

DIN EN 13445-6:2021-12 (E)

Unfired pressure vessels - Part 6: Requirements for the design and fabrication of pressure vessels and pressure parts constructed from spheroidal graphite cast iron

| Contents | | Page |
|-------------------------|--|-------------|
| European foreword | | 5 |
| 1 | Scope | 6 |
| 2 | Normative references | 6 |
| 3 | Terms, definitions units and symbols | 7 |
| 3.1 | Terms and definitions | 7 |
| 3.2 | Units | 9 |
| 3.3 | Symbols | 9 |
| 3.4 | Inter-relation of thicknesses definitions | 11 |
| 4 | Service conditions | 11 |
| 4.1 | Cyclic loading | 11 |
| 4.2 | Limitations on temperature and energy content | 12 |
| 5 | Requirements | 12 |
| 5.1 | Materials | 12 |
| 5.2 | Design | 14 |
| 5.2.1 | Technical documentation | 14 |
| 5.2.2 | Design methods | 14 |
| 5.3 | Founding | 21 |
| 5.3.1 | General | 21 |
| 5.3.2 | Welding | 21 |
| 6 | Material testing | 21 |
| 6.1 | General | 21 |
| 6.2 | Frequency and number of tests | 21 |
| 6.3 | Chemical analysis | 22 |
| 6.4 | Graphite structure | 22 |
| 6.5 | Inspection documents | 22 |
| 7 | Testing and final assessment | 22 |
| 7.1 | Testing | 22 |
| 7.1.1 | General | 22 |
| 7.1.2 | Testing requirements for CQ = 0,8 | 23 |
| 7.1.3 | Testing requirements for CQ = 0,9 | 23 |
| 7.1.4 | Surface imperfections | 24 |
| 7.1.5 | Cracks, laps, cold shut and non-fused chaplets | 24 |
| 7.1.6 | Ultrasonic testing and/or sectioning | 24 |
| 7.1.7 | Magnetic particle testing (only for ferritic grades) | 24 |
| 7.1.8 | Penetrant testing | 25 |
| 7.1.9 | Radiographic testing | 25 |
| 7.1.10 | Surface roughness | 25 |
| 7.1.11 | Minimum wall thickness | 25 |
| 7.1.12 | Wall thickness tolerances | 25 |
| 7.1.13 | Other dimensions | 25 |
| 7.1.14 | Qualification of testing personnel | 26 |
| 7.2 | Final assessment | 26 |
| 7.2.1 | General | 26 |
| 7.2.2 | Hydraulic test pressure | 26 |

| | | |
|-------|---|----|
| 8 | Pressure vessels constructed of a combination of parts in different materials | 26 |
| 9 | Marking and documentation | 26 |
| 9.1 | Marking of castings | 26 |
| 9.2 | Name plate for the complete pressure vessel | 27 |
| 9.3 | Documentation | 27 |
| | (normative) Technical data for the design calculations | 28 |
| A.1 | Purpose | 28 |
| A.2 | Technical data | 28 |
| A.2.1 | Ferritic spheroidal graphite cast iron according to EN 1563:2018 | 28 |
| A.2.2 | Austenitic spheroidal graphite cast iron according to EN 13835:2012 | 29 |
| | (informative) Ductility | 30 |
| | (informative) Determination of the minimum local wall thickness and minimum required burst test pressure | 32 |
| | (normative) Assessment of fatigue life | 34 |
| D.1 | Purpose | 34 |
| D.2 | Specific definitions | 34 |
| D.3 | Specific symbols and abbreviations | 34 |
| D.4 | Limitations | 35 |
| D.5 | General | 35 |
| D.6 | Simplified fatigue assessment | 35 |
| D.6.1 | Pseudo-elastic stress range | 35 |
| D.6.2 | Correction factors | 36 |
| D.6.3 | Fatigue design curves | 37 |
| D.6.4 | Allowable number of cycles | 43 |
| D.6.5 | Allowable stress range | 43 |
| D.7 | Detailed fatigue assessment | 43 |
| D.7.1 | Pseudo-elastic stress ranges | 43 |
| D.7.2 | Corrections to stress range | 44 |
| D.7.3 | Fatigue design curves | 45 |
| D.7.4 | Allowable number of cycles | 46 |
| D.7.5 | Allowable stress range | 47 |
| D.8 | Assessment rule for total fatigue damage | 47 |
| D.9 | Repairs of surface imperfections | 47 |
| | (normative) Design by analysis for castings | 48 |
| E.1 | Introduction | 48 |
| E.2 | Special requirements to EN 13445-3:2021, Annex B | 48 |
| E.2.1 | Addition to B.8.2.3: Design checks for normal operating load cases | 48 |
| E.2.2 | Addition to B.8.2.4: Design checks for testing load cases | 48 |
| E.3 | Additions to EN 13445-3:2021, Annex C | 48 |
| E.4 | Requirements | 49 |
| | (informative) Recommendations for in-service validation and inspection | 50 |
| F.1 | Purpose | 50 |
| F.2 | Tests during operation | 50 |
| F.3 | Measures to be taken when the calculated allowable fatigue lifetime has been reached.51 | |
| | F.3.1 General | 51 |
| F.3.2 | Testing of vessels and pressure parts at end of life without indicated damages | 51 |
| F.3.3 | Hydraulic testing of vessels and vessel parts with indicated damages | 51 |
| | (normative) Specific design requirements | 52 |

| | |
|---|-----------|
| Issue 1 (2021-05) G.1 Scope | 52 |
| G.2 Design | 52 |
| G.2.1 General | 52 |
| G.2.2 Cover crown thickness, pressure to convex side | 53 |
| G.2.3 Cover crown thickness, pressure to concave side | 53 |
| G.2.4 Flange thickness | 53 |
| (normative) Experimental cyclic pressure testing procedure | 54 |
| H.1 Purpose | 54 |
| H.1.1 General | 54 |
| H.1.2 Experimental methods and other design methods | 54 |
| H.2 Validity | 54 |
| H.3 Tests requirements | 54 |
| H.3.1 General | 54 |
| H.3.2 Number of parts | 54 |
| H.3.3 Procedure | 55 |
| H.3.4 Material tests | 57 |
| H.4 Allowable number of cycles | 57 |
| Annex ZA (informative) Relationship between this European Standard and the essential requirements of Directive 2014/68/EU (Pressure equipment Directive) aimed to be covered | 61 |
| Bibliography | 63 |