WIPCOOL®
TWÓJ KLUCZ DO KOMFORTU

OPERATING MANUAL · ENGLISH

PWM-40

Socket Fusion Welder for PP Pipes

Read this manual before use. Keep it with the unit for its entire service life.



Read the manual
Safety and connection rules before the first start-up.

Service and warranty
Service requests and warranty terms at wipcool.eu.

Documents online
Manual, data sheet and declaration of conformity at wipcool.eu.

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How to use this manual

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MEANING OF SYMBOLS



Separate collection of WEEE

Do not dispose of used equipment with household waste.



CE marking

Manufacturer's declaration of conformity with EU requirements.



Read the manual

Safety and operating rules before starting work.

Wipcool PWM-40 user manual

The Wipcool PWM-40 socket fusion welder is used to join PP-R, PE and PP-C pipes and fittings. It has electronic temperature control and a digital display.

The user manual is an integral part of the product. Please read this manual carefully and follow all instructions strictly.

General information

Wipcool products are designed for professional use by qualified air conditioning and refrigeration engineers. As the manufacturer, Wipcool stipulates that our equipment should only be operated by suitably qualified and trained personnel.

- Observe all local safety regulations and general safety standards when using the Wipcool PWM-40 socket fusion welder.
- The user manual should be kept near the device so that personnel can access it easily at all times.
- Before use, qualified personnel should read the user manual carefully and understand all the instructions it contains.
- The manufacturer accepts no liability for any damage resulting from improper use, failure to follow the user manual, lack of personnel qualifications or any unauthorised modifications to the device.
- The general terms of sale contained in the sales documents apply.

Symbols and conventions

Symbols and markings used on the device and in the manual:

01



Hot surface - allow to cool before touching.

02



Hazardous voltage - risk of electric shock.

03



Notice - risk of damage to the device or an incorrect result.

04



Indicates that the product meets the health, safety and environmental standards applicable in the European Union.

05



Do not dispose of the welder with household waste.

Safety information

WARNING

Hot components can cause burns. Wear heat-resistant protective gloves when operating the welder and changing the heating dies. Place the welder on its stand when it is not in use during heating and cooling.

WARNING

Do not modify the plug or open the handle housing - this can cause electric shock and damage to the device.

- Regularly check the condition of the welder, accessories, power cable and plug. Do not connect or use the device if you notice any damage.
- Do not weld materials other than PP-R, PE and PP-C.
- Use only original accessories and heating dies intended for this model.
- Do not use the welder in potentially explosive areas or in the presence of flammable materials.
- Do not use the welder outdoors in the rain. Protect the interior of the device from water and other liquids.

Technical specifications

Parameter	Value
Model	PWM-40
Power supply	230 V~ / 50 Hz
Power	900 W
Protection class	I
Device weight	0.45 kg
Pipe outside diameters	20 / 25 / 32 / 40 mm
Heating plate temperature - factory setting	260 ± 5 °C
Temperature adjustment range	100–320 °C
Maximum heating plate temperature	340 °C
Warning temperature	320 °C
Storage temperature	5–50 °C
Operating temperature	0–50 °C
Relative humidity	45–95% RH
Operating altitude	Up to 1000 m above sea level
Insulation resistance	Not less than 1 MΩ
Leakage current	≤ 5 mA (AC RMS)

Device diagram



Figure 1. Welder components, heating dies and close-up of welding.

Welder components:

01 Heating plate.

02 Display and control buttons.

03 Handle.

04 Stand.

05 Heating sockets.

06 Close-up of fusion welding (welder in operation).

Package contents

- PWM-40 welder with stand.
- Heating dies for pipes of 20 / 25 / 32 / 40 mm diameter.
- Hex key.
- Tool case.

- User manual.

Transport and storage

Do not throw the welder during transport. Protect it from shocks, excessive vibration, moisture, dust and extreme temperatures.

Store the welder horizontally in a dry, well-ventilated place, away from direct sunlight and heat sources.

Assembly

> **CAUTION**
> Do not overtighten the screws when the device is cold. This can damage the threads when removing the heating dies during operation.

> **WARNING**
> Take care when changing hot heating dies. Place removed heating dies where they will not cause burns.

01 Place the welder on the stand, seating the handle in both sockets on the stand. Hold the stand down with your foot during use.

02 Select heating dies to match the pipe diameter and secure them to the heating plate with M8 × 45 hex socket screws. Tighten the screws with the hex key.

Connection

Insert the power cable plug into an earthed 230 V~ socket.

How to use

Setting the temperature and heating

The red indicator shows that the device is heating, and the green indicator shows that it has reached the set temperature.

01 Keep the factory setting or change it using the ▲ (increase) and ▼ (decrease) buttons. A short press changes the setting once, while holding the button changes it continuously. Press SET to confirm the setting.

02 After confirming the setting, wait 3–5 s for heating to start.

03 Wait until the red indicator goes out and the green indicator comes on.

04 Wait until the red indicator comes on again. This indicates that the device has switched to maintaining the set temperature. Welding can begin from this point. Preparation for use usually takes less than 10 min.

Welding pipes and fittings

01 Cut the pipe square using a pipe cutter.

02 Push the pipe and fitting onto the heating dies at the same time, without turning them. Follow the insertion depth and heating time given in the table.

03 Quickly remove the heated parts from the heating dies and join the pipe to the fitting. Do not push them together with excessive force, as this may bend the end of the pipe. Follow the joining and cooling times given in the table.

Outside diameter [mm]	Insertion depth [mm]	Heating time [s]	Joining time [s]	Cooling time [min]
20	14	5	4	3
25	16	7	4	3
32	18.1	8	4	4
40	20.5	12	6	4

If the ambient temperature during use is below 5 °C, increase the heating time by 50%.

Finishing work

When you have finished, remove the plug from the socket. Put the welder in the case only after it has cooled completely.

Maintenance

Disconnect the welder from the power supply before maintenance or servicing.

01 Clean the housing with a soft, dry or slightly damp cloth. Do not use alcohol, petrol, solvents, corrosive substances or strong detergents. Do not immerse the device in water or other liquids.

02 After the device has cooled, remove plastic residue from the heating dies with a soft cloth or wooden tool. Do not use metal tools: a damaged Teflon coating causes plastic to stick, reduces joint quality and shortens the service life of the heating dies.

03 Replace damaged or worn heating dies. Check that the stand is stable and the heating dies are secure.

If the power cable is damaged, do not replace it yourself. Have it repaired by the service centre - submit a request at wipcool.pl/serwis.

Troubleshooting

Problem	Possible cause	Solution
The welder does not work when connected to the power supply	No power supply	Check the mains connection and power socket.
The welder does not work when connected to the power supply	Damaged cable or plug	Have it repaired by the service centre - submit a request at wipcool.pl/serwis.
The welder does not heat up	Incorrect temperature setting	Check the temperature setting.
The welder does not heat up	Damaged heating element	Have it repaired by the service centre - submit a request at wipcool.pl/serwis.
The temperature is unstable	Dirty or damaged heating dies	Clean the heating dies (see 'MAINTENANCE') or replace them (for fitting, see 'ASSEMBLY').
The temperature is unstable	Incorrect supply voltage	Check the power supply specifications.
Plastic sticks to the heating dies	Damaged Teflon coating	Replace the heating dies (for fitting, see 'ASSEMBLY').
Plastic sticks to the heating dies	Operating temperature too high	Reduce the temperature.
Pipe joints leak	Incorrect heating time	Repeat the welding, following the heating time given in the table in 'HOW TO USE'.
Pipe joints leak	Welding temperature too low	Increase the temperature.
The display does not work correctly	Power supply or electronics problem	Remove the plug from the socket, then plug it in again.
The device switches off during use	Thermal protection has tripped	Remove the plug from the socket. Once the welder has cooled, plug it in again.

Waste electrical and electronic equipment

01



The crossed-out bin symbol means that the device must not be disposed of with other waste at the end of its life.

Under the applicable regulations on waste electrical and electronic equipment, products marked with the separate collection symbol must not be placed with other municipal waste. Because they contain harmful substances, electronic products that are not sorted separately may be hazardous to the environment and human health. Proper separate collection of waste electrical and electronic equipment prevents adverse effects on the environment.

By taking waste equipment to a collection point, the user contributes to its reuse, recycling and recovery.

Recycling - a method of protecting the environment. The process of recovering substances from waste that can be reused as raw materials.

Waste recovery - the use of waste that has lost its useful value, such as plastics, paper and cardboard, as secondary raw materials; the term also commonly refers to its destruction.

Information on the collection system for waste electrical and electronic equipment

- Waste electrical and electronic equipment must not be placed with other waste.
- The collection of incomplete electrical and electronic equipment and parts from waste equipment is prohibited.
- A distributor delivering equipment intended for households to a purchaser must collect waste household equipment free of charge at the place of delivery, provided that the waste equipment is of the same type and performs the same function as the equipment delivered.
- The user may hand over waste equipment to a waste equipment collector, a treatment facility or a municipal waste collector in the local authority area.
- Information on collection points is available on the Public Information Bulletin (BIP) websites of regional, city and municipal offices.

Service and documents

Before submitting a request, prepare:

- Model - shown on the device nameplate and invoice.
- Serial number - if there is none, provide the production number (e.g. 11/2025), usually found on the bottom of the device.
- Proof of purchase - an invoice or receipt from an authorised distributor.
- Description of the fault - what is happening, when it started and under what conditions.

You can submit a service request at wipcool.pl/serwis. The warranty terms are also available there.

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SERVICE AND DOCUMENTS

PWM-40 · Operating manual

EDITION DETAILS

Model	**PWM-40**
Edition	**06.11.2026 · EN**
Manufacturer	**Zhejiang Wipcool Refrigeration Equipment Co., Ltd.**
Authorised representative	**4REF sp. z o.o., ul. gen. Władysława Andersa 38, 15-113 Białystok**

wipcool.eu

- online manual and other languages
- data sheet and declaration of conformity
- service and requests

CE

The CE marking confirms the declared conformity with EU requirements.
Crossed-out bin: do not dispose of used equipment with household waste.