



**SLOVENSKI STANDARD**  
**SIST EN 13480-4:2012/kFprA3:2016**  
**01-marec-2016**

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**Kovinski industrijski cevovodi - 4. del: Proizvodnja in vgradnja - Dopolnilo A3**

Metallic industrial piping - Part 4: Fabrication and installation

Metallische industrielle Rohrleitungen - Teil 4: Fertigung und Verlegung

Tuyauteries industrielles métalliques - Partie 4: Fabrication et installation

**Ta slovenski standard je istoveten z: EN 13480-4:2012/FprA3**

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**ICS:**

77.140.75	Jeklene cevi in cevni profili za posebne namene	Steel pipes and tubes for specific use
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**SIST EN 13480-4:2012/kFprA3:2016**      **en,fr,de**



EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**FINAL DRAFT**  
**EN 13480-4:2012**  
**FprA3**

December 2015

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ICS 23.040.01

English Version

## Metallic industrial piping - Part 4: Fabrication and installation

Tuyauteries industrielles métalliques - Partie 4:  
Fabrication et installation

Metallische industrielle Rohrleitungen - Teil 4:  
Fertigung und Verlegung

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 A3, if approved, will modify the European Standard EN 13480-4:2012. 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.

This draft amendment was established by CEN 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.

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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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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 13480-4:2012/FprA3:2015) 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(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of EN 13480-4:2012.

This document includes the text of the amendment itself. The amended/corrected pages of EN 13480-4:2012 will be published as Issue 5 of the European Standard.

**EN 13480-4:2012/FprA3:2015 (E)****1 Modifications to Clause 2, Normative references**

Replace the references to EN 287-1 and EN 1418 with:

“EN ISO 9606-1:2013, *Qualification testing of welders — Fusion welding — Part 1: Steels (ISO 9606-1:2012, including Cor 1:2012)*”

and

“EN ISO 14732:2013, *Welding personnel — Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials (ISO 14732:2013)*”.

Add the following new reference:

“EN ISO 3834-2, *Quality requirements for fusion welding of metallic materials — Part 2: Comprehensive quality requirements (ISO 3834-2)*”.

**2 Modification to 9.1, Welding personnel**

Replace the existing subclause 9.1.1 with the following:

**“9.1.1** Welding work shall be carried out by approved welders.

The welders shall be approved in accordance with EN ISO 9606-1:2013 for the intended processes, material groups and range of sizes and shall be in possession of a valid test certificate in accordance with

EN ISO 9606-1:2013, Annex A.

Welding operators for fully mechanized or automatic processes shall be approved in accordance with EN ISO 14732:2013.

For the application of this standard under the PED for pressure equipment of categories II, III and IV the re-validation in accordance with EN ISO 9606-1:2013, 9.3 c) or in accordance with EN ISO 14732:2013, 5.3 c) is permitted, provided that the notified body or recognized third party organizations perform the re-validation. Verification of the quality program in accordance with EN ISO 3834-2 or EN ISO 3834-3 does not require any certification.

NOTE Previous qualifications according to EN 287-1 or EN 1418 remain valid and may be prolonged in accordance with EN 287-1 or EN 1418.”.

**3 Modification to 9.14.6, Local heat treatment**

Replace the first paragraph with the following:

“When local heat treatment of circumferential welds is applied by heating a heated band around the entire circumference, the heated band shall be at minimum  $5 \cdot (((D - t) / 2) \cdot t)^{0,5}$

where

$D$  is the outer diameter of the pipe, in millimetres,

$t$  is the nominal thickness, in millimetres.”.

#### **4 Modifications to the Bibliography**

*Add the following references to the bibliography:*

*“EN 287-1, Qualification test of welders — Fusion welding — Part 1: Steels”*

*and*

*“EN 1418, Welding personnel — Approval testing of welding operators for fusion welding and resistance weld setters for fully mechanized and automatic welding of metallic materials”.*