ISO 15590-1:2024-07 (E)

Oil and gas industries including lower carbon energy - Factory bends, fittings and flanges for pipeline transportation systems - Part 1: Induction bends

Contents

Page

Foreword ..... **v**

1 Scope **1**

2 Normative references **1**

3 Terms and definitions **2**

4 Symbols and abbreviated terms **5**
4.1 Symbols 5
4.2 Abbreviated terms 6

5 General requirements **6**
5.1 Units of measurement 6
5.2 Rounding 6
5.3 Conformity to this document 6

6 Designation **7**

7 Pressure rating and design **7**

8 Purchaser-supplied information **8**
8.1 General information 8
8.2 Additional information 9
8.3 Information on the mother pipe 9

9 Manufacturing **10**
9.1 Mother pipe 10
9.2 Qualification test bend 10
9.3 Production bending 11
9.4 Post-bending heat treatment 11
9.5 Forming and sizing after bending 11
9.6 Strip/plate end welds 12
9.7 Jointers and girth welds 12
9.8 End preparation 12

10 Testing and inspection **12**
10.1 General requirements 12
10.2 Extent of testing and inspection 13
10.2.1 Qualification test bend 13
10.2.2 Production bends 13
10.2.3 Production test bends 13
10.3 Chemical composition 13
10.4 Physical testing 13
10.4.1 Test pieces — General 13
10.4.2 Tensile testing 13
10.4.3 Charpy V-notch impact testing 18
10.4.4 Through-thickness hardness testing 20
10.4.5 Surface hardness testing 20
10.4.6 Metallographic examination 20
10.4.7 Crack tip opening displacement testing 21
10.4.8 Guided bend testing 21
10.4.9 Flattening tests 21
10.4.10 Retesting 21
10.5 Non-destructive testing 22

10.5.1 General 22
10.5.2 Visual inspection 22
10.5.3 Weld seam testing 22
10.5.4 Inspection of bend ends 23
10.5.5 Magnetic particle testing or liquid-penetrant testing on the bend body 23
10.5.6 Ultrasonic testing on the bend body 23
10.5.7 Level of residual magnetism 23
10.5.8 Repairs 23
10.5.9 NDT personnel 23
10.6 Dimensions 23
10.7 Gauging 28
10.8 Hydrostatic testing 28
11 Inspection document **28**
12 Marking **28**
Annex A (normative) **Manufacturing procedure specification (MPS)** **29**
Annex B (normative) **PSL 2S bends ordered for sour service** **31**
Bibliography **35**