

LEEKKUUMUTUSETA SURVEANUMAD. OSA 4:
VALMISTAMINE

Unfired pressure vessels - Part 4: Fabrication

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 13445-4:2021 sisaldab Euroopa standardi EN 13445-4:2021 ingliskeelset teksti.	This Estonian standard EVS-EN 13445-4:2021 consists of the English text of the European standard EN 13445-4:2021.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation and Accreditation.
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English Version

Unfired pressure vessels - Part 4: Fabrication

Réceptacles sous pression non soumis à la flamme -
Partie 4: Fabrication

Unbefeuerte Druckbehälter - Teil 4: Herstellung

This European Standard was approved by CEN on 24 February 2021.

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Contents

	Page
European foreword.....	5
1 Scope.....	6
2 Normative references.....	6
3 Terms and definitions	8
4 Requirements for manufacturing and subcontracting.....	8
4.1 Manufacturing.....	8
4.2 Subcontracting.....	9
5 Materials.....	9
5.1 General.....	9
5.2 Material traceability	9
5.2.1 General.....	9
5.2.2 Identification system	10
5.2.3 Visibility.....	10
5.2.4 Review of material certification and material identification	10
5.2.5 Transfer of markings.....	11
6 Manufacturing tolerances.....	11
6.1 Surface geometry of welds.....	11
6.2 Middle line alignment.....	11
6.3 Surface alignment	13
6.3.1 Surface misalignment between parts	13
6.3.2 Joining of parts of different thickness	13
6.4 Tolerances for vessels subjected to internal pressure.....	13
6.4.1 External diameter	13
6.4.2 Out of roundness	13
6.4.3 Deviation from the longitudinal axis	14
6.4.4 Irregularities in profile.....	14
6.4.5 Local thinning.....	16
6.4.6 Dished ends.....	17
6.5 Tolerances for vessels subjected to external pressure	20
6.6 Structural tolerances	20
7 Weld details.....	20
7.1 General.....	20
7.2 Vessels or parts made of more than one course	20
7.3 Lapped joints, joggle joints, permanent backing strips	20
8 Welding.....	20
8.1 General.....	20
8.2 Welding procedure specification (WPS).....	21
8.3 Welding procedure qualification record (WPQR).....	21
8.4 Qualification of welders and welding operators	22
8.5 Filler metals and auxiliary materials.....	23
8.6 Joint preparation.....	23
8.7 Execution of welded joints.....	24
8.8 Attachments, supports and stiffeners.....	24

8.9	Preheat	24
8.10	Permanent joints other than welding	25
8.10.1	General	25
8.10.2	Mechanical roller expansion	25
8.10.3	Brazing.....	25
9	Manufacture and testing of welds — Production test	25
9.1	General	25
9.2	Reference criteria.....	26
9.3	Extent of testing.....	30
9.4	Performance of tests and acceptance criteria.....	32
9.4.1	General	32
9.4.2	Transverse tensile test	32
9.4.3	Longitudinal weld tensile test.....	32
9.4.4	Impact test.....	32
9.4.5	Bend test	32
9.4.6	Macro examination	33
9.4.7	Micro examination	33
9.4.8	Hardness test.....	33
9.4.9	Retests	33
9.4.10	Test report	34
10	Forming of pressure parts.....	34
10.1	General	34
10.2	Ratio of deformation	34
10.2.1	Dished circular products	34
10.2.2	Cylinders and cones made by rolling.....	35
10.2.3	Other product types.....	36
10.2.4	Tube bends.....	37
10.2.5	Forming of Segments.....	37
10.3	Forming procedures.....	38
10.3.1	Cold forming	38
10.3.2	Hot forming.....	39
10.4	Heat treatment after forming.....	41
10.4.1	General	41
10.4.2	Heat treatment of flat products after cold forming.....	41
10.4.3	Heat treatment of tubular products after cold forming.....	43
10.4.4	Heat treatment of clad steels after cold forming.....	43
10.4.5	Heat treatment after hot forming	43
10.4.6	Heat treatment of clad steels after hot forming	44
10.5	Sampling of formed test coupons.....	44
10.5.1	Cold formed products without heat treatment.....	44
10.5.2	Hot formed or cold formed products with heat treatment.....	44
10.6	Tests	45
10.6.1	Base material	45
10.6.2	Butt welds.....	45
10.6.3	Acceptance criteria for formed test coupons	46
10.6.4	Retests of formed coupons.....	46
10.7	Visual inspection and control of dimension	47
10.8	Marking	47
10.9	Documentation	47
11	Post weld heat treatment (PWHT)	47
11.1	General	47

11.2	Heat treatment conditions.....	48
11.3	Method of PWHT.....	51
11.4	PWHT procedure.....	52
11.5	Mechanical properties after heat treatment.....	53
11.6	Dissimilar ferritic joints	55
11.7	Special materials.....	56
11.8	Heat Treatment for reasons other than welding.....	56
12	Repairs.....	56
12.1	Repairs of surface defects in the parent metal.....	56
12.2	Repair of weld defects	57
13	Finishing operations	57
Annex A (informative) Structural tolerances.....		59
Annex B (informative) Example of a sub-contractors form		63
Annex C (normative) Specification and approval of expansion procedures and operators		64
C.1	General.....	64
C.1.1	Introduction	64
C.1.2	Responsibility.....	64
C.1.3	Specification of expansion procedures	64
C.1.4	Technical content of expansion procedure specification (EPS).....	65
C.1.5	Expansion procedure qualification test (EPQT)	66
C.2	Examination and testing.....	66
C.2.1	General.....	66
C.2.2	Visual examination.....	66
C.2.3	Dimensional verification.....	66
C.2.4	Testing.....	67
C.3	Range of approval	67
C.3.1	General.....	67
C.3.2	Manufacturer	67
C.3.3	Material.....	67
C.3.4	Tube dimensions	68
C.3.5	Expansion factor.....	68
C.3.6	Joint design.....	68
C.3.7	Tool.....	68
C.3.8	PWHT.....	68
C.4	Expansion Procedure Approval Record (EPAR)	69
C.5	Expansion operator approval.....	69
C.5.1	General.....	69
C.5.2	Validity range of expansion operator qualification.....	69
C.5.3	Qualification tests	69
C.5.4	Examination and testing.....	70
C.5.5	Period of validity	70
C.5.6	Certification.....	70
Annex Y (informative) History of EN 13445-4		71
Y.1	Differences between EN 13445-4:2014 and EN 13445-4:2021	71
Annex ZA (informative) Relationship between this European Standard and the essential requirements of Directive 2014/68/EU aimed to be covered.....		72
Bibliography.....		73

European foreword

This document (EN 13445-4:2021) has been prepared by Technical Committee CEN/TC 54 “Unfired pressure vessels”, the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2021, and conflicting national standards shall be withdrawn at the latest by November 2021.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document has been prepared under a standardization request given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

For relationship with EU Directive(s), see informative Annex ZA, which is an integral part of this document.

The list of all parts in the EN 13445 series can be found on the CEN website.

Although these Parts may be obtained separately, it should be recognised that the Parts are inter-dependant. As such the manufacture of unfired pressure vessels requires the application of all the relevant Parts in order for the requirements of the Standard to be satisfactorily fulfilled.

Corrections to the standard interpretations where several options seem possible are conducted through the Migration Help Desk (MHD). Information related to the Help Desk can be found at <http://www.unm.fr/en13445@unm.fr>. A form for submitting questions can be downloaded from the link to the MHD website. After subject experts have agreed an answer, the answer will be communicated to the questioner. Corrected pages will be given specific issue number and issued by CEN according to CEN Rules. Interpretation sheets will be posted on the website of the MHD.

This document supersedes EN 13445-4:2014. This new edition incorporates the Amendments which have been approved previously by CEN members, and the corrected pages up to Issue 5 without any further technical change. Annex Y provides details of significant technical changes between this European Standard and the previous edition.

Amendments to this new edition may be issued from time to time and then used immediately as alternatives to rules contained herein. It is intended to deliver a new Issue of EN 13445:2021 each year, starting with the precedent as Issue 1, consolidating these Amendments and including other identified corrections.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

1 Scope

This document specifies requirements for the manufacture of unfired pressure vessels and their parts, made of steels, including their connections to non-pressure parts. It specifies requirements for material traceability, manufacturing tolerances, welding requirements, requirements for permanent joints other than welding, production tests, forming requirements, heat treatment, repairs and finishing operations.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10028-2:2009, *Flat products made of steels for pressure purposes — Part 2: Non-alloy and alloy steels with specified elevated temperature properties*

EN 10028-3:2009, *Flat products made of steels for pressure purposes — Part 3: Weldable fine grain steels, normalized*

EN 10028-4:2009, *Flat products made of steels for pressure purposes — Part 4: Nickel alloy steels with specified low temperature properties*

EN 10216-1:2013, *Seamless steel tubes for pressure purposes — Technical delivery conditions — Part 1: Non-alloy steel tubes with specified room temperature properties*

EN 10216-2:2013, *Seamless steel tubes for pressure purposes — Technical delivery conditions — Part 2: Non-alloy and alloy steel tubes with specified elevated temperature properties*

EN 10216-3:2013, *Seamless steel tubes for pressure purposes — Technical delivery conditions — Part 3: Alloy fine grain steel tubes*

EN 10216-4:2013, *Seamless steel tubes for pressure purposes — Technical delivery conditions — Part 4: Non-alloy and alloy steel tubes with specified low temperature properties*

EN 10217-1:2002, EN 10217-1:2002/A1:2005, *Welded steel tubes for pressure purposes — Technical delivery conditions — Part 1: Non-alloy steel tubes with specified room temperature properties*

EN 10217-2:2002, EN 10217-2:2002/A1:2005, *Welded steel tubes for pressure purposes — Technical delivery conditions — Part 2: Electric welded non-alloy and alloy steel tubes with specified elevated temperature properties*

EN 10217-3:2002, EN 10217-3:2002/A1:2005, *Welded steel tubes for pressure purposes — Technical delivery conditions — Part 3: Alloy fine grain steel tubes*

EN 10217-4:2002, EN 10217-4:2002/A1:2005, *Welded steel tubes for pressure purposes — Technical delivery conditions — Part 4: Electric welded non-alloy and alloy steel tubes with specified low temperature properties*

EN 10217-5:2002, EN 10217-5:2002/A1:2005, *Welded steel tubes for pressure purposes — Technical delivery conditions — Part 5: Submerged arc welded non-alloy and alloy steel tubes with specified elevated temperature properties*

EN 10217-6:2002, EN 10217-6:2002/A1:2005, *Welded steel tubes for pressure purposes — Technical delivery conditions — Part 6: Submerged arc welded non-alloy steel tubes with specified low temperature properties*

EN 10222-2:1999, *Steel forgings for pressure purposes — Part 2: Ferritic and martensitic steels with specified elevated temperature properties*

EN 10222-3:1998, *Steel forgings for pressure purposes — Part 3: Nickel steels with specified low temperature properties*

EN 10222-4:1998+A1:2002, *Steel forgings for pressure purposes — Part 4: Weldable fine grain steels with high proof strength*

EN 13134:2000, *Brazing — Procedure approval*

EN 13445-1:2021, *Unfired pressure vessels — Part 1: General*

EN 13445-2:2021, *Unfired pressure vessels — Part 2: Materials*

EN 13445-3:2021, *Unfired pressure vessels — Part 3: Design*

EN 13445-5:2021, *Unfired pressure vessels — Part 5: Inspection and testing*

EN 14276-1:2006+A1:2011, *Pressure equipment for refrigerating systems and heat pumps — Part 1: Vessels — General requirements*

EN ISO 3834-2:2005, *Quality requirements for fusion welding of metallic materials — Part 2: Comprehensive quality requirements (ISO 3834-2:2005)*

EN ISO 3834-3:2005, *Quality requirements for fusion welding of metallic materials — Part 3: Standard quality requirements (ISO 3834-3:2005)*

EN ISO 4136:2012, *Destructive tests on welds in metallic materials — Transverse tensile test (ISO 4136:2012)*

EN ISO 5173:2010, *Destructive tests on welds in metallic materials — Bend tests (ISO 5173:2009)*

EN ISO 5178:2011, *Destructive tests on welds in metallic materials — Longitudinal tensile test on weld metal in fusion welded joints (ISO 5178:2001)*

EN ISO 9015-1:2011, *Destructive tests on welds in metallic materials — Hardness testing — Part 1: Hardness test on arc welded joints (ISO 9015-1:2001)*

EN ISO 9016:2012, *Destructive tests on welds in metallic materials — Impact tests — Test specimen location, notch orientation and examination (ISO 9016:2012)*

EN ISO 9606-1:2017, *Qualification testing of welders — Fusion welding — Part 1: Steels (ISO 9606 - 1:2012 including Cor 1:2012 and Cor 2:2013)*

EN ISO 13585:2012, *Brazing — Qualification test of brazers and brazing operators (ISO 13585:2012)*

EN ISO 14732:2013, *Welding personnel — Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials (ISO 14732:2013)*

EN ISO 15609-1:2004, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 1: Arc welding* (ISO 15609-1:2004)

EN ISO 15611:2003, *Specification and qualification of welding procedures for metallic materials — Qualification based on previous welding experience* (ISO 15611:2003)

EN ISO 15612:2018, *Specification and qualification of welding procedures for metallic materials — Qualification by adoption of a standard welding procedure* (ISO 15612:2018)

EN ISO 15613:2004, *Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test* (ISO 15613:2004)

EN ISO 15614-1:2017, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys* (ISO 15614-1:2017)

EN ISO 17639:2013, *Destructive tests on welds in metallic materials — Macroscopic and microscopic examination of welds* (ISO 17639:2003)

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

4 Requirements for manufacturing and subcontracting

4.1 Manufacturing

The general responsibilities of the pressure vessel manufacturer are stated in EN 13445-1:2021. Additionally to those requirements, the manufacturer shall ensure that:

- a) the organisation for the control of manufacturing operations which includes special processes such as welding, forming and heat treatment shall be clearly defined by the manufacturer;
- b) the manufacturing procedures such as welding, forming and heat treatment are adequate for the purpose and the pressure vessel meets the requirements of this standard. Where specific requirements are associated with materials these shall be taken into account, e.g. EAMs;
- c) the manufacturing equipment is adequate for fabrication;
- d) the staff is adequate for the assigned tasks;

NOTE As far as welding co-ordination is concerned, the qualifications, tasks and responsibilities can be defined by the manufacturer in accordance with EN ISO 14731:2007 [1] in the job assignment.

- e) the quality requirements for welding defined in EN ISO 3834-3:2005 are met as a minimum.