



# SLOVENSKI STANDARD

## SIST EN 13445-10:2021

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**Nekurjene tlačne posode - 10. del: Dodatne zahteve za tlačne posode iz niklja in nikljevih zlitin**

Unfired pressure vessels - Part 10: Additional requirements for pressure vessels of nickel and nickel alloys

Unbefeuerte Druckbehälter - Teil 10: Zusätzliche Anforderungen an Druckbehälter aus Nickel und Nickellegierungen

Réceptifs sous pression non soumis à la flamme - Partie 10: Exigences complémentaires pour les réceptifs sous pression en nickel et alliages de nickel

**Ta slovenski standard je istoveten z: EN 13445-10:2021**

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**ICS:**

23.020.32	Tlačne posode	Pressure vessels
77.150.40	Nikljevi in kromovi izdelki	Nickel and chromium products

**SIST EN 13445-10:2021**

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**Unfired pressure vessels - Part 10: Additional  
requirements for pressure vessels of nickel and nickel  
alloys**

Réceptacles sous pression non soumis à la flamme -  
Partie 10: Exigences complémentaires pour les  
réceptacles sous pression en nickel et alliages de nickel

Unbefeuerte Druckbehälter - Teil 10: Zusätzliche  
Anforderungen an Druckbehälter aus Nickel und  
Nickellegierungen

This European Standard was approved by CEN on 24 February 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.

**iTeh STANDARD PREVIEW**

This European Standard 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.

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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**

## Contents

	Page
<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 General information.....</b>	<b>6</b>
<b>5 Materials.....</b>	<b>6</b>
5.1 General.....	6
5.2 Material grouping system .....	6
5.3 Material documentation .....	6
5.4 Prevention of brittle fracture .....	6
<b>6 Design .....</b>	<b>7</b>
6.1 General.....	7
6.2 Time-independent nominal design stress .....	7
6.3 Creep design.....	8
6.4 Shells under external pressure .....	8
6.5 Fatigue design.....	8
<b>7 Manufacture .....</b>	<b>9</b>
7.1 General.....	9
7.2 Qualification of welding procedure specifications (WPQR) .....	9
7.4 Joint preparation.....	9
7.5 Preheat.....	10
7.6 Production test, reference criteria .....	10
7.7 Extent of testing.....	10
7.8 Performance of test and acceptance criteria .....	10
7.9 Forming procedures.....	10
7.9.1 Cold forming.....	10
7.9.2 Hot forming .....	11
7.10 Heat treatment after forming .....	11
7.10.1 General.....	11
7.10.2 Heat treatment of flat products after cold forming .....	11
7.10.3 Heat treatment of tubular products after cold forming .....	11
7.10.4 Heat treatment after hot forming.....	12
7.11 Sampling of formed products .....	12
7.11.1 Cold formed products without heat treatment .....	12
7.11.2 Hot formed or cold formed products with heat treatment .....	12
7.12 Tests.....	13
7.12.1 Base material .....	13
7.12.2 Butt welds .....	13
7.13 Post weld heat treatment (PWHT).....	13
7.14 Repairs .....	13

<b>8</b>	<b>Inspection and testing.....</b>	<b>13</b>
<b>8.1</b>	<b>General.....</b>	<b>13</b>
<b>8.2</b>	<b>Non-destructive testing of welded joints .....</b>	<b>14</b>
<b>8.2.1</b>	<b>General.....</b>	<b>14</b>
<b>8.2.2</b>	<b>Demonstration of satisfactory experience for testing group 2 .....</b>	<b>14</b>
<b>8.3</b>	<b>Determination of extent of non-destructive testing.....</b>	<b>15</b>
<b>8.4</b>	<b>Selection of non destructive testing methods for surface imperfections.....</b>	<b>19</b>
<b>8.5</b>	<b>Standard hydrostatic test.....</b>	<b>19</b>
<b>Annex A (normative).....</b>		<b>20</b>
<b>Annex B (informative) Designations of some nickel alloys .....</b>		<b>22</b>
<b>Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of EU Directive 2014/68/EU.....</b>		<b>27</b>

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## EN 13445-10:2021 Issue 1 (2021-05)

### European foreword

This document (EN 13445-10:2021) has been prepared by Technical Committee CEN/TC 54 “Unfired pressure vessels”, the secretariat of which is held by BSI.

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 November 2021, and conflicting national standards shall be withdrawn at the latest by November 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 13445-10:2015.

This document has been prepared under a standardization request 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.

list of all parts in the EN 13445 series can be found on the CEN website.

Although these Parts may be obtained separately, it should be recognised that the Parts are inter-dependant. As such the manufacture of unfired pressure vessels requires the application of all the relevant Parts in order for the requirements of the Standard to be satisfactorily fulfilled.

Corrections to the standard interpretations where several options seem possible are conducted through the Migration Help Desk (MHD). Information related to the Help Desk can be found at <http://www.unm.fr> ([en13445@unm.fr](mailto:en13445@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.

Amendments to this new edition may be issued from time to time and then used immediately as alternatives to rules contained herein. It is intended to deliver a new Issue of EN 13445:2021 each year, starting with the precedent as Issue 1, consolidating these Amendments and including other identified corrections.

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.

## 1 Scope

This Part 10 of this document specifies requirements for unfired pressure vessels and their parts made of nickel and nickel alloys (see 3.1) in addition to the general requirements for unfired pressure vessels under EN 13445-1:2021, EN 13445-2:2021, EN 13445-3:2021, EN 13445-4:2021 and EN 13445-5:2021.

NOTE Cast materials are not included in this version. Details regarding cast materials will be subject to an amendment to or a revision of this document.

## 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 764-5:2014, *Pressure equipment — Part 5: Inspection documentation of metallic materials and compliance with the material specification*

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

EN 13445-1:2021 *Unfired pressure vessels — Part 1: General*

EN 13445-2: 2021 *Unfired pressure vessels — Part 2: Materials*

EN 13445-3:2021, *Unfired pressure vessels — Part 3: Design*

EN 13445-4:2021, *Unfired pressure vessels — Part 4: Fabrication*

EN 13445-5:2021, *Unfired pressure vessels — Part 5: Inspection and testing*

EN ISO 9606-4:1999, *Approval testing of welders — Fusion welding — Part 4: Nickel and nickel alloys* (ISO 9606-4:1999)

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)

CEN ISO/TR 15608:2013, *Welding — Guidelines for a metallic materials grouping system* (ISO/TR 15608:2013)

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 13445-1:2021, EN 13445-2:2021, EN 13445-3:2021, EN 13445-4:2021 and EN 13445-5:2021 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 <http://www.iso.org/obp>

**EN 13445-10:2021**  
**Issue 1 (2021-05)**

### 3.1

#### **nickel alloys**

those alloys which contain a minimum of 30 % nickel and contain more nickel than iron

## 4 General information

The general information given in EN 13445-1:2021 on the scope of the standard as well as terms, definitions, quantities, symbols and units shall apply.

## 5 Materials

### 5.1 General

The general requirements of EN 13445-2:2021 shall apply with the following additions/exclusions in 5.2 – 5.4.

There are presently no European Standards specifically for nickel or nickel alloys for pressure purposes. However, some materials in Table A.2 can also be classified as stainless steels and are included in some harmonised standards. This part 10 of EN 13445 is therefore limited to European Approval of Materials (EAM) or the use of Particular Materials Appraisal (PMA). except when materials are sourced in accordance with a Harmonised standard.

All materials shall meet the requirements in 5.1 to 5.4 of this part 10 of EN 13445.

### 5.2 Material grouping system

Annex A of EN 13445-2:2021 is not applicable to pressure vessels of nickel and nickel alloys and is replaced by Annex A of this part 10 of EN 13445.

The grouping system for nickel and its alloys is shown in Table A.1 of this part 10 of EN 13445.

Only material having a minimum elongation after fracture greater than 25 % shall be used for construction of pressure vessels.

Materials which have mechanical properties enhanced by precipitation hardening are excluded from this part of EN 13445, unless they are to be used for bolting applications.

### 5.3 Material documentation

Materials for pressure bearing parts compliant with the requirements of this document shall be accompanied by inspection documentation in accordance with EN 10204:2004.

The type of inspection document shall be in accordance with EN 764-5:2014 and include a declaration of compliance to the material specification.

### 5.4 Prevention of brittle fracture

There are no general requirements for nickel and nickel alloys at temperatures down to –196 °C. However, the specific requirements of individual EAMs/PMAs shall be taken into account.



## 6 Design

### 6.1 General

All the design methods included in EN 13445-3:2021 shall apply, with the following amendments, given in 6.2 – 6.5.

The physical properties of nickel and nickel alloys may be based upon the technical data available for the types/grades of material listed in Annex B and agreed with the material manufacturer based on the properties in the PMA used in the design except where guaranteed properties are available in harmonised standards

### 6.2 Time-independent nominal design stress

The design methods included in EN 13445 3:2021, Clauses 5, 7 to 21, Annexes A,E,F,G,J,P and Q shall apply.

The design stress for nickel and nickel alloy materials entering service without any subsequent heat treatment shall be evaluated in accordance with Table 6.2-1.

If any material is subjected to subsequent heat treatment (for example, in the manufacture of dished ends) representative material test coupons shall be heat treated with the components and subjected to the same mechanical tests as used to certify the material at the manufacturer's works. The nominal design stress shall then be calculated in accordance with Table 6.2-1. If this design stress is lower than that used in the original calculations, the design of that component and any other related components shall be repeated using the nominal design stress derived from the properties of the heat treated material.

For designs using nickel and nickel alloys attention is drawn to the effect of heat treatment on the materials, and care should therefore be taken when determining the thickness of the materials that will receive subsequent heat treatments during manufacture.

**Table 6.2-1 — Maximum allowed values of the nominal design stress for nickel and nickel alloy materials for pressure parts**

Minimum specified elongation after fracture (A) (%)	Design stress for normal operating load cases (MPa)	Design stress for testing and exceptional load cases (MPa)
$A > 35$	$f_d = \min \left( \frac{R_{p1,0/T}}{1,2}; \frac{R_{m/T}}{3} \right)$	$f_{\text{test}} = \left( \frac{R_{p1,0/T_{\text{test}}}}{1,05} \right)$
$30 < A \leq 35$	$f_d = \left( \frac{R_{p1,0/T}}{1,5} \right)$	$f_{\text{test}} = \left( \frac{R_{p1,0/T_{\text{test}}}}{1,05} \right)$
$A \leq 30$	$f_d = \min \left( \frac{R_{p0,2/T}}{1,5}; \frac{R_{m/20}}{2,4} \right)$	$f_{\text{test}} = \left( \frac{R_{p0,2/T_{\text{test}}}}{1,05} \right)$

### 6.3 Creep design

Where sufficient material data is available, creep design may be applied to nickel and nickel alloys using the formulae and approach in Clause 19 of EN 13445-3:2021.

### 6.4 Shells under external pressure

The requirements in Clause 8 of EN 13445-3:2021 shall apply with the following modifications:

In EN 13445-3:2021, 8.4, for shells made in nickel or nickel alloys, the nominal elastic limit shall be given by:

$$\sigma_e = \frac{R_{p0,2/T}}{1,25}$$

and for stiffeners in the same material by:

$$\sigma_{es} = \frac{R_{p0,2/T,s}}{1,25}$$

### 6.5 Fatigue design

For loads up to 500 equivalent full pressure cycles no fatigue analysis is required. Above 500 cycles the requirements of Clause 17 of EN 13445-3:2021 shall apply with the following modifications:

The application of Clause 17 of EN 13445-3:2021 (see 17.4.4 of EN 13445-3:2021) to nickel and nickel alloys shall be limited to temperatures not exceeding 450 °C.

The correction factor to account for the influence of temperature on fatigue resistance (see 17.6.2.2 of EN 13445-3: 2021) is:

For  $T^* \geq 100$  °C:

$$C_t = 1,0164 - 1,4 \times 10^{-4} T^* - 2,4 \times 10^{-7} (T^*)^2$$

The requirements of Clause 18 of EN 13445-3:2021 shall apply with the following modifications:

The application of Clause 18 of EN 13445-3:2021 (see 18.4.3 of EN 13445-3:2021) to nickel and nickel alloys shall be limited to temperatures not exceeding 450 °C.

The correction factor to account for the influence of temperature on fatigue resistance,  $f_{T^*}$  (see 18.10.6.2 of EN 13445-3:2021) is given by:

$$f_{T^*} = 1,0164 - 1,4 \times 10^{-4} T^* - 2,4 \times 10^{-7} (T^*)^2$$

## 7 Manufacture

### 7.1 General

EN 13445-4:2021 shall apply, with the following amendments, given in 7.2 – 7.14.

NOTE 1 Not all welding processes are suitable for all nickel alloys.

NOTE 2 Welding consumables may be selected from EN ISO 14172:2015 and EN ISO 18274:2010.

### 7.2 Qualification of welding procedure specifications (WPQR)

The requirements of 8.3 of EN 13445-4:2021 shall apply with the following modifications:

- a) Annex B of EN 13445-2:2021 shall not apply.
- b) Impact testing is not normally required for pressure vessels of nickel and nickel alloys at temperatures down to  $-196^{\circ}\text{C}$  except for alloys in group 47.
- c) For nickel alloys in group 47 when the design temperature is below  $-105^{\circ}\text{C}$ , impact testing shall be carried out at and shall meet a minimum of 40 Joules when tested at  $-196^{\circ}\text{C}$  on the weld metal and heat affected zone of the WPQR.

### 7.3 Qualification of welders and welding operators

The requirements in 8.4 of EN 13445-4:2021 shall apply with the following modifications:

Replace reference to EN ISO 9606-1 2017 with EN ISO 9606-4:1999. For pressure vessels in the categories II, III and IV the examiner/ examining body shall be a notified body or recognised third party organisation

### 7.4 Joint preparation

In addition to the requirements of 8.6 in EN 13445-4:2021 the following shall apply for pressure vessels of nickel and its alloys:

- a) the edges of plates that have been thermally cut shall be dressed back by machining or grinding for a minimum distance of 1,5 mm to remove damaged material;

NOTE Nickel and nickel alloys are not subject to hardening by thermal cutting.

- b) for plates less than 20 mm thickness cold shearing is permissible, provided that the cut edges are dressed back mechanically by not less than 1,5 mm to permit a satisfactory examination of the edges prior to welding;
- c) plates less than 10 mm thick, which are cold sheared, need not be dressed prior to welding.
- d) coated parts shall be free of coating products for a minimum distance of 50 mm from the edge of the weld preparation, in order that the coating does not interfere with the welding process, and to safeguard the coating itself;

e) after welding, the welded areas shall be cleaned, and any residues, slag, spatter, etc. shall be removed.

## 7.5 Preheat

Preheating is not normally necessary for nickel and nickel alloys.

When the metal temperature is less than 5 °C, heat should be applied to a maximum temperature of 75 °C to remove condensation.

## 7.6 Production test, reference criteria

The requirements in 9.2 of EN 13445-4:2021 shall apply with the following modifications:

The requirements for impact testing of production control test plates are not applicable to nickel and its alloys; 9.2 a) of EN 13445-4:2021 is not applicable.

Production control test plates for nickel and nickel alloys vessels shall be carried out in accordance with 9.2 d) of EN 13445-4:2021.

## 7.7 Extent of testing

The requirements of 9.3 of EN 13445-4:2021 shall apply with the following modifications:

Table 9.3-1 shall be replaced by Table 7.7-1 below:

**Table 7.7-1 — Testing of production test plates**

Material Group	Thickness of test plate <sup>a</sup> mm	Test specimens <sup>b</sup>
All	$e \leq 12$	1 FB, 1 RB, 1 TT, 1 Ma, 1 Mi
	$12 < e$	2 SB <sup>c</sup> , 1 TT, 1Ma, 1Mi
<p><sup>a</sup> Thinner plate thickness.</p> <p><sup>b</sup> The symbols for Table 7.7-1 are given in Table 9.3-2 of EN 13445-4:2021.</p> <p><sup>c</sup> SB = side bends</p>		

## 7.8 Performance of test and acceptance criteria

The requirements in 9.4.1, 9.4.2, 9.4.3, 9.4.5, 9.4.6, 9.4.7, 9.4.9 and 9.4.10 of EN 13445-4:2021 shall apply.

## 7.9 Forming procedures

### 7.9.1 Cold forming

Cold forming of nickel and nickel alloy materials shall be carried out at temperatures below 300 °C. It is preferable that nickel and nickel alloys are cold formed whenever possible.