
**Plastics pipes and fittings — Butt
fusion jointing procedures for
polyethylene (PE) piping systems**

*Tubes et raccords en matières plastiques — Modes opératoires
d'assemblage par soudage bout à bout de tubes et raccords en
polyéthylène (PE)*

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Foreword

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This document was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 4, *Plastics pipes and fittings for the supply of gaseous fuels*.

This third edition cancels and replaces the second edition (ISO 21307:2011), which has been technically revised.

The main changes compared to the previous edition are as follows:

- Added calculation of gauge pressure in 4.7;
- Included normative non-destructive joint integrity testing (visual examination with requirements) in 6.3;
- Updated process parameters in Tables 1, 2, A.1, B.1 and C.1.