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