seam 10 mm
	146.649	Corner outside seam 12 mm
	146.651	Corner outside seam 15 mm
	145.811	Corner seam Ø 14 mm
	145.488	Corner seam Ø 20 mm
		* a = welding seam thickness
	139.460	45° angled adapter
	139.461	90° angled adapter
	134.361	Air filter (included with purchase)
	143.776	Textile dust filter (not included with purchase)
	155.829	Air filter
	131.451	Tool rest
	136.231	Preheat reflector
	154.002	Insulation sleeve

General accessories



FUSION 3 / 3C: THE slim twins

With its long and narrow shape, the FUSION 3 enables comfortable work, even on the ground. The slightly shorter 3C also provides an astounding output volume of up to eight pounds per hour.



Due to its length, the FUSION 3 is especially suited for civil engineering applications.

Air heated extrusion welder

FUSION 3



- High welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Dual-sided twist-free wire intake
- 360° rotatable welding shoe

Technical Data					
Welding rod Ø	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3500			
Material		PE / PP			
Size (L × W × H)	mm	670 × 90 × 180			
Weight	kg	7.2			
Conformity mark		CE			
Protection class II		□			

Artikel-Nr.
118.300 FUSION3, 230 V / 3500 W, Welding rod Ø 3 – 4 mm, Euro plug
144.615 FUSION3, 230 V / 3500 W, Welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION3, Welding shoe overlap 30 mm, storage case

Air heated extrusion welder

FUSION 3C



- High welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Dual-sided twist-free wire intake
- 360° rotatable welding shoe

Technical Data					
Welding rod Ø	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3200			
Material		PE / PP			
Size (L × W × H)	mm	588 × 98 × 225			
Weight	kg	6.9			
Conformity mark		CE			
Protection class II		□			

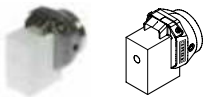








Artikel-Nr.
123.866 FUSION3C, 230 V / 3200 W, Welding rod Ø 3 – 4 mm, Euro plug
144.826 FUSION3C, 230 V / 3200 W, Welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION3C, blank welding shoe, storage case



The FUSION3 for comfortable working in upright positions.

Accessories FUSION 3 / FUSION 3C

	145.945	Welding shoe complete
	145.946	45 x 30 x 54 mm blank welding shoe
	145.896	25 mm overlap
	145.947	30 mm overlap
	145.897	35 mm overlap
	145.915	8 / 10 mm V-seam
	145.907	12 mm V-seam
	145.903	15 mm V-seam
	145.909	20 mm V-seam
	145.916	25 mm V-seam
	145.905	30 mm V-seam
	145.944	8 / 10 mm fillet weld (a = 7 mm*)
	145.815	12 mm fillet weld (a = 8.5 mm*)
	145.812	15 mm fillet weld (a = 10 mm*)
	145.940	20 mm fillet weld (a = 14 mm*)
	145.816	25 mm fillet weld (a = 17.5 mm*)
	145.817	30 mm fillet weld (a = 21 mm*)
	146.643	Corner outside seam 8 mm
	146.645	Corner outside seam 10 mm
	146.649	Corner outside seam 12 mm
	146.651	Corner outside seam 15 mm
	145.811	Corner seam \varnothing 14 mm
	145.488	Corner seam \varnothing 20 mm
* a = welding seam thickness		
	148.817	45° angled adapter
	148.816	90° angled adapter
	135.082	Air filter in stainless steel FUSION3C
	131.451	Tool rest WELDPLAST S2 / S2 PVC / FUSION2
	160.454	FUSION 3C WELDPLAST S4 / S6 / FUSION3
	136.231	Preheat reflector
	149.421	Insulation sleeve FUSION 3
	149.420	Insulation sleeve FUSION3C

General accessories

	144.095	Welding rod de-reeler
	123.173	Storage case WELDPLAST S4 / FUSION3
	119.540	WELDPLAST S2 / S2 TPO / FUSION 3C (included with purchase)
	134.567	Heating element, 230 V / 2600 W, for WELDPLASTS6
	109.984	230 V / 2200 W, for WELDPLAST S4 / S2
	113.268	230 V / 1100 + 1100 W, for FUSION3
	123.561	230 V / 1750 W, for FUSION3C

FUSION3C with heat blanket.



EXAMO: The inspector

Is your seam sealed? Can it withstand the specified peel, tensile and shear forces? EXAMO performs tests at the construction site – quick, reliable and uncomplicated.

Tensiometer

EXAMO 300F USB, 600F USB



- Construction-site approved
- Handy, robust and reliable
- Testing of elongation, peak force, tear force, test speed and position
- With jaws also suitable for geo textiles (see accessories)
- Electronic recording of the measurement data

Technical Data			
Type		300F USB	600F USB
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	20 – 550	20 – 550
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L x W x H)	mm	750 x 270 x 190 (case)	1050 x 270 x 190 (case)
Weight	kg	14	17.5
Conformity mark		CE	CE
Protection class I		⊕	⊕

Article No.:
 139.059 EXAMO 300F USB, 230 V / 200 W, incl. USB memory stick, Euro plug
 139.060 EXAMO 600F USB, 230 V / 200 W, incl. USB memory stick, Euro plug



Blank in uniform size, quickly produced with the COUPON CUTTER 500.

Accessories EXAMO 300F USB, 600F USB

	108.185	Jaw kit 60 mm for geotextiles including two pairs of jaws
	144.416	USB memory-stick
	161.540	COUPON CUTTER 500, for standard-compliant specimens: 15/20/25 x 150 mm
	160.576	Cutting plate
	137.855	Leister cutter with four spare blades
	138.902	Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	138.539	Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	163.140	MEMBRANE PULLER Pull handle for membranes 1.0 – 3.0 mm

VACUUM PUMP / VACUUM BOX: Fast and reliable

The simple, safe and non-destructive way to test the tightness of overlap weld seams, using the Leister VACUUM BOX/BELL. Soapy water is applied to the welding zone to be checked. After connection to the VACUUM PUMP, a vacuum is generated above the zone with the VACUUM BOX/BELL. Thanks to its generous dimensions, and the practical drain valve, even longer weld seams can be tested quickly and reliably.

Testing instruments

VACUUM BELL



- Simple and precise tightness testing
- Round structural form, ideal for details and uneven surfaces.
- Manometer bar/psi

Testing instruments

VACUUM BOX



- Large testing area
- Simple handling
- Clear arrangement of the fittings
- Manometer bar/psi

Testing instruments

VACUUM PUMP



- Durable VACUUM PUMP
- Perfectly packaged and handy
- Flexible, robust hose

Article No.:

153.026 VACUUMBELL320 × 320 mm

152.981 VACUUMBOX830 × 320 × 150 mm

153.024 VACUUMPUMP 230V

153.025 VACUUMPUMP 120V

Caution: The complete testing system is made up from a combination of one VACUUM BOX or VACUUM BELL to be operated with one VACUUM PUMP.

Included with purchase: VACUUM-BELL and VACUUM-BOX with equipment case
Included with purchase VACUUMPUMP: equipment case, air hose

Compressed air testing device

The reliable and handy compressed air testing device from Leister is the perfect solution for testing the tightness of double tap seams with test channels. The revised model now offers even more reliable results – not only during operation but also for the discovery of leaks.



Testing the leak-tightness of lap seams with test channel.

Testing instrument

Compressed air testing device with thin testing needle



- Thin, flexible needle
- Simple and precise tightness testing
- High user safety through hand and needle protection
- Manometer with bar and psi scale
- Practical device case



Manometer standard
(bar/psi)

Article No.:

142.475 Flexible injection needle with manometer

Included with purchase: Compressed air tester, storage case, spare seals, operating instructions

Testing instrument

Compressed air testing device with thick testing needle



- Very strong, tapered needle
- Simple and precise tightness testing
- High user safety through hand and needle protection
- Manometer with bar and psi scale
- Practical device case



Manometer ASTM
(psi/kPa)

Article No.:

150.720 Tapered injection needle with manometer (standard)

158.374 Tapered injection needle with manometer PSI (ASTM)

Included with purchase: Compressed air tester, storage case, spare seals, operating instructions

Accessories



142.569 Flexible spare needle
(fits also to 150.720)



150.142 Tapered Spare needle
(fits also to 142.475)