

DIN EN 14917:2022-02 (E)

Metal bellows expansion joints for pressure applications

Contents		Page
	European foreword	7
1	Scope	10
2	Normative references	10
3	Terms and definitions	14
4	Classification	17
4.1	Classification of expansion joints	17
4.1.1	General	17
4.1.2	Axial	17
4.1.3	Angular	17
4.1.4	Lateral	17
4.1.5	Universal	17
4.1.6	Pressure balanced designs (axial or universal)	17
4.2	Classification of the parts of expansion joints	20
4.2.1	Main pressure-bearing parts (A)	20
4.2.2	Pressure parts other than main pressure-bearing parts (B)	20
4.2.3	Attachments to main pressure-bearing parts and to pressure parts (C)	20
4.2.4	Other parts (D)	20
5	Materials	22
5.1	General	22
5.1.1	Materials for pressure-bearing parts	22
5.1.2	Materials for parts attached to pressure-bearing parts	22
5.1.3	Materials for non-pressure parts	22
5.2	Pressure-bearing parts	22
5.2.1	Bellows	22
5.2.2	Other pressure-bearing parts	22
5.2.3	Ductility	23
5.2.4	Brittle fracture	23
5.3	Material documentation	27
6	Design	28
6.1	General	28
6.1.1	Symbols	28
6.1.2	Basic design criteria	34
6.1.3	Allowable stresses	34
6.1.4	Additional loadings	37
6.2	Bellows design	38
6.2.1	Purpose	38
6.2.2	Conditions of applicability	38
6.2.3	Design of U-shaped unreinforced bellows	56
6.2.4	Design of U-shaped reinforced bellows	72
6.2.5	Design of toroidal bellows	75
6.2.6	Fatigue	82
6.2.7	Bellows under the influence of movements	87
6.2.8	Equivalent axial displacement per corrugation	92
6.2.9	Forces and moments on pressurized expansion joints	97
6.2.10	Torsion acting on bellows (unreinforced or reinforced)	108
6.3	Internal sleeve	109

6.3.1	Scope	109
6.3.2	Additional symbols	109
6.3.3	Flow velocity	109
6.3.4	Design conditions	112
6.4	Hardware	113
6.4.1	General	113
6.4.2	Design parameters	113
6.4.3	Hardware parts	115
6.4.4	Permanent joints	116
7	Manufacturing	118
7.1	General	118
7.2	Materials	118
7.2.1	General	118
7.2.2	Material traceability	118
7.3	Permanent joints	119
7.3.1	General	119
7.3.2	Process and personal	119
7.3.3	Repair and rework during manufacturing	120
7.4	Forming of the bellows	120
7.4.1	Forming processes	120
7.4.2	Heat treatment	121
7.5	Tolerances	122
7.5.1	General	122
7.5.2	Bellows	122
7.5.3	Expansion joint	123
7.6	Production tests	123
8	Testing, inspection and documentation	124
8.1	General	124
8.2	Abbreviations	124
8.3	Documents	124
8.4	In-process inspection and testing	125
8.4.1	General	125
8.4.2	Materials	125
8.4.3	Permanent joints	125
8.4.4	Non-destructive testing of welds	127
8.5	NDT methods	134
8.5.1	Quality level	134
8.5.2	Acceptance levels and testing techniques	134
8.5.3	Non-destructive testing Personnel qualifications and approval	135
8.5.4	Non-destructive testing documentation	135
8.6	Final assessment and documentation	137
8.6.1	General	137
8.6.2	Final inspection	138
8.7	Documentation	140
8.7.1	Final documentation package	140
8.7.2	Declaration/certification	140
8.7.3	Operating instructions	141
9	Marking and labelling	141
10	Handling and installation	141
10.1	General instructions	141
10.2	Packaging and storage	142
10.3	Installation	142
10.4	Unrestrained expansion joints	142
10.5	Restrained expansions joints	142
Annex A (informative)	Categories of expansion joints	143
A.1	General	143

A.2	Determination of expansion joints categories	143
A.3	Fluid groups	143
A.3.1	General	143
A.3.2	Group 1	143
A.3.3	Group 2	144
A.4	Technical requirements	144
A.4.1	Expansion joints for vessels	144
A.4.2	Expansion joints for piping	144
A.4.3	Sound engineering practice (SEP)	145
A.5	Expansion joint category	145
Annex B (informative) Specification for materials 1.4828, 1.4876, 2.4360 and 2.4858		147
Annex C (informative) Incorporation of expansion joints into piping or pressure vessels		154
C.1	General	154
C.2	Specific symbols and definitions	155
C.3	Application criteria for expansion joints in piping	156
C.3.1	General	156
C.3.2	Use of axial expansion joints	156
C.3.3	Use of restraint expansion joints	162
C.3.4	Use of universal expansion joints	168
C.3.5	Indeterminate configurations of expansion joints	170
C.4	Application criteria for expansion joints in pressure vessels	173
C.4.1	General	173
C.4.2	Axial expansion joint installed in the shell	173
C.4.3	Axial expansion joint installed at the floating head	174
Annex D (informative) Calculation methods for systems of pipes containing expansion joints		175
D.1	General	175
D.1.1	Preliminary remarks	175
D.1.2	Determining movement values	175
D.1.3	Thermal expansion	175
D.2	Approximate calculation of bellows movement	177
D.2.1	General	177
D.2.2	Hinged systems	178
D.2.3	Definitions	178
D.3	Exact calculation of bellows movement	182
D.3.1	Two hinges in a plane system (Z-system)	182
D.3.2	Two gimbals in a three-dimensional system (Z-system)	183
D.3.3	Three hinges in a plane system (U-system)	184
D.3.4	Three hinges in a plane system (L-system)	185
D.3.5	Three hinges in a three-dimensional system (Z-system)	187
D.4	Calculation of forces and moments	190
Annex E (informative) Explanatory notes on the design of expansion bellows		191
E.1	General	191
E.2	Calculation design	191
E.3	Types of bellows	192
E.3.1	Corrugation shape	192
E.3.2	Number of plies	192
E.4	Fatigue life expectancy	192
E.5	Instability	193
E.5.1	General	193
E.5.2	Column instability	193
E.5.3	In-plane instability	193
E.5.4	Buckling	193
E.6	Bellows spring rate	194
Annex F (informative) Procedure for setting-up a design fatigue curve		196

F.1	General	196
F.2	Procedure for setting up a design fatigue curve for expansion bellows	196
F.2.1	General	196
F.2.2	Number of tests	196
F.2.3	Extrapolation range	196
F.2.4	Manufacturing methods	196
F.2.5	Bellows material	197
F.3	Tests	197
F.3.1	Movement	197
F.3.2	Test pressure	197
F.3.3	Other test conditions	197
F.3.4	Fatigue test equipment	198
F.4	Evaluation of the test results	199
F.5	Linear regression	204
Annex G (informative) Polynomial approximations for coefficients C_p , C_f , C_d		205
G.1	Coefficient C_p	205
G.2	Coefficient C_f	206
G.3	Coefficient C_d	207
G.4	Linear interpolation	208
Annex H (informative) Required design data and information		210
H.1	Required design conditions	210
H.2	Additional information	210
Annex I (informative) Expansion joints risk analyses		211
Annex J (informative) Additional material properties		212
Annex K (normative) Hardware calculation		217
K.1	General	217
K.2	Additional symbols	217
K.3	Force due to pressure	220
K.4	Tie bar	221
K.4.1	General	221
K.4.2	Tie bar in tension	221
K.4.3	Tie bar in compression	222
K.5	Pin	222
K.6	Lug with bore	225
K.6.1	General	225
K.6.2	Forces due to pressure	225
K.6.3	Stresses due to reaction force	226
K.7	Gimbal, square and round	227
K.7.1	General	227
K.7.2	Stresses in bored section	227
K.7.3	Square type gimbal	228
K.7.4	Round type gimbal	231
K.8	Attachment plate	233
K.8.1	Attachment plate (closed/open) with 2 restraining parts	233
K.8.2	Circular attachment plate with 3 or more tie bars valid up to DN 800	241
K.9	Lug-plate connection (hinge/gimbal)	244
K.9.1	General	244
K.9.2	Lug-plate for form-lock connection	245
K.9.3	Lug-plate for welded buttonhole connection	248
K.10	Tie bar and lug attachment on flanges	249
K.10.1	Integral flange	249
K.10.2	Plate welded on flange	253
K.11	Gusset	256

K.12	Gusset with reinforcing rings	256
K.12.1	General	256
K.12.2	Basic definitions	258
K.12.3	Stresses in the gussets	259
K.12.4	Stresses in the ring and pipe	259
K.12.5	Stresses in welds a7, a8 and a9	260
Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of EU Directive 2014/68/EU		262
Bibliography		264