



# SLOVENSKI STANDARD

## SIST EN 1092-2:2024

01-februar-2024

Nadomešča:  
SIST EN 1092-2:1998

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**Prirobnice in prirobnični spoji - Okrogle prirobnice za cevi, ventile, fitinge in pribor z oznako PN - 2. del: Prirobnice iz litega železa**

Flanges and their joints - Circular flanges for pipes, valves, fittings and accessories, PN designated - Part 2: Cast iron flanges

Flansche und ihre Verbindungen - Runde Flansche für Röhre, Armaturen, Formstücke und Zubehörteile, nach PN bezeichnet - Teil 2: Gußeisenflansche

Brides et leurs assemblages - Brides circulaires pour tuyaux, appareils de robinetterie, raccords et accessoires, désignées PN - Partie 2 : Brides en fonte

**Ta slovenski standard je istoveten z: EN 1092-2:2023**

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**ICS:**

23.040.60 Prirobnice, oglavki in spojni elementi Flanges, couplings and joints

**SIST EN 1092-2:2024**

**en,fr,de**



EUROPEAN STANDARD  
NORME EUROPÉENNE  
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English Version

**Flanges and their joints - Circular flanges for pipes, valves,  
fittings and accessories, PN designated - Part 2: Cast iron  
flanges**

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This European Standard was approved by CEN on 22 October 2023.

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

**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

<b>Contents</b>	<b>Page</b>
<b>European foreword</b> .....	<b>3</b>
<b>Introduction</b> .....	<b>4</b>
<b>1 Scope</b> .....	<b>5</b>
<b>2 Normative references</b> .....	<b>5</b>
<b>3 Terms and definitions</b> .....	<b>5</b>
<b>4 Designation and types</b> .....	<b>7</b>
<b>4.1 Range of DN</b> .....	<b>7</b>
<b>4.2 Range of PN designations</b> .....	<b>7</b>
<b>4.3 Types of flanges</b> .....	<b>7</b>
<b>4.4 Standard designation</b> .....	<b>7</b>
<b>4.5 Information to be supplied by the purchaser</b> .....	<b>8</b>
<b>5 General requirements</b> .....	<b>8</b>
<b>5.1 Flange materials</b> .....	<b>8</b>
<b>5.2 Repairs by welding</b> .....	<b>8</b>
<b>5.3 Bolting</b> .....	<b>8</b>
<b>5.4 Gaskets</b> .....	<b>8</b>
<b>5.5 Pressure/Temperature ratings (p/T)</b> .....	<b>8</b>
<b>5.5.1 General</b> .....	<b>8</b>
<b>5.5.2 p/T rating of flanged joints</b> .....	<b>9</b>
<b>5.6 Dimensions</b> .....	<b>9</b>
<b>5.7 Flange facings</b> .....	<b>9</b>
<b>5.7.1 Types of facings</b> .....	<b>9</b>
<b>5.7.2 Jointing face finish</b> .....	<b>10</b>
<b>5.8 Spot facing or back facing</b> .....	<b>10</b>
<b>5.9 Tolerances</b> .....	<b>10</b>
<b>5.10 Marking and stamping</b> .....	<b>11</b>
<b>5.10.1 Marking</b> .....	<b>11</b>
<b>5.10.2 Stamping</b> .....	<b>11</b>
<b>5.10.3 Omission of markings</b> .....	<b>11</b>
<b>5.11 Quality assurance</b> .....	<b>11</b>
<b>5.11.1 General</b> .....	<b>11</b>
<b>5.11.2 Quality assurance system</b> .....	<b>11</b>
<b>Annex A (normative) Information to be supplied by the purchaser</b> .....	<b>59</b>
<b>Annex B (Informative) NOTES to Tables 6 to 13</b> .....	<b>60</b>
<b>Bibliography</b> .....	<b>61</b>

## European foreword

This document (EN 1092-2:2023) has been prepared by Technical Committee CEN/TC 74 “Flanges and their joints”, the secretariat of which is held by DIN.

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 May 2024, and conflicting national standards shall be withdrawn at the latest by May 2024.

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 1092-2:1997.

In comparison with the previous edition, the following technical modifications have been made:

- update of normative references;
- introduction of new DN and PN;
- specification regarding repairs and face finish.

EN 1092 will consist of the following four parts:

- Part 1: Steel flanges;
- Part 2: Cast iron flanges;
- Part 3: Copper alloy flanges;
- Part 4: Aluminium alloy flanges.

This document is related to ISO 7005-2:1988 and ISO 2531:2009, as types of flanges and their mating dimensions are compatible with those flanges of the same DN and PN. <https://standards.iteh.ai/> <https://standards.iteh.ai/standards/2024/04/01/202404013798/sist-en-1092-2-2024>

The mating dimensions of the flanges of this document are compatible with those flanges of other materials in accordance with the other parts of EN 1092 series.

Any feedback and questions on this document should be directed to the users' national standards body. A complete listing of these bodies can be found on the CEN website.

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, Türkiye and the United Kingdom.

**EN 1092-2:2023 (E)****Introduction**

Materials that are in permanent or temporary contact with drinking water are not detrimental to the quality of the drinking water and do not violate EC Directives or EFTA regulations concerning the quality of drinking water.

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## 1 Scope

This document specifies requirements for circular flanges made from ductile, grey and malleable cast iron for DN 10 to DN 4000 and PN 2,5 to PN 100.

NOTE See 4.1 and 4.2 for information regarding allowed DN and PN.

This document specifies the types of flanges and their facings, dimension and tolerances, bolt sizes, surface finish of jointing faces, marking, testing, quality assurance and materials together with associated pressure/temperature (p/T) ratings.

## 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 545:2010, *Ductile iron pipes, fittings, accessories and their joints for water pipelines - Requirements and test methods*

EN 1092-1:2018, *Flanges and their joints - Circular flanges for pipes, valves, fittings and accessories, PN designated - Part 1: Steel flanges*

EN 1370:2012, *Founding — Examination of surface condition*

EN 1561:2011, *Founding - Grey cast irons*

EN 1563:2018, *Founding - Spheroidal graphite cast irons*

EN ISO 4287:2005, *Geometrical product specifications (GPS) — Surface texture: Profile method — Terms, definitions and surface texture parameters (ISO 4287)*

ISO 185:2005, *Grey cast irons — Classification*

ISO 887:2000, *Plain washers for metric bolts, screws and nuts for general purposes — General plan*

ISO 1083:2018, *Spheroidal graphite cast irons — Classification* <https://www.iso.org/obp/ui/#iso:code:38100:1083>

ISO 5922:2005, *Malleable cast iron*

## 3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

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

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

### 3.1

#### **flange**

flat circular end of a pipe component extending perpendicular to its axis, with bolt holes equally spaced on a circle

NOTE 1 to entry: See Figure 1.

NOTE 2 to entry: A flange can be fixed (i.e. integrally cast, screwed or welded on) or adjustable; an adjustable flange comprises a ring, in one or several parts assembled together, which bears on an end joint hub and can be freely rotated around the pipe axis before jointing.

**EN 1092-2:2023 (E)****3.2****DN (Nominal size)**

alphanumeric designation of size for components of a pipework system, which is used for reference purposes and which comprises the letters DN followed by a dimensionless whole number that is indirectly related to the physical size, in millimetres, of the bore or outside diameter of the end connections

NOTE 1 to entry: The number following the letters DN does not represent a measurable value and should not be used for calculation purposes except where specified in the relevant standard.

NOTE 2 to entry: In those standards which use the DN designation system, any relationship between DN and component dimensions should be given, e.g. DN/OD or DN/ID.

[SOURCE: EN ISO 6708:1995, 2.1]

**3.3****PN**

alphanumeric designation which is used for reference purposes related to a combination of mechanical and dimensional characteristics of a component of a pipework system and which comprises the letters PN followed by a dimensionless number

NOTE 1 to entry: The number following the letters PN does not represent a measurable value and should not be used for calculation purposes except where specified in the relevant standard.

NOTE 2 to entry: The designation PN is not meaningful unless it is related to the relevant component standard number.

NOTE 3 to entry: The maximum allowable pressure of a pipework component depends on the PN number, the material and the design of the component, its maximum allowable temperature, etc. The relevant component standards include tables of specified pressure/temperature ratings (p/T) or, in minimum, include rules how to determine pressure/temperature ratings (p/T).

NOTE 4 to entry: It is intended that all components with the same PN and DN designations have the same mating dimensions for compatible flange types.

[SOURCE: EN 1333:2006, 2.1]

**3.4****ductile iron**

cast iron in which graphite is present substantially in spheroidal form

**3.5****grey iron**

cast iron in which graphite is present substantially in lamellar form

**3.6****malleable iron**

cast iron in which graphite is present substantially in nodular form (temper carbon), and can be partially or wholly decarburized

**3.7****joint**

connection between the flanged ends of piping systems components in which a gasket is used to effect a seal



## 4 Designation and types

### 4.1 Range of DN

DN 10 – DN 15 – DN 20 – DN 25 – DN 32 – DN 40 – DN 50 – DN 60 – DN 65 – DN 80 – DN 100 – DN 125 – DN 150 – DN 200 – DN 250 – DN 300 – DN 350 – DN 400 – DN 450 – DN 500 – DN 600 – DN 700 – DN 800 – DN 900 – DN 1000 – DN 1100 – DN 1200 – DN 1400 – DN 1500 – DN 1600 – DN 1800 – DN 2000 – DN 2200 – DN 2400 – DN 2500 – DN 2600 – DN 2800 – DN 3000 – DN 3200 – DN 3400 – DN 3600 – DN 3800 – DN 4000.

The range of DN applicable to each flange type and to each PN shall be as specified in Tables 2 to 4 as appropriate.

### 4.2 Range of PN designations

PN 2,5 – PN 6 – PN 10 – PN 16 – PN 25 – PN 40 – PN 63 – PN 100.

### 4.3 Types of flanges

Figure 1 illustrates flanges identified according to type:

- a) 05: blank flange
- b) 11: weld-neck flange
- c) 12: hubbed slip-on flange for welding
- d) 13: hubbed threaded flange
- e) 14: hubbed socket welding flange
- f) 16: adjustable flange
- g) 21: integral flange

By agreement between customer and manufacturer, an integral flange, modified as follows, can be supplied:

- i) bolt hole diameters and flange facing diameter in accordance with EN 1092-1:2018;
- ii) for ductile iron, flange thickness to be as grey iron flanges.

Such flanges is designated as type 21-2.

Figure 2 illustrates facing types A and B, which are used where applicable in conjunction with flanges shown in Figure 1 (see 5.7.1).

### 4.4 Standard designation

Flanges conforming to this document shall be designated as follows:

- a) term: flange;
- b) number of this document: EN 1092-2;
- c) DN (see 4.1);
- d) PN (see 4.2);

**EN 1092-2:2023 (E)**

- e) number of flange type (see 4.3);
- f) material type and grade (see 5.1);
- g) flange facing type for malleable cast iron (see 5.7.1).

EXAMPLE Designation of a weld-neck flange DN100, PN 40, type 11, material designated type MI (malleable iron), with grade B30-06 and facing type A.

**Flange EN 1092-2/DN100/PN40/11/MI B30-06/A**

**4.5 Information to be supplied by the purchaser**

The information to be supplied by the purchaser shall be as given in Annex A.

**5 General requirements****5.1 Flange materials**

Flanges shall be manufactured from the materials specified in Table 15. Material shall be selected according to their field of application (environment, temperature, pressure and size).

**5.2 Repairs by welding**

When necessary, flanges can be repaired, in order to remove surface imperfections and localized and visible defects. Repairs should not be accepted when metallurgy concern occurs. Repairs are carried out according to the manufacturer's written procedure.

**5.3 Bolting**

The bolting shall be chosen by the user according to the pressure, temperature, flange material and gasket. For joints comprising at least one grey iron flange it is recommended that bolting having a yield strength not exceeding 240 N/mm<sup>2</sup> should be used.

**5.4 Gaskets**

The gaskets are not within the scope of this document. For information on types, dimensions and types of gaskets, see relevant EN 1514 series.

**5.5 Pressure/Temperature ratings (p/T)****5.5.1 General**

The pressure/temperature ratings (p/T) of the flanges manufactured from the materials specified in Table 15 correspond to the allowable non-surge pressure at the temperature given in Tables 16 and 17 (ductile iron), 18 (grey iron) and 19 (malleable iron). Linear interpolation is permitted for intermediate temperatures.

NOTE The p/T rating of a flange is not necessarily the p/T rating of the whole pipework system. Gasket materials can also impose limitation on the p/T rating of a flanged joint and the gasket manufacturer is consulted when selecting the material of the gasket.

## 5.5.2 p/T rating of flanged joints

Where two flanges in a flanged joint do not have the same p/T rating, the p/T rating of the joint at any temperature shall not exceed the lower of the two flanges p/T ratings at that temperature.

NOTE 1 Temperature is that of the contained fluid. Use of a temperature other than that of the contained fluid is the responsibility of the user, subject to the requirements of any applicable code or regulation.

NOTE 2 For application of the p/T ratings given in this document to flange joints, take into consideration the risk of leakage due to forces and moments developed in the connecting pipework.

NOTE 3 Owing to the nature of any thread sealing method used, additional limitations can be placed on a threaded flange.

NOTE 4 These NOTES on service considerations are not intended to be exhaustive.

## 5.6 Dimensions

Dimensions of flanges shall be in accordance with the following Tables and Figures as appropriate:

- flanges PN 2,5: Table 6 and Figure 3;
- flanges PN 6: Table 7 and Figure 4;
- flanges PN 10: Table 8 and Figure 5;
- flanges PN 16: Table 9 and Figure 6;
- flanges PN 25: Table 10 and Figure 7;
- flanges PN 40: Table 11 and Figure 8;
- flanges PN 63: Table 12 and Figure 9;
- flanges PN 100: Table 13 and Figure 10.

NOTE 1 Dimensions which are not given in this document are determined by the manufacturer for his flange design.

NOTE 2 Details of attachment for welded, threaded and adjustable flanges are not within the scope of this document.

## 5.7 Flange facings

### 5.7.1 Types of facings

The flange facings specified (flat face type A and raised face type B) are illustrated in Figure 2 and their raised face dimensions shall be as given in Table 5.

Flanges made of ductile iron shall have raised faces.

Flanges made of grey iron shall have raised faces. See 5.3 for the limitations on bolting due to this material.

Flanges made of malleable iron shall have either flat faces or raised faces.

NOTE The transition from the outside diameter of the raised face to the flange face is at the option of the manufacturer (i.e. either a radius or chamfer can be used).

**EN 1092-2:2023 (E)****5.7.2 Jointing face finish**

All flange jointing faces shall be finished in accordance with Table 1. These faces shall be compared by visual or tactile means with reference specimens which conform with the  $R_a$  and  $R_z$  roughness values given in Table 1.

Flange connections, for example in drinking water applications, can usually be equipped with coated flange surfaces for corrosion protection reasons. Table 1 does not include roughness relative to coated surfaces.

An appropriate combination of flanges with an adequate gasket to compensate for the settling of the coating shall be selected, e.g. rubber coated sealing ring with metal insert.

NOTE 1 It is not intended that instrument measurements are taken on the flange jointing faces:  $R_a$  and  $R_z$  values as defined in EN ISO 4287:2005 relate to the reference specimens.

NOTE 2 Other finishes can be agreed between the manufacturer and purchaser.

**Table 1 — Numerical values of the surface finish parameters ( $R_a$  and  $R_z$ ) of flange jointing faces**

Values in micrometers

Manufacturing process	$R_a$	$R_z$
Turning <sup>1</sup>	3,2 to 12,5	12,5 to 50
Other machining processes <sup>2</sup>	3,2 to 6,3	12,5 to 25
As cast <sup>3</sup>	3,2 to 25	-
<p><sup>1</sup>) "Turning" covers any method of machine operation producing either serrated concentric or serrated spiral grooves.</p> <p><sup>2</sup>) Machining processes other than turning are permissible provided that they give a surface finish in compliance with the <math>R_a</math> and <math>R_z</math> values specified.</p> <p><sup>3</sup>) "As cast" covers surfaces produced by moulding processes where the resultant casting can or cannot be subjected to shot or grit blast cleaning operations. Their roughness is assessed by comparison with reference specimens complying with EN 1370:2012. As cast surfaces can have serrated concentric grooves to enhance gasket sealing efficiency. They are normally used for application where joints incorporate gaskets of readily deformable material, e.g. rubber, application for which the above surface characteristics can also apply to the other manufacturing processes.</p>		

**5.8 Spot facing or back facing**

Any spot facing or back facing required shall not reduce the flange thickness to less than the thickness specified. When spot facing is used, the diameter shall be large enough to accommodate the outside diameter of the equivalent normal series of washers complying with ISO 887:2000, for the bolt size being fitted. When a flange is back faced, it is permissible for the fillet radius to be reduced but it shall not be eliminated entirely. The bearing surfaces for the bolting shall be parallel to the flange face within 2°.

**5.9 Tolerances**

The tolerances or dimensions are as specified in Table 14.

## 5.10 Marking and stamping

### 5.10.1 Marking

Blank flanges and flanges which are supplied not attached to pipeline components shall be marked as follows:

- a) DN (nominal size);
- b) PN designation;
- c) material identification;
- d) manufacturer's name or trade-mark

EXAMPLE      **DN300 PN16 420-5 XXX**

Where a flange is subsequently used to form an integral part of a component and the component has a lower pressure p/T rating than that of the flange, the lower p/T rating should be clearly marked on the component and the lower p/T rating applies.

### 5.10.2 Stamping

Where steel stamps are used, the marking shall be positioned on the outer rim of the flange. Low stress round nose stamps shall be used.

### 5.10.3 Omission of markings

If a flange is too small to enable all the markings required in 5.10.1 to be marked on the flange, then marking of nominal size can be omitted.

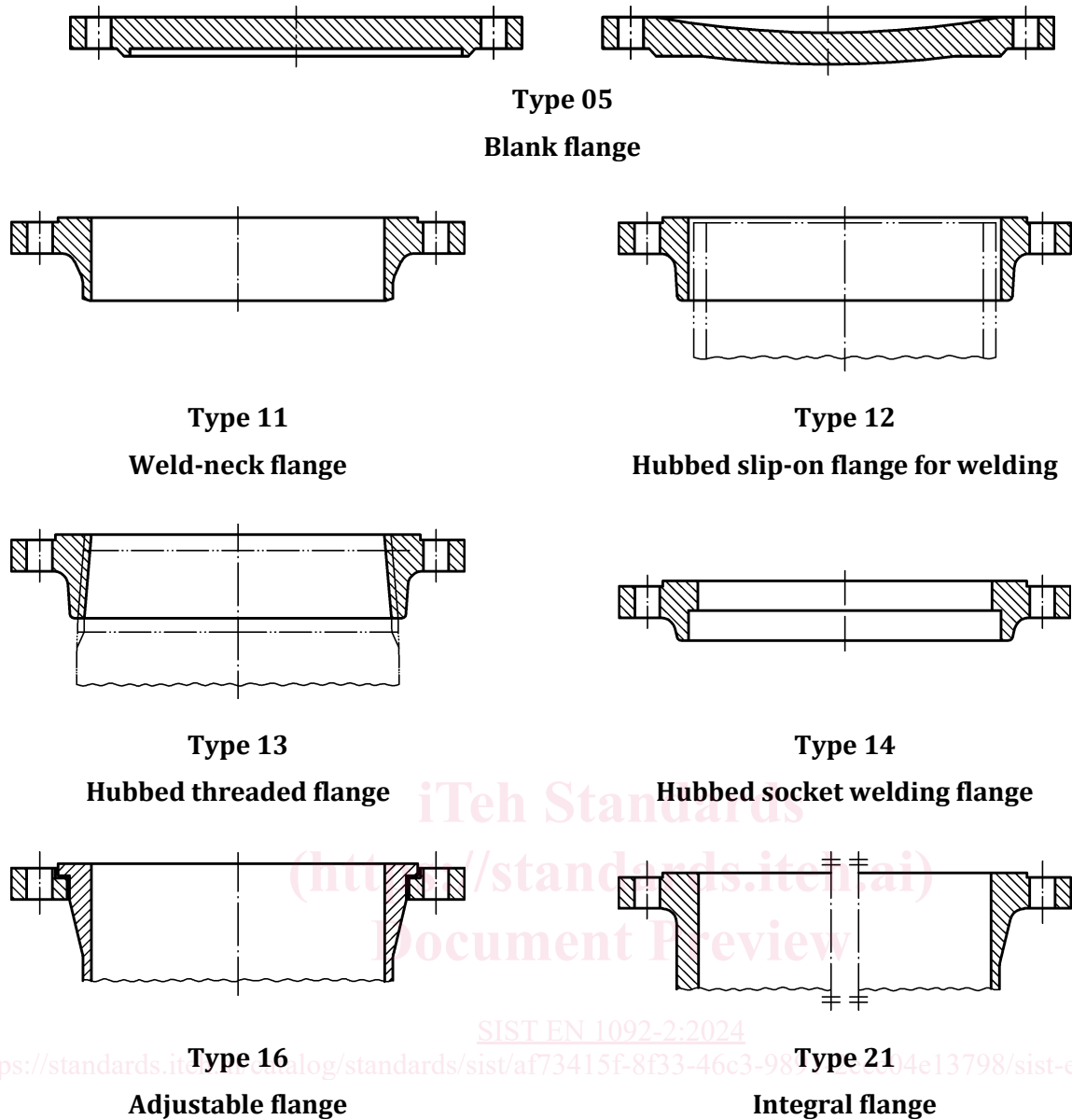
## 5.11 Quality assurance

### 5.11.1 General

The following quality assurance requirement applies to all types of flanges except for those delivered attached to a pipeline component. The quality assurance requirements for those flanges are given in the appropriate component standards.

### 5.11.2 Quality assurance system

The manufacturer shall operate a quality assurance system (see EN ISO 9001:2015 for further information).

**Figure 1 — Types of flanges**

NOTE 1 The transition from the edge of the raised face to the flange jointing face is either by radius or chamfer (see 5.7.1).

NOTE 2 Type 21 flange is an integral part of some other product or component.

NOTE 3 Flanges can be designated by type number or by description.