

VASK JA VASESULAMID. ÕMBLUSTETA ÜMARAD
VASKTORUD MEDITSIINILISTELE GAASIDELE VÕI
VAAKUMILE

Copper and copper alloys - Seamless, round copper
tubes for medical gases or vacuum

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 13348:2016 sisaldab Euroopa standardi EN 13348:2016 ingliskeelset teksti.	This Estonian standard EVS-EN 13348:2016 consists of the English text of the European standard EN 13348:2016.
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 15.06.2016.	Date of Availability of the European standard is 15.06.2016.
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 23.040.15

Standardite reprodutseerimise ja levitamise õigus kuulub Eesti Standardikeskusele

Andmete paljundamine, taastekitamine, kopeerimine, salvestamine elektroonsesse süsteemi või edastamine ükskõik millises vormis või millisel teel ilma Eesti Standardikeskuse kirjaliku loata on keelatud.

Kui Teil on küsimusi standardite autorikaitse kohta, võtke palun ühendust Eesti Standardikeskusega:

Aru 10, 10317 Tallinn, Eesti; koduleht www.evs.ee; telefon 605 5050; e-post info@evs.ee

The right to reproduce and distribute standards belongs to the Estonian Centre for Standardisation

No part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying, without a written permission from the Estonian Centre for Standardisation.

If you have any questions about copyright, please contact Estonian Centre for Standardisation:

Aru 10, 10317 Tallinn, Estonia; homepage www.evs.ee; phone +372 605 5050; e-mail info@evs.ee

English Version

Copper and copper alloys - Seamless, round copper tubes for medical gases or vacuum

Cuivre et alliages de cuivre - Tubes ronds sans soudure
en cuivre pour gaz médicaux ou le vide

Kupfer und Kupferlegierungen - Nahtlose Rundrohre
aus Kupfer für medizinische Gase oder Vakuum

This European Standard was approved by CEN on 28 February 2016.

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 CEN-CENELEC 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of 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, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

Contents	Page
European foreword	3
Introduction	5
1 Scope	6
2 Normative references	6
3 Terms and definitions	7
4 Designations	8
5 Ordering information	9
6 Requirements	9
7 Sampling	14
8 Test methods	15
9 Inspection documentation	16
10 Packaging, marking and form of delivery	16
Annex A (normative) Marking durability test	18
A.1 Abrasion test	18
A.2 Climatic test	18
Annex B (normative) Freedom from defects test	19
B.1 Eddy current test	19
B.2 Hydrostatic test	19
B.3 Pneumatic test	20
Annex ZA (informative) Relationship between this European Standard and the Essential Requirements of Directive 2014/68/EU aimed to be covered	21
Bibliography	22
Tables	
Table 1 — Mechanical properties	10
Table 2 — Nominal outside diameters and wall thicknesses	11
Table 3 — Tolerances on outside diameter	12
Table 4 — Tolerance on wall thickness	12
Table 5 — Lubricant residue on the inner surface of the tube	13
Table 6 — Testing of bending and drift expanding	14
Table 7 — Sampling rate	14
Table 8 — Minimum radius of curvature	15
Table 9 — Recommended form of delivery	17
Table B.1 — Maximum drill diameters for the reference standard tube	19
Table B.2 — Hydrostatic pressure test	19
Table ZA.1 — Correspondence between this European Standard and Annex I of Directive 2014/68/EU	21

European foreword

This document (EN 13348:2016) 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 December 2016 and conflicting national standards shall be withdrawn at the latest by December 2016.

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 13348:2008.

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 Directive 2014/68/EU, Pressure Equipment Directive (PED).

For relationship with Directive 2014/68/EU, see informative Annex ZA, which is an integral part of this document.

Within its programme of work, Technical Committee CEN/TC 133 requested CEN/TC 133/WG 3 "Copper tubes (installation and industrial)" to revise EN 13348:2008.

In comparison with EN 13348:2008, the following significant technical changes were made:

- a) The size range of the outside diameters has been increased from 133 mm to 219 mm;
- b) Nominal outside diameters have been added to Table 1;
- c) Lubricant residue values for the new outside diameters have been added in 6.5;
- d) Sub-clause 8.7 has been revised and a new normative Annex B "Freedom from defects tests" has been added.

This is one of a series of European Standards for copper and copper alloy tubes. Other products are specified as follows:

- EN 1057, *Copper and copper alloys — Seamless, round copper tubes for water and gas in sanitary and heating applications*
- EN 12449, *Copper and copper alloys — Seamless, round tubes for general purposes*
- EN 12450, *Copper and copper alloys — Seamless, round copper capillary tubes*
- EN 12451, *Copper and copper alloys — Seamless, round tubes for heat exchangers*
- EN 12452, *Copper and copper alloys — Rolled, finned, seamless tubes for heat exchangers*
- EN 12735-1, *Copper and copper alloys — Seamless, round tubes for air conditioning and refrigeration — Part 1: Tubes for piping systems*

- EN 12735-2, *Copper and copper alloys — Seamless, round tubes for air conditioning and refrigeration — Part 2: Tubes for equipment*
- EN 13349, *Copper and copper alloys — Pre-insulated copper tubes with solid covering*
- EN 13600, *Copper and copper alloys — Seamless copper tubes for electrical purposes*

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, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Introduction

It is recommended that tubes manufactured to this European Standard are certified as conforming to the requirements of this standard based on continuing surveillance which should be coupled with an assessment of a supplier's quality management system such as EN ISO 9001.

Tubes to this European Standard are suitable for capillary soldering, brazing or assembling by mechanical compression or collared fittings.

NOTE It is advised to take appropriate precautions if applying insulating material because it could be detrimental to the copper tube.

1 Scope

This European Standard specifies the requirements, sampling, test methods and conditions of delivery for copper tubes.

It is applicable to seamless round copper tubes having an outside diameter from 6 mm up to and including 219 mm for pipeline systems under vacuum or for distributing the following medical gases intended to be used at operating pressures up to 2 000 kPa:

- oxygen, nitrous oxide, nitrogen, helium, carbon dioxide, xenon;
- medical air;
- specific mixtures of these above mentioned gases;
- air for driving surgical tools;
- anaesthetic gases and vapours.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 723, *Copper and copper alloys - Combustion method for determination of the carbon content on the inner surface of copper tubes or fittings*

EN 1173, *Copper and copper alloys - Material condition designation*

EN 1971-1, *Copper and copper alloys - Eddy current test for measuring defects on seamless round copper and copper alloy tubes - Part 1: Test with an encircling test coil on the outer surface*

EN 1971-2, *Copper and copper alloys - Eddy current test for measuring defects on seamless round copper and copper alloy tubes - Part 2: Test with an internal probe on the inner surface*

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

EN ISO 6507-1, *Metallic materials - Vickers hardness test - Part 1: Test method (ISO 6507-1)*

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

EN ISO 8491, *Metallic materials - Tube (in full section) - Bend test (ISO 8491)*

EN ISO 8493, *Metallic materials - Tube - Drift-expanding test (ISO 8493)*

ISO 1553, *Unalloyed copper containing not less than 99,90 % of copper - Determination of copper content - Electrolytic method*

ISO 4741, *Copper and copper alloys - Determination of phosphorus content - Molybdovanadate spectrometric method*