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**Kovinski industrijski cevovodi - 4. del: Proizvodnja in vgradnja - Dopolnilo A2**

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/prA2**

[SIST EN 13480-4:2018/oprA2:2020](https://standards.iteh.ai/catalog/standards/sist/3017ed82-af1c-46fe-96f1-e31616055ed6/sist-en-13480-4-2018-opra2-2020)

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**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/oprA2:2020**      **en,fr,de**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**DRAFT**  
**EN 13480-4:2017**  
**prA2**

May 2020

ICS

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 draft amendment is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 267.

This draft amendment A2, if approved, will modify the European Standard EN 13480-4:2017. If this draft becomes an amendment, CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant national standard without any alteration.

This draft amendment was established by CEN 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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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

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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**

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## European foreword

This document (EN 13480-4:2017/prA2:2020) has been prepared by Technical Committee CEN/TC 267 “Industrial piping and pipelines”, the secretariat of which is held by AFNOR.

This document is currently submitted to the CEN Enquiry.

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 EN 13480-4:2017.

This document includes the text of the amendment itself. The amended/corrected pages of EN 13480-4:2017 will be published as Issue 4 of the European Standard.

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[SIST EN 13480-4:2018/oprA2:2020](https://standards.iteh.ai/catalog/standards/sist/3017ed82-af1c-46fe-96f1-e31616055ed6/sist-en-13480-4-2018-opra2-2020)

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**EN 13480-4:2017/prA2:2020 (E)****1 Modification to 9.14.1, “General”**

*Replace the 7th paragraph with the following:*

“For PWHT, conservative P values for material groups and materials are given in Table 9.14.1-3.”

*Replace the 8th paragraph with the following:*

“Heat treatment as per Table 9.14.1-3 particularly in the upper range of holding temperature and/or holding time may unduly impair the physical properties (e.g. yield, tensile strength and toughness of the material) the additional effect of multiple heating cycles should be considered. This effect is given in Formula (9.14.1-1).”

*Behind the new 8th paragraph introduce the new 9th paragraph as follows:*

“Where P of the actual heat treatment exceeds the values in Table 9.14.1-3, the value obtained in the applicable welding procedures qualification replaces the value in the table, for example see informative Annex C.”

**2 Modification to 11.2.2, “CE Marking of installed piping”**

*Introduce the following as a new last paragraph:*

“For modifications (e.g. new piping in existing plants) within complex piping systems, a centrally positioned CE marking may be replaced by a unique number permanently attached to the piping. This unique number shall give a clear, unambiguous link to the required documentation and the manufacturer. The documentation shall contain all the information required by 11.2.2 and 11.2.3 and shall completely define the limit of the relevant piping.”

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### 3 Introduction of new informative Annex C, “Example for the extension of the P value”

Introduce the new informative Annex C:

“

#### Annex C (informative)

##### Example for the extension of the P value

The temperature range validated is the holding temperature used in the welding procedure test  $\pm 20\text{ }^{\circ}\text{C}$  (according to EN ISO 15614-1:2017, 8.4.12).

Table C.1 gives an example for the extension of the P value.

**Table C.1 — Qualification range for material group 6.4 according to CEN ISO/TR 15608 material X10CrMoVNb9-1 with wall thickness of 22 mm at 750 °C**

	Wall thickness (mm)	Temperature (°C)	Holding time (min)	P	Assessment
Actual welded (WPQR)	22	750	60	20,66	-
P Range qualified	22	730 770	60	20,06 20,86	-
Application Example 1	11	750	30	20,15	Within range
Application Example 2	11	750	60	20,46	Within range
Application Example 3	11	770	90	21,04	Out of range
Application Example 4	44	750	110	20,73	Within range
Application Example 5	44	750	120	20,77	Within range
Application Example 6	44	770	120	21,17	Out of range

## EN 13480-4:2017/prA2:2020 (E)

Table C.2 — Qualification range for material group 6.4 according to CEN ISO/TR 15608 material X10CrMoVNb9-1 with wall thickness of 22 mm at 760 °C

	Wall thickness (mm)	Temperature (°C)	Holding time (min)	P	Assessment
Actual welded (WPQR)	22	760	60	20,66	-
P Range qualified	22	740 780 (770) <sup>a</sup>	60	20,26 21,06	-
Application Example 1	11	760	30	20,35	Within range
Application Example 2	11	760	60	20,66	Within range
Application Example 3	11	770	90	21,04	Within range
Application Example 4	44	760	110	20,93	Within range
Application Example 5	44	760	120	20,97	Within range
Application Example 6	44	770	120	21,17	Out of range

<sup>a</sup> EN 13480-4, Table 9.14.1-1 limits the PWHT temperature to maximum 770 °C. Nevertheless, the qualification of P range may be made using the temperature of 780 °C.

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