

SLOVENSKI STANDARD
SIST EN 10208-2:1998/AC:1998
01-avgust-1998

Jeklene cevi za cevovode za prenos plinastih in tekočih goriv - Tehnični dobavni pogoji - 2. del: Cevi razreda zahtevnosti B

Steel pipes for pipelines for combustible fluids - Technical delivery conditions - Part 2: Pipes of requirement class B

Stahlrohre für Rohrleitungen für brennbare Medien - Technische Lieferbedingungen - Teil 2: Rohre der Anforderungsklasse B

Tubes en acier pour conduites de fluides combustibles - Conditions techniques de livraison - Partie 2: Tubes de la classe de prescription B

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Ta slovenski standard je istoveten z: EN 10208-2:1996/AC:1996

ICS:

75.200	Oprema za skladiščenje nafte, naftnih proizvodov in zemeljskega plina	Petroleum products and natural gas handling equipment
77.140.75	Jeklene cevi in cevni profili za posebne namene	Steel pipes and tubes for specific use

SIST EN 10208-2:1998/AC:1998 **en**

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EUROPEAN STANDARD EN 10208-2:1996
AC:1996

NORME EUROPEENNE

EUROPÄISCHE NORM

August 1996
 août 1996
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English version
 Version française
 Deutsche Fassung

Amends EN 10208-2, June 1996
Amende EN 10208-2, juin 1996
Änderung zur EN 10208-2, Juni 1996

Steel pipes for pipelines for combustible fluids -
 Technical delivery conditions - Part 2: Pipes of
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Stahlrohre für Rohrleitungen für brennbare Medien - Technische Lieferbedingungen - Teil 2: Rohre der Anforderungsklasse B

This corrigendum becomes effective on 1996-08-21 for incorporation in the three official language versions of the EN.

Ce corrigendum prendra effet le 1996-08-21 pour introduction dans les trois versions officielles de la EN.

Die Berichtigung tritt am 1996-08-21 in Kraft und ist in die drei offiziellen Fassungen der EN einzufügen.

CEN

European Committee for Standardization
 Comité Européen de Normalisation
 Europäisches Komitee für Normung

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Ref. no. EN 10208-2:1996/AC:1996 E/F/D

Table 17: Survey of tests and requirements

1	2				3	4	5		6	7	8						
	The specification in column 3 to 8 apply for ¹⁾											Type of test or requirement	Test status ²⁾	Frequency of testing	Sampling conditions	Test method	Requirements
	S	IIFW	SAW,COW												see	see	see
pipes		lgt.	hel.														
a1	x	x	x	x	Cast analysis	m	1 analysis/cast			Left to the discretion of the manufacturer.	table 3						
a2	x	x	x	x	Product analysis	m	1 analysis/cast		8.2.2.1	8.2.3.1	table 4						
b1	x	x	x	x	Tensile test ³⁾ - on the pipe body	m	Except for strip end weld testing the test units shall consist only of pipes of - the same cast - the same heat treatment condition - the same dimension and a) in the case of outside diameters < 508 mm not more than 100 pipes b) otherwise not more than 50 pipes. For strip end welds the test unit shall consist of not more than 50 pipes containing strip end welds per order item. One sample shall be taken per test unit.	Test pieces per sample 1	8.2.2.2.1 and table 18	8.2.3.2	table 5						
b2		x	x	x	- on the weld seam (D ≥ 210 mm)	m						1					
b3				x	- on the strip end weld seam (D ≥ 210 mm)	m						1					
c1	x	x	x	x	Charpy V-notch impact test (for T ≥ 5 mm) ⁴⁾ - on the pipe body	m						3					
c2		x	x	x	- on the weld seam ⁵⁾	m						3					
c3				x	- on the strip end weld seam ⁵⁾	m						3					
d	x	x	x	x	Drop weight tear test on the pipe body ⁶⁾	o						2					
e1			x	x	Bend test - on the weld seam	m						2					
e2				x	- on the strip end weld seam	m						2					
f		x			Flattening test	m						4 tests per coil; plus 2 tests in the case of a weld stop.	fig. 4 and 8.2.2.6	8.2.3.6	figure 4, table 5 and 8.2.3.6.2		
g1			x	x	Macro- and metallographic examination - Metallography	m	Once per shift or when pipe size is changed.	8.2.2.3	8.2.3.7.1	7.6.5.3.							
g2		x			- Metallography	m	Once per shift or when size or steel grade of the pipe is changed.				8.2.3.7.2	8.2.3.7.2					
h1		x	x	x	Hardness test	m	In cold formed pipe any hard spot exceeding 50 mm in any direction shall be tested.	-	8.2.3.9	7.5.8							
h2		x				o	To be carried out by agreement for seam heat treated IIFW pipes.	-	-	"							
i	x	x	x	x	Hydrostatic testing	m	Each pipe shall be tested.	-	8.2.3.8	8.2.3.8 and table 5							
j	x	x	x	x	Visual examination	m	Each pipe shall be examined.	-	8.2.3.9	7.5							
k1	x	x	x	x	Dimensional testing - outside or inside diameter and out-of-roundness of pipe ends - wall thickness of pipe ends - other dimensional characteristics excluding the seam - weld seam	m	Dimensions of each pipe shall be verified. At random testing. The details are left to the discretion of the inspector.	-	8.2.3.10.1, 8.2.3.10.2	7.6.3.1 and table 9							
k2	x	x	x	x		m		8.2.3.10.4	7.6.3.2 and table 10								
k3	x	x	x	x		m		8.2.3.10.3, 8.2.3.10.4	7.6.3.3, 7.6.3.4, 7.6.4								
k4		x	x	x		m		7.6.5									
l	x	x	x	x	Weighing	m	Each pipe or lot shall be weighed.	-	8.2.3.11	7.6.6							
m	x	x	x	x	Non-destructive testing				See table D.1								

1) S = seamless; IIFW = high frequency welded; SAW = Submerged arc welded; COW = Combination welded; lgt. = longitudinal seam; hel. = helical seam
 2) m = mandatory; o = optional;
 3) D = outside diameter;
 4) T = wall thickness
 5) As for test pieces transverse to the weld seam with a width of ≥ 5 mm are obtainable without straightening.
 6) To be carried out by agreement for pipes with an outside diameter > 500 mm, a wall thickness > 8 mm and a minimum yield strength greater than 360 N/mm².
 7) The hardness values shall be agreed.