

DIN EN 13445-4:2010-12 (E)

Unfired pressure vessels - Part 4: Fabrication

| Contents | | Page |
|-----------------|--|-------------|
| Foreword | | 4 |
| 1 | Scope | 5 |
| 2 | Normative references | 5 |
| 3 | Requirements for manufacturing and subcontracting | 7 |
| 3.1 | Manufacturing | 7 |
| 3.2 | Subcontracting | 7 |
| 4 | Materials | 8 |
| 4.1 | General | 8 |
| 4.2 | Material traceability | 8 |
| 4.2.1 | General | 8 |
| 4.2.2 | Identification system | 8 |
| 4.2.3 | Visibility | 9 |
| 4.2.4 | Review of material certification and material identification | 9 |
| 4.2.5 | Transfer of markings | 9 |
| 5 | Manufacturing tolerances | 9 |
| 5.1 | Surface geometry of welds | 9 |
| 5.2 | Middle line alignment | 9 |
| 5.3 | Surface alignment | 11 |
| 5.3.1 | Surface misalignment between parts | 11 |
| 5.3.2 | Joining of parts of different thickness | 11 |
| 5.4 | Tolerances for vessels subjected to internal pressure | 11 |
| 5.4.1 | External diameter | 11 |
| 5.4.2 | Out of roundness | 11 |
| 5.4.3 | Deviation from the longitudinal axis | 12 |
| 5.4.4 | Irregularities in profile | 12 |
| 5.4.5 | Local thinning | 14 |
| 5.4.5 | Dished ends | 15 |
| 5.5 | Tolerances for vessels subjected to external pressure | 17 |
| 5.6 | Structural tolerances | 17 |
| 6 | Weld details | 17 |
| 6.1 | General | 17 |
| 6.2 | Vessels or parts made of more than one course | 17 |
| 6.3 | Lapped joints, joggle joints, permanent backing strips | 17 |
| 7 | Welding | 17 |
| 7.1 | General | 17 |
| 7.2 | Welding procedure specification (WPS) | 18 |
| 7.3 | Qualification of welding procedure specifications (WPAR) | 18 |
| 7.4 | Qualification of welders and welding operators | 19 |
| 7.5 | Filler metals and auxiliary materials | 19 |
| 7.6 | Joint preparation | 19 |
| 7.7 | Execution of welded joints | 20 |
| 7.8 | Attachments, supports and stiffeners | 20 |
| 7.9 | Preheat | 21 |
| 8 | Manufacture and testing of welds -- Production test | 21 |

| | | |
|--|--|----|
| 8.1 | General | 21 |
| 8.2 | Reference criteria | 21 |
| 8.3 | Extent of testing | 25 |
| 8.4 | Performance of tests and acceptance criteria | 27 |
| 8.4.1 | General | 27 |
| 8.4.2 | Transverse tensile test | 27 |
| Issue 2 (2010-07) 8.4.3 Longitudinal weld tensile test | | 27 |
| 8.4.4 | Impact test | 27 |
| 8.4.5 | Bend test | 27 |
| 8.4.6 | Macro examination | 28 |
| 8.4.7 | Micro examination | 28 |
| 8.4.8 | Hardness test | 28 |
| 8.4.9 | Retests | 28 |
| 8.4.10 | Test report | 29 |
| 9 | Forming of pressure parts | 29 |
| 9.1 | General | 29 |
| 9.2 | Ratio of deformation | 29 |
| 9.2.1 | Dished circular products | 29 |
| 9.2.2 | Cylinders and cones made by rolling | 30 |
| 9.2.3 | Other product types | 31 |
| 9.2.4 | Tube bends | 32 |
| 9.2.5 | Forming of Segments | 32 |
| 9.3 | Forming procedures | 33 |
| 9.3.1 | Cold forming | 33 |
| 9.3.2 | Hot forming | 33 |
| 9.4 | Heat treatment after forming | 36 |
| 9.4.1 | General | 36 |
| 9.4.2 | Heat treatment of flat products after cold forming | 36 |
| 9.4.3 | Heat treatment of tubular products after cold forming | 38 |
| 9.4.4 | Heat treatment of clad steels after cold forming | 38 |
| 9.4.5 | Heat treatment after hot forming | 38 |
| 9.4.6 | Heat treatment of clad steels after hot forming | 39 |
| 9.5 | Sampling of formed test coupons | 39 |
| 9.5.1 | Cold formed products without heat treatment | 39 |
| 9.5.2 | Hot formed or cold formed products with heat treatment | 39 |
| 9.6 | Tests | 40 |
| 9.6.1 | Base material | 40 |
| 9.6.2 | Butt welds | 40 |
| 9.6.3 | Acceptance criteria for formed test coupons | 41 |
| 9.6.4 | Retests of formed coupons | 41 |
| 9.7 | Visual inspection and control of dimension | 41 |
| 9.8 | Marking | 42 |
| 9.9 | Documentation | 42 |
| 10 | Post weld heat treatment (PWHT) | 42 |
| 10.1 | General | 42 |
| 10.2 | Heat treatment conditions | 43 |
| 10.3 | Method of PWHT | 45 |
| 10.4 | PWHT procedure | 46 |
| 10.5 | Mechanical properties after heat treatment | 46 |
| 10.6 | Dissimilar ferritic joints | 47 |
| 10.7 | Special materials | 48 |
| 11 | Repairs | 48 |
| 11.1 | Repairs of surface defects in the parent metal | 49 |
| 11.2 | Repair of weld defects | 49 |
| 12 | Finishing operations | 49 |
| Annex A (informative) Structural tolerances | | 51 |

Annex B (informative) Example of a sub-contractors form 55

Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of the EU Pressure Equipment Directive 97/23/EC 57

Bibliography 58