

Contents

	Page
European foreword	4
Introduction	5
1 Scope.....	6
2 Normative references	6
3 Terms and definitions.....	7
4 Requirements	8
4.1 Steel parts	8
4.1.1 General.....	8
4.1.2 Specification.....	8
4.1.3 Wall thickness and diameter.....	8
4.1.4 Bends.....	8
4.1.5 T-pieces.....	10
4.1.6 Reducers	10
4.1.7 Anchors	10
4.1.8 Single use compensators.....	10
4.1.9 Caps.....	10
4.1.10 Fusion welding of steel fittings	10
4.1.11 Surface condition	14
4.2 Casing.....	14
4.3 Polyurethane (PUR) foam thermal insulation.....	14
4.4 Fitting assemblies.....	14
4.4.1 Fitting ends	14
4.4.2 Angle between casing segments of bend and minimum length.....	15
4.4.3 Requirements of polyethylene welding.....	15
4.4.4 Leak-tightness of the welded casing	17
4.4.5 Diameter and wall thickness of the casing	17
4.4.6 Minimum thickness of the thermal insulation in bends.....	17
4.4.7 Tolerances of the main fitting dimensions	18
4.5 Surveillance system	18
5 Test methods.....	18
5.1 General	18
5.2 Test specimens.....	19
5.3 Steel parts	19
5.3.1 Visual surface examination of welds	19
5.3.2 Leak-tightness test with water.....	19
5.3.3 Leak-tightness test with air	19
5.3.4 Non-destructive examination of welds	19
5.3.5 NDT of welds	20
5.4 Casing.....	20
5.5 Polyurethane (PUR) foam thermal insulation.....	20
5.6 Fitting assemblies.....	20
5.6.1 Centre line deviation and angular deviation	20
5.6.2 Visual examination of welds on casing	20
5.6.3 Bending test.....	20
5.6.4 Minimum thickness of the thermal insulation	21
5.7 Surveillance system	21
6 Marking.....	21
6.1 General	21
6.2 Steel service pipe	22
6.3 Casing.....	22
6.4 Fitting assembly	22
6.5 Single use compensators	22

Annex A (informative) Guidelines for inspection and testing	24
Annex B (informative) Procedures for casing welding	28
Annex C (informative) Waste treatment and recycling	32
Bibliography	33

QUESTO DOCUMENTO È UNA PREVIEW. RIPRODUZIONE VIETATA

European foreword

This document (EN 448:2019) has been prepared by Technical Committee CEN/TC 107 “Prefabricated district heating and district cooling pipe system”, the secretariat of which is held by DS.

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of an identical text or by endorsement, at the latest by April 2020, and conflicting national standards shall be withdrawn at the latest by April 2020.

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 supersedes EN 448:2015.

In comparison with the previous edition, the main changes in EN 448:2019 are:

- editorial changes to the new structure of standards prepared by the Technical Committee CEN/TC 107.

According to the CEN-CENELEC Internal Regulations, the national standards organisations 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, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Introduction

EN 448 has been aligned with EN 488 and other relevant European Standards.

Other standards from CEN/TC 107 are:

- EN 253, *District heating pipes — Bonded single pipe systems for directly buried hot water networks — Factory made pipe assembly of steel service pipe, polyurethane thermal insulation and a casing of polyethylene;*
- EN 488, *District heating pipes — Bonded single pipe systems for directly buried hot water networks — Factory made steel valve assembly for steel service pipes, polyurethane thermal insulation and a casing of polyethylene ;*
- EN 489-1, *District heating pipes — Bonded single and twin pipe systems for buried hot water networks — Part 1: Joint casing assemblies and thermal insulation for hot water networks in accordance with EN 13941-1;*
- EN 13941-1, *District heating pipes — Design and installation of thermal insulated bonded single and twin pipe systems for directly buried hot water networks — Part 1: Design;*
- EN 13941-2, *District heating pipes — Design and installation of thermal insulated bonded single and twin pipe systems for directly buried hot water networks — Part 2: Installation;*
- EN 14419, *District heating pipes — Bonded single and twin pipe systems for directly buried hot water networks — Surveillance systems;*
- EN 15632 (all parts), *District heating pipes — Pre-insulated flexible pipe systems;*
- EN 15698-1, *District heating pipes — Bonded twin pipe systems for directly buried hot water networks — Part 1: Factory made twin pipe assembly of steel service pipes, polyurethane thermal insulation and one casing of polyethylene ;*
- EN 15698-2, *District heating pipes — Bonded twin pipe systems for directly buried hot water networks — Part 2: Factory made fitting and valve assemblies of steel service pipes, polyurethane thermal insulation and one casing of polyethylene*
- EN 17248, *District heating and district cooling pipe systems — Terms and definitions.*

1 Scope

This document specifies requirements and test methods for factory made thermally insulated bonded fitting assemblies for hot water networks in accordance with EN 13941-1, comprising a steel service fitting, rigid polyurethane foam thermal insulation and a casing of polyethylene.

The fitting assembly could also include the following additional elements: measuring wires, spacers and diffusion barriers.

This document covers the following fitting assemblies: bend, tee, reducer, single use compensator and anchor.

This document applies to fitting assemblies with a minimum design pressure of 1,6 MPa (overpressure).

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 253, *District heating pipes — Bonded single pipe systems for directly buried hot water networks — Factory made pipe assembly of steel service pipe, polyurethane thermal insulation and a casing of polyethylene*

EN 10204, *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 10217-2, *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 10217-5, *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 10253-2, *Butt-welding pipe fittings — Part 2: Non alloy and ferritic alloy steels with specific inspection requirements*

EN 12814-1, *Testing of welded joints of thermoplastics semi-finished products — Part 1: Bend test*

EN 13018, *Non-destructive testing — Visual testing — General principles*

EN 13941-1, *District heating pipes — Design and installation of thermal insulated bonded single and twin pipe systems for directly buried hot water networks — Part 1: Design*

EN 13941-2, *District heating pipes — Design and installation of thermal insulated bonded single and twin pipe systems for directly buried hot water networks — Part 2: Installation*

EN 14419, *District heating pipes — Preinsulated bonded pipe systems for directly buried hot water networks — Surveillance systems*

EN 14870-1, *Petroleum and natural gas industries — Induction bends, fittings and flanges for pipeline transportation systems — Part 1: Induction bends (ISO 15590-1)*

EN 17248, *District heating and district cooling pipe systems — Terms and definitions*

EN ISO 3452-1, *Non-destructive testing — Penetrant testing — Part 1: General principles (ISO 3452-1)*

EN ISO 5579, *Non-destructive testing — Radiographic testing of metallic materials using film and X- or gamma rays — Basic rules (ISO 5579)*