

# DIN EN 15542:2008-06 (E)

## Ductile iron pipes, fittings and accessories - External cement mortar coating for pipes - Requirements and test methods

---

<b>Contents</b>		<b>Page</b>
Foreword .....		4
Introduction .....		5
1	Scope .....	6
2	Normative references .....	6
3	Terms and definitions .....	7
4	Ordering information .....	8
5	Technical requirements .....	8
5.1	Zinc coating .....	8
5.2	Primer film thickness .....	8
5.3	Fresh cement mortar composition .....	8
5.4	Fresh cement mortar layer thickness .....	9
5.5	Pipe ends .....	9
5.6	Appearance of cured cement mortar coating .....	9
5.7	Thickness of cured cement mortar coating .....	9
5.8	Repairs .....	10
5.9	Marking .....	10
6	Performance requirements .....	10
6.1	Cement mortar Constituents .....	10
6.1.1	Cement .....	10
6.1.2	Sand .....	10
6.1.3	Fibres .....	10
6.1.4	Surface tissue .....	10
6.1.5	Organic components .....	11
6.2	Bond strength .....	11
6.3	Impact resistance .....	11
7	Test methods .....	11
7.1	Routine tests .....	11
7.1.1	Zinc coating .....	11
7.1.2	Primer .....	11
7.1.3	Fresh cement mortar composition .....	11
7.1.4	Thickness of the cement mortar layer .....	11
7.1.5	Pipe ends .....	11
7.1.6	Appearance and continuity of cured cement mortar coating .....	12
7.1.7	Thickness of the cured cement mortar coating .....	12
7.1.8	Repairs .....	12
7.1.9	Marking .....	12
7.2	Performance tests .....	12
7.2.1	Constituents .....	12
7.2.2	Bond strength .....	13
7.2.3	Impact strength .....	13
Annex A (informative)	Quality assurance .....	14

<b>A.1</b>	<b>General</b> .....	<b>14</b>
<b>A.2</b>	<b>Performance test</b> .....	<b>15</b>
<b>A.3</b>	<b>Quality assessment system</b> .....	<b>16</b>
<b>Annex B (informative) Application process</b> .....		<b>17</b>
<b>B.1</b>	<b>Coating process</b> .....	<b>17</b>
<b>B.1.1</b>	<b>Temperature during work</b> .....	<b>17</b>
<b>B.1.2</b>	<b>Application of zinc coating</b> .....	<b>17</b>
<b>B.1.3</b>	<b>Application of primer</b> .....	<b>17</b>
<b>B.2</b>	<b>Application of cement mortar</b> .....	<b>17</b>
<b>B.2.1</b>	<b>Application with primer</b> .....	<b>17</b>
<b>B.2.2</b>	<b>Application without primer</b> .....	<b>17</b>
<b>Annex C (informative) Explanatory notes</b> .....		<b>18</b>
<b>Annex D (informative) Calculation of fresh cement mortar composition</b> .....		<b>19</b>
<b>D.1</b>	<b>General</b> .....	<b>19</b>
<b>D.2</b>	<b>Sampling</b> .....	<b>19</b>
<b>D.3</b>	<b>Determination of the content of sand and fibres</b> .....	<b>19</b>
<b>D.4</b>	<b>Determination of the fibre content</b> .....	<b>20</b>
<b>Bibliography</b> .....		<b>21</b>