



SLOVENSKI STANDARD

SIST EN 1256:2006

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Nadomešča:
SIST EN 1256:1998

Oprema za plamensko varjenje - Določila za cevne vode za varilno opremo, rezanje in sorodne postopke

Gas welding equipment - Specification for hose assemblies for equipment for welding, cutting and allied processes

Gasschweißgeräte - Festlegungen für Schlauchleitungen für Ausrüstungen für Schweißen, Schneiden und verwandte Prozesse

Matériel de soudage aux gaz - Spécifications relatives aux assemblages des tuyaux souples sur les douilles porte-tuyaux pour matériel de soudage, coupage et techniques connexes

Ta slovenski standard je istoveten z: EN 1256:2006

ICS:

25.160.30	Varilna oprema	Welding equipment
83.140.40	Gumene cevi	Hoses

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EUROPEAN STANDARD

EN 1256

NORME EUROPÉENNE

EUROPÄISCHE NORM

February 2006

ICS 25.160.30

Supersedes EN 1256:1996

English Version

Gas welding equipment - Specification for hose assemblies for equipment for welding, cutting and allied processes

Matériel de soudage aux gaz - Spécifications relatives aux assemblages des tuyaux souples sur les douilles portetuyaux pour matériel de soudage, coupage et techniques connexes

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This European Standard was approved by CEN on 16 December 2005.

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.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom 2006

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

Management Centre: rue de Stassart, 36 B-1050 Brussels

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Foreword

This European Standard (EN 1256:2006) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DIN.

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 August 2006, and conflicting national standards shall be withdrawn at the latest by August 2006.

This European Standard supersedes EN 1256:1996.

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

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EN 1256:2006 (E)**1 Scope**

This European Standard specifies performance and test requirements of hose assemblies, if supplied in assembled condition for equipment for gas welding, cutting and allied processes using rubber hoses in compliance with EN 559.

This European Standard is not applicable to hose assemblies where the hoses are not in compliance with EN 559 (e.g. high pressure hoses).

2 Normative references

The following referenced documents are indispensable for the application of this European Standard. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 559, *Gas welding equipment — Rubber hoses for welding, cutting and allied processes*

EN 560, *Gas welding equipment — Hose connections for equipment for welding, cutting and allied processes*

EN 29090, *Gas tightness of equipment for gas welding and allied processes (ISO 9090:1989)*

EN 29539, *Materials for equipment used in gas welding, cutting and allied processes (ISO 9539:1988)*

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3 Terms and definitions

For the purposes of this European Standard, the following terms and definitions apply.

3.1**hose assembly**

assembly consisting of a hose tail inserted into the end of a hose and secured by a suitable hose mounting device against sliding off (see Figure 1)

3.2**hose tail**

end of a coupling device (e.g. nipple/nozzle) to be inserted into a hose

3.3**hose mounting device**

non-detachable component such as ferrule or hose clip, which prevents sliding off of the hose from the hose tail

3.4**ferrule**

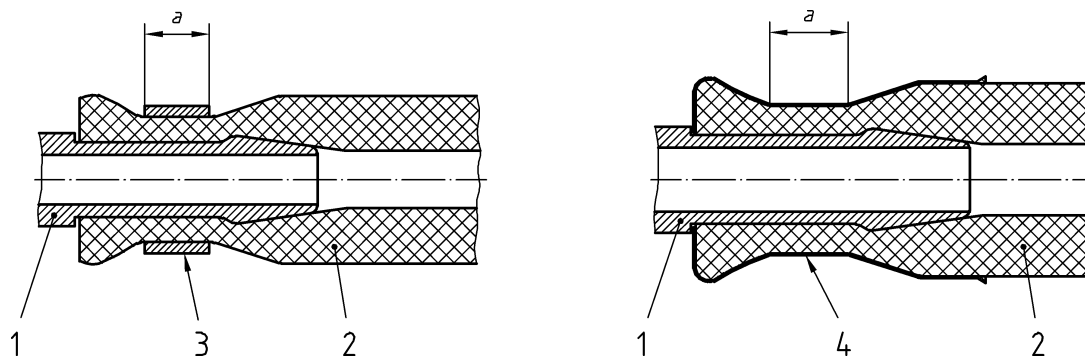
metallic component providing frictional connection between sleeve, hose and hose tail by means of pressing

3.5**hose clip**

metallic component providing frictional connection between sleeve, hose and hose tail by means of clamping

3.6**mounting area**

area on the hose tail where the hose mounting device is positioned



Key

- | | | | |
|---|---------------------------------|---|-----------|
| 1 | hose tail according to EN 560 | 3 | hose clip |
| 2 | rubber hose according to EN 559 | 4 | ferrule |
| a | dimensions for mounting area | | |

Figure 1 — Examples for hose assemblies

4 Construction

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4.1 Materials

Hose assemblies shall be manufactured using hose connections according to EN 560, hoses according to EN 559. Other components for assembled hoses that come into direct contact with the gas supply shall comply with EN 29539. The materials used for hose mounting devices shall be corrosion resistant or protected against corrosion.

For the manufacturing of assembled hoses no greases or pastes shall be used.

4.2 Design of hose tail and hose assembly

4.2.1 General

Annex A (informative) gives some examples for hose tails whose dimensions and shapes are in any case left to the manufacturers practice. The following general requirements shall be in any case fulfilled.

4.2.2 Hose tail

The hose tail profile shall have no sharp edges that could damage the hose during the assembly operation and during use.

The hose tail shall provide an adequate mounting area including dimensional additions on both sides for a safe positioning of the hose mounting device.

4.2.3 Hose assembly

The hose shall be fitted to the hose tail by means of compatible hose mounting device, which provide a reproducible crimping performance. No worm screw drive or similar detachable clips or clamps shall be used to secure the hose to the hose tail.

EN 1256:2006 (E)**4.3 Hose assemblies**

Before fitting any connections the hose shall be free from cuts, abrasions or any other external damage and, internally, free from dirt, talcum powder, rubber fragments or other particles that could interfere with the correct gas flow and the operation of safety devices. The hose mounting device shall not have prominent parts which could cause injuries during operation.

NOTE In order to prevent the kinking of the hose adjacent to the coupling kinking protection in accordance with Annex B (informative) should be added, if required specifically for the application.

5 Performance requirements and test methods**5.1 General**

The following type tests shall be carried out for each combination of a hose tail with the hose and the hose mounting device.

5.2 Gas tightness**5.2.1 Test method**

The hose assembly shall be tested in accordance with the test described in EN 29090. The test shall be carried out only at the maximum operating pressure of the hose.

5.2.2 Acceptance requirements

The measured leakage rate shall not exceed $4 \text{ cm}^3/\text{h}$.

5.3 Resistance to separation under pressure**5.3.1 Test method**

The hose assemblies shall be plugged and pressurised with an internal hydrostatic pressure of three times the maximum operating pressure of the hose.

NOTE Pneumatic testing can be used for this test provided adequate safety precautions are taken to protect persons at risk in the event of equipment failure.

5.3.2 Acceptance requirements

When tested in accordance with 5.3.1 the hose shall not separate from the hose tail.

5.4 Resistance to separation under axial load**5.4.1 Test method**

The un-pressurized assembled hose is subjected to the loads given in Table 1. Apply the load in an axial direction and hold for 2 min.

5.4.2 Acceptance requirements

During the test no separation of the hose from the hose tail or fracture of components shall occur under axial load. After removal of the load the hose assembly shall remain gas tight when tested in accordance with 5.2.

Table 1 — Axial load for separation test

Hose bore (nominal) in mm	Axial load in N
5	440
6,3	520
8	650
10	850
12,5	1 050
16	1 360
20	1 700

6 Marking of hose assemblies

Hose assemblies shall be durably marked with the following information:

- manufacture name or trade mark;
- reference to this European Standard, i.e. EN 1256.

This information shall be marked on the hose mounting device or on a separate band fixed on the hose adjacent to the coupling or on the mounting device.

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