



SLOVENSKI STANDARD
SIST EN 13480-8:2007/A1:2011
01-november-2011

Kovinski industrijski cevovodi - 8. del: Dodatne zahteve za cevovode iz aluminija in aluminijevih zlitin - Dopolnilo A1

Metallic industrial piping - Part 8: Additional requirements for aluminium and aluminium alloy piping

Metallische industrielle Rohrleitungen - Teil 8: Zusatzanforderungen an Rohrleitungen aus Aluminium und Aluminiumlegierungen

Tuyauteries industrielles métalliques - Partie 8: Exigences complémentaires relatives aux tuyauteries en aluminium en alliages d'aluminium

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Ta slovenski standard je istoveten z: EN 13480-8:2007/A1:2011

ICS:

77.140.75	Jeklene cevi in cevni profili za posebne namene	Steel pipes and tubes for specific use
77.150.10	Aluminijski izdelki	Aluminium products

SIST EN 13480-8:2007/A1:2011 **en,fr,de**

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EUROPEAN STANDARD

EN 13480-8:2007/A1

NORME EUROPÉENNE

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Metallic industrial piping - Part 8: Additional requirements for aluminium and aluminium alloy piping

Tuyauteries industrielles métalliques - Partie 8: Exigences complémentaires relatives aux tuyauteries en aluminium et alliages d'aluminium

Metallische industrielle Rohrleitungen - Teil 8: Zusatzanforderungen an Rohrleitungen aus Aluminium und Aluminiumlegierungen

This amendment A1 modifies the European Standard EN 13480-8:2007; it was approved by CEN on 24 April 2011.

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

This amendment 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, 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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Foreword

This document (EN 13480-8:2007/A1:2011) has been prepared by Technical Committee CEN/TC 267 "Metallic industrial piping", the secretariat of which is held by AFNOR.

This Amendment to the European Standard EN 13480-8:2007 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2012, and conflicting national standards shall be withdrawn at the latest by January 2012.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

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.

This European Amendment contains changes to Clauses 2, 5.8, 8.2.3, 8.5.1 and Tables 6.2-2 8.5-1 of EN 13480-8:2007.

This document includes the text of the amendment itself. The corrected pages of EN 13480-2 will be delivered as issue 16 of the standard.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, 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 the United Kingdom.

EN 13480-8:2007/A1:2011 (E)**1 Modification to Clause 2**

Add the date to the following normative reference:

EN 13445-8:2009, *Unfired pressure vessels - Part 8: Additional requirements for pressure vessels of aluminium and aluminium alloys*

Delete:

EN 1289:1998, *Non-destructive examination of welds – Penetrant testing of welds – Acceptance levels*

and replace with:

EN ISO 23277:2009, *Non-destructive testing of welds – Penetrant testing of welds – Acceptance levels (ISO 23277:2006)*

Delete:

EN 1712:2002, *Non-destructive examination of welds – Ultrasonic examination of welded joints – Acceptance levels*

and replace with:

EN ISO 11666:2010, *Non-destructive testing of welds – Ultrasonic testing – Acceptance levels (ISO 11666:2010)*

Delete:

EN 1714:1997, *Non-destructive examination of welds – Ultrasonic examination of welded joints*

and replace with:

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EN ISO, 17640:2010, *Non-destructive testing of welds – Ultrasonic testing – Techniques, testing levels, and assessment (ISO 17640:2010)*

2 Modification to Clause 5.8

Change the cross reference from "5.6" to "5.7" to read as follows:

"Threads of bolts and studs shall be rolled. Regarding prevention of brittle fracture for materials of fasteners 5.7 of this standard applies."

3 Modification to Table 6.2-2

Replace Table 6.2-2 by the following:

Table 6.2-2 — Allowable design strength values for 6 000 series aluminium alloys in the welded condition (see 5.6)

Material designation to EN 12392	Value of f for design temperature (°C) not exceeding					
	50	75	100	125 ^a	150	175 ^a
EN AW-6060	40	40	40	38	-	-
EN AW-6061	55	55	55	54	51	43

^a For maximum design temperature see 5.6. Values for 125 °C (EN AW-6060) and 175 °C (EN AW-6061) shall be used for interpolation only.

NOTE Data are derived from EN 13445-8:2009

4 Modification to Clause 8.2.3

Add the following sentence before Table 8.2-1:

"Destructive testing is not required for formed parts with welds for which the manufacturer applies a welding procedure approval that comprises heat treatment."

5 Modification to Table 8.5-1

Replace Table 8.5-1 by the following:

EN 13480-8:2007/A1:2011 (E)

Table 8.5-1 — Techniques, methods, acceptance criteria

Technique (abbreviations)	Methods	Acceptance criteria
Visual inspection (VT)	EN 970	EN ISO 10042:2005 Acceptance level B ^a
Radiography (RT)	EN 1435:1997 class B ^b	EN ISO 10042:2005 Acceptance level B ^c
Ultrasonic Testing (UT)	Manual UT, EN ISO 17640 For thickness e_n (mm) $4 \leq e_n < 40$ class A $40 \leq e_n < 100$ class B $e_n \geq 100$ class C Automatic UT, EN 10246 ^e	EN ISO 11666 Acceptance level 2 ^d
Penetrant Testing (PT)	EN 571-1 and testing parameters of EN ISO 23277	EN ISO 23277 Acceptance level 2

^a For imperfections 1.11 (502) (excess weld metal for butt weld), 1.12 (503) (excessive convexity for fillet welds), 1.14 (504) (excess penetration), 3.1 (507) (linear misalignment, for circumferential welds only), 1.10 (5011) (continuous undercut, but max depth 0,2 mm) 1.18 (5013/515) (shrinkage groove/root concavity), 1.16 (511) (incompletely filled groove) according to EN ISO 10042: level C is sufficient.

^b However, the minimum number of exposure for circumferential weld testing may correspond to the requirements of class A of EN 1435.

^c For imperfections No 2.7 (2016) (wormholes isolated), 2.8 (303) (Oxide inclusion), 2.9 (3041) (tungsten inclusion), 2.3 (2011) (Pore isolated), 2.5 (2013) (clustered (localized) porosity) according to EN ISO 10042, level C is sufficient.

^d No planar imperfections accepted. For $e_n \geq 60$ mm UT shall include examination for imperfections perpendicular to the surface in accordance with EN 583-4.

^e EN 10246 applies to NDT of steel tubes. Until an NDT European Standard for automatic ultrasonic testing of aluminium and aluminium alloy materials is issued, EN 10246-9 and EN 10246-16 shall be used as reference standard for acceptable method of automatic ultrasonic testing of aluminium and aluminium alloy materials according to this European Standard.