

A welding method at manufacture of spirally wound pipe from thermoplastic profile of rectangular cross section, at which hollow profile is wound along helix line around welding drum at simultaneous warming-up of the surfaces to be welded to the assigned temperature with their subsequent compression with each other. In this case, a dual weld between two adjacent turns of hollow profile is formed. Welding is performed by a welding head connected with the extruder and equipped with welding keel, which from outside is inserted between two profile surfaces to be welded. In this case, heating of the surfaces to be welded is performed by hot air supplied through two pairs of air openings located on the side of welding keel.