DIN EN 13445-6:2021-12 (E)

Unfired pressure vessels - Part 6: Requirements for the design and fabrication of pressure vessels and pressure parts constructed from spheroidal graphite cast iron

Contents

Page

European foreword 5

1 Scope 6

2 Normative references 6

3 Terms, definitions units and symbols 7
3.1 Terms and definitions 7
3.2 Units 9
3.3 Symbols 9
3.4 Inter-relation of thicknesses definitions 11

4 Service conditions 11
4.1 Cyclic loading 11
4.2 Limitations on temperature and energy content 12

5 Requirements 12
5.1 Materials 12
5.2 Design 14
5.2.1 Technical documentation 14
5.2.2 Design methods 14
5.3 Founding 21
5.3.1 General 21
5.3.2 Welding 21

6 Material testing 21
6.1 General 21
6.2 Frequency and number of tests 21
6.3 Chemical analysis 22
6.4 Graphite structure 22
6.5 Inspection documents 22

7 Testing and final assessment 22
7.1 Testing 22
7.1.1 General 22
7.1.2 Testing requirements for CQ = 0,8 23
7.1.3 Testing requirements for CQ = 0,9 23
7.1.4 Surface imperfections 24
7.1.5 Cracks, laps, cold shut and non-fused chaplets 24
7.1.6 Ultrasonic testing and/or sectioning 24
7.1.7 Magnetic particle testing (only for ferritic grades) 24
7.1.8 Penetrant testing 25
7.1.9 Radiographic testing 25
7.1.10 Surface roughness 25
7.1.11 Minimum wall thickness 25
7.1.12 Wall thickness tolerances 25
7.1.13 Other dimensions 25
7.1.14 Qualification of testing personnel 26
7.2 Final assessment 26
7.2.1 General 26
7.2.2 Hydraulic test pressure 26

8 Pressure vessels constructed of a combination of parts in different materials 26

9 Marking and documentation 26
9.1 Marking of castings 26
9.2 Name plate for the complete pressure vessel 27
9.3 Documentation 27

(normative) Technical data for the design calculations 28

A.1 Purpose 28
A.2 Technical data 28
A.2.1 Ferritic spheroidal graphite cast iron according to EN 1563:2018 28
A.2.2 Austenitic spheroidal graphite cast iron according to EN 13835:2012 29

(informative) Ductility 30

(informative) Determination of the minimum local wall thickness and minimum required burst test pressure 32

(normative) Assessment of fatigue life 34

D.1 Purpose 34
D.2 Specific definitions 34
D.3 Specific symbols and abbreviations 34
D.4 Limitations 35
D.5 General 35
D.6 Simplified fatigue assessment 35
D.6.1 Pseudo-elastic stress range 35
D.6.2 Correction factors 36
D.6.3 Fatigue design curves 37
D.6.4 Allowable number of cycles 43
D.6.5 Allowable stress range 43
D.7 Detailed fatigue assessment 43
D.7.1 Pseudo-elastic stress ranges 43
D.7.2 Corrections to stress range 44
D.7.3 Fatigue design curves 45
D.7.4 Allowable number of cycles 46
D.7.5 Allowable stress range 47
D.8 Assessment rule for total fatigue damage 47
D.9 Repairs of surface imperfections 47

(normative) Design by analysis for castings 48

E.1 Introduction 48
E.2 Special requirements to EN 13445-3:2021, Annex B 48
E.2.1 Addition to B.8.2.3: Design checks for normal operating load cases 48
E.2.2 Addition to B.8.2.4: Design checks for testing load cases 48
E.3 Additions to EN 13445-3:2021, Annex C 48
E.4 Requirements 49

(informative) Recommendations for in-service validation and inspection 50

F.1 Purpose 50
F.2 Tests during operation 50
F.3 Measures to be taken when the calculated allowable fatigue lifetime has been reached.51
F.3.1 General 51
F.3.2 Testing of vessels and pressure parts at end of life without indicated damages 51
F.3.3 Hydraulic testing of vessels and vessel parts with indicated damages 51

(normative) Specific design requirements 52

Issue 1 (2021-05) G.1 Scope 52

G.2 Design 52
G.2.1 General 52
G.2.2 Cover crown thickness, pressure to convex side 53
G.2.3 Cover crown thickness, pressure to concave side 53
G.2.4 Flange thickness 53

(normative) Experimental cyclic pressure testing procedure 54

H.1 Purpose 54
H.1.1 General 54
H.1.2 Experimental methods and other design methods 54
H.2 Validity 54
H.3 Tests requirements 54
H.3.1 General 54
H.3.2 Number of parts 54
H.3.3 Procedure 55
H.3.4 Material tests 57
H.4 Allowable number of cycles 57

Annex ZA (informative) Relationship between this European Standard and the essential requirements of Directive 2014/68/EU (Pressure equipment Directive) aimed to be covered 61

Bibliography 63