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Industriella rörledningar av metalliska material – Del 5: Kontroll och provning

Metallic industrial piping – Part 5: Inspection and testing

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Denna standard är framtagen av kommittén för Konstruktion, tillverkning och kontroll av tryckbärande anordningar, SIS/TK 298.

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EUROPEAN STANDARD

EN 13480-5:2012/A2

NORME EUROPÉENNE

EUROPÄISCHE NORM

March 2017

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English Version

Metallic industrial piping - Part 5: Inspection and testing

Tuyauteries industrielles métalliques - Partie 5:
Inspection et contrôle

Metallische industrielle Rohrleitungen - Teil 5: Prüfung

This amendment A2 modifies the European Standard EN 13480-5:2012; it was approved by CEN on 16 January 2017.

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This amendment 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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COMITÉ EUROPÉEN DE NORMALISATION
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European foreword

This document (EN 13480-5:2012/A2:2017) has been prepared by Technical Committee CEN/TC 267 "Industrial piping and pipelines", the secretariat of which is held by AFNOR.

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of an identical text or by endorsement, at the latest by September 2017, and conflicting national standards shall be withdrawn at the latest by September 2017.

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 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 13480-5:2012.

This document includes the text of the amendment itself. The amended/corrected pages of EN 13480-5:2012 will be published in the new Edition 2017 of the European Standard.

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 Modification to Clause 2

Add the following normative references:

“EN ISO 10893-5:2011, *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 10893-5:2011)*”

ISO 3057:1998, *Non-destructive testing — Metallographic replica techniques of surface examination*”.

2 Modification to 7.2.4

Replace sub-clause 7.2.4 with the following: “

7.2.4 Non-destructive testing of formed parts

7.2.4.1 General

All formed parts shall be subject to non-destructive testing. Depending on material, dimensions and type of forming process testing may include:

- a) visual testing;
- b) wall thickness measurements;
- c) dimensional checks (ovality, angle of bend etc.) and tolerances (see EN 13480-4);
- d) hardness tests;
- e) testing for surface imperfections (magnetic particle or penetrant testing);

on formed parts of each component or batch of identical components.

Material, heat treatment conditions, heat treatment lot, degree of deformation shall be considered in the definition of the batch.

Replicas of the surface structure in the tension zone may be required in case of lifetime monitoring for creep range application.

Ultrasonic testing may be performed if specified. Specification shall include area, extent, method and acceptance criteria.

NOTE A customary interpretation of a heat treatment lot is the entire content of a furnace of a single heat treatment.

7.2.4.2 Induction bending

Material surfaces shall be suitable for induction bending. EN ISO 10893-5 specifies surface qualities and acceptance levels. The acceptance levels shall be agreed, considering material, dimensions and service (creep, fatigue).

Induction bends shall be tested according to Table 7.2.4.2-1.

Heat treatment shall be done if required by EN 13480-4. Subsequent hardness testing shall be performed on the straight length and within bending zone to verify the homogeneity of annealing.

If no heat treatment is required after forming, hardness testing is required in the bending zone only if specified for service reasons.

Dimensional checks shall include ovality, angle of bend, wall thickness and tolerances (see EN 13480-4).