

DIN EN 10242:2026-02 (E)

Threaded pipe fittings in malleable cast iron

Contents		Page
	European foreword	4
1	Scope	5
2	Normative references	5
3	Terms and definitions	6
4	Types of fittings	8
5	Materials	10
5.1	General	10
5.2	Material of the fitting	10
5.2.1	Malleable cast iron	10
5.2.2	Other ferrous materials	10
6	Corrosion protection	10
6.1	General	10
6.2	Hot dip galvanizing	10
6.2.1	General	10
6.2.2	Chemical composition of the hot dip zinc coating	11
6.2.3	Coating mass per surface unit and layer thickness	11
6.2.4	Surface condition of the hot dip zinc coating	11
6.3	Dangerous substances	11
6.3.1	General	11
6.3.2	Hot dip zinc coating	11
6.3.3	Despatch conditions of finished fittings	11
7	Design	12
7.1	General	12
7.2	Design characteristic	12
8	Dimensions and tolerances	12
8.1	Relationship between fitting size and nominal size (DN)	12
8.2	Tolerance of the dimensions	13
8.3	Lengths of engagement	13
8.4	Widths across flats	14
8.4.1	General	14
8.4.2	Design of flats	14
8.4.3	Minimum depth of spanner flats	14
8.5	Reaction to fire	15
9	Threads	15
9.1	Choice of thread	15
9.1.1	Jointing thread	15
9.1.2	Fastening threads	15
9.2	Alignment of threads	15
9.3	Chamfering	15
10	Manufacture	15
11	Required characteristics	15

11.1	Allowable operating pressure and temperature	15
11.2	Design strength	16
11.3	Assembly	16
12	Testing and inspection	17
12.1	Malleable cast iron	17
12.2	Hot dip zinc coating	17
12.3	Threads	17
12.3.1	Jointing threads	17
12.3.2	Fastening threads	17
12.3.3	Alignment	17
12.4	Leak tightness test	17
12.5	Final visual inspection	18
12.6	Acceptance tests for higher performances	18
12.6.1	General	18
12.6.2	Hydrostatic pressure tests	18
12.7	Analysis of polycyclic aromatic hydrocarbons	18
12.8	Inspection documents	18
12.8.1	Quality documentation	18
12.8.2	Product documentation	18
13	Designation of fittings	18
13.1	Elements of the designation for ordering	18
13.2	Additional notes on designation of size	18
13.3	Example of designation	19
14	Marking	20
15	Tables with dimensions	21
	Bibliography	49