



**SLOVENSKI STANDARD**  
**oSIST prEN 13369:2022**  
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**Splošna pravila za montažne betonske izdelke**

Common rules for precast concrete products

Allgemeine Regeln für Betonfertigteile

Règles communes pour les produits préfabriqués en béton

Ta slovenski standard je istoveten z: **prEN 13369**

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Beton in betonski izdelki Concrete and concrete products

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## Common rules for precast concrete products

Règles communes pour les produits préfabriqués en  
béton

Allgemeine Regeln für Betonfertigteile

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 229.

If this draft becomes a European Standard, 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.

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## Contents

	Page
European foreword.....	6
Introduction .....	8
1 Scope.....	9
2 Normative references.....	9
3 Terms and definitions .....	10
3.1 General.....	10
4 Specifications.....	13
4.1 Material specifications.....	13
4.1.1 General.....	13
4.1.2 Constituent materials of concrete.....	13
4.1.3 Reinforcing steel.....	14
4.1.4 Prestressing steel.....	14
4.1.5 Inserts and connectors.....	14
4.2 Production specifications.....	14
4.2.1 Concrete production .....	14
4.2.2 Hardened concrete .....	17
4.2.3 Structural reinforcement .....	18
4.3 Finished product specifications.....	20
4.3.1 Geometrical properties.....	20
4.3.2 Surface characteristics.....	21
4.3.3 Mechanical resistance .....	21
4.3.4 Resistance and reaction to fire.....	22
4.3.5 Acoustic properties .....	23
4.3.6 Thermal properties.....	24
4.3.7 Durability .....	24
4.3.8 Other specifications .....	25
5 Test methods .....	26
5.1 Tests on concrete .....	26
5.1.1 Compressive strength.....	26
5.1.2 Water absorption .....	26
5.1.3 Dry density of concrete .....	27
5.2 Measuring of dimensions and surface characteristics .....	27
5.3 Weight of the products.....	27
6 Assessment and verification of constancy of performance .....	27
6.1 General.....	27
6.1.1 General.....	27
6.1.2 Demonstration of compliance .....	27
6.1.3 Assessment of constancy of performance .....	28
6.1.4 Product families.....	28
6.2 Assessment of the performance.....	28
6.2.1 General.....	28
6.2.2 Testing and compliance criteria .....	29
6.3 Factory production control .....	29
6.3.1 General.....	29
6.3.2 Organization .....	29

6.3.3	Control system .....	30
6.3.4	Document control .....	30
6.3.5	Process control .....	30
6.3.6	Inspection and testing.....	30
6.3.7	Non-compliant products .....	31
6.3.8	Compliance criteria.....	31
6.3.9	Indirect or alternative test method .....	32
6.3.10	Initial inspection of factory and of FPC.....	32
6.3.11	Continuous surveillance of FPC .....	33
6.3.12	Procedure for modifications.....	33
7	Marking .....	33
8	Technical documentation .....	34
Annex A (informative) Concrete cover as regard to corrosion .....		35
A.1	Minimum concrete cover for base conditions.....	35
A.2	Alternative conditions .....	36
Annex B (informative) Concrete strength quality control.....		38
B.1	Statistical representative values.....	38
B.2	Compliance criteria for potential strength .....	38
B.3	Direct structural strength.....	38
B.4	Indirect structural strength.....	38
B.5	Direct assessment of possibly non-conforming units .....	39
Annex C (informative) Reliability considerations .....		41
C.1	General .....	41
C.2	Reduction based on quality control and reduced tolerances .....	41
C.3	Reduction based on using reduced or measured geometrical parameters in design .....	41
C.4	Reduction based on assessment of concrete strength in finished structure .....	42
C.5	Reduction of $\gamma_G$ based on control of self-weight.....	42
Annex D (normative) Inspection schemes.....		43
D.1	General .....	43
D.2	Equipment inspection .....	43
D.3	Inspection of incoming materials .....	45
D.4	Process inspection.....	47
D.5	Finished product inspection.....	51
D.6	Switching rules .....	51
Annex E (informative) Assessment of compliance .....		53
E.1	General .....	53
E.1.1	General remark .....	53
E.1.2	Compliance of factory quality system .....	53
E.1.3	Compliance of the product .....	53

E.2	Initial inspection .....	53
E.3	Continuous surveillance .....	53
E.4	Audit testing.....	54
Annex F (normative) Test of water absorption.....		55
F.1	Method .....	55
F.2	Sampling.....	55
F.3	Materials.....	58
F.4	Apparatus.....	58
F.5	Preparation .....	58
F.6	Procedure.....	58
F.7	Results.....	59
Annex G (informative) Measurement of dimensions .....		60
G.1	Length, height, width and thickness.....	60
G.2	Warp and straightness .....	61
G.3	Out of squareness.....	61
G.4	Surface characteristics.....	61
G.5	Angular deviation lateral bow, camber and sag.....	65
Annex H (informative) Prestressing losses.....		66
H.1	General.....	66
H.2	Calculation of losses (general method).....	66
H.2.1	Losses before transfer of the prestress force.....	66
H.2.2	Loss at transfer of the prestress force.....	67
H.2.3	Losses after transfer of the prestressing force.....	67
H.2.4	Final prestress loss at infinite time .....	67
H.3	Simplified method.....	67
Annex I (informative) Technical documentation .....		69
I.1	General.....	69
I.2	Product documentation .....	69
I.3	Production documentation.....	69
I.4	Erection documentation .....	70
Annex J (informative) Properties of indented bars and wire.....		71
Annex K (informative) Resistance to fire: recommendations for the use of EN 1992-1-2.....		72
K.1	Use of tabulated data .....	72
K.2	Use of calculation methods.....	72
Annex L (informative) Survey of type testing .....		73
Annex M (informative) Performance-based approach for precast concrete products.....		75

<b>M.1</b>	<b>Introduction.....</b>	<b>75</b>
<b>M.2</b>	<b>Equivalent Durability Procedure.....</b>	<b>75</b>
<b>M.3</b>	<b>Exposure Resistance Classes .....</b>	<b>76</b>
<b>M.4</b>	<b>Specifications to implement PBA for precast concrete products.....</b>	<b>76</b>
	<b>Bibliography .....</b>	<b>77</b>

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## European foreword

This document (prEN 13369:2022) has been prepared by Technical Committee CEN/TC 229 “Precast concrete products”, the secretariat of which is held by AFNOR.

This document is currently submitted to the CEN Enquiry.

This document supersedes EN 13369:2018.

The main technical changes that have been made in this new edition are the following ones:

- a) normative references have been updated taking into account the new version of EN 206;
- b) terms and definitions have been reviewed according to Construction Product Regulation, term and definition of “Product-type” are added;
- c) the clause for reclaimed crushed aggregates and recycled coarse aggregates was reviewed;
- d) the clause of Assessment and verification of constancy of performance was revised according to the wording of Construction Product Regulation;
- e) an informative Annex related to the performance-based approach was added.

EN 13369 is a common reference for the following group of specific product standards prepared by Technical Committee CEN/TC 229:

- EN 1168, *Precast concrete products — Hollow core slabs*;
- EN 12737, *Precast concrete products — Floor slats for livestock*;
- EN 12794, *Precast concrete products — Foundation piles*;
- EN 12839, *Precast concrete products — Elements for fences*;
- EN 12843, *Precast concrete products — Masts and poles*;
- EN 13198, *Precast concrete products — Street furniture and garden products*;
- EN 13224, *Precast concrete products — Ribbed floor elements*;
- EN 13225, *Precast concrete products — Linear structural elements*;
- EN 13693, *Precast concrete products — Special roof elements*;
- EN 13747, *Precast concrete products — Floor plates for floor systems*;
- EN 13748-1, *Terrazzo tiles — Part 1: Terrazzo tiles for internal use*;
- EN 13748-2, *Terrazzo tiles — Part 2: Terrazzo tiles for external use*;
- EN 13978-1, *Precast concrete products — Precast concrete garages — Part 1: Requirements for reinforced garages monolithic or consisting of single sections with room dimensions*;
- EN 14843, *Precast concrete products — Stairs*;



- EN 14844, *Precast concrete products — Box culverts*;
- EN 14991, *Precast concrete products — Foundation elements*;
- EN 14992, *Precast concrete products — Wall elements*;
- EN 15037-1, *Precast concrete products — Beam-and-block floor systems — Part 1: Beams*;
- EN 15037-2, *Precast concrete products — Beam-and-block floor systems — Part 2: Concrete blocks*;
- EN 15037-3, *Precast concrete products — Beam-and-block floor systems — Part 3: Clay blocks*;
- EN 15037-4, *Precast concrete products — Beam-and-block floor systems — Part 4: Expanded polystyrene blocks*;
- EN 15037-5, *Precast concrete products — Beam-and-block floor systems — Part 5: Lightweight blocks for simple formwork*;
- EN 15050, *Precast concrete products — Bridge elements*;
- EN 15258, *Precast concrete products — Retaining wall elements*;
- EN 15435, *Precast concrete products — Normal weight and lightweight concrete shuttering blocks — Product properties and performances*;
- EN 15498, *Precast concrete products — Wood-chip concrete shuttering blocks — Product properties and performances*.

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## Introduction

This document is intended to outline the general common requirements applicable to a large variety of precast concrete products manufactured in a factory environment. It acts as a reference standard for other standards to enable a more consistent approach to standardization in the field of precast concrete products and to reduce the variations brought about by a large number of standards produced in parallel by different groups of experts. At the same time, it allows those experts the flexibility to include variations in specific product standards where they are required.

This standard has been produced as part of the total CEN programme for construction and refers to the relevant specifications of associated standards EN 206 for concrete and EN 1992 for the design of concrete structures. The installation of some precast concrete products is dealt with by EN 13670.

As it is not a harmonized standard, it may not be used on its own for the purpose of CE marking of precast concrete products.

The design of precast concrete products should be verified to ensure the fitness of their properties for the particular application, particular attention being paid to design co-ordination with other parts of the construction.

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## 1 Scope

This document specifies the requirements, the basic performance criteria and the Assessment and Verification of Constancy of Performance (AVCP) for unreinforced, reinforced and prestressed precast concrete products made of compact light-, normal- and heavyweight concrete according to EN 206 with no appreciable amount of entrapped air other than entrained air. Concrete containing fibres for other than mechanical properties (steel, polymer or other fibres) is also covered. It does not cover prefabricated reinforced components of lightweight aggregate concrete with open structure nor glass-fibre reinforced concrete.

It can also be used to specify products for which there is no standard. Not all of the requirements (Clause 4) of this standard are relevant to all precast concrete products.

Some European product standards refer to this standard. They can include specific provisions that take precedence over the provisions of this standard.

## 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 206:2013+A1:2016, *Concrete - Specification, performance, production and conformity*

EN 934-2, *Admixtures for concrete, mortar and grout - Part 2: Concrete admixtures - Definitions, requirements, conformity, marking and labelling*

EN 1008, *Mixing water for concrete - Specification for sampling, testing and assessing the suitability of water, including water recovered from processes in the concrete industry, as mixing water for concrete*

EN 1097-6, *Tests for mechanical and physical properties of aggregates - Part 6: Determination of particle density and water absorption*

EN 1992-1-1:2004,<sup>1</sup> *Eurocode 2: Design of concrete structures - Part 1-1: General rules and rules for buildings*

EN 1992-1-2:2004,<sup>2</sup> *Eurocode 2: Design of concrete structures - Part 1-2: General rules - Structural fire design*

EN 10080:2005, *Steel for the reinforcement of concrete - Weldable reinforcing steel - General*

EN 12350-2, *Testing fresh concrete - Part 2: Slump test*

EN 12350-4, *Testing fresh concrete - Part 4: Degree of compactability*

EN 12350-5, *Testing fresh concrete - Part 5: Flow table test*

EN 12350-6, *Testing fresh concrete - Part 6: Density*

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<sup>1</sup> As impacted by EN 1992-1-1:2004/AC:2010 and EN 1992-1-1:2004/A1:2014.

<sup>2</sup> As impacted by EN 1992-1-2:2004/AC:2008 and EN 1992-1-2:2004/A1:2019.

**prEN 13369:2022 (E)**

EN 12350-7, *Testing fresh concrete - Part 7: Air content - Pressure methods*

EN 12350-8, *Testing fresh concrete - Part 8: Self-compacting concrete - Slump-flow test*

EN 12350-9, *Testing fresh concrete - Part 9: Self-compacting concrete - V-funnel test*

EN 12350-10, *Testing fresh concrete - Part 10: Self-compacting concrete - L box test*

EN 12350-11, *Testing fresh concrete - Part 11: Self-compacting concrete - Sieve segregation test*

EN 12350-12, *Testing fresh concrete - Part 12: Self-compacting concrete - J-ring test*

EN 12390-1, *Testing hardened concrete - Part 1: Shape, dimensions and other requirements for specimens and moulds*

EN 12390-2, *Testing hardened concrete - Part 2: Making and curing specimens for strength tests*

EN 12390-3, *Testing hardened concrete - Part 3: Compressive strength of test specimens*

EN 12390-7, *Testing hardened concrete - Part 7: Density of hardened concrete*

EN 12504-1, *Testing concrete in structures - Part 1: Cored specimens - Taking, examining and testing in compression*

EN 13501-1, *Fire classification of construction products and building elements - Part 1: Classification using data from reaction to fire tests*

EN ISO 717-1, *Acoustics - Rating of sound insulation in buildings and of building elements - Part 1: Airborne sound insulation (ISO 717-1)*

EN ISO 717-2, *Acoustics - Rating of sound insulation in buildings and of building elements - Part 2: Impact sound insulation (ISO 717-2)*

EN ISO 10456, *Building materials and products - Hygrothermal properties - Tabulated design values and procedures for determining declared and design thermal values (ISO 10456)*

ASTM C173/C173M - 10b, *Standard Test Method for Air Content of Freshly Mixed Concrete by the Volumetric Method*

### **3 Terms and definitions**

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

#### **3.1 General**

##### **3.1.1**

##### **precast concrete product**

product which is made of concrete and is manufactured in accordance with this standard or a specific product standard in a place different from the final destination of use, protected from adverse weather conditions during production and which is the result of an industrial process under a factory production control system and with the possibility of sorting before delivery

Note 1 to entry: In relevant European Standards, the shorter term “Precast product” is often used.

**3.1.2****(concrete) cover**

distance between the surface of the reinforcement closest to the nearest concrete surface (including links and stirrups and surface reinforcement where relevant) and the nearest concrete surface

[SOURCE: EN 1992-1-1:2004]

**3.1.3****concrete family**

group of concrete compositions for which a reliable relationship between relevant properties is established and documented

[SOURCE: EN 206:2013+A1:2016]

**3.1.4****tendon**

prestressing unit (wire, strand or bar) subjected to pre-tensioning

**3.1.5****lightweight concrete**

concrete with a closed structure and with an oven-dry density of 800 kg/m<sup>3</sup> to 2 000 kg/m<sup>3</sup>

**3.1.6****normal weight concrete**

concrete with an oven-dry density of 2 000 kg/m<sup>3</sup> to 2 600 kg/m<sup>3</sup>

**3.1.7****heavyweight concrete**

concrete with an oven-dry density of more than 2 600 kg/m<sup>3</sup>

**3.1.8****product-type**

set of representative performance levels or classes of construction product, in relation to its characteristics, produced using a given combination of raw materials or other elements in a specific production process

**3.1.9****reclaimed crushed aggregate**

aggregate gained by crushing hardened concrete that has not been previously used in construction

**3.1.10****recycled aggregate**

aggregate resulting from the processing of inorganic material previously used in construction

**3.2 Dimensions****3.2.1****principal dimensions**

length, width, depth or thickness

**3.2.2****nominal dimension**

dimension declared in the technical documentation and targeted at manufacture

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**prEN 13369:2022 (E)****3.3 Tolerances****3.3.1****tolerance**

sum of the absolute values of the upper and the lower permitted deviation

**3.3.2****deviation**

difference between an actual measure and the corresponding nominal dimension

**3.4 Durability****3.4.1****durability**

ability of a precast concrete product to satisfy, with anticipated maintenance, the design performance requirements during its design working life under the influence of the expected environmental actions

**3.4.2****design working life**

assumed period for which a structure or part of it is to be used for its intended purpose with anticipated maintenance but without major repair being necessary

**3.4.3****environmental conditions**

physical or chemical impacts to which the precast concrete product is exposed and which result in effects on the concrete or reinforcement or embedded metal that are not considered as loads in structural design

**3.4.4****ambient conditions**

hygrothermic conditions in the factory which result in effects on the hardening process of the concrete

**3.5 Mechanical properties****3.5.1****potential strength**

compressive concrete strength derived from tests on cubes or cylinders moulded and cured in laboratory conditions in accordance with EN 12390-2

**3.5.2****structural strength**

compressive concrete strength derived from tests on specimens (drilled cores or cut prisms) taken from the precast concrete product (direct structural strength) or derived from tests on moulded specimens cured in the same ambient conditions as the product itself (indirect structural strength)

**3.5.3****characteristic strength**

value of strength below which 5 % of the population of all possible strength determinations of the volume of concrete under consideration are expected to fall

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## 4 Specifications

### 4.1 Material specifications

#### 4.1.1 General

Only materials with established suitability shall be used.

For a particular material, the establishment of suitability may be based on a European Standard which refers specifically to the use of this material in concrete or in precast concrete products; in absence of a European Standard, it may also result, under the same conditions, from an ISO Standard.

Where this material is not covered by a European or ISO Standard, or if it deviates from the specifications of these standards, the establishment of suitability may be based on:

- the provisions valid in the place of use of the precast concrete product which refer specifically to the use of this material in concrete or in precast concrete products; or
- a European Technical Assessment specifically for the use of this material in concrete or precast concrete products.

#### 4.1.2 Constituent materials of concrete

##### 4.1.2.1 General

EN 206:2013+A1:2016, 5.1 shall apply. When relevant, the following additional provisions can be used complementarily.

##### 4.1.2.2 Reclaimed crushed aggregates and recycled coarse aggregates

###### 4.1.2.2.1 General

Reclaimed crushed aggregates and recycled aggregates to be used for concrete, mixed with or without natural aggregates, shall not adversely alter the rate of setting and hardening of concrete, nor shall it be detrimental to the durability of the precast concrete product in the end-use conditions.

###### 4.1.2.2.2 Reclaimed aggregates

Reclaimed aggregates may be used for concrete provided it is only used internally by the manufacturer. They shall not be added in quantities greater than 5 % by mass of the total aggregate if they aren't properly separated in function of their particle size.

Reclaimed aggregates may be used up to 20 % as coarse aggregates and up to 10 % as fine aggregates provided that:

- a) they come from a concrete with strength class at least equal to the required strength class of the new concrete product,
- b) they are properly separated in function of their particle size,
- c) they are stored and handled so that their properties do not change significantly and are not subject to contamination.

Reclaimed aggregates used in higher percentages shall be treated as recycled aggregates.