

DIN 2460:2022-10 (E)

Steel water pipes and fittings

Contents		Page
Foreword		5
1	Scope	7
2	Normative references	7
3	Terms and definitions	9
4	General	11
5	Ordering information	12
5.1	General	12
5.2	Required ordering information for pipes	12
5.3	Required ordering information for fittings	12
5.4	Additional ordering information	12
6	Pipes	14
7	Fittings	14
8	Dimensions and tolerances	14
8.1	General	14
8.2	Outside diameter and wall thickness	14
8.3	Lengths	14
9	Joints for pipes and fittings	15
9.1	General	15
9.2	Pipe ends	15
9.2.1	General	15
9.2.2	Plain ends	15
9.2.3	Bevelled ends	15
9.3	Slip welding joints	15
9.4	Socket joints	15
9.5	Flange joints	15
9.6	Couplings	15
9.7	Other pipe joints	16
10	Linings and internal coatings	16
10.1	Drinking water pipelines	16
10.2	Pipelines for other aqueous fluids	16
11	External coatings	16
11.1	General requirements	16
11.2	Polyethylene external coatings	16
11.3	Polypropylene external coatings	17
11.4	Fibre cement mortar external coatings	17
11.5	Other external coatings	17
12	Inspection documents	17
13	Marking	18

Annex A (normative) Steel grades according to DIN EN Standards	25
Annex B (normative) Static calculation of buried steel pipe	27
B.1 General	27
B.2 Symbols and units	27
B.3 Load assumptions	28
B.3.1 Soil load	28
B.3.2 Traffic loads	29
B.3.3 Total load	30
B.3.4 Lateral soil pressure	30
B.4 Ring stiffness under service conditions	31
B.5 Gravity pipelines, non-pressurized pipelines	31
B.6 Pipe buckling	31
B.7 Pressurized pipelines -- Load case: internal pressure, soil load and traffic load	32
Annex C (normative) Calculation of wall thicknesses of steel pipes for internal pressure	33
C.1 General	33
C.2 Symbols and units	33
C.3 Wall thickness calculation	34
C.4 Explanatory notes on calculations	35
C.5 Design pressure	36
C.6 Maximum permissible stress	36
C.7 Primarily static loading rated up to 120 °C	37
C.8 Dynamic loading rated up to 120 °C	37
C.8.1 General	37
C.8.2 Cycles of constant stress amplitude	39
C.8.3 Cycles of varying stress amplitude	39
C.9 Allowable pressures	40
Annex D (informative) Support span analysis for steel pipes	41
D.1 General	41
D.2 Symbols and units	41
D.3 Calculation of the allowable elastic deflection	42
D.4 Calculation of unsupported span of pipes under operating conditions	42
Annex E (normative) Additional information on the thickness of cement mortar lining	44
Annex F (informative) Information on conformity assessment	45
Bibliography	54
Figure 1 -- Butt weld joint	18
Figure 2 -- Slip welding joint	20
Figure 3 -- Socket joint	21
Figure 4 -- Socket joint, axially force-locking	22
Figure 5 -- Coupling joint with rolled groove pipe end	23
Figure 6 -- Coupling joint with cut groove pipe end	23
Figure B.1 -- Heavy lorry (SLW), bridge class 60/30	29
Figure B.2 -- Heavy lorry (SLW 30)	29
Figure B.3 -- Lorry (LKW 12)	30

Figure C.1 -- Fatigue strength of seamless steel pipes and high frequency welded pipes ($vN = 1$)	38
Figure C.2 -- Fatigue strength of submerged arc-welded pipes ($vN = 1$)	39
Table 1 -- Additional ordering information	13
Table 2 -- Further internal coatings of steel pipes	16
Table 3 -- Further external coatings of steel pipes	17
Table 4 -- Dimensions, mass per unit length and allowable operating pressure of welded and seamless steel pipes for butt weld joints	19
Table 5 -- Dimensions, mass per unit length and allowable operating pressure of welded steel pipes for slip welding joints	20
Table 6 -- Dimensions, mass per unit length and allowable operating pressure of welded steel socket pipes	22
Table 7 -- Dimensions, mass per unit length and allowable operating pressure for welded steel pipes with cut or rolled groove ends	24
Table A.1 -- Comparable steel grades	25
Table A.2 -- Length types, ranges and tolerances	25
Table A.3 -- Random lengths according to DIN EN 10224	25
Table A.4 -- Tolerances for random lengths according to DIN EN ISO 3183 and API SPEC 5L	26
Table A.5 -- Tolerances on exact lengths	26
Table B.1 -- Symbols, design parameters and units	27
Table B.2 -- Specific gravity and friction angle of various soil types	28
Table B.3 -- Impact factors for standard vehicles	30
Table C.1 -- Symbols, design parameters, units	33
Table C.2 -- Determination of the design wall thickness s_v	34
Table C.3 -- Maximum number of load cycles for seamless steel pipes and high frequency welded steel pipes ($vN = 1$) (determined with $SL = 10$ from Figure C.1 in Clause C.8)	36
Table C.4 -- Maximum number of load cycles for submerged arc-welded steel pipes ($vN = 1$) (determined with $SL = 10$ from Figure C.2 in Clause C.8)	37
Table D.1 -- Symbols, design parameters, units	41
Table E.1 -- Thicknesses of cement mortar lining	44
Table F.1 -- Initial type testing, factory production control and third party inspection; scope and frequencies of tests/inspections/verifications	45