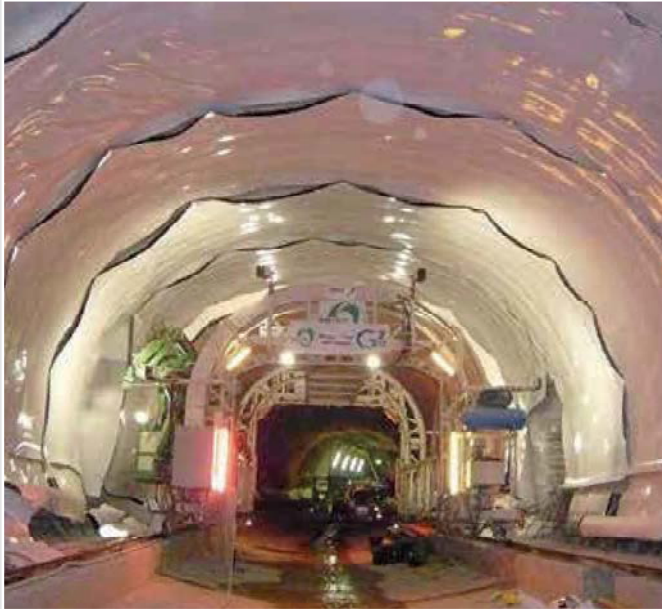




Shrimp Farm HDPE 0.5 mm



Tunnel PVC 2.5 mm



Water Reservoir HDPE 2.0 mm



Civil Engineering / Tunneling / Landfills

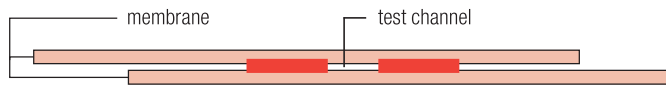
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Possibilities of welding seams







Double tap seam with test channel



Double tap seam without test channel



Product overview wedge welders for Civil Engineering / Tunnelling / Landfills

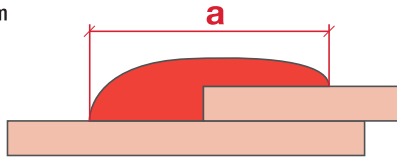
						
Device type	GEOSTAR G5	GEOSTAR G7	COMET / COMET USB	TWINNY T / TWINNY T USB	TWINNY S	TRIAC DRIVE AT
Voltage V~	120 / 230	230	120 / 230	230	120 / 230	230
Max. Power W	1800 / 2800	2800	1800 / 1500 / 1200	2300	1900 / 2900	1700
Temperature °C	80 – 460	80 – 460	80 – 420	80 – 560	80 – 600	80 – 650
Speed m/min	0.8 – 12	0.8 – 12	0.8 – 3.2	0.8 – 3.2	0.2 – 2.5 (4.0/6.0 ¹)	0.5 – 3.0
Max. Welding pressure N	1500	1500	1000	1000	1000 (500)	n.a.
Weld seam width mm	2 x 15	2 x 15	2 x 15	2 x 15	2 x 15	30
Material thickness mm	0.8 - 3.0	1.0 - 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0
Max. overlap mm	150	150	125	125	125	
Data recording	- / ✓	- / ✓	- / ✓	- / ✓		
Digital display	✓	✓	✓	✓		✓
Size (L x W x H) mm	482 x 278 x 269	482 x 278 x 269	295 x 250 x 245	340 x 360 x 245	350 x 390 x 270	300 x 230 x 380
Weight kg	16.4	17.7	7.5	6.9 – 7.9	6.5 – 6.9	4.1
Conformity mark	CE	CE	CE	CE	CE	CE
Protection class	⊕	⊕	⊕	⊕	⊞	⊞
Welding technologies						
Hot-wedge welding	✓	✓	✓			
Combi-wedge welding				✓	✓	(✓)
Applications						
HDPE, LDPE, TPO, FPO, PP	0.8 - 3.0 mm	1.0 - 3.0 mm	0.5 - 2.5 mm	0.5 - 2.5 mm	0.5 - 2.5 mm	0.5 - 2.0 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
Catalog page	 66 / 69	66 / 69	70 / 71	72 / 73	73	75

¹ For details, see page 73

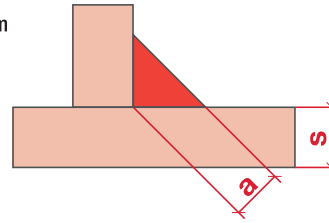
Attention these are Leister recommendations only, depending upon material specifications the possible min. thicknesses may vary.
For more information please contact your Leister Distributor.

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







Overlap seam



Fillet welding seam



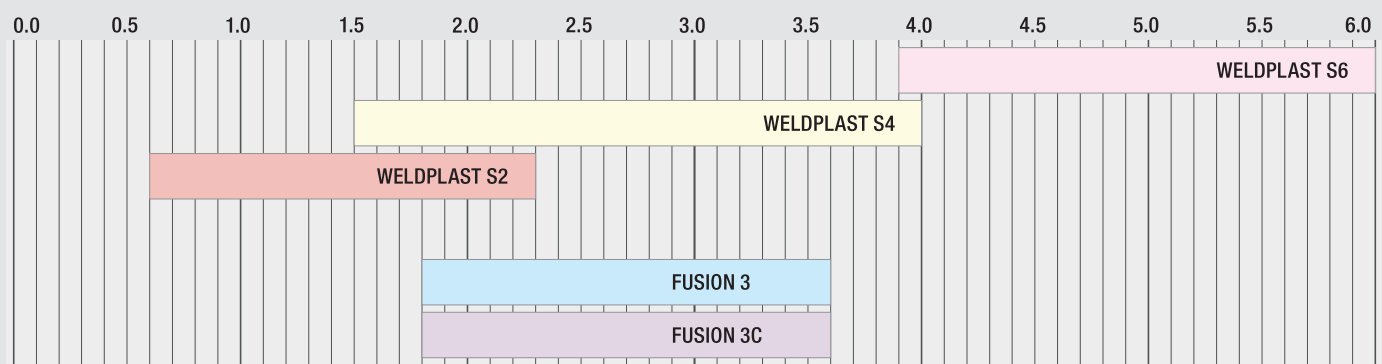
Product comparison

	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	 76	77	78	79 / 80	79 / 80

✓✓ 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. Additional features

Wedge welders

GEOSTAR G5/G7

1



Maintenance friendly:

The well-thought-out construction enables easy access to mechanical parts for cleaning or service.

2



eDrive:

Integrated display of weld pressure, travel speed, wedge temperature and supply voltage enables constant monitoring of key weld parameters during the work process.

3



Ergonomic:

The newly developed clamping mechanism enables simple, one-hand operation to engage rollers and begin welding.

4



Shifting gears:

The GEOSTAR is equipped with a two-gear transmission that can be modified in accordance with work conditions in just a few steps.

5



Weld pressure measurement:

Constant measurement and display of weld pressure.

6



Spacious:

Plenty of room for easy loading of material into the machine to accelerate the start of the welding process.

7



The new wedge geometry:

The new geometry supports the natural flow of geomembranes over the wedge. An intelligent interface makes it possible to replace the wedge in less than one minute!

8



Powerful Drive motor: G7 supplies up to 100% more power than the G5

1

2

3

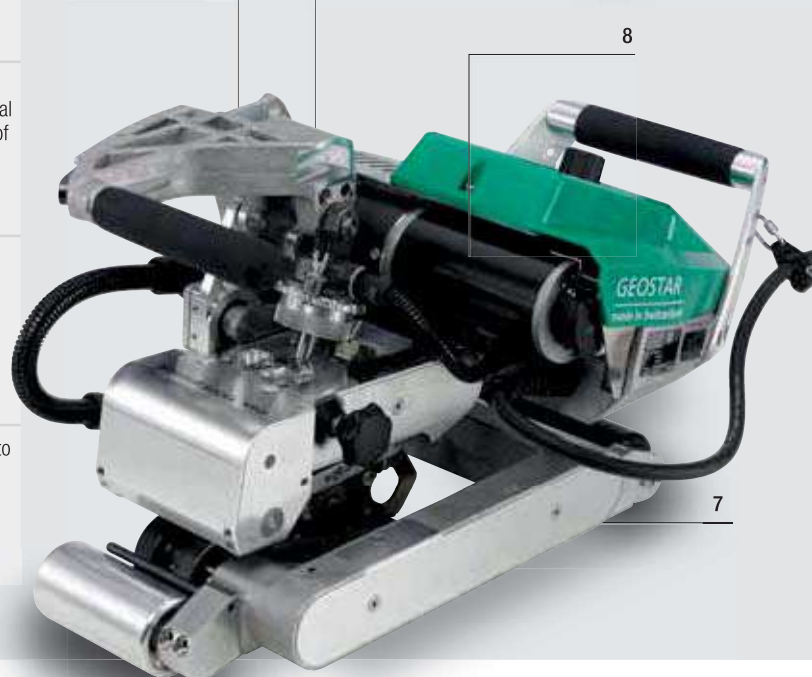
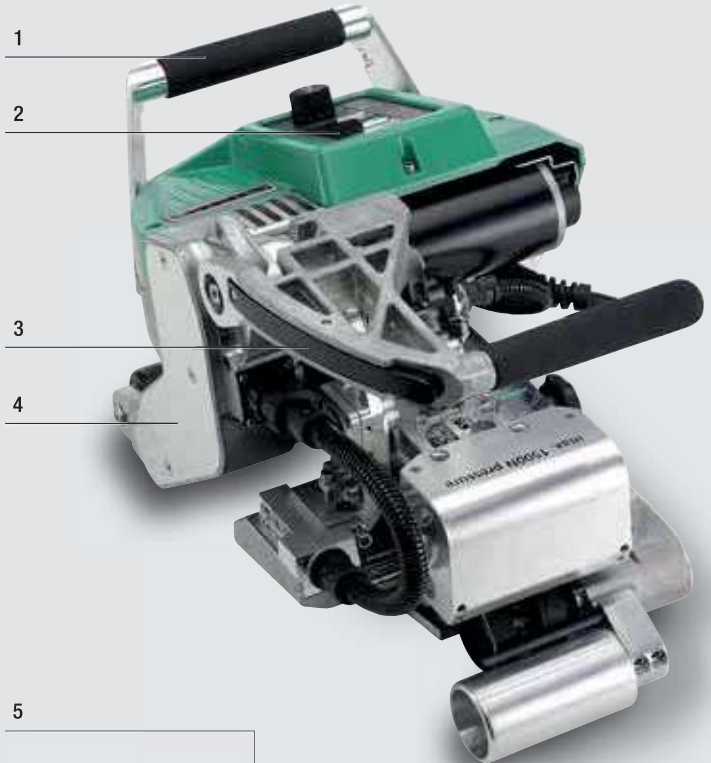
4

5

6

8

7



include: easy loading 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 GEOSTAR G5 and extended-wedge GEOSTAR G7.



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

Wedge welders

GEOSTAR G5/G7

- Welding speed up to 12 m/min
- G7 Longer wedge means int welds 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 G5 / G5 LQS	GEOSTAR G7 / G7 LQS
Voltage	V~	120 / 220 - 240	220 - 240
Frequency	Hz	50 / 60	50 / 60
Power	W	1800 / 2800	2800
Max. heating temperature	°C	460	460
Welding wedge	mm	90 x 50	130 x 50
Max. overlap	mm	150	150
Max. welding force	N	1500	1500
Weld width with test channel	mm	2 x 11 / 2 x 15	2 x 15
Drive speed*1	m/min	0.8–12 Level 1: 0.8–6 Level 2: 1.5–12	0.8–12 Level 1: 0.8–7 Level 2: 1.5–12
Dimensions (L x W x H)	mm	482 x 278 x 269	482 x 278 x 269
Weight	kg	16.4	17.7
Materials		HD-PE 0.8–3.0 mm PP, LD-PE ,TPO, FPO, PVC-P*2, CSPE*2, EIA*2 additional materials upon request	HD-PE 1.0–3.0 mm PP, LD-PE ,TPO, FPO
Mark of conformity		CE	CE
Protection Class I		⏏	⏏

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

*2: Requires steel wedge

Article No.

151.035	GEOSTAR G7, 230V / 2800W, Roller width 50 mm, copper wedge with test channel, with Euro plug
151.683	GEOSTAR G5, 230V / 2800W, Roller width 50 mm, copper wedge with test channel, with Euro plug
151.618	GEOSTAR G5, 120V / 1800W, Roller width 50 mm, copper wedge with test channel, without plug

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

Accessories GEOSTAR G5/G7

	148.489 Wedge Kit GEOSTAR G7, 130 x 50 mm, 230V/2500W, copper wedge with test channel
	151.684 Wedge Kit GEOSTAR G5, 90 x 50 mm, 230V/2500W, copper wedge with test channel
	153.557 stainless steel wedge with test channel 90 x 50mm, 230V/2500W
	149.174 Wedge-Kit GEOSTAR G5, 90 x 50 mm 120V/1600W, copper wedge with test channel
	153.560 stainless steel wedge with test channel 90 x 50 mm 120V/1600W Other wedges on request
	153.361 Drive roll D50 mm x 50 (75) mm; Traction Step, Steel, pointed knurled, with test channel
	153.338 Drive roll D50 mm x 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



GEOSTAR G5 / G7 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 GEOSTAR G7 / G5 LQS provides all the advantages of state-of-the-art technology. It really stands out from the crowd – helping you to win over your client!

Article No.:

- 155.152 GEOSTAR G7 LQS data recording, 230 V / 2800 W, 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



GPS



GEOSTAR G5 / G7



Pinpoint precision

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



GEOSTAR G7 / G5 LQS

- Proven Geostar welding technology
- 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.



GEOSTAR G5 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 to welding data, e.g., from back office



Welding report

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

- DVS 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	1850 / 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, EURO plug

Included with purchase: Welder, manual, 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	1850 / 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 COMET USB, with wedge 50 mm for PE, 230 V / 1200 W *
- 138.088 COMET USB, with wedge 70 mm for PE, 230 V / 1500 W *
- 146.052 COMET USB, with wedge 95 mm for PE, 230 V / 1850 W *

* with test channel, EURO plug

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

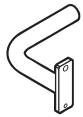
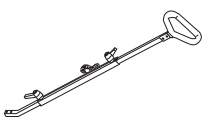



Comet operating in the tunnel ...



... 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

TWINNY T / TWINNY T USB: The little all-rounders.

The TWINNY T is excellent for welding PVC and other thin or soft membranes. It is available either with or without air-test channel. The TWINNY T USB, which makes data storage and display easy with a USB flash memory system, is perfect for critical applications where constant real-time monitoring of primary weld conditions can be stored and displayed.

Combi-wedge welder

TWINNY T



- Simple operation
- High welding speed
- Digital display of temperature and velocity
- Closed-loop control of temperature and drive
- Perfect welding result even in harsh environmental conditions thanks to hot-air system.

Technical Data

Voltage	V~	230 / 120
Power	W	2300 / 1900
Temperature	°C	80 – 560
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Size (L × W × H)	mm	340 × 360 × 245
Weight	kg	6.9 – 7.9
Conformity mark	CE	
Protection class I	⊕	

Article No.

107.562	TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge long, with Euro plug
107.564	TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge short, with Euro plug
111.190	TWINNY T for tunnel construction, 230 V / 2300 W, with test channel, with combi-wedge short, with Euro plug
143.842	TWINNY T for tunnel construction, 120 V / 1900 W, with test channel, with combiwedge short, with UK plug
Civil engineering version: Welder, manual, guide-bar long (129.224), storage case	
Tunneling version: Welder, manual, guide-bar short, storage case	

Combi-wedge welder

TWINNY T USB



- Digital display of welding pressure
- Complete recording of all relevant welding parameters
- USB memory system
- Data transfer made simple

Technical Data

Voltage	V~	230 / 120
Power	W	2300 / 1900
Temperature	°C	80 – 560
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Size (L × W × H)	mm	340 × 360 × 245
Weight	kg	6.9 – 7.9
Conformity mark	CE	
Protection class I	⊕	

Article No.

138.089	TWINNY T USB for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge long, with Euro plug
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Additional versions (incl. 120 V) available upon request.

Civil engineering version:	Welder, manual, guide-bar long (129.224), USB-memory-stick, storage case
Tunneling version:	Welder, manual, guide-bar short, storage case

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.



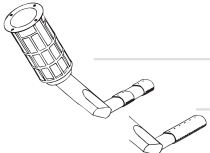
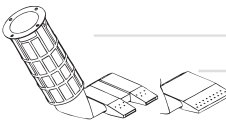


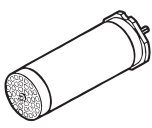
Technical Data

Voltage	V~	120 / 230
Power	W	2900 / 1900
Temperature	°C	80 – 600
Max. overlap	mm	125
Speed		
drive 256:1	m/min	0.2 – 2.5
drive 144:1		1.4 – 4 (6)
Welding pressure	N	1000 / 500 (256:1 / 144:1)
Size (L x W x H)	mm	350 x 390 x 270
Weight	kg	6.5 – 6.9
Conformity mark		CE
Protection class II		□

Article No.

119.031	TWINNY S for tunnel construction, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
119.027	TWINNY S for civil engineering, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
119.008	TWINNY S for civil engineering, drive 144:1, 230 V / 2900 W, with test channel, combi-wedge short, Euro plug
128.808	TWINNY S for civil engineering, drive 144:1, 6 m/min, 230 V / 2900 W, with test channel, combi-wedge short, Euro plug
119.039	TWINNY S for tunnel construction, drive 256:1, 120 V / 1900 W, with test channel, combi-wedge long, w/o plug

Accessories TWINNY T / T USB / TWINNY S

	112.974 Extremely light cross handle 145 gram, material: aluminum
	129.224 Guide bar, complete
	Combi-wedge short 100.517 50 mm, with test channel 100.519 30 mm, with test channel 100.518 50 mm, without test channel 100.520 30 mm, without test channel
	Combi-wedge long, complete 100.525 50 mm, with test channel 100.526 50 mm, without test channel, slotted, perforated
	144.416 USB memory stick TWINNY T USB
	126.448 Storage case (included with purchase)
	103.604 230 V / 2100 W heating element, TWINNY T / T USB 103.602 120 V / 1800 W heating element, TWINNY T / T USB 101.905 230 V / 2750 W heating element, TWINNY S 101.910 230 V / 2100 W heating element, TWINNY S 101.913 120 V / 1800 W heating element, TWINNY S

See COMET for roles.

Cvile engineering version: Welder, manual, guide-bar long (129.224), storage case
Tunneling version: Welder, manual, guide-bar short, storage case



TRIAC DRIVE AT: The little all-rounder

This semi-automatic hot-air welder that's truly one-of-a-kind. Its flexible concept enables the TRIAC DRIVE AT to be used in all kinds of applications.



The perfect choice for welding joint sealing tape.

Semiautomatic hot-air welder

TRIAC DRIVE AT



- Consistent and up to 3x faster than hand welding
- Unique semi-automatic welding machine
- Can perform automatic welding in places other devices can't reach
- With guide, inside or outside nozzle for all precision work in tunnels (available as optional accessory)







Technical Data

Voltage	V~	230
Power	W	1700
Temperature	°C	80 – 650
Speed	m/min	0.5 – 3
Air flow	l / min	(20 °C) 120 – 240
Size (L x W x H)	mm	340 x 360 x 245
Weight	kg	4.1 (with 3 m cable)
Conformity mark	CE	
Protection class II	□	

Article No.

- 117.331 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 30 mm, without grip, pressure roller silicone, EURO-plug
- 148.606 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 12 mm, with grip, pressure roller steel, EURO-plug
- 148.605 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 38 mm, without grip, pressure roller steel, EURO-plug
- Additional versions available upon request.

Accessories TRIAC DRIVE AT

	115.274	12 mm pressure roller, steel
	115.176	30 mm pressure roller, steel
	115.712	40 mm pressure roller, steel
	115.857	30 mm pressure roller, silicone
	115.276	Single supporting carrier, brass
	138.570	Silicone roller
		Overlap welding nozzle, inside, push-fit
	115.281	38 mm, with grip
	115.279	30 mm, with grip
	115.699	12 mm, without grip
	115.703	38 mm, without grip
		Overlap welding nozzle, outside, push-fit
	115.280	38 mm, with grip
	115.278	30 mm, with grip
	115.702	38 mm, without grip
	115.700	30 mm, without grip
	108.985	Storage case (included with purchase)
	142.717	230 V / 1550 W heating element for TRIAC AT

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

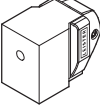


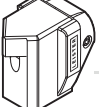
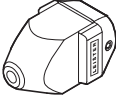
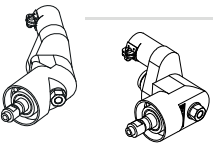



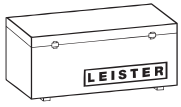

Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 – 5
Output	kg/h	3.9 – 6.0
Size (L × W × H)	mm	821 × 116 × 240
Weight	kg	14
Conformity mark		CE
Protection class I		⊕

Article No.

134.318 Extrusion Welder WELDPLAST S6, 230 V / 4600 W, with CEE 32A 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
	146.242	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
	144.905	45° angled adapter
	145.705	90° angled adapter
Caution: You must use welding shoes with an integrated air guide for this.		
	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

* a = welding seam thickness

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

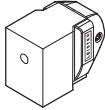



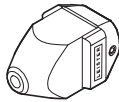
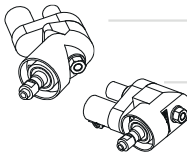


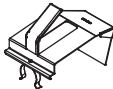
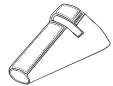
WELDPLAST S4



- 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	WELDPLAST S4, 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	WELDPLAST S4, 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

	146.239	Welding shoe complete
	146.240	54 × 40 × 52 mm blank welding shoe
	146.241	25 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
	146.231	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
	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
	117.053	preheat nozzle small, 20 mm
	117.518	medium, 25 mm
	141.177	large, 35 mm
	136.231	Pre-heat reflector
	149.723	Insulation sleeve

* a = welding seam thickness

WELDPLAST S2: The masterpiece.

The WELDPLAST S2 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 WELDPLAST S2, 230 V / 3000 W, with Euro plug
Included with purchase: WELDPLAST S2, blank welding shoe, storage case
136.602 WELDPLAST S2, 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*)
	145.812	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
	139.460	45° angled adapter
	139.461	90° angled adapter
	134.361	Air filter
	143.776	(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

* a = welding seam thickness

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		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	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	FUSION 3, 230 V / 3500 W, Welding rod Ø 3 – 4 mm, Euro plug				
144.615	FUSION 3, 230 V / 3500 W, Welding rod Ø 4 – 5 mm, Euro plug				
Included with purchase: FUSION 3, blank welding shoe, storage case					

Air heated extrusion welder

FUSION 3C



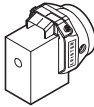

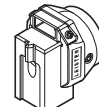



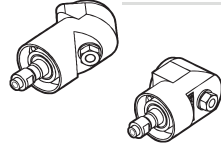


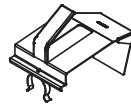

- High welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Dual-sided twist-free wire intake
- 360° rotatable welding shoe

Technical Data		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	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	FUSION 3C, 230 V / 3200 W, Welding rod Ø 3 – 4 mm, Euro plug				
144.826	FUSION 3C, 230 V / 3200 W, Welding rod Ø 4 – 5 mm, Euro plug				
Included with purchase: FUSION 3C, blank welding shoe, storage case					






The FUSION 3 for comfortable working in upright positions.

Accessories FUSION 3 / FUSION 3C

	145.945	Welding shoe complete
	145.946	45 × 30 × 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*)
	145.812	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 Ø 14 mm
	145.488	Corner seam Ø 20 mm
	148.817	45° angled adapter
	148.816	90° angled adapter
	135.082	Air filter in stainless steel FUSION 3C
	131.451	Tool rest WELDPLAST S2 / S2 PVC / FUSION 2 FUSION 3C
	136.231	Preheat reflector
	149.421	Insulation sleeve FUSION 3
	149.420	Insulation sleeve FUSION 3C

General accessories

	144.095	Welding rod de-reeler
	123.173	Storage case
	119.540	WELDPLAST S4 / FUSION 3 WELDPLAST S2 / S2 TPO / FUSION 3C (included with purchase)
	134.567	Heating element,
	109.984	230 V / 2600 W, for WELDPLAST S6
	113.268	230 V / 2200 W, for WELDPLAST S4 / S2
	123.561	230 V / 1100 + 1100 W, for FUSION 3 230 V / 1750 W, for FUSION 3C

FUSION 3C 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.



Blank in uniform size, quickly produced with the Coupon Cutter.

Tensiometer

EXAMO 300F USB, 600F USB




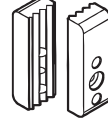

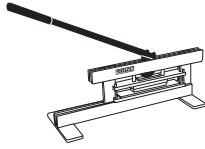
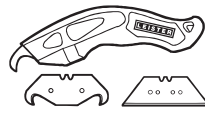
- Construction-site approved
- Handy, robust and reliable
- Testing of elongation, peak force, tear force, test speed and position
- With jaws also suitable for geo textiles (see accessories)
- Electronic recording of the measurement data

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	10 – 550	10 – 550
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L × W × H)	mm	750 × 270 × 190 (case)	1050 × 270 × 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

Accessories EXAMO 300F USB, 600F USB

	134.832 Testing and calibration kit to test and calibrate your EXAMO USB
	108.185 Jaw kit 60 mm for geotextiles including two pairs of jaws
	144.416 USB memory-stick
	145.813 COUPON CUTTER 20 × 150 mm 143.824 Spare blade 150 × 20 mm 146.449 COUPON CUTTER (25 × 150 mm) 146.468 Spare blade 150 × 25 mm 143.828 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)

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 VACUUM BELL Ø 320 mm

152.981 VACUUM BOX 830 x 320 x 150 mm

153.024 VACUUM PUMP 230V

153.025 VACUUM PUMP 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.

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

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

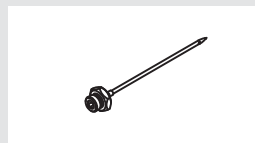


Manometer ASTM
(psi/kPa)

Article No.:

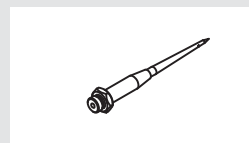
150.720 Tapered injection needle with manometer (standard)
158.374 Tapered injection needle with manometer PSI (ASTM)

Accessories



142.569 Flexible spare needle
(fits also to 150.720)

Accessories



150.142 Tapered Spare needle
(fits also to 142.475)