
Cevi za daljinsko ogrevanje - Projektiranje in vgradnja toplotno izoliranih spojenih eno- in dvocevni sistemov za neposredno zakopana vročevodna omrežja - 2. del: Vgradnja - Dopolnilo A1

District heating pipes - Design and installation of thermal insulated bonded single and twin pipe systems for directly buried hot water networks - Part 2: Installation

Fernwärmerohre - Auslegung und Bauausführung von gedämmten Ein- und Doppelrohr-Verbundsystemen für direkt erdverlegte Fernwärmenetze - Teil 2: Bauausführung

Tuyaux de chauffage urbain - Conception et installation des systèmes bloqués de tuyaux monotubes et bitubes isolés thermiquement pour les réseaux d'eau chaude enterrés directement - Partie 2 : Installation

Ta slovenski standard je istoveten z: EN 13941-2:2019/prA1

ICS:

23.040.07	Cevovodi za daljinsko ogrevanje in njihovi deli	Pipeline and its parts for district heat
91.140.10	Sistemi centralnega ogrevanja	Central heating systems

SIST EN 13941-2:2019/oprA1:2021 en,fr,de

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

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EN 13941-2:2019
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ICS 23.040.07; 23.040.10; 91.140.10

English Version

District heating pipes - Design and installation of thermal insulated bonded single and twin pipe systems for directly buried hot water networks - Part 2: Installation

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This draft amendment is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 107.

This draft amendment A1, if approved, will modify the European Standard EN 13941-2:2019. 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.

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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 foreword

This document (EN 13941-2:2019/prA1:2021) has been prepared by Technical Committee CEN/TC 107 “Prefabricated district heating and district cooling pipe systems”, the secretariat of which is held by DS.

This document is currently submitted to the CEN Enquiry.

EN 13941, *District heating pipes — Design and installation of thermal insulated bonded single and twin pipe systems for directly buried hot water networks* consists of the following parts:

- Part 1: Design;
- Part 2: Installation.

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EN 13941-2:2019/prA1:2021 (E)**1 Modifications to Clause 2 "Normative references"**

Delete footnote 1 "Under preparation. Stage at time of publication: prEN 17248:2018." at the entry of "EN 17248,¹ District heating and district cooling pipe systems - Terms and definitions".

Delete reference "ISO 6761, Steel tubes — Preparation of ends of tubes and fittings for welding" (see also Modification 3 related to 11.3.1.6.1).

2 Modifications to subclause 11.3.1.3 "Welding procedures and the welding process"

Replace the first five paragraphs

"The welding procedure to be used shall be suitable for welding pipes and components in field conditions.

Any type of welding process is permitted as long as it is demonstrated that the welded joint has comparable mechanical and technological properties to the base materials.

Welding procedures shall be in accordance with EN ISO 15609-1 or EN ISO 15609-2.

This Welding procedure specification (WPS) shall be in accordance with EN ISO 15610, EN ISO 15613 or EN ISO 15614-1.

The application of EN ISO 15610 is not permitted for:" with

"The welding procedure to be used shall be suitable for welding pipes and components in field conditions.

Any type of welding process is permitted, if it is demonstrated that the welded joints have mechanical properties corresponding to the mechanical properties of the steel pipes.

Welding procedure specification (WPS) shall fulfil the requirements given in EN ISO 15609-1 or EN ISO 15609-2.

The welding procedure shall be qualified in accordance with EN ISO 15610, EN ISO 15613 or EN ISO 15614-1.

The application of EN ISO 15610 is not permitted for:".

And replace the last sentence

"The welding procedure qualification report (WPQR) shall be carried out on a water filled test pipe."

with

"The welding procedure qualification records (WPQR) shall be verified by use of water filled test pipes."

3 Modifications to subclause 11.3.1.6.1 "Joint edge preparation and different wall thickness"

Delete the last four words from clauses heading so that it changes from

"Joint edge preparation and different wall thickness" to "Joint edge preparation".

Replace the first three sentences

"All steel pipe ends shall be prepared in accordance with ISO 6761.

For joints between sections of different wall thickness Figure 2 shall apply.

For the different values of the possible misalignment and difference in wall thickness Table 3 shall apply."

with

"The ends of the steel service pipes shall be prepared for welding as determined in the welding procedure specification (WPS)."

In the next paragraph (fourth paragraph), add "service" in front of the word "pipe" so that it reads:

"Minor differences in service pipe end measurements are to be distributed evenly over the entire circumference by centring of the pipes."

Followed by the following new sentence

"For joints between service pipe ends with different values of the possible misalignment and difference in wall thickness Table 3 in conjunction with Figure 2 shall apply."

4 Modification to "Figure 4"

Replace the title of Figure 4

"Typical detail of a factory made draining/venting valve assembly, made from non corrosion resistant steel, for screwing a standpipe from the surface" *with*

"Typical detail of a factory made draining/venting valve assembly for operating a standpipe from the surface".

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5 Modifications to subclause 11.5.2 "Visual test with over pressure by air"

Replace "over pressure" in the title with "overpressure".

Also replace the first paragraph "The pipe section for testing shall be an enclosed pressure chamber for to bring up over pressure by air as test medium." with

"The tested pipe section shall be closed in order to apply overpressure."

Also, replace "over-pressure" with "overpressure" in the second paragraph.

6 Modification to subclause 11.5.4.1 "General"

Replace the fifth paragraph

"The pipe section for testing shall be a discharge chamber for to bring up over pressure to the water as test medium." *with*

"The tested pipe section shall be closed in order to apply overpressure."

7 Modification to subclause 11.6.1 "General"

Add "PE materials which do not differ more than 0,5 g/10 min in MFR shall be considered fusible to each other." after the first paragraph.

8 Modifications to subclause 11.6.2 "Joints"

In the third paragraph, delete "according to EN 489".

Delete the fifth paragraph also: "The requirements depend on the type of joint involved."