

Q What is standard lead time?

A 2 to 6 weeks from date of purchase order unless already in stock (1-2 weeks).

Q How long will Fusible Brute and Fusible Series last once installed?

A The PVC industry rates PVC pipe at a design life of 100 years or greater.

Q Can I order Fusible Brute and Fusible Series in different colors for different applications?

A Yes. Blue for potable water, green for sewer, purple for reclaimed water and white for storm sewer and irrigation are all available depending on the required quantity.

Q What types of fittings are typically used in conjunction with butt-fused PVC pipe systems?

A Fusible Brute and Fusible Series pipe systems utilize readily available standard PVC CIOD or IPS fittings that most owners already have in stock and crews are trained in installing. Expensive thermal tapping or repairs are therefore unnecessary. For recommendations on specific fittings or connection hardware - please feel free to call IPEX.

Q Are the joints fused per an AWWA specification as with HDPE?

A AWWA C906 for HDPE gives very general guidelines that would not be specific enough or appropriate for actual pipe fusion. AWWA C906 eventually refers to Plastic Pipe Institute Technical Report 33 (PPI-TR33) which in turn specifies temperature and pressure ranges but eventually acknowledges that other procedures are viable and pipe manufacturers should also be consulted. IPEX would meet these specifications if they were written for PVC. However, IPEX goes a step further by only allowing fusion to be accomplished by technicians that have been trained through a 3-day course held by the Company. IPEX has the sole license for PVC fusion in Canada and therefore does not require an industry standard to govern proper fusion techniques by potentially unqualified field personnel. IPEX will only license a fusion contractor after contractor personnel have been trained in the techniques of PVC butt-fusion by the Company.

Q Where does one obtain Fusible Brute and Fusible Series pipe?

A Contact your regional IPEX sales office.

FAQs

Frequently Asked Questions on...

Fusible Brute™ & Fusible Series™

Capable of being used in a variety of trenchless or conventional direct bury applications, Fusible PVC™ pipe systems have been installed at numerous sites throughout the United States, Canada and Mexico. Applications include pressure and non-pressure installations in the water and sewer industries.



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FAQs

Q What are the unique factors that allow Fusible Brute™ and Fusible Series™ pipe to be fused?

A Fusible Brute and Fusible Series is a proprietary formulation that meets ASTM 1245B and NSF-61 for use with drinking water. Additionally, the patented fusion process ensures a high integrity, “seamless” fused joint.

Q What is the tensile strength of the fusion joint?

A Third party testing demonstrates tensile strength across the joint bead to be 96% to 104% of the tensile strength of the pipe. This tensile strength determines the safe pull stress or force during installation.

Q What are the bending radii?

A A full list bending radii is available on the specification sheet.

Q What is the difference between PE (polyethylene) fusion and Fusible Brute and Fusible Series?

A Fusible Brute and Fusible Series fusion varies from PE in the temperature, pressure, and duration of each step of the process. Overall fusion time requirements are comparable to those of PE.

Q Is special training needed?

A Yes. Fusion technician training/qualification can be achieved by contacting IPEX. Fusible Brute and Fusible Series can only reliably be completed by qualified fusion technicians. See separate Contractor FAQ for more information.

Q What equipment is needed to fuse Fusible Brute and Fusible Series?

A Standard butt-fusion equipment with technical modifications made for PVC fusion can be utilized to reliably fuse IPEX pipe systems. However, fusion equipment must be properly maintained and in good working order per manufacturer recommendations - an inspection may be required.

Q Does the fusion joint qualify as a restrained joint?

A Yes.

Q Is the exterior fusion bead left on or removed?

A IPEX only recommends that the external bead be removed when a possible catch point may exist in a reamed HDD drill hole or in a host pipe at a joint during sliplining, otherwise the bead may be left intact. Bead removal can add cost but not time to the process as it is typically accomplished during the cool down period.

Q Is the internal fusion bead left on or removed?

A Studies indicate negligible loss of performance in flow under pressure due to the internal bead. The internal bead is recommended to be left intact for pressure applications. (Example: When comparing a continuous length of 8" DR18 with no internal bead to one with an internal bead, the difference in flow of 1000gpm is 0.173gpm and a head loss of .013 ft.)

Q Can any C-900/C-905 PVC pipe be fused?

A No. High strength joints are only achieved with the specific IPEX PVC extrusion formulation, found only in Fusible Brute when combined with the patented fusion process.

Q Can it be tapped?

A Yes, Fusible Brute can be tapped using standard AWWA PVC tapping saddles. Tapping without a saddle or sleeve is not recommended. Approved Uni-Bell standard PVC procedures are recommended.

Q What are the applications for Fusible Brute and Fusible Series?

A Many sliplining, direct bury, pipe bursting and horizontal directional drilling applications have already been completed. Micro-tunneling and pipe jacking are also feasible. Please call your company representative for case studies and examples.

Q What are the safe (or allowable) pull back forces?

A A full list of pulling force information is available on a specification sheet.

Q What is the critical buckling pressure?

A Critical buckling pressures are dependent on pipe DR rating. A full list of critical buckling pressure information is available on a specification sheet.

Q What sizes are available?

A Diameter: 100mm - 900mm (4" - 36") CIOD (larger sizes in development)
Length: 12m (40') sticks and custom lengths are available DR-14 through DR-41
Other IPS sizes are available.

see the back page for more info