SLOVENSKI STANDARD
SIST EN 12760:2000

01-september-2000

Ventili - Notranji varilni nastavki za jeklene ventile

Valves - Socket welding ends for steel valves

Armaturen - Schweißmuffenenden für Armaturen aus Stahl

Appareils de robinetterie - Extrémités a emboîter et a souder pour appareils de robinetterie en acier

Ta slovenski standard je istoveten z: **EN 12760:1999**

ICS:

23.060.01 Ventili na splošno Valves in general

SIST EN 12760:2000 **en**

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 12760

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ICS 23.040.60

English version

Valves - Socket welding ends for steel valves

Appareils de robinetterie - Extrémités à emboîter et à souder pour appareils de robinetterie en acier

Armaturen - Schweißmuffenenden für Armaturen aus Stahl

This European Standard was approved by CEN on 16 August 1999.

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 Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

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

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Contents

Foreword

This European Standard has been prepared by Technical Committee CEN/TC 69 "Industrial valves", 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of an identical text or by endorsement, at the latest by March 2000, and conflicting national standards shall be withdrawn at the latest by March 2000.

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, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This European Standard specifies the dimensions of socket welding ends of steel valves designed to be socket welded to standarised pipes in the size range DN 6 to DN 65.

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.

EN 736-1	Valves - Terminology - Part 1: Definition of types of valves
EN 736-2	Valves - Terminology - Part 2: Definition of components of valves
EN 736-3	Valves - Terminology - Part 3: Definition of terms
ISO 4200	Plain end steel tubes, welded and seamless - General tables of dimensions and masses per unit length

3 Definitions

For the purposes of this standard the definitions of EN 736-1, EN 736-2 and EN 736-3 apply

4 Requirements

4.1 Socket welding ends of steel valve bodies shall have the form shown in figure 1 and dimensions as stated in table 1

4.2 The width of the flat welding surface, C, shall not be less than 0,81 x Pipe wall thickness as specified in ISO 4200 or 3 mm, whichever is the greater.

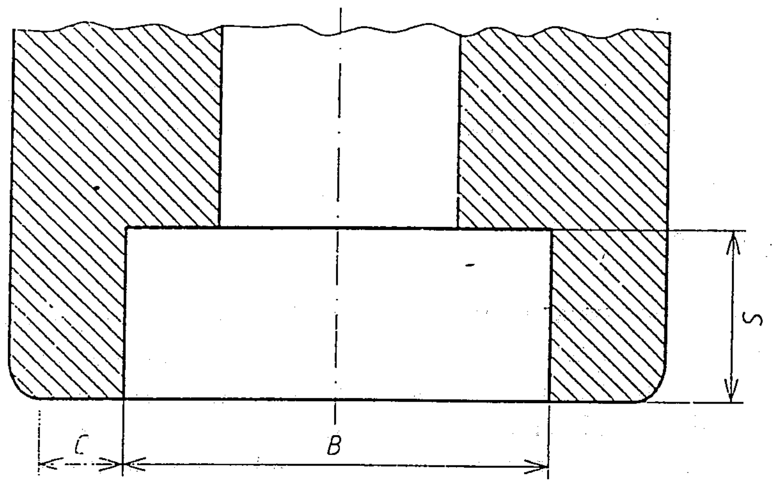

Figure 1 - Socket welding end detail

Table 1 - Dimensions of socket welding ends

Valve DN (Nominal Size)	DN 6	DN 8	DN 10	DN 15	DN 20	DN 25	DN 32	DN 40	DN 50	DN 65
Inside diameter of socket max. ∅B in mm. min.	11,15 10,65	14,60 14,10	18,05 17,55	22,20 21,70	27,55 27,05	34,30 33,80	43,05 42,55	49,15 48,65	61,60 61,10	77,40 76,80
Depth of socket S in mm. min.	10,0	10,0	10,0	10,0	13,0	13,0	13,0	13,0	16,0	16,0

5 Designation

A socket welding end shall be designated by

- the wording “socket welding end (SW)”;
- the number of this European Standard (EN 12760);
- the nominal size DN of the valve (e.g. DN 50).

Example Socket welding end (SW) EN 12760 DN 50

Annex A (informative)

Recommended welding detail

It is recommended that the width of fillet weld C_x as shown in figure A.1 should not be less than 1,09 x Pipe wall thickness or 3mm, whichever is the greater. A gap of approximately 2mm should be left between the bottom of the socket and the end of the pipe.

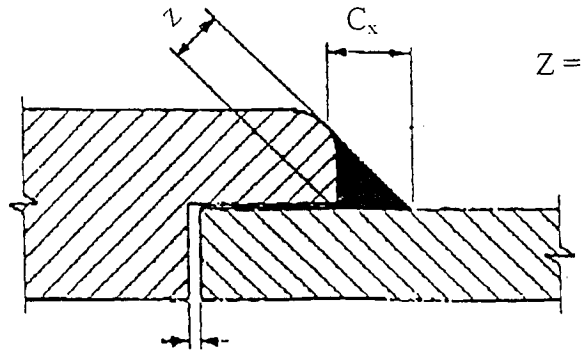

Figure A.1 - Recommended welding detail