



SLOVENSKI STANDARD

SIST EN 13480-4:2002

01-november-2002

Kovinski industrijski cevovodi - 4. del: Proizvodnja in vgradnja

Metallic industrial piping - Part 4: Fabrication and installation

Metallische industrielle Rohrleitungen - Teil 4: Fertigung und Verlegung

Tuyauteries industrielles métalliques - Partie 4: Fabrication et installation

Ta slovenski standard je istoveten z: **EN 13480-4:2002**

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ICS:

77.140.75	Jeklene cevi in cevni profili za posebne namene	Steel pipes and tubes for specific use
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EUROPEAN STANDARD
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May 2002

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Metallic industrial piping - Part 4: Fabrication and installation

Tuyauteries industrielles métalliques - Partie 4: Fabrication
et installation

Metallische industrielle Rohrleitungen - Teil 4: Fertigung
und Verlegung

This European Standard was approved by CEN on 23 May 2002.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Management Centre or to any CEN member.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (EN 13480-4:2002) has been prepared by Technical Committee CEN/TC 267 "Industrial piping and pipelines", the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2002, and conflicting national standards shall be withdrawn at the latest by November 2002.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative annex ZA, which is an integral part of this document.

In this standard the Annex A is informative and the Annex B is normative.

This European Standard EN 13480 for metallic industrial piping consists of seven interdependent and not dissociable parts which are :

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— *Part 1 : General.*

— *Part 2 : Materials.*

— *Part 3 : Design.*

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— *Part 4 : Fabrication and installation.*

— *Part 5 : Inspection and testing.*

— *Part 6 : Additional requirements for buried piping.*

CEN/TR 13480-7, *Guidance on the use of conformity assessment procedures.*

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

EN 13480-4:2002 (E)
Issue 1 (2002-05)**1 Scope**

This Part of this European Standard specifies the requirements for fabrication and installation of piping systems, including supports, designed in accordance with EN 13480-3.

2 Normative references

This European Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies (including amendments).

EN 287-1: 1992, *Approval testing of welders – Fusion welding – Part 1: Steels.*

EN 288-2, *Specification and approval of welding procedures for metallic materials – Part 2 : Welding procedure specification for arc welding.*

EN 288-3, *Specification and approval of welding procedures for metallic materials – Part 3 : Welding procedure tests for the arc welding of steels.*

EN 288-5, *Specification and approval of welding procedures for metallic materials – Part 5 : Approval by using approved welding consumables for arc welding.*

EN 288-6, *Specification and approval of welding procedures for metallic materials – Part 6 : Approval related to previous experience.*

EN 288-7, *Specification and approval of welding procedures for metallic materials – Part 7 : Approval by a standard welding procedure for arc welding.*

EN 288-8, *Specification and approval of welding procedures for metallic materials – Part 8 : Approval by a pre-production welding test.*

EN 1418, *Welding personnel – Approval testing of welding operators for fusion welding and resistance weld setters for fully mechanized and automatic welding of metallic materials*

EN 10088-1, *Stainless steels – Part 1 : List of stainless steels.*

EN 10204:1991, *Metallic materials – Types of inspection documents.*

EN 13480-1, *Metallic industrial piping – Part 1: General.*

EN 13480-3, *Metallic industrial piping – Part 3: Design and calculation.*

EN 13480-5:2002, *Metallic industrial piping – Part 5: Inspection and testing.*

EN ISO 13920:1996, *Welding – General tolerances for welded constructions – Dimensions for lengths and angles - Shape and position (ISO 13920:1996).*

CR ISO 15608:2000, *Welding – Guidelines for a metallic material grouping system (ISO/TR 15608:2000)*.

EN 24063, *Welding, brazing, soldering and braze welding of metals - Nomenclature of processes and reference numbers for symbolic representation on drawings (ISO 4063:1990)*.

EN 25817, *Arc-welded joints in steel - Guidance on quality levels for imperfections (ISO 5817:1992)*.

3 Terms and definitions

For the purposes of this Part of this European Standard, the terms and definitions given in EN 13480-1 together with the following apply.

3.1

field run piping

piping installed without preplanning by drawings of the piping routing and the support points

NOTE Typical dimensions are DN 50 or smaller.

3.2

spool (with or without overlength)

prefabricated assembly of components which forms part of a piping system

3.3

cold forming

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3.3.1

cold forming for ferritic steels

forming at temperatures 20 °C to 30 °C below the maximum permissible temperature for post-weld heat treatment in accordance with Table 9.14.1-1

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3.3.2

cold forming for austenitic steels

forming at temperatures below 300 °C

3.4

hot forming

for ferritic steels, forming at temperatures at or above the maximum permissible temperature for post-weld heat treatment in accordance with Table 9.14.1-1

4 Symbols

For the purposes of this Part of this European Standard, the symbols given in EN 13480-1 apply. Additional symbols are defined in appropriate clauses of this Part.

5 General

5.1 Requirements on the manufacturer

The manufacturer shall be responsible for the fabrication and the installation, even if this work will be sub-contracted.

5.2 Requirements on fabricators and installers of piping and supports

5.2.1 The fabricators and/or installers shall ensure the correct transport, handling, storage, fabrication and installation of all piping components including supports.

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5.2.2 The fabricators and installers shall have access to facilities which enable them to handle the piping components including supports correctly and to carry out the required tests.

5.2.3 The fabricators and/or installers shall employ their own responsible supervisors and competent personnel.

If sub-contractors are employed, the fabricator and/or installer shall remain responsible for their competence and the compliance with this European Standard.

5.2.4 All stages of fabrication and installation shall be supervised in such a way as to maintain the design integrity of the finished system.

5.2.5 Co-ordination between those responsible for design and those responsible for fabrication and/or installation shall be maintained at all times, to ensure that fabrication and installation is carried out in accordance with the design specification.

5.3 Requirements for fabrication and installation

5.3.1 Prior to any operation, a check shall be made to ensure that the spools and components supplied are in accordance with the relevant documents (specifications, drawings, certificates etc.).

5.3.2 Prefabricated spools and components shall be protected during handling, transport, and storage.

5.3.3 When joining spools or components, they shall not be strained nor deformed other than as may be required by the design. Designer's installation instructions, if any, shall be observed.

NOTE 5.3.3 is deemed to be fulfilled, when the quality characteristics of the material are not impaired by cold or hot forming, e.g. by cutting, grinding, straightening or bending, of the pipes and when the different pipes have been joined such that stresses and deformations which can impair the safety of the piping are excluded.

5.3.4 Any temporary supports or restraints used as an aid during transport, installation or testing shall be removed prior to commissioning.

5.3.5 Appropriate measures shall be taken to avoid corrosion-inducing contamination of stainless steel and non-ferrous materials. If contamination occurs, it shall be properly removed as soon as practicable, notwithstanding any final treatment.

NOTE Recommended methods for the prevention and removal of contamination on stainless steel are given in Annex A.

5.3.6 Piping for fluids which are likely to cause condensation shall be installed with adequate slopes and traps.

5.4 Classification of piping

The piping systems shall be classified into different classes depending on the fluid carried, diameter and pressure. These are given in EN 13480-1.

5.5 Material grouping

Material grouping shall comply with CR ISO 15608.

5.6 Tolerances

Tolerances shall comply with EN ISO 13920:1996, class C and class G except where other classes are specified in this European Standard.

Angular tolerances for fabricated pipework shall be determined by the dimensional tolerance for the terminal points of the finished part.

Alternative tolerances for fabrication and installation of pipework shall be determined and in all cases these shall be identified in the specification. Dimensional tolerances for fabricated spools shall comply with Annex B.

6 Cutting and bevelling

6.1 General

Cutting and bevelling by machining shall be permitted for all materials.

Flame cutting shall be permitted for material groups 1, 2, 3, 4 and 5 only with preheating as for welding.

NOTE Flame cutting for material groups 1 and 2 can be used for bevelling, if the required bevel forms and tolerances can be achieved and the heat affected zone has no detrimental effects on the quality of the weld.

For material groups 3, 4 and 5, the heat affected zone shall be removed by machining or grinding.

Plasma cutting shall be permitted for all material groups given in this European Standard. Plasma cutting shall be preceded by preheating, as specified for welding in 9.11.1.

Other cutting and bevelling processes shall be permitted, provided their suitability is demonstrated.

6.2 Transfer of marking for pressure parts

For pressure parts, identification of materials shall remain possible, either by retaining or by transferring the mark stipulated by the product standard, or by using a unique code kept in the records of the piping fabricator.

Stamping shall not introduce a notching effect, therefore stamping with round edges is recommended.

If any method of marking other than hard-stamping or engraving (vibrograph) is used, the fabricator shall ensure that confusion between different materials is not possible, e.g. by separate handling (time and/or place), stamped bands.

7 Bending and other forming

7.1 General

7.1.1 Fabricators of formed pressure parts shall have adequate equipment for the forming procedures and the subsequent heat treatment.

NOTE 1 Forming of expansion bellows is specified in EN 13445-3:2002, clause 14.

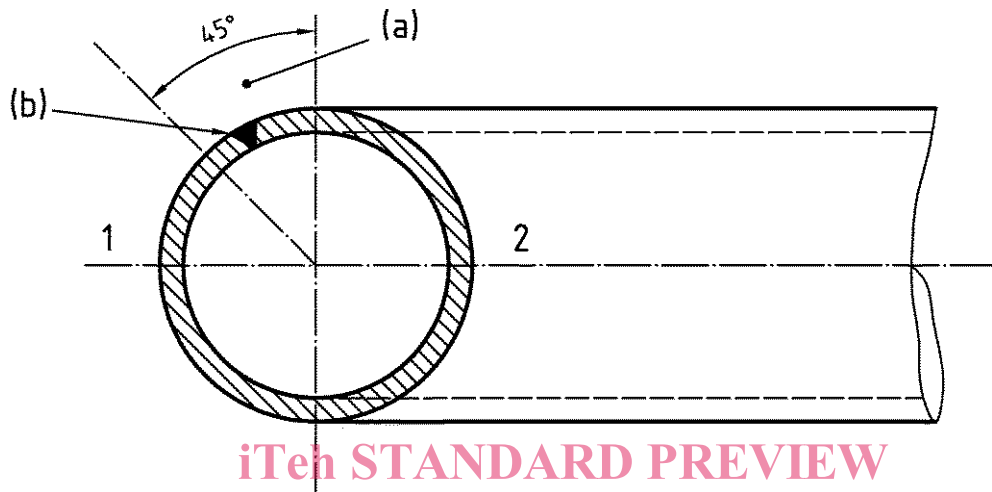
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Pipes with internal coating such as glass, rubber or plastics shall not be formed unless it has been demonstrated that the forming process is not detrimental to the lining.

NOTE 2 There are two kinds of forming within the scope of this standard: cold forming and hot forming.

The thickness after bending or forming shall be not less than that required by the design.

NOTE 3 Longitudinal welds should be located at the neutral zone. The range of the neutral zone after bending is given in Figure 7.1.1-1.



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Key

1 extrados

2 intrados

a optimal range for the longitudinal weld seam at bending

b weld seam

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Figure 7.1.1-1 — Optimal range for the longitudinal weld seam at bending

7.1.2 The forming and post-forming heat treatment of thermomechanical steels shall be given individual consideration. Account shall be taken of the recommendations of the steelmakers.

NOTE Pipes whose properties have been generated by thermomechanical means such as controlled rolling can be formed by hot or cold methods. Such materials may be substantially changed by the forming process and require particular consideration to ensure that the specified properties are recovered after forming.

7.1.3 The following equations shall be used for the calculation of the percentage deformation for cold formed cylinders and cone products made by rolling (see Figure 7.1.3-1) :

a) For cylinders and cones rolled from flat materials (see Figures 7.1.3-1a) and 7.1.3-1c):

$$V_d = \frac{50e_{ord}}{r_{mf}} \quad (7.1.3-1)$$

b) For cylinders and cones rolled from intermediate product (see Figures 7.1.3-1b) and 7.1.3-1c) :

$$V_d = \frac{50e_{\text{int}}}{r_{\text{mf}}} \left(1 - \frac{r_{\text{mf}}}{r_{\text{mi}}} \right) \quad (7.1.3-2)$$

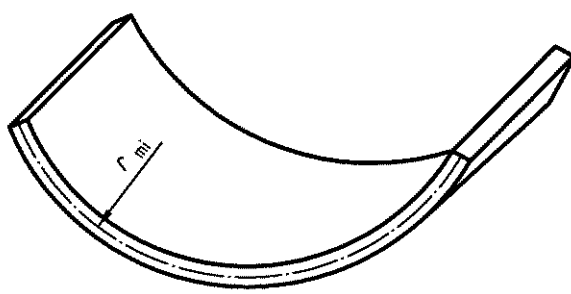
where

- e_{ord} is the ordered thickness;
- e_{int} is the thickness of the intermediate product;
- r_{mf} is the average radius of the finished product;
- r_{mi} is the average radius of the intermediate product;
- V_d is the deformation as a percentage.

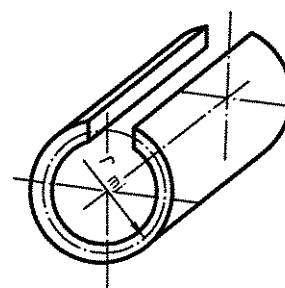
NOTE If no intermediate quality heat treatment is applied between individual forming steps, the deformation is the total amount of deformation of the individual steps. If intermediate quality heat treatment is applied between the forming steps, the deformation is that deformation applied after the last treatment.



a) [SIST EN 13480-4:2002](https://standards.iteh.ai/catalog/standards/sist/f0055e34-b167-4540-a8a4-d1eb8ff9f0dd/sist-en-13480-4-2002)
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b)



c)

a) Initial product

b) Intermediate product

c) Finished product

Figure 7.1.3-1 — Forming of cylinders and cones