



SLOVENSKI STANDARD

SIST EN 13480-4:2018

01-januar-2018

Nadomešča:

SIST EN 13480-4:2012

SIST EN 13480-4:2012/A1:2013

SIST EN 13480-4:2012/A2:2016

SIST EN 13480-4:2012/A3:2017

SIST EN 13480-4:2012/A4:2017

SIST EN 13480-4:2012/A5:2018

Kovinski industrijski cevovodi - 4. del: Proizvodnja in vgradnja

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 13480-4:2017

ICS:

23.040.10	Železne in jeklene cevi	Iron and steel pipes
77.140.75	Jeklene cevi in cevni profili za posebne namene	Steel pipes and tubes for specific use

SIST EN 13480-4:2018

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 13480-4

June 2017

ICS 23.040.01

Supersedes EN 13480-4:2012

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 European Standard was approved by CEN on 21 June 2017.

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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EUROPÄISCHES KOMITEE FÜR NORMUNG

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

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European foreword

This document (EN 13480-4:2017) has been prepared by Technical Committee CEN/TC 267 “Industrial piping and pipelines”, 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of an identical text or by endorsement, at the latest by December 2017, and conflicting national standards shall be withdrawn at the latest by December 2017.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 European Standard EN 13480 for metallic industrial piping consists of eight interdependent and not dissociable Parts which are:

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- *Part 1: General;*
 - *Part 2: Materials;* <https://standards.iteh.ai/catalog/standards/sist/20650b99-9f14-4de1-9391-ee744e2d8777/sist-en-13480-4-2018>
 - *Part 3: Design and calculation;*
 - *Part 4: Fabrication and installation;*
 - *Part 5: Inspection and testing;*
 - *Part 6: Additional requirements for buried piping;*
 - *CEN/TR 13480-7, Guidance on the use of conformity assessment procedures;*
 - *Part 8: Additional requirements for aluminium and aluminium alloy piping.*

Although these Parts may be obtained separately, it should be recognised that the Parts are interdependent. As such the manufacture of metallic industrial piping requires the application of all the relevant Parts in order for the requirements of the Standard to be satisfactorily fulfilled.

This European Standard will be maintained by a Maintenance MHD working group whose scope of working is limited to corrections and interpretations related to EN 13480.

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The contact to submit queries can be found at <http://www.unm.fr> (en13480@unm.fr). A form for submitting questions can be downloaded from the link to the MHD website. After subject experts have agreed an answer, the answer will be communicated to the questioner. Corrected pages will be given specific issue number and issued by CEN according to CEN Rules. Interpretation sheets will be posted on the website of the MHD.

This document supersedes EN 13480-4:2012. This new edition incorporates the Amendments which have been approved previously by CEN members, and the corrected pages up to Issue 4 without any further technical change. Annex Y provides details of significant technical changes between this European Standard and the previous edition.

Amendments to this new edition may be issued from time to time and then used immediately as alternatives to rules contained herein.

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.

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1 Scope

This Part of this European Standard specifies the requirements for fabrication and installation of piping systems, including supports, designed in accordance with EN 13480-3:2017.

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 10204:2004, *Metallic products — Types of inspection documents*

EN 12952-5:2011, *Water-tube boilers and auxiliary installations — Part 5: Workmanship and construction of pressure parts of the boiler*

EN 13480-1:2017, *Metallic industrial piping — Part 1: General*

EN 13480-2:2017, *Metallic industrial piping — Part 2: Materials*

EN 13480-3:2017, *Metallic industrial piping — Part 3: Design and calculation*

EN 13480-5:2017, *Metallic industrial piping — Part 5: Inspection and testing*

EN ISO 3834-3:2005, *Quality requirements for fusion welding of metallic materials — Part 3: Standard quality requirements (ISO 3834-3:2005)*

EN ISO 4063:2010, *Welding and allied processes — Nomenclature of processes and reference numbers (ISO 4063:2009, Corrected version 2010-03-01)*

EN ISO 5817:2007, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections (ISO 5817:2003, corrected version:2005, including Technical Corrigendum 1:2006)*

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

EN ISO 13920, *Welding — General tolerances for welded constructions — Dimensions for lengths and angles — Shape and position (ISO 13920)*

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)*

EN ISO 15609 (all parts), *Specification and qualification of welding procedures for metallic materials — Welding procedure specification*

EN ISO 15610:2003, *Specification and qualification of welding procedures for metallic materials — Qualification based on tested welding consumables (ISO 15610:2003)*

EN ISO 15611:2003, *Specification and qualification of welding procedures for metallic materials — Qualification based on previous welding experience (ISO 15611:2003)*

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EN ISO 15612:2004, *Specification and qualification of welding procedures for metallic materials — Qualification by adoption of a standard welding procedure (ISO 15612:2004)*

EN ISO 15613:2004, *Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test (ISO 15613:2004)*

EN ISO 15614-1:2004, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys (ISO 15614-1:2004)*

EN ISO 17663:2009, *Welding — Quality requirements for heat treatment in connection with welding and allied processes (ISO 17663:2009)*

CEN ISO/TR 15608, *Welding — Guidelines for a metallic materials grouping system (ISO/TR 15608)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 13480-1:2017 together with the following apply.

3.1 field run piping

piping installed without preplanning by drawings of the piping routing and the support points

Note 1 to entry: Typical dimensions are DN 50 or smaller.

3.2 spool (with or without overlength)

prefabricated assembly of components which forms part of a piping system

3.3 cold forming

forming at ambient temperature, but not below + 5 °C

3.4 hot forming

for ferritic steels, forming at temperatures at or above the maximum permissible temperature for post-weld heat treatment; for austenitic and austenitic-ferritic steels at temperatures above 300 °C

4 Symbols

For the purposes of this Part of this European Standard, the symbols given in EN 13480-1:2017 apply. Additional symbols are defined in appropriate clauses of this Part.

5 General

5.1 Requirements on the manufacturer

The manufacturer shall be responsible for the fabrication and the installation, even if this work will be sub-contracted to other fabricators and/or installers.

5.2 Requirements on fabricators and installers of piping and supports

5.2.1 The fabricators and/or installers shall ensure the correct transport, handling, storage, fabrication, installation and testing of all piping components including supports.

5.2.2 The fabricators and installers shall have access to facilities which enable them to handle the piping components including supports correctly and to carry out the required tests.

5.2.3 The fabricators and/or installers shall employ their own responsible supervisors and competent personnel. If sub-contractors are employed, the fabricator and/or installer remain responsible for their competence and the compliance with this European Standard.

NOTE The task and responsibilities of a welding co-ordinator are described in EN ISO 14731.

5.2.4 All stages of fabrication and installation shall be supervised in such a way as to maintain the design integrity of the finished system.

5.2.5 Co-ordination between those responsible for design and those responsible for fabrication and/or installation and testing shall be maintained at all times, to ensure that fabrication, installation and testing is carried out in accordance with the design specification.

5.2.6 The fabricator and/or installer of the piping shall fulfil the requirements of EN ISO 3834-3.

5.3 Requirements for fabrication and installation

5.3.1 Prior to any operation, a check shall be made to ensure that the spools and components supplied are in accordance with the relevant documents (specifications, drawings, certificates etc.).

5.3.2 Prefabricated spools and components shall be protected during handling, transport, and storage.

5.3.3 When joining spools or components, they shall not be strained nor deformed other than as may be required by the design. Designer's installation instructions, if any, shall be observed.

NOTE 5.3.3 is deemed to be fulfilled, when the quality characteristics of the material are not impaired by cold or hot forming, e.g. by cutting, grinding, straightening or bending, of the components and when the different components have been joined such that stresses and deformations which can impair the safety of the piping are excluded.

5.3.4 Any temporary supports or restraints used as an aid during transport, installation or testing shall be removed prior to commissioning.

5.3.5 Appropriate measures shall be taken to avoid corrosion-inducing contamination of stainless steel and non-ferrous materials. If contamination occurs, it shall be properly removed as soon as practicable, notwithstanding any final treatment.

NOTE Recommended methods for the prevention and removal of contamination on stainless steel are given in Annex A.

5.3.6 Piping for fluids which are likely to cause condensation shall be installed with adequate slopes and traps.

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5.4 Classification of piping

The piping systems shall be classified into different categories depending on the fluid carried, diameter and pressure. These are given in EN 13480-1.

5.5 Material grouping

Material grouping is given in EN 13480-2.

5.6 Tolerances

Tolerances shall comply with EN ISO 13920, class C and class G, except where other classes are specified in this European Standard or by design.

Angular tolerances for fabricated pipework shall be determined by the dimensional tolerance for the terminal points of the finished part.

Alternative tolerances for fabrication and installation of pipework shall be determined and in all cases these shall be identified in the specification. Dimensional tolerances for fabricated spools shall comply with Annex B.

6 Cutting and bevelling

6.1 General

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Cutting and bevelling by machining shall be permitted for all materials.

Flame cutting shall be permitted for material groups 1, 2, 3, 4 and 5 only with preheating as specified for welding.

NOTE Flame cutting for material groups 1 and 2 can be used for bevelling, if the required bevel forms and tolerances can be achieved and the heat affected zone has no detrimental effects on the quality of the weld.

For material groups 3, 4 and 5, the heat affected zone shall be removed by machining or grinding.

Plasma cutting shall be permitted for all material groups given in this European Standard. Plasma cutting shall be preceded by preheating, as specified for welding.

Other cutting and bevelling processes are permitted, provided their suitability is demonstrated.

6.2 Identification of pressure parts

For pressure parts, identification of materials shall remain possible, either by retaining or by transferring the mark stipulated by the product standard, or by using a unique code kept in the records of the piping fabricator.

Stamping shall not introduce a notching effect, therefore low-stress stamping is recommended.

If any method of marking other than hard-stamping, edging or engraving (vibrograph) is used, the fabricator shall ensure that confusion between different materials is not possible.

7 Bending and other forming

7.1 General

7.1.1 Fabricators of formed pressure parts shall have adequate procedures, equipment and tools for the forming and the subsequent heat treatment.

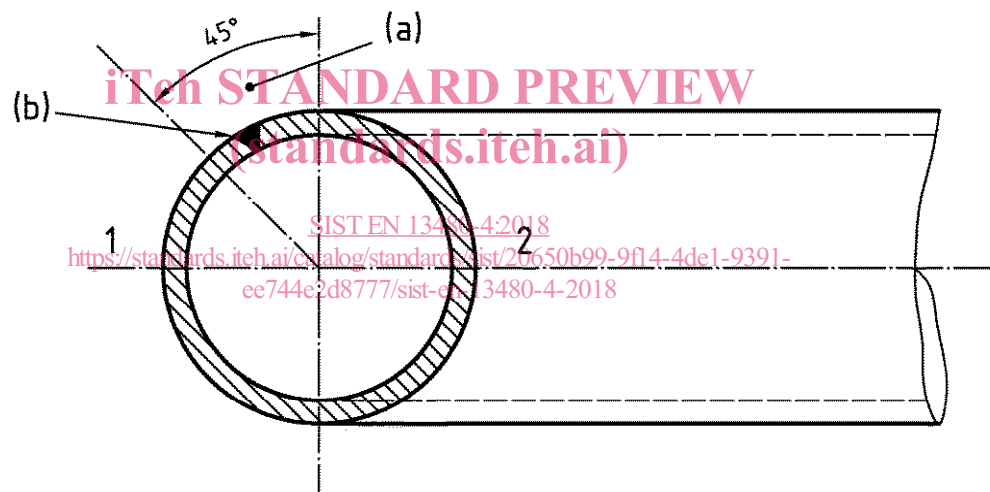
The procedure for bending shall be qualified according to EN 12952-5:2011, Annex A, with regard to examination and range of qualification.

Pipes with internal coating such as glass, rubber or plastics shall not be formed unless it has been demonstrated that the forming process is not detrimental to the lining.

NOTE There are two kinds of forming within the scope of this European Standard: cold forming and hot forming.

The thickness after bending or forming shall be not less than that required by the design.

Longitudinal welds should be located at the neutral zone. The range of the neutral zone after bending is given in Figure 7.1.1-1.



Key

1 extrados

2 intrados

(a) optimal range for the longitudinal weld at bending

(b) weld

Figure 7.1.1-1 — Optimal range for the longitudinal weld at bending

7.1.2 The forming and post-forming heat treatment of thermomechanical steels shall be given individual consideration. Account shall be taken of the recommendations of the steelmakers.

Pipes whose properties have been generated by thermomechanical means such as controlled rolling can be formed by cold methods. Such materials may be substantially changed by the forming process and require particular consideration to ensure that the specified properties are recovered after forming.

7.1.3 The following formulae shall be used for the calculation of the percentage deformation for cold formed cylinders and cone products made by rolling (see Figure 7.1.3-1):

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a) For cylinders and cones rolled from flat materials (see Figures 7.1.3-1a) and 7.1.3-1c)):

$$V_d = \frac{50 e_{\text{ord}}}{r_{\text{mf}}} \quad (7.1.3-1)$$

b) For cylinders and cones rolled from intermediate product (see Figures 7.1.3-1b) and 7.1.3-1c)):

$$V_d = \frac{50 e_{\text{int}}}{r_{\text{mf}}} \left(1 - \frac{r_{\text{mf}}}{r_{\text{mi}}} \right) \quad (7.1.3-2)$$

where

- e_{ord} is the ordered thickness;
- e_{int} is the thickness of the intermediate product;
- r_{mf} is the average radius of the finished product;
- r_{mi} is the average radius of the intermediate product;
- V_d is the deformation as a percentage.

NOTE If no intermediate quality heat treatment is applied between individual forming steps, the deformation is the total amount of deformation of the individual steps. If intermediate quality heat treatment is applied between the forming steps, the deformation is that deformation applied after the last treatment.

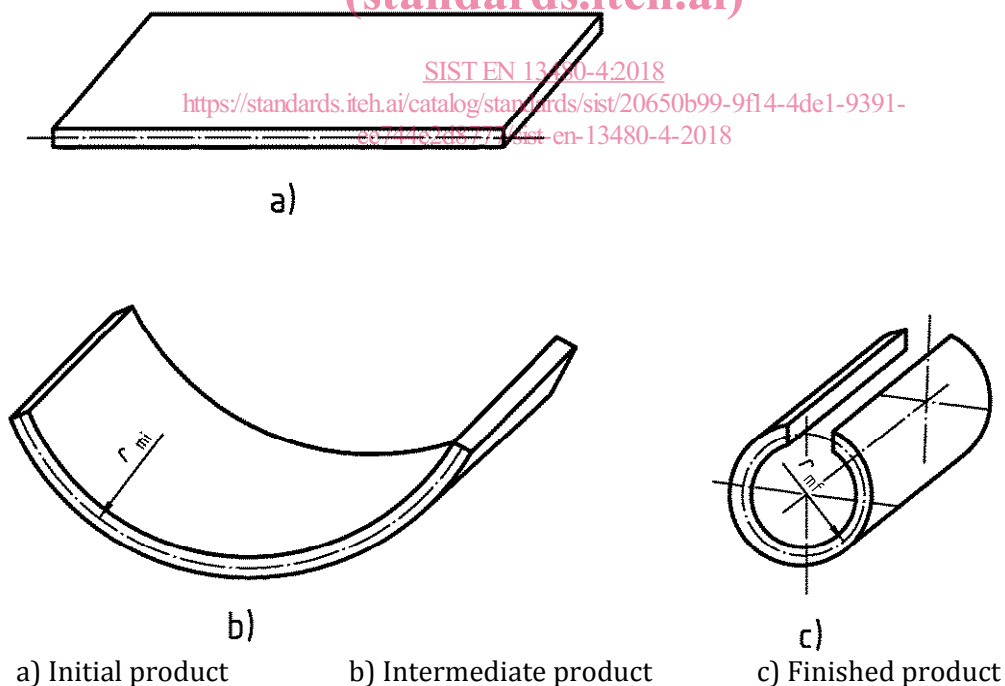


Figure 7.1.3-1 — Forming of cylinders and cones

7.1.4 Tools and equipment used for forming shall be maintained to ensure a smooth profile free from stress-raising defects, e.g. scores.

7.1.5 Heat treatment after forming shall be in accordance with the respective material standard.

7.1.6 Welding on to formed areas shall not be performed until heat treatment is complete.

7.2 Heat treatment after cold forming

7.2.1 Flat products

Flat products shall be heat treated after cold forming as required in Table 7.2.1-1.

For special design reasons, for example cyclic loading or stress corrosion cracking, heat treatment in excess of that in Table 7.2.1-1 may be specified after cold forming.

No heat treatment for austenitic steels is required:

- a) For austenitic steels having a documented minimum value of elongation after fracture (rupture) A_5 equal to or greater than 30 %, a maximum level of 15 % cold deformation shall be acceptable.

A greater deformation may be accepted if the evidence is supplied that there is a minimum elongation after fracture (rupture) of 15 % after cold forming.

Such evidence shall be deemed supplied, if the acceptance certificate shows that elongation after fracture (rupture) A_5 is not less than 30 %. This shall be applicable only in cases where there is no risk of stress corrosion cracking;

- b) For austenitic steels having a required minimum value of elongation after fracture (rupture) A_5 less than 30 %, evidence shall be supplied that there is a minimum elongation of 15 % after cold forming; <https://standards.iteh.ai/catalog/standards/sist/20650b99-9f14-4de1-9391-ee744e2d8777/sist-en-13480-4-2018>
- c) Deformation shall not exceed 10 % if the working temperature is below -196 °C.

Table 7.2.1-1 — Heat treatment after cold forming of flat products

Material groups according to CEN ISO/TR 15608	Deformation	Heat treatment
1.1, 1.2, 1.3, 2.1, 2.2 ^a , 3, 4 ^b , 5.1, 5.2 ^b , 5.3 ^b , 5.4 ^b , 6 ^b , 7.1, 7.2, 7.3, 9.1, 9.2, 10	≤ 5 %	no
	> 5 %	yes
8.1, 8.2	c	d
<p>a If not heat treated, qualification tests are required to demonstrate that the material properties are not impaired.</p> <p>b Heat treatment required in accordance with the material standards where the minimum metal temperature is below - 10 °C.</p> <p>c See 7.2.1 a), b) and c).</p> <p>d Solution annealed and quenched or stabilised materials do not require heat treatment after cold forming.</p>		

7.2.2 Pipes

Pipes shall be heat treated after cold forming in accordance with Table 7.2.2-1.