

DIN EN 13445-5:2014-12 (E)

Unfired pressure vessels - Part 5: Inspection and testing

Contents		Page
Foreword		5
1	Scope	7
2	Normative references	7
3	Terms and definitions	8
4	Performance of inspection and testing	9
4.1	General	9
4.2	Inspection	9
4.3	Non-destructive testing (NDT)	9
5	Technical documentation	10
5.1	General	10
5.2	Information to be contained in the technical documentation	10
5.2.1	General	10
5.2.2	General description of the pressure vessel	10
5.2.3	Design and construction drawings	10
5.2.4	Descriptions and explanations necessary for an understanding of the drawings and diagrams and the operation of the pressure vessel	11
5.2.5	Results of design calculations and examinations carried out	11
5.2.6	Test reports	12
5.2.7	Technical/manufacturing schedule	12
5.3	Design review	13
5.3.1	General	13
5.3.2	Design review	13
6	Inspection and testing during fabrication	14
6.1	General	14
6.2	Manufacturing procedures and construction drawings	14
6.3	Material traceability	14
6.3.1	General	14
6.3.2	Special Conditions - Material marking	14
6.4	Preparation for manufacturing processes	14
6.4.1	General	14
6.4.2	Joint preparation testing	15
6.4.3	Inspection of vessel supports	15
6.4.4	Inspection associated with forming	15
6.4.5	Testing of areas subject to significant through thickness tensile stress	15
6.5	Welding	15
6.5.1	General	15
6.5.2	Verification of welder and welding operator qualification and procedures qualification	16
6.5.3	Inspection of repairs	16
6.6	Non-destructive testing of welded joints	16
6.6.1	Extent of non-destructive testing	16
6.6.2	Determination of extent of non-destructive testing	19
6.6.3	Performing non-destructive testing	27
6.6.4	Description and acceptance level of imperfections	28
6.6.5	Stage of performance	28
6.6.6	Procedure for non-destructive retesting	28
6.6.7	Non-destructive testing documentation	28

6.7	Destructive testing	29
6.7.1	Extent of destructive testing	29
6.7.2	Schedule for destructive testing	29
6.7.3	Verification of destructive tests	29
6.7.4	Records	29
6.8	Heat-treatment	29
Issue 1 (2014-09) 7 Subcontracted items		29
7.1	General	29
7.2	Subcontracted welding related activities	30
7.3	Subcontracted non-destructive testing activities	30
7.3.1	Use of contract NDT personnel at the premises of the vessel manufacturer	30
7.3.2	Subcontracting of NDT at a subcontractors premises	30
8	Miscellaneous tests	30
9	Calibration	31
9.1	General	31
9.2	Calibration procedure	31
9.2.1	General	31
9.2.2	Calibration	31
9.2.3	Frequency	32
9.3	Identification	32
9.4	Registration	32
10	Final assessment	33
10.1	General	33
10.2	Extent of final assessment	33
10.2.1	Visual and dimensional inspection	33
10.2.2	Review of documentation	34
10.2.3	Proof test	34
10.2.4	Post pressure test inspection	43
10.2.5	Inspection of safety accessories	44
11	Marking and declaration of compliance with the standard	44
11.1	General	44
11.2	Marking method	44
11.2.1	General	44
11.2.2	Direct stamping	44
11.2.3	Nameplate	44
11.3	Marking units	45
11.4	Marking contents	45
11.5	Declaration of compliance with the standard	46
12	Documents	46
12.1	Type of documents	46
12.2	Control and access of documents	47
12.3	Retention of documents	47
Annex A (normative) Inspection and testing of serially produced pressure vessels		48
A.1	Introduction	48
A.2	Limitations for vessels permitted to be classified as serially produced	48
A.3	Limitations for model	48
A.4	Prototype test	49
A.5	Model acceptance	49
A.6	Quality or manufacturing plan	49
A.7	Inspection, non-destructive testing and pressure testing	50
A.7.1	Introduction	50
A.7.2	General NDT procedure for serially produced pressure vessels	50
A.7.3	Pressure test for serially produced pressure vessels	50

A.8	Marking	50
A.9	Documentation / Certification	50
Annex B (normative) Detailed dimensional requirements for pressure vessels		51
Annex C (normative) Access and inspection openings, closing mechanisms and special locking elements		53
C.1	General	53
C.2	Types and dimensions of access and inspection openings	53
C.2.1	Sightholes	53
C.2.2	Handholes	53
Issue 1 (2014-09) C.2.3 Headholes		53
C.2.4	Manholes	54
C.2.5	Rescue holes	54
C.3	Types, location and minimum number of access and inspection openings	54
C.4	Alternative requirements for sightholes openings on small vessels	56
C.5	Closing mechanisms and special locking elements	56
C.5.1	Purpose	56
C.5.2	Definitions	56
C.5.3	Materials of construction, design	56
C.5.4	Screw clamps	57
C.5.5	Hinged bolts	58
C.5.6	Yoke-type closures	58
C.5.7	Quick opening and closing devices	59
Annex D (informative) Leak Testing		65
D.1	General	65
D.2	Leak testing personnel	65
Annex E (informative) Acoustic emission		66
E.1	General	66
E.2	Useful standards	66
E.3	Acoustic emission personnel	66
E.4	Additional requirements	66
Annex F (normative) Inspection and testing of pressure vessels or parts subject to creep		68
F.1	General	68
F.2	Extent of inspection and testing	68
F.3	Performance of NDT and acceptance criteria	70
F.4	Documents	70
Annex G (normative) Inspection and testing of pressure vessels subject to cyclic loads		71
G.1	General	71
G.2	Extent of inspection and testing	71
G.3	Performance and acceptance criteria	71
G.4	Technical documentation, additional requirements	72
Annex H (informative) Declaration of compliance with this standard		73
Annex I (informative) Specific tests during construction to assist in-service inspection		75
I.1	General	75
I.2	Metallographic investigation	75
I.3	Hardness measurements	75
I.4	Dimensional measurements	76

Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of the EU Pressure Equipment Directive 97/23/EC	78
Bibliography	79