DIN 2460:2022-10 (E)

Steel water pipes and fittings

Contents

Page

Foreword 5

1 Scope 7

2 Normative references 7

3 Terms and definitions 9

4 General 11

5 Ordering information 12
5.1 General 12
5.2 Required ordering information for pipes 12
5.3 Required ordering information for fittings 12
5.4 Additional ordering information 12

6 Pipes 14

7 Fittings 14

8 Dimensions and tolerances 14
8.1 General 14
8.2 Outside diameter and wall thickness 14
8.3 Lengths 14

9 Joints for pipes and fittings 15
9.1 General 15
9.2 Pipe ends 15
9.2.1 General 15
9.2.2 Plain ends 15
9.2.3 Bevelled ends 15
9.3 Slip welding joints 15
9.4 Socket joints 15
9.5 Flange joints 15
9.6 Couplings 15
9.7 Other pipe joints 16

10 Linings and internal coatings 16
10.1 Drinking water pipelines 16
10.2 Pipelines for other aqueous fluids 16

11 External coatings 16
11.1 General requirements 16
11.2 Polyethylene external coatings 16
11.3 Polypropylene external coatings 17
11.4 Fibre cement mortar external coatings 17
11.5 Other external coatings 17

12 Inspection documents 17

13 Marking 18

Annex A (normative) Steel grades according to DIN EN Standards ... 25

Annex B (normative) Static calculation of buried steel pipe ... 27

B.1 General ... 27
B.2 Symbols and units ... 27
B.3 Load assumptions ... 28
B.3.1 Soil load ... 28
B.3.2 Traffic loads ... 29
B.3.3 Total load ... 30
B.3.4 Lateral soil pressure ... 30
B.4 Ring stiffness under service conditions ... 31
B.5 Gravity pipelines, non-pressurized pipelines ... 31
B.6 Pipe buckling ... 31
B.7 Pressurized pipelines -- Load case: internal pressure, soil load and traffic load ... 32

Annex C (normative) Calculation of wall thicknesses of steel pipes for internal pressure ... 33

C.1 General ... 33
C.2 Symbols and units ... 33
C.3 Wall thickness calculation ... 34
C.4 Explanatory notes on calculations ... 35
C.5 Design pressure ... 36
C.6 Maximum permissible stress ... 36
C.7 Primarily static loading rated up to 120 °C ... 37
C.8 Dynamic loading rated up to 120 °C ... 37
C.8.1 General ... 37
C.8.2 Cycles of constant stress amplitude ... 39
C.8.3 Cycles of varying stress amplitude ... 39
C.9 Allowable pressures ... 40

Annex D (informative) Support span analysis for steel pipes ... 41

D.1 General ... 41
D.2 Symbols and units ... 41
D.3 Calculation of the allowable elastic deflection ... 42
D.4 Calculation of unsupported span of pipes under operating conditions ... 42

Annex E (normative) Additional information on the thickness of cement mortar lining ... 44

Annex F (informative) Information on conformity assessment ... 45

Bibliography ... 54

Figure 1 -- Butt weld joint ... 18

Figure 2 -- Slip welding joint ... 20

Figure 3 -- Socket joint ... 21

Figure 4 -- Socket joint, axially force-locking ... 22

Figure 5 -- Coupling joint with rolled groove pipe end ... 23

Figure 6 -- Coupling joint with cut groove pipe end ... 23

Figure B.1 -- Heavy lorry (SLW), bridge class 60/30 ... 29

Figure B.2 -- Heavy lorry (SLW 30) ... 29

Figure B.3 -- Lorry (LKW 12) ... 30

Figure C.1 -- Fatigue strength of seamless steel pipes and high frequency welded pipes (vN = 1) 38

Figure C.2 -- Fatigue strength of submerged arc-welded pipes (vN = 1) 39

Table 1 -- Additional ordering information 13

Table 2 -- Further internal coatings of steel pipes 16

Table 3 -- Further external coatings of steel pipes 17

Table 4 -- Dimensions, mass per unit length and allowable operating pressure of welded and seamless steel pipes for butt weld joints 19

Table 5 -- Dimensions, mass per unit length and allowable operating pressure of welded steel pipes for slip welding joints 20

Table 6 -- Dimensions, mass per unit length and allowable operating pressure of welded steel socket pipes 22

Table 7 -- Dimensions, mass per unit length and allowable operating pressure for welded steel pipes with cut or rolled groove ends 24

Table A.1 -- Comparable steel grades 25

Table A.2 -- Length types, ranges and tolerances 25

Table A.3 -- Random lengths according to DIN EN 10224 25

Table A.4 -- Tolerances for random lengths according to DIN EN ISO 3183 and API SPEC 5L 26

Table A.5 -- Tolerances on exact lengths 26

Table B.1 -- Symbols, design parameters and units 27

Table B.2 -- Specific gravity and friction angle of various soil types 28

Table B.3 -- Impact factors for standard vehicles 30

Table C.1 -- Symbols, design parameters, units 33

Table C.2 -- Determination of the design wall thickness sv 34

Table C.3 -- Maximum number of load cycles for seamless steel pipes and high frequency welded steel pipes (vN = 1) (determined with SL = 10 from Figure C.1 in Clause C.8) 36

Table C.4 -- Maximum number of load cycles for submerged arc-welded steel pipes (vN = 1) (determined with SL = 10 from Figure C.2 in Clause C.8) 37

Table D.1 -- Symbols, design parameters, units 41

Table E.1 -- Thicknesses of cement mortar lining 44

Table F.1 -- Initial type testing, factory production control and third party inspection; scope and frequencies of tests/inspections/verifications 45