

DIN EN 10255:2007-07 (Englisc h)

Non-alloy steel tubes suitable for welding and threading - Technical delivery conditions (includes Amendment A1:2007)

Contents		Page
Foreword		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	6
4	Classification and designation	6
5	Information to be obtained from the purchaser	6
5.1	Mandatory information	6
5.2	Options	6
5.3	Examples of ordering	7
5.3.1	By outside diameter and thickness	7
5.3.2	By thread size and series	7
6	Manufacturing process	7
6.1	Steelmaking process	7
6.2	Tube manufacturing process	7
7	Delivery conditions	8
7.1	General	8
7.2	Alternative finishes and protection of the tube ends	8
7.3	Suitability for hot dip galvanizing	8
7.4	Hot dip galvanized condition	8
8	Requirements	8
8.1	General	8
8.2	Chemical composition and mechanical properties	9
8.3	Appearance	9
8.4	Dimensions, masses and tolerances	9
8.5	Leak tightness	11
8.6	Dangerous substances	11
8.7	Reaction to fire	12
9	Inspection	12
9.1	Type of inspection	12
9.2	Inspection documents	12
9.3	Tensile test	12
9.4	Bend test	12
9.5	Flattening test	13
9.6	Leak tightness test	13
9.7	Dimensional inspection	13
9.8	Visual examination	13
10	Marking	13
11	Temporary protective coating	14
12	Evaluation of conformity	14

12.1	General	14
12.2	Initial type testing (ITT)	14
12.2.1	General	14
12.2.2	Characteristics	15
12.2.3	Product families	15
12.2.4	Use of historical data	15
12.2.5	Deemed to satisfy' provisions and use of reference tabulated data	15
12.2.6	Sampling	15
12.3	Factory production control (FPC)	15
12.3.1	General	15
12.3.2	Equipment	16
12.3.3	Raw materials and components	16
12.3.4	Product testing and evaluation	16
12.3.5	Inspection	16
12.3.6	Non-conforming products	16
Annex A (informative) Correlation between specified outside diameter, thread size, and nominal diameter		17
Annex B (normative) Types of tubes with wall thickness different from medium and heavy series ...		18
B.1	General	18
B.2	Requirements	18
B.3	Marking	18
Annex ZA (informative) !!!!Clauses of this European Standard addressing the provisions of the EC Construction Products Directive for applications covered by Mandate M/131		20
ZA.1	Scope and relevant characteristics	20
ZA.2	Procedure for attestation of conformity of pipes	21
ZA.2.2	Declaration of conformity	22
ZA.3	CE marking and labelling	23