

DIN EN 1594:2024-05 (E)

Gas infrastructure - Pipelines for maximum operating pressure over 16 bar - Functional requirements

Contents		Page
European foreword		6
Introduction		8
1	Scope	9
2	Normative references	11
3	Terms and definitions	13
4	Quality and management systems	18
5	Safety and the environment	19
5.1	General	19
5.2	Appropriate safety measures	19
5.3	Routing considerations	20
5.3.1	General	20
5.3.2	Surveys	20
5.3.3	Environmental impact	20
5.3.4	Ground conditions	21
5.4	Line valve spacing	21
6	Pressure safety	21
6.1	Pressure levels	21
6.2	Normal operation	22
6.3	Requirements for installation of pressure safety devices	22
6.4	Pipeline with DP equal to or less than 40 bar and hoop stress 0,45 Rt0,5	23
6.5	Pipeline with DP equal to or less than 24 bar and hoop stress 0,30 Rt0,5	23
7	Design	23
7.1	General	23
7.1.1	Design principles	23
7.1.2	Basis of design	23
7.2	Wall thickness determination	24
7.2.1	Straight pipe	24
7.2.2	Bends and elbows	25
7.3	Additional design requirements	25
7.3.1	Forces	25
7.3.2	Soil engineering data required	26
7.3.3	Structural models for pipeline sections	26
7.4	Analysis of stress and strain	27
7.4.1	Elastic and extended elastic design	27
7.4.2	Limit state design	28
7.5	Design report	29
7.6	Land management and geotechnical studies	30
7.7	Depth of cover	30
7.8	Casing pipes	30
7.9	Station design	31
7.9.1	Layout	31
7.9.2	Components	32
7.9.3	Interaction with onshore pipeline section	32

7.9.4	Station pipework	33
7.10	Pipeline components	33
7.11	Pigging suitability	33
7.12	Arrangements for venting, recompression and flaring	33
7.13	Corrosion protection	34
7.13.1	General	34
7.13.2	External coating	34
7.13.3	Cathodic protection	35
7.14	Grid connections	35
8	Materials and components	36
8.1	General	36
8.1.1	Base material	36
8.1.2	Manufacturing requirements	36
8.1.3	Manufacturing procedure	36
8.1.4	Weldability	36
8.1.5	Mechanical properties	37
8.1.6	Inspection documents	38
8.1.7	Other steel types or grades	38
8.1.8	Records	38
8.2	Pipes	38
8.3	Fittings	39
8.3.1	General	39
8.3.2	Manufacturing	39
8.4	Flanged connections	39
8.5	Insulating connections	39
8.5.1	Type test	39
8.5.2	Strength test	39
8.5.3	Electrical test	40
8.5.4	External tightness test	40
8.6	Valves	40
8.7	External and internal coatings	40
8.8	Welding end preparation	40
9	Construction	40
9.1	General	40
9.2	Execution of work	40
9.2.1	General	40
9.2.2	Marking out the site	40
9.2.3	Initial site inspections	41
9.2.4	Working strip	41
9.2.5	Separation of topsoil	41
9.2.6	Trenches	41
9.2.7	Crossing and proximity of buried structures (cables and pipes)	42
9.2.8	Handling and stringing	42
9.2.9	Bends	43
9.2.10	Welding and weld examination	43
9.2.11	External coating	43
9.2.12	Lowering into the trench	46
9.2.13	Ballasting and anchoring	46
9.2.14	Tie-ins	46
9.2.15	Backfill	46
9.2.16	Reinstatement	47
9.2.17	Markings	47
9.2.18	Final site inspection with owners and users	47
9.3	Special crossings	47
9.3.1	General	47
9.3.2	Open-trench road or path crossings	47
9.3.3	Trenchless crossings	48
9.3.4	Requirements for casings	51
9.3.5	Open trench major water crossings	51
9.3.6	Horizontal directional drilling	51

9.4	Cleaning	52
9.5	Testing	52
9.5.1	General	52
9.5.2	Test preparation	53
9.5.3	Strength test	53
9.5.4	Tightness test	53
9.5.5	Pre-testing	54
9.5.6	Dewatering	54
9.5.7	Golden welds	54
9.6	Acceptance	54
9.6.1	As-built documents	54
9.6.2	Pre-commissioning	54
9.6.3	Handover and documentation	55
10	Operation and maintenance	55
10.1	General	55
10.1.1	Policy	55
10.1.2	Safety and environment	55
10.2	Organization	55
10.3	Operating and maintenance instructions	56
10.4	Emergency plan	57
10.5	Records and documentation	57
10.6	Commissioning	57
10.7	Decommissioning	58
10.8	Recommissioning	58
10.9	Maintenance, modification, and repair	58
10.9.1	General	58
10.9.2	Pipeline surveillance, inspection and monitoring	58
10.9.3	Execution of repairs and modifications	59
10.9.4	Work involving cutting of the pipeline	59
10.9.5	Work on in-service pipelines	59
10.9.6	Repairs after emergency	60
10.9.7	Other and special maintenance activities	60
10.10	Introduction of hydrogen in existing natural gas pipelines	61
10.11	Abandonment and removal	61
Annex A (normative) Requirements for fracture arrest of line pipe		62
A.1	General	62
A.2	CVN impact test	63
A.3	Drop weight tear test	65
A.4	Test pieces, method, and frequency for CVN and DWT tests	65
Annex B (informative) Hydrogen gas pipelines		66
B.1	General	66
B.2	New pipelines	66
B.3	Existing pipelines	66
B.4	Other considerations	67
Bibliography		68