DIN EN 10217-2:2019-08 (E)

Welded steel tubes for pressure purposes - Technical d elivery conditions - Part 2: Electric welded non-alloy and alloy steel tubes with specified elevated temperature properties

Contents

Page

European foreword 4

1 Scope 5

2 Normative references 5

3 Terms and definitions 6

4 Symbols 7

5 Classification and designation 7
5.1 Classification 7
5.2 Designation 7

6 Information to be supplied by the purchaser 7
6.1 Mandatory information 7
6.2 Options 8
6.3 Example of an order 9

7 Manufacturing process 9
7.1 Steelmaking process 9
7.2 Tube manufacture and delivery conditions 9
7.3 Non Destructive Testing Personnel Requirements 10

8 Requirements 10
8.1 General 10
8.2 Chemical composition 10
8.2.1 Cast analysis 10
8.2.2 Product analysis 12
8.3 Mechanical properties 12
8.4 Appearance and internal soundness 13
8.4.1 Weld seam 13
8.4.2 Tube surface 14
8.4.3 Internal soundness 14
8.5 Straightness 14
8.6 Preparation of ends 14
8.7 Dimensions, masses and tolerances 15
8.7.1 Diameter and wall thickness 15
8.7.2 Mass 19
8.7.3 Lengths 19
8.7.4 Tolerances 19

9 Inspection 20
9.1 Type of inspection 20
9.2 Inspection documents 20
9.2.1 Types of inspection documents 20
9.2.2 Content of inspection documents 21
9.3 Summary of inspection and testing 21

10 Sampling ... 23
10.1 Frequency of tests ... 23
10.1.1 Test unit ... 23
10.1.2 Number of sample tubes per test unit ... 23
10.2 Preparation of samples and test pieces ... 24
10.2.1 Selection and preparation of samples for product analysis ... 24
10.2.2 Location, orientation and preparation of samples and test pieces for mechanical tests ... 24

11 Verification of test methods ... 25
11.1 Chemical analysis ... 25
11.2 Tensile test on the tube body ... 25
11.2.1 At room temperature ... 25
11.2.2 At elevated temperature ... 25
11.3 Transverse tensile test on the weld ... 26
11.4 Flattening test ... 26
11.5 Ring tensile test ... 26
11.6 Drift expanding test ... 26
11.7 Ring expanding test ... 27
11.8 Impact test ... 27
11.9 Leak tightness test ... 28
11.9.1 Hydrostatic test ... 28
11.9.2 Electromagnetic test ... 28
11.10 Dimensional inspection ... 28
11.11 Visual examination ... 29
11.12 Non-Destructive Testing ... 29
11.13 Material identification ... 29
11.14 Retests, sorting and reprocessing ... 29

12 Marking ... 30
12.1 Marking to be applied ... 30
12.2 Additional marking ... 30

13 Protection ... 30

Annex A (informative) Technical changes from the previous edition ... 31

A.1 Introduction ... 31
A.2 Technical changes ... 31

Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of 2014/68/EU ... 33

Bibliography ... 34