ISO 15590-2:2021 (E)

Petroleum and natural gas industries — Factory bends, fittings and flanges for pipeline transportation systems — Part 2: Fittings

Contents

Foreword

Introduction

1 Scope

2 Normative references

3 Terms and definitions

4 Symbols and abbreviated terms

4.1 Symbols
4.2 Abbreviated terms

5 Designation of fittings

6 Pressure rating and design

6.1 General
6.2 Tees

7 Information to be supplied by the purchaser

7.1 General information
7.2 Additional information

8 Manufacturing

8.1 Manufacturing procedure specification
8.2 Starting material
8.3 Fitting manufacture
8.3.1 Forming
8.3.2 Welding
8.3.3 Heat treatment
8.3.4 End preparation

9 Testing and inspection

9.1 General requirements
9.2 Extent of testing and inspection
9.3 Chemical composition
9.4 Mechanical testing
9.4.1 Preparation of test pieces
9.4.2 Tensile testing
9.4.2.1 Test pieces
9.4.2.2 Test method
9.4.2.3 Requirements
9.4.3 Charpy V-notch impact testing
9.4.3.1 Test pieces
9.4.3.2 Test method
9.4.3.3 Requirements
9.4.4 Through-thickness hardness testing
9.4.4.1 Test method
9.4.4.2 Acceptance criteria
9.4.5 Surface hardness testing
9.4.6 Metallographic examination
9.4.6.1 Test method

9.4.6.2 Acceptance criteria
9.4.7 HIC testing
9.4.8 SSC testing
9.4.9 CTOD testing
9.4.10 Guided weld bend testing
9.4.10.1 Test pieces
9.4.10.2 Test method
9.4.10.3 Acceptance criteria
9.5 Non-destructive testing
9.5.1 NDT procedures and personnel
9.5.2 Condition of fittings
9.5.3 Treatment of imperfections
9.5.3.1 Defects
9.5.3.2 Treatment of surface imperfections
9.5.3.3 Treatment of dressable surface defects
9.5.3.4 Treatment of non-dressable surface defects
9.5.3.5 Repair of defects by welding
9.5.4 Fitting ends
9.5.5 Weld seams
9.5.6 Guide bar attachment welds
9.5.7 Fitting body
9.5.8 Residual magnetism
9.6 Dimensions
9.7 Gauging
9.8 Hydrostatic testing

10 Inspection document

11 Marking

Annex A (normative) Design calculations

A.1 Elbows
A.2 Caps
A.3 Reducers (eccentric or concentric)
A.3.1 Reducers with tangents
A.3.2 Conical reducers
A.4 Tees (full outlet and reducing)
A.5 Additional design calculations

Annex B (normative) Proof test

B.1 Preparation for testing
B.2 Test pressure
B.3 Test method and equipment
B.4 Establishment of the equivalent wall or schedule
B.5 Applicability of results
B.6 Test report
B.7 Maintenance of results

Page count: 27