



SLOVENSKI STANDARD

SIST EN 12760:2016

01-julij-2016

Nadomešča:
SIST EN 12760:2000

Industrijski ventili - Notranji varilni nastavki za jeklene ventile

Industrial valves - Socket welding ends for steel valves

Industriearmaturen - Schweißmuffenenden für Armaturen aus Stahl

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

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Ta slovenski standard je istoveten z: EN 12760:2016

[SIST EN 12760:2016](#)

[http://www.sist.si/standards/sist-en-12760-2016/e0-49ba-9c41-44f85a8ff74/sist-en-12760-2016](#)

ICS:

23.060.01 Ventili na splošno Valves in general

SIST EN 12760:2016

en,fr,de

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EUROPEAN STANDARD

EN 12760

NORME EUROPÉENNE

EUROPÄISCHE NORM

April 2016

ICS 23.040.60

Supersedes EN 12760:1999

English Version

Industrial valves - Socket welding ends for steel valves

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

Industriearmaturen - Schweißmuffenenden für Armaturen aus Stahl

This European Standard was approved by CEN on 3 March 2016.

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 CEN-CENELEC Management Centre 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 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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.

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

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

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European foreword

This document (EN 12760:2016) 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 October 2016, and conflicting national standards shall be withdrawn at the latest by October 2016.

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 supersedes EN 12760:1999.

The main change is the update of the standard to be in compliance with the present rules for the structure and drafting of CEN-CENELEC publications.

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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom. (standards.iteh.ai)

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1 Scope

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

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) 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 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 736-1, EN 736-2 and EN 736-3 apply.

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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.

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

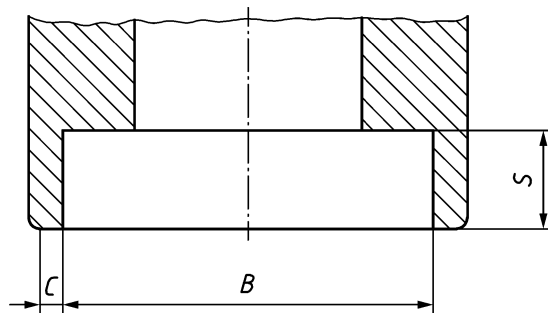


Figure 1 — Socket welding end detail

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.	11,15	14,60	18,05	22,20	27,55	34,30	43,05	49,15	61,60	77,40
ØB in mm. min.	10,65	14,10	17,55	21,70	27,05	33,80	42,55	48,65	61,10	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 following:

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

EXAMPLE Socket welding end (SW) EN 12760 DN 50.

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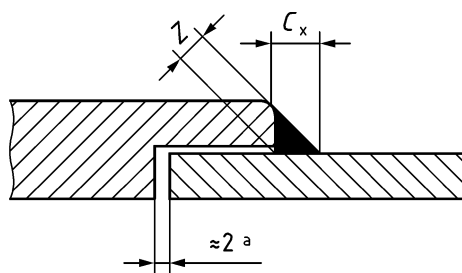
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Annex A (informative)

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 $1,09 \times$ pipe wall thickness or 3 mm, whichever is the greater. A gap of approximately 2 mm should be left between the bottom of the socket and the end of the pipe.



Key

Z $0,707 \times C_x$

^a Approximately 2,0 mm before welding

Figure A.1 — Recommended welding detail

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