

**Vask ja vasesulamid.  
Torustikuliitmikud. Osa 1: Kapillaarse  
pehmejoodise ja kapillaarse  
kõvajoodise jaoks ettenähtud otsaga  
liitmikud vasktorude jaoks**

Copper and copper alloy - Plumbing fittings - Part 1:  
Fittings with ends for capillary soldering or capillary  
brazing to copper tubes

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 1254-1:1999 sisaldab Euroopa standardi EN 1254-1:1998 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 12.12.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 1254-1:1999 consists of the English text of the European standard EN 1254-1:1998.</p> <p>This document is endorsed on 12.12.1999 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p><b>Käsitlusala:</b></p> <p>Käesolev Euroopa standard määrab kindlaks materjali, koostemõõtmed ja tolerantsid ning testimisnõuded pinnakattega või pinnakatteta vasest ja vasesulamitest liitmike jaoks. Samuti on kehtestatud maksimaalsed lubatud temperatuurid ja rõhud. Käesolev normdokumendi 1254 osa määrab kindlaks kapillaarse pehmejoodise ja kapillaarse kõvajoodise ühendusotsa mõõtmed normdokumendis EN 1057 kindlaks määratud vasktorude ühendamiseks.</p>	<p><b>Scope:</b></p>
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**ICS** 23.040.40

**Võtmesõnad:** keevitatavad ühendused, mõõtmed, mõõtmeterantsid, märgistus, testimine, toruliitmikud, tähistus, vasesulamid, vask, vasktorud, ühendamine

ICS 23.040.40

Descriptors: Copper, plumbing fittings.

**English version**

**Copper and copper alloys – Plumbing fittings**

Part 1: Fittings with ends for capillary soldering or capillary brazing  
to copper tubes

Cuivre et alliages de cuivre – Rac-  
cords – Partie 1: Raccords à braser  
par capillarité pour tubes en cuivre

Kupfer und Kupferlegierungen –  
Fittings – Teil 1: Kapillarlöt fittings für  
Kupferrohre (Weich- und Hartlötten)

This European Standard was approved by CEN on 1997-11-24.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

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**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

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## Foreword

This European Standard has been prepared by Technical Committee CEN/TC 133 "Copper and copper alloys", the secretariat of which is held by DIN.

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 July 1998, and conflicting national standards shall be withdrawn at the latest by July 1998.

Within its programme of work, Technical Committee CEN/TC 133 requested CEN/TC 133/WG 8 "Copper and copper alloy fittings" to prepare the following standard:

EN 1254-1 Copper and copper alloys - Plumbing fittings - Part 1: Fittings with ends for capillary soldering or capillary brazing to copper tubes

This standard is one of five parts for copper and copper alloy fittings for joining copper tubes or plastics pipes. The other four parts of the standard are :

EN 1254-2 Copper and copper alloys - Plumbing fittings - Part 2: Fittings with compression ends for use with copper tubes

EN 1254-3 Copper and copper alloys - Plumbing fittings - Part 3: Fittings with compression ends for use with plastics pipes

EN 1254-4 Copper and copper alloys - Plumbing fittings - Part 4: Fittings combining other end connections with capillary or compression ends

EN 1254-5 Copper and copper alloys - Plumbing fittings - Part 5: Fittings with short ends for capillary brazing to copper tubes

It is recommended that fittings manufactured to this standard are certified as conforming to the requirements of this standard, based on third party testing and continuing surveillance which should be coupled with an assessment of a supplier's quality system against the appropriate standard i.e. EN ISO 9001 or EN ISO 9002.

In respect of potential adverse effects on the quality of water intended for human consumption, caused by the product covered by this standard:

1) this standard provides no information as to whether the product may be used without restriction in any of the Member States of the EU or EFTA;

2) it should be noted that, while awaiting the adoption of verifiable European criteria, existing national regulations concerning the use and/or the characteristics of this product remain in force.

The attention of the user of this standard is drawn to the fact that national or local regulations or practices might restrict the choice of dimensions and threads in the application of products conforming to this standard.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

This European Standard specifies materials, assembly dimensions and tolerances and test requirements for fittings of copper and copper alloys with or without plating. Maximum permissible temperatures and pressures are also established. This Part of EN 1254 specifies connection end dimensions of capillary soldering and brazing ends for the purposes of joining copper tubes specified in EN 1057. Fittings may comprise a combination of any of the end types specified in EN 1254-1 to EN 1254-5 or other standards.

The standard establishes a designation system for the fittings.

## 2 Normative references

This European Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies.

EN 723	Copper and copper alloys - Combustion method for determination of carbon on the inner surface of copper tubes or fittings
EN 1057	Copper and copper alloys - Seamless, round copper tubes for water and gas in sanitary and heating applications
EN 1254-2	Copper and copper alloys - Plumbing fittings - Part 2: Fittings with compression ends for use with copper tubes
EN 1254-3	Copper and copper alloys - Plumbing fittings - Part 3: Fittings with compression ends for use with plastics pipes
EN 1254-4	Copper and copper alloys - Plumbing fittings - Part 4: Fittings combining other end connections with capillary or compression ends
EN 1254-5	Copper and copper alloys - Plumbing fittings - Part 5: Fittings with short ends for capillary brazing to copper tubes
EN ISO 6509 :1995	Corrosion of metals and alloys - Determination of dezincification resistance of brass (ISO 6509: 1981)

NOTE: Informative references to documents used in the preparation of this standard, and cited at the appropriate places in the text, are listed in a bibliography, see annex C.

### **3 Definitions**

For the purposes of this standard, the following definitions apply:

#### **3.1 plumbing fitting**

Device used in a tube system for the purpose of connecting the tubes either to each other or to a component part of a system.

#### **3.2 capillary end**

End in which the joint is made by the flow of solder or brazing alloy by capillary action into the annular space.

#### **3.3 reducer (capillary soldering or brazing for copper tube)**

Component used to enable an end to connect tube of a smaller nominal diameter than the nominal diameter of the fitting end.