



SLOVENSKI STANDARD
SIST EN 13480-8:2007/kFprA1:2011
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Kovinski industrijski cevovodi - 8. del: Dodatne zahteve za cevovode iz aluminija in aluminijevih zlitin - Dopnilo 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

Ta slovenski standard je istoveten z: EN 13480-8:2007/FprA1

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

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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 en alliages d'aluminium

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

This draft amendment is submitted to CEN members for unique acceptance procedure. It has been drawn up by the Technical Committee CEN/TC 267.

This draft amendment A1, if approved, will modify the European Standard EN 13480-8:2007. If this draft becomes an amendment, 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.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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Contents

Page

Foreword.....	3
1 Modification to Clause 2	4
2 Modification to Clause 5.8	4
3 Modification to Table 6.2-2	4
4 Modification to Clause 8.2.3	4
5 Modification to Table 8.5-1	4

Foreword

This document (EN 13480-8:2007/FprA1:2010) has been prepared by Technical Committee CEN/TC 267 "Metallic industrial piping", the secretariat of which is held by AFNOR.

This document is currently submitted to the Unique Acceptance Procedure.

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 97/23/EC.

For relationship with EU Directives, see informative Annex ZA, which is an integral part of this document.

This European Amendment contains changes to Clauses 2, 5.7, 8.2.3, 8.5.1 and Table 6.2-2 of EN 13480-8:2007.

EN 13480-8:2007/FprA1:2010 (E)**1 Modification to Clause 2**

Add the date to the following normative reference:

EN 13445-8:2006, *Unfired pressure vessels - Part 8: Additional requirements for pressure vessels of aluminium and aluminium alloys*

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 13445-8:2006

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:

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 1714 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 1712:1997 Acceptance level 2 ^d
Penetrant Testing (PT)	EN 571-1 and testing parameters of EN 1289:1998, Table A.1	EN 1289:1998 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.