Veetorudega katlad ja abipaigaldised. Osa 5: Katla survedetailide väljatöötamisviis ja valmistamine

Water-tube boilers and auxillary installations - Part 5: Workmanship and construction of pressure parts of the boiler

EESTI STANDARDIKESKUS
ESTONIAN CENTRE FOR STANDARDISATION

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 12952-5:2011 sisaldab Euroopa standardi EN 12952-5:2011 ingliskeelset teksti.	This Estonian standard EVS-EN 12952-5:2011 consists of the English text of the European standard EN 12952-5:2011.
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.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 02.11.2011.	Date of Availability of the European standard is 02.11.2011.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

Tagasisidet standardi sisu kohta on võimalik edastada, kasutades EVS-i veebilehel asuvat tagasiside vormi või saates e-kirja meiliaadressile standardiosakond@evs.ee.

ICS 27.040

Võtmesõnad: auxiliary equipment, boilers, definitions, materials, pressurized components, processing, quality requirements, specification (approval), specifications, steam boilers, tanks, water-tube boilers, workmanship,

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 12952-5

November 2011

ICS 27.040

Supersedes EN 12952-5:2001

English Version

Water-tube boilers and auxiliary installations - Part 5: Workmanship and construction of pressure parts of the boiler

Chaudières à tubes d'eau et installations auxiliaires - Partie 5: Fabrication et construction des parties sous pression de la chaudière

Wasserrohrkessel und Anlagenkomponenten - Teil 5: Verarbeitung und Bauausführung für drucktragende Kesselteile

This European Standard was approved by CEN on 10 September 2011.

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This European Standard exists 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 CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Ref. No. EN 12952-5:2011: E

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Foreword

This document (EN 12952-5:2011) has been prepared by Technical Committee CEN/TC 269 “Shell and water-tube boilers”, 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 May 2012, and conflicting national standards shall be withdrawn at the latest by May 2012.

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

This document supersedes EN 12952-5:2001.

This document has been prepared under a mandate 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 97/23/EC, see informative Annex ZA, which is an integral part of this document.

Annex G provides details of significant technical changes between this European Standard and the previous edition.

The European Standard series EN 12952 concerning water-tube boilers and auxiliary installations consists of the following parts:

— Part 1: *General;*

— Part 2: *Materials for pressure parts of boilers and accessories;*

— Part 3: *Design and calculation for pressure parts of the boiler;*

— Part 4: *In-service boiler life expectancy calculations;*

— Part 5: *Workmanship and construction of pressure parts of the boiler;*

— Part 6: *Inspection during construction; documentation and marking of pressure parts of the boiler;*

— Part 7: *Requirements for equipment for the boiler;*

— Part 8: *Requirements for firing systems for liquid and gaseous fuels for the boiler;*

— Part 9: *Requirements for firing systems for pulverized solid fuels for the boiler;*

— Part 10: *Requirements for safeguards against excessive pressure;*

— Part 11: *Requirements for limiting devices of the boiler and accessories;*

— Part 12: *Requirements for boiler feedwater and boiler water quality;*

— Part 13: *Requirements for flue gas cleaning systems;*

— Part 14: *Requirements for flue gas DENOX-systems using liquefied pressurized ammonia and ammonia water solution;*

— Part 15: *Acceptance tests;*

— Part 16: *Requirements for grate and fluidized-bed firing systems for solid fuels for the boiler;*

— CR 12952 Part 17: *Guideline for the involvement of an inspection body independent of the manufacturer.*

NOTE 1 A Part 18 on operating instructions is currently in preparation.

Although these parts may be obtained separately, it should be recognized that the parts are inter-dependent. As such, the design and manufacture of boilers requires the application of more than one part in order for the requirements of the European Standard to be satisfactorily fulfilled.

NOTE 2 Part 4 and Part 15 are not applicable during the design, construction and installation stages.

NOTE 3 A "Boiler Helpdesk" has been established in CEN/TC 269 which may be contacted for any questions regarding the application of European Standards series EN 12952 and EN 12953, see the following website: http://www.boiler-helpdesk.din.de.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This European Standard specifies requirements for the workmanship and construction of water-tube boilers as defined in EN 12952-1:2001.

2 Normative references

The following referenced documents are indispensable for the application 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 287-1:2011, *Qualification test of welders — Fusion welding — Part 1: Steels*

EN 473, *Non-destructive testing — Qualification and certification of NDT personnel — General principles*

EN 571-1:1997, *Non destructive testing — Penetrant testing — Part 1: General principles*

EN 1092-1:2007, *Flanges and their joints — Circular flanges for pipes, valves, fittings and accessories, PN designated — Part 1: Steel flanges*

EN 1418:1997, *Welding personnel — Approval testing of welding operators for fusion welding and resistance weld setters for fully mechanized and automatic welding of metallic materials*

EN 1759-1:2004, *Flanges and their joints — Circular flanges for pipes, valves, fittings and accessories, Class designated — Part 1: Steel flanges, NPS 1/2 to 24*

EN 10025-2, *Hot rolled products of structural steels — Part 2: Technical delivery conditions for non-alloy structural steels*

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

EN 10204:2004, *Metallic products — Types of inspection documents*

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

EN 10253-2:2007, *Butt-welding pipe fittings — Part 2: Non alloy and ferritic alloy steels with specific inspection requirements*

EN 10253-4:2008, *Butt-welding pipe fittings — Part 4: Wrought austenitic and austenitic-ferritic (duplex) stainless steels with specific inspection requirements*

EN 12952-1:2001, *Water-tube boilers and auxiliary installations — Part 1: General*

EN 12952-2:2011, *Water-tube boilers and auxiliary installations — Part 2: Materials for pressure parts of boilers and accessories*

EN 12952-3:2011, *Water-tube boilers and auxiliary installations — Part 3: Design and calculation for pressure parts*

EN 12952-6:2011, *Water-tube boilers and auxiliary installations — Part 6: Inspection during construction; documentation and marking of pressure parts of the boiler*

EN 12952-7:2002, *Water-tube boilers and auxiliary installations — Part 7: Requirements for equipment for the boiler*

EN ISO 148-1:2010, *Metallic materials — Charpy pendulum impact test — Part 1: Test method (ISO 148-1:2009)*

EN ISO 4759-1:2000, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C (ISO 4759-1:2000)*

EN ISO 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections (ISO 5817:2003, corrected version:2005, including Technical Corrigendum 1:2006)*

EN ISO 6520-1, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 1: Fusion welding (ISO 6520-1:2007)*

EN ISO 6892-1:2009, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1:2009)*

EN ISO 14555:2006, *Welding — Arc stud welding of metallic materials (ISO 14555:2006)*

EN ISO 15609 (all parts), *Specification and qualification of welding procedures for metallic materials — Welding procedure specification*

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

EN ISO 15614-1:2004, *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 15614-1:2004)*

EN ISO 17638:2009, *Non-destructive testing of welds — Magnetic particle testing (ISO 17638:2003)*

EN ISO 17663:2009, *Welding — Quality requirements for heat treatment in connection with welding and allied processes (ISO 17663:2009)*

EN ISO 23277:2009, *Non-destructive testing of welds — Penetrant testing of welds — Acceptance levels (ISO 23277:2006)*

EN ISO 23278:2009, *Non-destructive testing of welds — Magnetic particle testing of welds — Acceptance levels (ISO 23278:2006)*

CEN ISO/TR 15608, *Welding — Guidelines for a metallic material grouping system (ISO/TR 15608:2005)*

3 Terms and definitions

For the purposes of this document the terms and definitions given in EN 12952-1:2001 and the following apply.

3.1
cold forming
for ferritic steels, it is forming at temperatures below the maximum permissible temperature for post-weld heat treatment and for austenitic materials it is forming at temperatures below 300 °C

NOTE See Table 10.4-2.

3.2
hot forming
for ferritic steels, it is forming at temperatures at or above the maximum permissible temperature for post-weld heat treatment