DIN EN 488:2016-02 (E)

District heating pipes - Preinsulated bonded pipe systems f or directly buried hot water networks - Steel valve assembly for steel service pipes, polyurethane thermal insulation and outer casing of polyethylene

Contents

Page

European foreword 4

Introduction 5

1 Scope 6

2 Normative references 6

3 Terms and definitions 7

4 Requirements 8
4.1 Pressure ratings for valves 8
4.1.1 General 8
4.1.2 Valves without indicated flow direction 8
4.2 Service temperatures for valves 9
4.3 Steel parts 9
4.3.1 General 9
4.3.2 Valve 9
4.3.3 Valve extension pipe 9
4.3.4 Welding ends 9
4.3.5 Welding of steel parts 9
4.4 Casing 9
4.4.1 General 9
4.4.2 Requirements for polyethylene welding 9
4.4.3 Diameter and wall thickness of the casing 10
4.5 Polyurethane rigid foam insulation (PUR) 10
4.5.1 General 10
4.5.2 Minimum insulation thickness 10
4.6 Valve assembly 10
4.6.1 Ends of valve assembly 10
4.6.2 End of stem construction 10
4.6.3 Main dimensions of the valve assembly 11
4.6.4 Installation of measuring elements 12
4.7 Requirements for effective operation and maintenance 12
4.8 Resistance to axial forces and bending moments 12

5 Testing, test methods and test requirements 13
5.1 General 13
5.2 Test specimens 13
5.2.1 General 13
5.2.2 Test specimens for type testing steel parts of valve 13
5.2.3 Test specimens from casings and polyurethane foam 13
5.3 Steel parts 13
5.3.1 General 13
5.3.2 Type test of the steel parts 13
5.3.3 Production testing of valves 17
5.4 Casing 18
5.4.1 General 18
5.4.2 Leak-tightness of the welded casing 18

5.5 Polyurethane rigid foam insulation 18
5.6 Valve assembly 18
5.7 Surveillance system 18

6 Marking 18
6.1 General 18
6.2 Steel valve 18
6.3 Casing 18
6.4 Valve assembly 19

7 Installation and maintenance 19

Annex A (informative) Guidelines for inspection and testing 20

A.1 General 20
A.2 Manufacturer's type test 20
A.3 Manufacturer's quality control 20
A.4 External inspection 20
A.5 Extent of inspection 20
A.6 Manufacturer's responsibility 20

Annex B (normative) Resistance to axial force and bending moment 22

B.1 Axial strength test 22
B.2 Bending test 22

Annex C (normative) Resistance to bending forces 24

C.1 General 24
C.2 Standard test assembly (four point bending test) 25

Bibliography 29