

**Veetorudega katlad ja abipaigaldised.  
Osa 6: Inspekteerimine katla  
survedetailide valmistamise,  
dokumenteerimise ja märgistamise ajal**

Water-tube boilers and auxiliary installations - Part 6:  
Inspection during construction; documentation and  
marking of pressure parts of the boiler

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 12952-6:2002 sisaldab Euroopa standardi EN 12952-6:2002 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 18.10.2002 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 12952-6:2002 consists of the English text of the European standard EN 12952-6:2002.</p> <p>This document is endorsed on 18.10.2002 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>This Part of this European Standard specifies requirements for the inspection during construction, documentation and marking of water-tube boilers as defined in EN 12952-1.</p>	<p><b>Scope:</b></p> <p>This Part of this European Standard specifies requirements for the inspection during construction, documentation and marking of water-tube boilers as defined in EN 12952-1.</p>
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**ICS 27.040**

**Võtmesõnad:** boilers, heat exchangers, pressure, pumps, safety, safety engineering, safety requirements, sample surveys, specification (approval), specifications, steam boilers, steam generators, surveillance (approval), temperature measurement, testing, valves, water preheaters

ICS 27.040

English version

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

Chaudières à tubes d'eau et installations auxiliaires - Partie 6: Contrôle en cours de construction, documentation et marquage des parties sous pression de la chaudière

Wasserrohrkessel und Anlagenkomponenten - Teil 6: Prüfung während der Herstellung; Dokumentation und Kennzeichnung für drucktragende Kesselteile

This European Standard was approved by CEN on 15 May 2002.

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 Management Centre or to any CEN member.

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 Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
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## Foreword

This document (EN 12952-6:2002) 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 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(s), see informative Annex ZA, which is an integral part of this standard.

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 2002, and conflicting national standards shall be withdrawn at the latest by November 2002.

The European Standard 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.*
- *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.*
- *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.*

Although these Parts can be obtained separately, it should be recognized that the Parts are inter-dependent. As such, the design and manufacture of water-tube boilers requires the application of more than one Part in order for the requirements of the standard to be satisfactorily fulfilled.

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

Annex A is normative.

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, Malta, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

## 1 Scope

This Part of this European Standard specifies requirements for the inspection during construction, documentation and marking of water-tube boilers as defined in EN 12952-1.

## 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 (including amendments).

EN 287-1, *Approval testing of welders — Fusion welding — Part 1: Steels.*

EN 288-3, *Specification and approval of welding procedures for metallic materials — Part 3: Welding procedure tests for the arc welding of steels.*

EN 288-8, *Specification and approval of welding procedures for metallic materials — Part 8: Approval by a pre-production welding test.*

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

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

EN 970, *Non-destructive examination of fusion welds — Visual examination.*

EN 1289, *Non-destructive examination of welds — Penetrant testing of welds — Acceptance levels.*

EN 1291, *Non-destructive examination of welds — Magnetic particle testing of welds — Acceptance levels.*

EN 1321, *Destructive tests on welds in metallic materials - Macroscopic and microscopic examination of welds.*

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 1435, *Non-destructive examination of welds — Radiographic examination of welded joints.*

EN 1712, *Non-destructive examination of welds — Ultrasonic examination of welded joints — Acceptance levels.*

EN 1714, *Non-destructive examination of welds — Ultrasonic examination of welded joints.*

EN 10045-1, *Metallic materials — Charpy impact test — Part 1: Test method.*

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

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

EN 12952-3:2001, *Water-tube boilers and auxiliary installations - Part 3: Design and calculation for pressure parts.*

EN 12952-5:2001, *Water-tube boilers and auxiliary installations — Part 5: Workmanship and construction of pressure parts of the boiler.*

EN 25817, *Arc-welded joints in steel — Guidance on quality levels for imperfections (ISO 5817:1992).*

EN ISO 6520-1:1998, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 1: Fusion welding (ISO 6520-1:1998).*