

DIN EN 15698-1:2025-07 (E)

District heating pipes - Bonded twin pipe systems for directly buried hot water networks - Part 1: Factory made twin pipe assembly of steel service pipes, polyurethane thermal insulation and one casing of polyethylene

Contents		Page
European foreword		4
Introduction		5
1	Scope	6
2	Normative references	6
3	Terms and definitions	6
4	Requirements	6
4.1	Steel service pipe	6
4.1.1	Specification	6
4.1.2	Diameter and wall thickness	7
4.1.3	Surface condition	7
4.2	Casing	7
4.3	Polyurethane foam thermal insulation	7
4.4	Twin pipe assembly	7
4.4.1	General	7
4.4.2	Thermal insulation series	7
Table 1 --	Casing diameters	8
4.4.3	End alignment of flow and return steel service pipes	8
4.4.4	Distance between flow and return steel service pipes	8
Table 2 --	Distance between steel service pipes	9
4.4.5	Twisting of steel service pipes	9
Figure 1 --	Twisting, w, and distance between steel service pipes, Lp	10
4.4.6	Centre line deviation	10
Table 3 --	Centre line deviation related to nominal outside diameters	10
4.4.7	Ends of twin pipe assembly	10
4.4.8	Expected thermal life and long-term temperature resistance	11
4.4.9	Axial shear strength	11
4.4.10	Thermal conductivity in unaged condition	11
4.4.11	Impact resistance	11
4.4.12	Surface conditions at delivery	11
4.4.13	Linear water tightness	11
4.4.14	Measuring wires for surveillance systems	11
5	Test methods	11
5.1	General	11
5.2	Test specimens	11
Figure 2 --	Areas for test specimens	12
5.3	Polyurethane foam thermal insulation	12
5.4	Twin pipe assembly	12
5.4.1	Axial shear strength	12

Figure 3 -- Axial shear test arrangement	13
5.4.2 Expected thermal life and long-term temperature resistance	14
5.4.3 Thermal conductivity in unaged condition	14
5.4.4 Thermal conductivity at artificially aged condition	14
5.4.5 Impact resistance	14
5.4.6 Linear water tightness	14
6 Marking	14
Annex A (informative) Guidelines for inspection and testing	15
A.1 General	15
A.2 Manufacturer's type test	15
A.3 Manufacturer's quality control	15
A.4 Additional inspection	15
Table A.1 -- Twin pipe assembly inspection	16
Annex B (informative) Waste treatment and recycling	17
Bibliography	18