



**SLOVENSKI STANDARD**  
**SIST EN 13480-4:2012/A4:2017**  
**01-julij-2017**

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**Kovinski industrijski cevovodi - 4. del: Proizvodnja in vgradnja - Dopolnilo A4**

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/A4:2017**

[SIST EN 13480-4:2012/A4:2017](https://standards.iteh.ai/catalog/standards/sist/8215a478-1253-4542-882b-e396a2f86034/sist-en-13480-4-2012-a4-2017)

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**ICS:**

|           |  |   |
|-----------|--|---|
| 77.140.75 | Jeklene cevi in cevni profili<br>za posebne namene | Steel pipes and tubes for<br>specific use |
|-----------|--|---|

**SIST EN 13480-4:2012/A4:2017**                      **en**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 13480-4:2012/A4**

April 2017

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 amendment A4 modifies the European Standard EN 13480-4:2012; it was approved by CEN on 27 February 2017.

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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, 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 13480-4:2012/A4:2017) has been prepared by Technical Committee CEN/TC 267 "Metallic industrial piping", 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 2017, and conflicting national standards shall be withdrawn at the latest by October 2017.

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 document includes the text of the amendment itself. The amended/corrected pages of EN 13480-4:2012 will be published in the 2017 edition of the European 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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

**EN 13480-4:2012/A4:2017 (E)****1 Modification to 9.14.1**

Replace the two paragraphs above Table 9.14.1-1 with the following:

“For PWHT,  $P_{\text{crit}}$  values for material groups and materials are given in Table 9.14.1-3.

Heat treatment as per Table 9.14.1-3 particularly in the upper range of holding temperature and/or holding time may unduly impair the physical properties (e.g. yield, tensile strength and toughness of the material) the additional effect of multiple heating cycles should be considered. This effect is explained and published as Hollomon-Jaffe Parameter  $P$  as given in Formula (9.14.1-1).

The actual value  $P$  shall be calculated in accordance with (9.14.1-1).

$$P = T_s (20 + \lg t) 10^{-3} \quad (9.14.1-1)$$

where

$T_s$  is the holding temperature, in Kelvin;

$t$  is the holding time, in hours;

$\lg = \log_{10}$ .

The heat treatment shall be performed taking into account the quality requirements given in EN ISO 17663:2009.”

**2 Modification to 10.3**

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Replace the second paragraph with the following:

“Repair welds shall be made using qualified procedures by qualified welding personnel. Prior to repair welding, the surface of the joint shall be examined by NDT to ensure freedom from cracks and other defects.”

**3 Modification to 12.5**

Replace the first paragraph by the following:

“The piping in an ambient explosive atmosphere shall be installed in such a way that any operation cannot cause any harmful static electricity.

For the case that the pipework is not grounded by direct contact over the structural supports earthing shall be provided. In this case the resistance measured between piping and earth shall not be more than  $10^6 \Omega$ .”