

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 |