

DIN EN 13445-4:2013-12 (E)

Unfired pressure vessels - Part 4: Fabrication

Contents		Page
Foreword		4
1	Scope	4
2	Normative references	5
3	Requirements for manufacturing and subcontracting	7
3.1	Manufacturing	7
3.2	Subcontracting	7
4	Materials	8
4.1	General	8
4.2	Material traceability	8
4.2.1	General	8
4.2.2	Identification system	8
4.2.3	Visibility	9
4.2.4	Review of material certification and material identification	9
4.2.5	Transfer of markings	9
5	Manufacturing tolerances	9
5.1	Surface geometry of welds	9
5.2	Middle line alignment	9
5.3	Surface alignment	11
5.3.1	Surface misalignment between parts	11
5.3.2	Joining of parts of different thickness	11
5.4	Tolerances for vessels subjected to internal pressure	11
5.4.1	External diameter	11
5.4.2	Out of roundness	11
5.4.3	Deviation from the longitudinal axis	12
5.4.4	Irregularities in profile	12
5.4.5	Local thinning	14
5.4.6	Dished ends	15
5.5	Tolerances for vessels subjected to external pressure	17
5.6	Structural tolerances	17
6	Weld details	17
6.1	General	17
6.2	Vessels or parts made of more than one course	17
6.3	Lapped joints, joggle joints, permanent backing strips	17
7	Welding	17
7.1	General	17
7.2	Welding procedure specification (WPS)	18
7.3	Welding procedure qualification record (WPQR)	18
7.4	Qualification of welders and welding operators	19
7.5	Filler metals and auxiliary materials	19
7.6	Joint preparation	19
7.7	Execution of welded joints	20
7.8	Attachments, supports and stiffeners	20
7.9	Preheat	21
8	Manufacture and testing of welds -- Production test	21

8.1	General	21
8.2	Reference criteria	21
8.3	Extent of testing	25
8.4	Performance of tests and acceptance criteria	27
8.4.1	General	27
8.4.2	Transverse tensile test	27
Issue 5 (2013-07) 8.4.3 Longitudinal weld tensile test		27
8.4.4	Impact test	27
8.4.5	Bend test	27
8.4.6	Macro examination	28
8.4.7	Micro examination	28
8.4.8	Hardness test	28
8.4.9	Retests	28
8.4.10	Test report	29
9	Forming of pressure parts	29
9.1	General	29
9.2	Ratio of deformation	29
9.2.1	Dished circular products	29
9.2.2	Cylinders and cones made by rolling	30
9.2.3	Other product types	31
9.2.4	Tube bends	32
9.2.5	Forming of Segments	32
9.3	Forming procedures	33
9.3.1	Cold forming	33
9.3.2	Hot forming	33
9.4	Heat treatment after forming	36
9.4.1	General	36
9.4.2	Heat treatment of flat products after cold forming	36
9.4.3	Heat treatment of tubular products after cold forming	38
9.4.4	Heat treatment of clad steels after cold forming	38
9.4.5	Heat treatment after hot forming	38
9.4.6	Heat treatment of clad steels after hot forming	39
9.5	Sampling of formed test coupons	39
9.5.1	Cold formed products without heat treatment	39
9.5.2	Hot formed or cold formed products with heat treatment	39
9.6	Tests	40
9.6.1	Base material	40
9.6.2	Butt welds	40
9.6.3	Acceptance criteria for formed test coupons	41
9.6.4	Retests of formed coupons	41
9.7	Visual inspection and control of dimension	41
9.8	Marking	42
9.9	Documentation	42
10	Post weld heat treatment (PWHT)	42
10.1	General	42
10.2	Heat treatment conditions	43
10.3	Method of PWHT	45
10.4	PWHT procedure	46
10.5	Mechanical properties after heat treatment	46
10.6	Dissimilar ferritic joints	47
10.7	Special materials	48
10.8	Heat Treatment for reasons other than welding	48
11	Repairs	49
11.1	Repairs of surface defects in the parent metal	49
11.2	Repair of weld defects	49
12	Finishing operations	49

Annex A (informative) Structural tolerances51
Annex B (informative) Example of a sub-contractors form55
Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of the EU Pressure Equipment Directive 97/23/EC57
Bibliography58