
**Petroleum and natural gas
industries — Induction bends,
fittings and flanges for pipeline
transportation systems —**

**Part 1:
Induction bends**

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*Industries du pétrole et du gaz naturel — Coudes d'induction,
raccords et brides pour systèmes de transport par conduites —*

Partie 1: Coudes d'induction

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Published in Switzerland

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 67, *Materials, equipment and offshore structures for petroleum, petrochemical and natural gas industries*, Subcommittee SC 2, *Pipeline transportation systems*.

This third edition cancels and replaces the second edition (ISO 15590-1:2009), which has been technically revised.

A list of all parts in the ISO 15590 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

This document makes reference to line pipe and bends with delivery conditions based on ISO 3183.

The requirements of the annex(es) apply only when specified on the purchase order.

This document does not provide guidance on when it is necessary to specify the above supplementary requirements. It is the responsibility of the purchaser to specify, based upon the intended use and design requirements, the supplementary requirements that will apply for a particular purchase order.

Users of this document should be aware that further or differing requirements can be needed for individual applications. This document is not intended to inhibit a manufacturer from offering, or the purchaser from accepting, alternative equipment or engineering solutions for the individual application. This can be particularly applicable where there is innovative or developing technology. Where an alternative is offered, it is the responsibility of the manufacturer to identify and provide details of any variations from this document.

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Petroleum and natural gas industries — Induction bends, fittings and flanges for pipeline transportation systems —

Part 1: Induction bends

1 Scope

This document specifies the technical delivery conditions for bends made by the induction bending process for use in pipeline transportation systems for the petroleum and natural gas industries as defined in ISO 13623.

This document is applicable to induction bends made from seamless and welded pipe of unalloyed or low-alloy steels.

NOTE These are typically C-Mn steels or low-alloy steels that are appropriate for the corresponding level and grade of line pipe in accordance with ISO 3183.

This document specifies the requirements for the manufacture of two product specification levels (PSLs) of induction bends corresponding to product specification levels given for pipe in ISO 3183.

This document is not applicable to the selection of the induction bend PSL. It is the responsibility of the purchaser to specify the PSL, based upon the intended use and design requirements; see also ISO 3183, Introduction.

ISO 15590-1:2018

This document is not applicable to pipeline bends made by other manufacturing processes.

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.

ISO 80000-1:2009, *Quantities and units — Part 1: General*

ISO 148-1, *Metallic materials — Charpy pendulum impact test — Part 1: Test method*

ISO 3183:2012, *Petroleum and natural gas industries — Steel pipe for pipeline transportation systems*

ISO 6507 (all parts), *Metallic materials — Vickers hardness test*

ISO 6508 (all parts), *Metallic materials — Rockwell hardness test*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 6892-2, *Metallic materials — Tensile testing — Part 2: Method of test at elevated temperature*

ISO 7438, *Metallic materials — Bend test*

ISO 7539-2, *Corrosion of metals and alloys — Stress corrosion testing — Part 2: Preparation and use of bent-beam specimens*

ISO 8501-1, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings*

ISO 15590-1:2018(E)

ISO 9712, *Non-destructive testing — Qualification and certification of NDT personnel*

ISO 10474, *Steel and steel products — Inspection documents*

ISO 10893-4, *Non-destructive testing of steel tubes — Part 4: Liquid penetrant inspection of seamless and welded steel tubes for the detection of surface imperfections*

ISO 10893-5, *Non-destructive testing of steel tubes — Part 5: Magnetic particle inspection of seamless and welded ferromagnetic steel tubes for the detection of surface imperfections*

ISO 10893-8, *Non-destructive testing of steel tubes — Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections*

ISO 10893-9, *Non-destructive testing of steel tubes — Part 9: Automated ultrasonic testing for the detection of laminar imperfections in strip/plate used for the manufacture of welded steel tubes*

ISO 10893-10:2011, *Non-destructive testing of steel tubes — Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections*

ISO 10893-11:2011, *Non-destructive testing of steel tubes — Part 11: Automated ultrasonic testing of the weld seam of welded steel tubes for the detection of longitudinal and/or transverse imperfections*

ISO 12095, *Seamless and welded steel tubes for pressure purposes – Liquid penetrant testing*

ISO 13623, *Petroleum and natural gas industries — Pipeline transportation systems*

ISO 17640, *Non-destructive testing of welds — Ultrasonic testing — Techniques, testing levels, and assessment*

ASNT SNT-TC-1A¹⁾, *Recommended Practice No. SNT-TC-1A: Personnel Qualification and Certification in Nondestructive Testing*

<https://standards.iteh.ai/catalog/standards/sist/6139d518-96da-439b-b01f>

ASTM A370²⁾, *Standard Test Methods and Definitions for Mechanical Testing of Steel Products*

ASTM A435, *Standard Specification for Straight-Beam Ultrasonic Examination of Steel Plates*

ASTM A578/A578M, *Standard Specification for Straight-Beam Ultrasonic Examination of Rolled Steel Plates for Special Applications*

ASTM E18, *Standard Test Methods for Rockwell Hardness of Metallic Materials*

ASTM E92, *Standard Test Method for Vickers Hardness of Metallic Materials*

ASTM E112, *Standard Test Methods for Determining Average Grain Size*

ASTM E165, *Standard Test Method for Liquid Penetrant Examination*

ASTM E213, *Standard Practice for Ultrasonic Testing of Metal Pipe and Tubing*

ASTM E214, *Standard Practice for Ultrasonic Pulse-Echo Straight-Beam Contact Testing*

ASTM E340, *Standard Test Method for Macroetching Metals and Alloys*

ASTM E709, *Standard Guide for Magnetic Particle Testing*

ASTM E797, *Standard Practice for Measuring Thickness by Manual Ultrasonic Pulse-Echo Contact Method*

ASTM G39, *Standard Practice for Preparation and Use of Bent-Beam Stress-Corrosion Test Specimens*

1) American Society for Nondestructive Testing, 1711 Arlingate Lane, Columbus, OH 43228-0518, USA.

2) American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959, USA.

NACE TM0177:2016³⁾, *Laboratory Testing of Metals for Resistance to Sulfide Stress Cracking in Hydrogen Sulfide (H₂S) Environments*

NACE TM0284:2016, *Standard Test Method — Evaluation of Pipeline and Pressure Vessel Steels for Resistance to Hydrogen-Induced Cracking*

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:

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

3.1

arc

curved portion of a bend

3.2

as agreed

agreed upon by the manufacturer and purchaser, and specified in the purchase order

3.3

bend angle

amount of directional change through the bend

3.4

bend qualification test

qualification test that produces a bend in accordance with the MPS and demonstrates that bends that meet the specified requirements of this document can be produced

3.5

bend radius

distance from the centre of curvature to the centreline axis of the bent pipe

3.6

chord

line segment connecting start and stop points of the bend zone measured at the centreline axis

3.7

defect

imperfection of a size and/or population density greater than the acceptance criteria specified in this document

3.8

extrados

outer curved section of the bend arc

3.9

heat

batch of steel prepared in one steel-making operation

3.10

if agreed

as prescribed, or more stringent than is prescribed, if agreed upon by the manufacturer and the purchaser and specified in the purchase order

3) NACE International, 1440 South Creek Drive, P.O. Box 201009, Houston, TX 77084-4906, USA.

3.11

imperfection

discontinuity or irregularity in the product wall or on the product surface that is detectable by inspection methods outlined in this document

3.12

indication

evidence obtained by non-destructive inspection

3.13

induction bending

continuous bending process that utilizes induction heating to create a narrow, circumferential, heated band around the material being bent

3.14

inspection

activities, such as measuring, examining, testing, weighing or gauging one or more characteristics of a product and comparing the results of such activities with the specified requirements in order to determine conformity

3.15

intrados

inner curved section of the bend arc

3.16

lamination

internal metal separation that creates layers, generally parallel to the pipe/bend surface

3.17

manufacturer

firm, company, or corporation responsible for making and marking the product in accordance with the requirements of this document

3.18

manufacturing procedure specification

MPS

document that specifies the properties and description of the mother pipe, the bending procedure, the post-bending heat treatment equipment and cycle, the qualification bend testing results, the non-destructive testing procedures and the weld end bevel details used for the manufacture of the bends

3.19

mother pipe

straight section of pipe from which an induction bend is made

3.20

non-destructive inspection

inspection to reveal imperfections, using radiographic, ultrasonic or other methods specified in this document that do not involve disturbance, stressing or breaking of the materials

3.21

purchaser

party responsible for both the definition of requirements for a product order and for payment of that order

3.22

submerged-arc welding

SAW

welding process that produces melting and coalescence of metals by heating them with an arc or arcs between a bare metal consumable electrode or electrodes and the workpiece, wherein the arc and molten metal are shielded by a blanket of granular flux

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3.23**service condition**

condition of use that is specified by the purchaser in the purchase order

Note 1 to entry: In this document, the terms “sour service” and “offshore service” are service conditions.

3.24**strip/plate end weld**

weld that joins strip or plate ends together

3.25**tangent**

straight section at the end of an induction bend

3.26**transition zone**

area of the start and stop points of induction heating, which includes material that extends from the unheated mother pipe to the material that has been heated to the full bending temperature

3.27**wall thinning**

amount of reduction from the original wall thickness of the pipe to the wall thickness in the extrados after bending

4 Symbols and abbreviated terms**4.1 Symbols**

<i>A</i>	elongation of tensile test specimen after fracture, expressed as a percentage
<i>CVD, L_{CVD}</i>	crest to valley depth
<i>D₂ and D₄</i>	outside diameters of two adjacent crests
<i>D₃</i>	outside diameter of the intervening valley
<i>D</i>	specified diameter, outside or inside
<i>D_{max}</i>	maximum measured diameter, outside or inside
<i>D_{min}</i>	minimum measured diameter, outside or inside
<i>l</i>	distance between adjacent crests for waviness
<i>O</i>	out-of-roundness
<i>r_b</i>	bend centreline radius
<i>r_p</i>	nominal mid-thickness radius of the mother pipe
<i>R_m</i>	ultimate tensile strength
<i>R_{t0,5}</i>	yield strength for 0,5 % total elongation
<i>T_{dmin}</i>	minimum design temperature specified by the purchaser
<i>t_i</i>	minimum wall thickness at the bend intrados
<i>t_{min}</i>	minimum wall thickness required in accordance with ISO 13623, or other applicable design code, for the straight pipe adjacent to the bend, including any corrosion allowance

4.2 Abbreviated terms

BQT	bend qualification test
CTOD	crack tip opening displacement testing
HAZ	heat-affected zone
HIC	hydrogen-induced cracking
HFW	high-frequency electric welding process for pipe during manufacturing
MPS	manufacturing procedure specification
MT	magnetic particle testing
NDT	non-destructive testing
PSL	product specification level
PT	liquid-penetrant testing
RT	radiographic testing
SAW	submerged arc welding process for pipe during manufacture
SAWH	submerged arc helical welding process for pipe during manufacture
SAWL	submerged arc longitudinal welding process for pipe during manufacture
SSC	sulfide stress-cracking
SWC	step-wise cracking
UT	ultrasonic testing
WPS	welding procedure specification

5 General requirements

5.1 Units of measurement

In this document, data are expressed in both SI units and USC units. For a specific order item, unless otherwise stated, only one system of units shall be used, without combining data expressed in the other system.

For data expressed in SI units, a comma is used as the decimal separator and a space is used as the thousands separator. For data expressed in USC units, a dot (on the line) is used as the decimal separator and a space is used as the thousands separator.

5.2 Rounding

Unless otherwise stated in this document, to determine conformance with the specified requirements, observed or calculated values shall be rounded to the nearest unit in the last right-hand place of figures used in expressing the limiting value, in accordance with ISO 80000-1:2009, Annex B, Rule A.

NOTE For the purposes of this provision, the rounding method of ASTM E29-04^[3] is equivalent to ISO 80000-1:2009, Annex B, Rule A.

5.3 Conformance to this document

A quality management system should be applied to assist conformance to the requirements of this document.

NOTE ISO/TS 29001[2] gives sector-specific guidance on quality management systems.

A contract may specify that the manufacturer is responsible for conforming to all the applicable requirements of this document. It shall be permissible for the purchaser to make any investigation necessary to be assured of conformance by the manufacturer and to reject any material that does not conform.

6 Designation

Designation of induction bends shall take the form “IB xxx-PSL 1” or “IB xxx-PSL 2” or “IB xxx-PSL 2S”, where

- “xxx” is the specified minimum yield strength, expressed in megapascals (MPa);
- the letters “PSL 1” or “PSL 2” identify the technical delivery conditions class for induction bends in non-sour service;
- the letters “PSL 2S” identify PSL 2 bends for use in sour service conditions;
- the letters “PSL 2O” identify PSL 2 bends for use in offshore service conditions;
- the letters “PSL 2SO” identify PSL 2 bends for use in both offshore and sour service conditions.

7 Pressure rating and design

The hoop stress in the induction bend due to internal fluid pressure shall not exceed the hoop stress permitted in ISO 13623, or other applicable design code, for straight pipe in the location of the bend.

NOTE 1 The purchaser normally performs the pressure design and specifies the minimum wall thickness t_{\min} .

The wall thickness of the bend extrados shall be at least t_{\min} .

The wall thickness at the bend intrados shall be at least as given in [Formula \(1\)](#):

$$t_i = t_{\min} \times \frac{2r_b - r_p}{2(r_b - r_p)} \quad (1)$$

NOTE 2 For pipelines not designed in accordance with ISO 13623, the minimum required wall thickness of the bend extrados can be less than t_{\min} .

NOTE 3 The requirements in this clause address the design of a bend against internal pressure. It is necessary that the purchaser or designer also consider other loads, both static and dynamic, and pipeline test conditions to demonstrate compliance with the strength requirements of ISO 13623.

8 Information that shall be supplied by the purchaser

8.1 General information

The purchaser shall provide the following information:

- a) number of this document and year of publication (i.e. ISO 15590-1:2018);
- b) bend designation of each bend;
- c) quantity of bends;