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Nevarjene jeklene cevi za tlačne posode - Tehnični dobavni pogoji - 5. del: Cevi iz nerjavnega jekla

Seamless steel tubes for pressure purposes - Technical delivery conditions - Part 5: Stainless steel tubes

Nahltlose Stahlrohre für Druckbeanspruchungen - Technische Lieferbedingungen - Teil 5: Rohre aus nichtrostenden Stählen

Tubes sans soudure pour service sous pression - Conditions techniques de livraison - Partie 5 : Tubes en aciers inoxydables

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Seamless steel tubes for pressure purposes - Technical delivery conditions - Part 5: Stainless steel tubes

Tubes sans soudure pour service sous pression -
 Conditions techniques de livraison - Partie 5 : Tubes en
 aciers inoxydables

Nahtlose Stahlrohre für Druckbeanspruchung -
 Technische Lieferbedingungen - Teil 5: Rohre aus
 nichtrostenden Stählen

This European Standard was approved by CEN on 12 March 2021.

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.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
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CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents	Page
European foreword.....	4
1 Scope.....	6
2 Normative references.....	6
3 Terms and definitions.....	8
4 Symbols.....	8
5 Classification and designation.....	8
5.1 Classification.....	8
5.2 Designation.....	8
6 Information to be supplied by the purchaser.....	9
6.1 Mandatory information.....	9
6.2 Options.....	9
6.3 Examples of an order.....	10
6.3.1 Example 1.....	10
6.3.2 Example 2.....	10
7 Manufacturing process.....	10
7.1 Steelmaking process.....	10
7.2 Tube manufacture and delivery conditions.....	11
8 Requirements.....	12
8.1 General.....	12
8.2 Chemical composition.....	12
8.2.1 Cast analysis.....	12
8.2.2 Product analysis.....	12
8.3 Mechanical properties.....	18
8.3.1 At room temperature.....	18
8.3.2 At elevated temperature.....	18
8.3.3 At low temperature.....	18
8.4 Corrosion resistance.....	27
8.5 Appearance and soundness.....	27
8.5.1 Appearance.....	27
8.5.2 Soundness.....	27
8.6 Straightness.....	28
8.7 Preparation of ends.....	28
8.8 Dimensions, masses and tolerances.....	29
8.8.1 Outside diameter and wall thickness.....	29
8.8.2 Mass.....	29
8.8.3 Lengths.....	29
8.8.4 Tolerances.....	29
9 Inspection.....	30
9.1 Type of inspection.....	30
9.2 Inspection documents.....	30
9.2.1 Types of inspection documents.....	30
9.2.2 Content of inspection documents.....	31
9.3 Summary of inspection and verification testing.....	31

10	Sampling	31
10.1	Test unit	31
10.2	Preparation of samples and test pieces.....	33
10.2.1	Selection and preparation of samples for product analysis	33
10.2.2	Location, orientation and preparation of samples and test pieces for mechanical tests.....	33
11	Verification test methods	34
11.1	Chemical analysis	34
11.2	Tensile test.....	34
11.2.1	At room temperature	34
11.2.2	At elevated temperature	34
11.3	Technological tests.....	35
11.3.1	General	35
11.3.2	Flattening test.....	35
11.3.3	Ring tensile test.....	35
11.3.4	Drift expanding test.....	36
11.3.5	Ring expanding test	36
11.4	Impact test.....	36
11.5	Intergranular corrosion test	37
11.6	Leak tightness test.....	37
11.6.1	Hydrostatic test.....	37
11.6.2	Eddy current test	38
11.6.3	Ultrasonic test.....	38
11.7	Dimensional inspection.....	38
11.8	Visual examination	38
11.9	Non-destructive testing.....	38
11.10	Material identification.....	38
11.11	Retests, sorting and reprocessing	38
12	Marking	39
12.1	Marking to be applied	39
12.2	Additional marking.....	39
13	Handling and packaging.....	39
Annex A	(informative) Reference data of strength values for creep rupture of austenitic steels in the solution annealed condition.....	40
Annex ZA	(informative) Relationship between this European Standard and the Essential Requirements of Directive 2014/68/EU aimed to be covered	46
Bibliography	47

EN 10216-5:2021 (E)**European foreword**

This document (EN 10216-5:2021) has been prepared by Technical Committee CEN/TC 459/SC 10 “Steel tubes, and iron and steel fittings”, the secretariat of which is held by UNI.

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 2021, and conflicting national standards shall be withdrawn at the latest by October 2021.

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

This document supersedes EN 10216-5:2013.

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 2014/68/EU.

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

The following changes have been made in comparison to the previous edition EN 10216-5:2013:

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- a) the normative references have been updated;
 - b) in Table 6 and Table 7, the footnote “a” has been completed;
 - c) in 8.8, the dated reference of the standards has been deleted;
 - d) in Table 15, the frequency of testing in test category 2 for tensile test at room temperature has been modified;
 - e) the impact testing (11.4.1) has been modified;
 - f) the standard has been editorially revised.

EN 10216 consists of the following parts, under the general title *Seamless steel tubes for pressure purposes – Technical delivery conditions*:

- *Part 1: Non-alloy steel tubes with specified room temperature properties;*
- *Part 2: Non-alloy and alloy steel tubes with specified elevated temperature properties;*
- *Part 3: Alloy fine grain steel tubes;*
- *Part 4: Non-alloy and alloy steel tubes with specified low temperature properties;*
- *Part 5: Stainless steel tubes (the present document).*

Another European Standard series covering tubes for pressure purposes is:

- EN 10217 series, *Welded steel tubes for pressure purposes – Technical delivery conditions.*

According to the CEN-CENELEC Internal Regulations, the national standards organisations 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, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

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EN 10216-5:2021 (E)**1 Scope**

This document specifies the technical delivery conditions in two test categories for seamless tubes of a circular cross section made of austenitic (including creep resisting steel) and austenitic-ferritic stainless steel which are intended for pressure and corrosion resisting purposes at room temperature, at low temperatures or at elevated temperatures.

NOTE Once this document is published in the Official Journal of the European Union (OJEU) under Directive 2014/68/EC, presumption of conformity to the Essential Safety Requirements (ESR) of Directive 2014/68/EC is limited to technical data of materials in this document and does not presume adequacy of the material to a specific item of equipment. Consequently, the assessment of the technical data stated in this material standard against the design requirements of this specific item of equipment to verify that the ESRs of the Pressure Equipment Directive are satisfied will be done by the designer or manufacturer of the pressure equipment, taking also into account the subsequent manufacturing processes which could affect properties of the base materials.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10020:2000, *Definition and classification of grades of steel*

EN 10021:2006, *General technical delivery conditions for steel products*

EN 10027-1:2016, *Designation systems for steels - Part 1: Steel names*

EN 10027-2:2015, *Designation systems for steels - Part 2: Numerical system*

EN 10028-7:2016, *Flat products made of steels for pressure purposes - Part 7: Stainless steels*

EN 10088-1:2014, *Stainless steels - Part 1: List of stainless steels*

EN 10168:2004, *Steel products - Inspection documents - List of information and description*

EN 10204:2004, *Metallic products - Types of inspection documents*

EN 10266:2003, *Steel tubes, fittings and structural hollow sections - Symbols and definitions of terms for use in product standards*

CEN/TR 10261:2018, *Iron and steel - European standards for the determination of chemical composition*

EN ISO 148-1:2016, *Metallic materials - Charpy pendulum impact test - Part 1: Test method (ISO 148-1:2016)*

EN ISO 377:2017, *Steel and steel products - Location and preparation of samples and test pieces for mechanical testing (ISO 377:2017)*

EN ISO 643:2020, *Steels - Micrographic determination of the apparent grain size (ISO 643:2019, Corrected version 2020-03)*

EN ISO 1127:1996, *Stainless steel tubes - Dimensions, tolerances and conventional masses per unit length (ISO 1127:1992)*

EN ISO 2566-2:1999, *Steel - Conversion of elongation values - Part 2: Austenitic steels (ISO 2566-2:1984)*

EN ISO 3651-2:1998, *Determination of resistance to intergranular corrosion of stainless steels - Part 2: Ferritic, austenitic and ferritic-austenitic (duplex) stainless steels - Corrosion test in media containing sulfuric acid (ISO 3651-2:1998)*

EN ISO 4885:2018, *Ferrous materials - Heat treatments - Vocabulary (ISO 4885:2018)*

EN ISO 6892-1:2019, *Metallic materials - Tensile testing - Part 1: Method of test at room temperature (ISO 6892-1:2019)*

EN ISO 6892-2:2018, *Metallic materials - Tensile testing - Part 2: Method of test at elevated temperature (ISO 6892-2:2018)*

EN ISO 8492:2013, *Metallic materials - Tube - Flattening test (ISO 8492:2013)*

EN ISO 8493:2004, *Metallic materials - Tube - Drift-expanding test (ISO 8493:1998)*

EN ISO 8495:2013, *Metallic materials - Tube - Ring-expanding test (ISO 8495:2013)*

EN ISO 8496:2013, *Metallic materials - Tube - Ring tensile test (ISO 8496:2013)*

EN ISO 10893-1:2011,¹ *Non-destructive testing of steel tubes - Part 1: Automated electromagnetic testing of seamless and welded (except submerged arc-welded) steel tubes for the verification of hydraulic leaktightness (ISO 10893-1:2011)*

EN ISO 10893-8:2011,² *Non-destructive testing of steel tubes - Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections (ISO 10893-8:2011)*

EN ISO 10893-10:2011,³ *Non-destructive testing of steel tubes - Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections (ISO 10893-10:2011)*

EN ISO 14284:2002, *Steel and iron - Sampling and preparation of samples for the determination of chemical composition (ISO 14284:1996)*

ISO 11484:2019, *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*

¹ As impacted by EN ISO 10893-1:2011/A1:2020.

² As impacted by EN ISO 10893-8:2011/A1:2020.

³ As impacted by EN ISO 10893-10:2011/A1:2020.

EN 10216-5:2021 (E)**3 Terms and definitions**

For the purposes of this document, the terms and definitions given in EN 10020:2000, EN 10021:2006, EN ISO 4885:2018 and EN 10266:2003 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

3.1**test category**

classification that indicates the extent and level of inspection and testing

3.2**employer**

organization for which a person works on a regular basis

Note 1 to entry: The employer may be either the tube manufacturer or supplier or a third party organization providing non-destructive testing (NDT) services.

4 Symbols

For the purposes of this document, the symbols given in EN 10266:2003 and the following apply:

- TC test category

NOTE See also Table 1 for symbols of the delivery condition.

5 Classification and designation**5.1 Classification**

According to the classification system in EN 10020:2000, the steel grades are classified as:

- austenitic steels (corrosion resisting or creep resisting steels);
- austenitic-ferritic steels.

For more details, see EN 10088-1.

5.2 Designation

For the tubes covered by this document, the steel designation consists of:

- number of this part of EN 10216 (EN 10216-5);

plus either

- steel name in accordance with EN 10027-1:2016;

or

- steel number allocated in accordance with EN 10027-2:2015.

6 Information to be supplied by the purchaser

6.1 Mandatory information

The following information shall be supplied by the purchaser at the time of enquiry and order:

- a) quantity (mass or total length or number);
- b) term "tube";
- c) dimensions (outside diameter D and wall thickness T) (see 8.8.1);
- d) designation of the steel grade according to this part of EN 10216 (see 5.2);
- e) test category (see 9.3).

6.2 Options

A number of options are specified in this part of EN 10216 and these are listed below. In the event that the purchaser does not indicate a wish to implement any of these options at the time of enquiry and order, the tube shall be supplied in accordance with the basic specification (see 6.1).

- 1) information about steelmaking process (see 7.1);
- 2) delivery condition (see 7.2.4);
- 3) specified range for sulphur content (see Table 2, footnote b);
- 4) product analysis (see 8.2.2);
- 5) additional verifications of mechanical properties on samples which have undergone a different or additional heat treatment (see 8.3.1);
- 6) verification of impact energy at room temperature (see 8.3.1);
- 7) agreed mechanical properties at room temperature for austenitic corrosion resisting steel tubes with wall thicknesses greater than 60 mm (see Table 6, footnote a);
- 8) agreed mechanical properties at room temperature for austenitic creep resisting steel tubes with wall thicknesses greater than 50 mm (see Table 7, footnote a);
- 9) verification of proof strength $R_{p0,2}$ or $R_{p1,0}$ at elevated temperatures (see 8.3.2.1);
- 10) agreed proof strength values at elevated temperatures for austenitic corrosion resisting steel tubes with wall thicknesses greater than 60 mm (see Table 9, footnote a);
- 11) verification of impact energy at low temperature (see 8.3.3);
- 12) intergranular corrosion test (see 8.4);
- 13) selection of method for verification of leak-tightness test method (see 8.5.2.1);
- 14) Non-Destructive Testing for test category 2 tubes with specified outside diameter less than or equal to 101,6 mm and specified wall thickness less than or equal to 5,6 mm for detection of longitudinal imperfections (see 8.5.2.2);

EN 10216-5:2021 (E)

- 15) Non-Destructive Testing for test category 2 tubes for detection of transverse imperfections (see 8.5.2.2);
- 16) Non-Destructive Testing for test category 2 tubes with specified wall thickness greater than 40 mm for detection of laminar imperfections at tube ends (see 8.5.2.2);
- 17) special ends preparation (see 8.7);
- 18) exact lengths (see 8.8.3);
- 19) sized tube ends for tube of $D > 219,1$ mm (see Table 12);
- 20) tolerance classes D 4 and T 4 for tubes ordered cold finished (see Table 13);
- 21) inspection certificate 3.2 other than the standard document (see 9.2.1);
- 22) test pressure for hydrostatic leak-tightness test (see 11.6.1);
- 23) wall thickness measurement away from the ends (see 11.7);
- 24) additional marking (see 12.2);
- 25) special protection (see Clause 13).

6.3 Examples of an order

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6.3.1 Example 1

2 000 m of hot finished descaled seamless tube with an outside diameter of 168,3 mm, a wall thickness of 4,5 mm, in accordance with this part of EN 10216, tolerance classes D 2 and T 2, made of steel grade X2CrNi19-11, to test category 1, with a 3.1 inspection certificate in accordance with EN 10204:

EXAMPLE 2 000 m - HFD Tube - 168,3 X 4,5 - EN 10216-5 - X2CrNi19-11 - TC 1

6.3.2 Example 2

300 m of cold finished descaled seamless tube with an outside diameter of 42,4 mm, a wall thickness of 2,6 mm, in accordance with this part of EN 10216, tolerance classes D 3 and T 3, made of steel grade 1.4301, to test category 2, with intergranular corrosion test (EN ISO 3651-2:1998, method A), verification of proof strength at 300° C, non-destructive testing for detection of longitudinal and transverse imperfections, with a 3.2 inspection certificate in accordance with EN 10204:

EXAMPLE 300 m - CFD Tube - 42,4 X 2,6 - EN 10216-5 - 1.4301 - TC 2 - Option 9: 300° C - Option 12: A - Option 14 - Option 15 - Option 21: 3.2

7 Manufacturing process**7.1 Steelmaking process**

The steelmaking process is at the discretion of the manufacturer, but see option 1.

Option 1: *The purchaser shall be informed about the steelmaking process used. The process shall be reported in the inspection document.*

7.2 Tube manufacture and delivery conditions

7.2.1 All NDT activities shall be carried out by qualified and competent level 1, 2 and/or 3 personnel authorized to operate by the employer.

The qualification shall be in accordance with ISO 11484:2019 (See note 2).

It is recommended that the level 3 personnel be certified in accordance to EN ISO 9712 (See note 2).

The operating authorization issued by the employer shall be in accordance with a written procedure.

NDT operations shall be authorized by a level 3 NDT individual approved by the employer.

NOTE 1 The definition of level 1, 2 and 3 can be found in appropriate standards, e.g. EN ISO 9712 and ISO 11484.

NOTE 2 Other equivalent standard can be used.

7.2.2 The tubes shall be manufactured by a seamless process, and may be hot finished or cold finished. The terms “ hot finished “ and “ cold finished “ apply to the condition of the tube before it is heat treated in accordance with 7.2.3.

The process of manufacture is left to the discretion of the manufacturer, but see option 2.

7.2.3 The tubes shall be supplied in the solution annealed condition over their full length in either:

— reference heat treatment conditions,

or

— solution annealed conditions obtained directly by extrusion and subsequent cooling provided the mechanical properties, corrosion resistance and other properties are in accordance with this part of EN 10216. All specified mechanical properties shall be met even after a subsequent reference heat treatment (solution annealing).

Solution treatment shall consist of heating the tubes uniformly to a temperature within the range given for the steel grade concerned in Tables 6, 7 and 8 and cooling rapidly.

7.2.4 The types of delivery condition of the tubes are given in Table 1.

Unless option 2 is specified, the type of delivery condition is at the discretion of the manufacturer.

Option 2: *The delivery condition is specified by the purchaser.*