European Committee for Standardization

Comité Européen de Normalisation

Europaïsches Komitee für Normung

CEN/TC 267/WG 8 N 126

CEN/TC 267/WG 8 (MHD) « *Maintenance of EN 13480 series* »
MHD questions of 2025 on EN 13480 series

MHD questions N°	Date of MHD questions	Clauses	Type of MHD questions	MHD answers Doc. N°	Subsequent actions
1-001-2025	2025-04-30	Table 5.1-1	Editorial correction	N 126	to CEN/TC 267/WG 1 next EN 13480-1:2024/prA1
2-001-2025	2024-12-06	B.2.2.6	Technical clarification	N 126	answer to the questioner
2-002-2025	2025-04-05	Annex B	Technical clarification	N 126	answer to the questioner
3-001-2025	2025-04-25	6.6.4	Editorial correction	N 126	answer to the questioner
3-002-2025	2025-07-09	8.4.3	Technical clarification	N 126	answer to the questioner
3-003-2025	2025-07-11	9.3.2	Technical clarification	N 126	answer to the questioner
3-004-2025	2025-08-21	8.3.3	Technical clarification	N 126	answer to the questioner
3-005-2025	2025-10-13	Annex O	Technical clarification	N 126	to CEN/TC 267/WG 3 next EN 13480-3:2024/prA2
3-006-2025	2025-10-22	9.3.3	Technical clarification	N 126	answer to the questioner
4-001-2025	2025-07-02	Annex B	Technical clarification	N 126	to CEN/TC 267/WG 4 for EN 13480-4:2024/prA1
5-001-2025	2025-05-01	7.3.5	Technical clarification	N 126	answer to the questioner
5-002-2025	2025-06-18	9.3.2.2	Technical clarification	N 126	answer to the questioner
5-003-2025	2025-08-03	9.3.2.1.2	Technical clarification	N 126	to CEN/TC 267/WG 5 next EN 13480-5:2024/prA2
5-004-2025	2025-07-21	8.1.3/9.3.1	Technical clarification	N 126	answer to the questioner
5-005-2025	2025-08-26	8.4.4.3	Technical clarification	N 126	to CEN/TC 267/WG 4 for EN 13480-5:2024/prA1
5-006-2025	2025-11-13	8.4.2	Technical clarification	N 126	answer to the questioner

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CEN/TC 267/WG 8 N 126

6-001-2025	2025-04-30	A.3.4	Technical clarification	N 126	to CEN/TC 267/WG 1 next EN 13480-6:2024/prA1
6-002-2025	2025-04-30	6.1	Technical clarification	N 126	answer to the questioner

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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **1-001-2025**			**Date: 2025-04-30**	
Please fulfil the following				
Part: EN 13480-1	Issue: 2024-12	Page 11	Subclause Table 5.1.1	National Standard Reference DIN
Subject:				
Type of request:	☐ Technical clarification		☒ Editorial correction	
	☐ Technical comment		☐ Translation correction	

From :
Company:Caliqua AG.....
Name:Roland Dietler .....
Postal address:Bruderholzstarsse 31, CH-4053 Basel.
e-mail:roland.dietller@caliqua.ch.....
phone: +41613663510 .....

X Manufacturer	☐ User	☐ Other (please specify):

Question/comment:

There is no Figure A.1, A.2, A.3 A.4 in this norm an also not in the CEN/TR 13480-7:2017

Proposed answer(s): *

Add this figure to the CEN/TR 13480-7:2017 (Diagramm 6 to 9 in the PED)

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

No nessecity to repeat the content of the PED 2014/68/EU. The corresponding column of Table 5.1-1 will need to be withdrawn. This modification to be carried out within the frame of the next Draft Amendment EN 13480-1:2024/prA1. Action to be taken by CEN/TC 267/WG 1.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **2-001-2025**				**Date: 2024-12-06**
Please fulfil the following				
Part: EN 13480-2	Issue: 2024	Page 28	Subclause B.2.2.6	National Standard Reference --
Subject:				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	
From : Company: CO2Next..... Name: Jan-Willem Rensman ..... Postal address: Taurusavenue 155, 2132 LS, Hoofddorp, the Netherlands.....			e-mail: jan-willem.rensman@fluor.com ..... phone: +31 23 543 2164	
☐ Manufacturer	☒ User	☐ Other (please specify):		

European Committee for Standardization
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Question/comment:

Consider a liquefied CO2 terminal with an operating temperature window between -50 °C and +50 °C at a design pressure of 240 barg. The foreseen piping material for a 16" pipe is P355NL2 steel in the as-welded condition, impact tested for 27J at -50 °C with an allowable stress of approx. 204 MPa. Design, construction, and testing meet the requirements of EN 13480.

Consider a case of rapid depressurization during which CO2 temperatures can reach -78.5 °C by evaporative cooling, following the vapor-liquid/solid equilibrium of the CO2 phase diagram, as dictated by physics. Approximate low temperature pressure/temperature combinations of the CO2 phase diagram equilibrium are:

T (°C)	P (barg)
-50	5.8
-55	4.5
-60	3.0
-65	1.8
-70	0.9
-75	0.3
-78.5	0.0

The membrane stresses due to internal pressure during depressurization at temperatures below -50 °C are determined not to exceed 240/5.8 = 2.5% of the allowable stress. Membrane stresses due to external pressure are nonexistent. Membrane stresses due to dead weight will not exceed 10% of the allowable stress. Total membrane stress due to pressure and dead weight combined will not exceed 50 MPa.

Q1: Can EN 13480-2, Method 1, Table B.2-12, be utilized for establishing that at a membrane stress below 50 MPa, a temperature adjustment T_A of +40 °C is appropriate for P355NL2 in AW condition.

Proposed answer:

A1: Yes.

Q2: At a membrane stress below 50 MPa, is a metal temperature T_M of -80 °C thus justified during depressurization for an impact test temperature of T_R = -50 °C for P355NL2 in AW condition, according to the formula $T_R = T_M + T_A$ (per EN 13480-2, section 3.1.3).

Proposed answer:

A2: Yes.

Answer from the MHD *(to be filled by MHD):* 2025-11-19

Q1: Yes, Table B.2-12 of EN 13480-2:2024, Annex B, can be used for methods 1 and 2

Q2: This question is out of the scope of the Maintenance Working Group which shall not offer any consulting services

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

European Committee for Standardization
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Europaïsches Komitee für Normung

EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD):* **2-002-2025**			**Date: 2025-04-05**	
Please fulfil the following				
Part: EN 13480-2	Issue: 2024	Page *	Subclause	National Standard Reference BS
Subject: Clarification on Brittle Fracture Requirements in EN 13480-2				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	
From : Company: Hyundai Engineering..... Name: Kyoungwon Jung..... Postal address: Seoul, South Korea.....			e-mail: jkyoungwon@hec.co.kr ..... phone: +.....	
☐ Manufacturer	☒ User	☐ Other (please specify):		

Question/comment:

I would like to gain a better understanding of the EN standard approach regarding brittle fracture requirements as specified in EN 13480-2. As I understand it, for the use of materials at low temperatures where brittle fracture is a concern, Annex B of EN 13480-2 provides the relevant rules and guidance.

Annex B – Requirements for prevention of brittle fracture at low temperatures

Method 1: Use According to Code Practice

Based on my understanding, materials can be selected using the design reference temperature (TR) values provided in Tables B.2-1 to B.2-11.

For example,

the pipe EN 10216-2 – P265GH (1.0425) – TC2 may be used down to a design temperature of -20°C without any additional brittle fracture assessment.

Q1. Is my understanding above correct?

Method 2:

From my interpretation, Method 2 allows the use of materials based on a more detailed assessment. Below are two application scenarios for this method:

* Given Condition 1

(1) Pipe: EN 10216-2 – P265GH (1.0425) – TC2, seamless (non-welded)

(2) Reference thickness (eB): 15 mm

(3) Design temperature: - 46°C

(4) Minimum yield strength: 265 N/mm²

(5) Applicable curve: Figure B.2-1 (as per Table B.2.13)

(6) Required impact energy (KV) for full-size specimen (10 mm × 10 mm): minimum 27 J

Q2. Related to Given Condition1: If the impact test is performed at (TKV) - 46°C and the test results exceed 27 J, is the pipe acceptable for use at the given design temperature of -46°C?

* Given Condition 2

(1) Approach: Method 2

(2) Pipe: EN 10216-2 – P265GH(1.0425) – TC2, Non welded (Seamless)

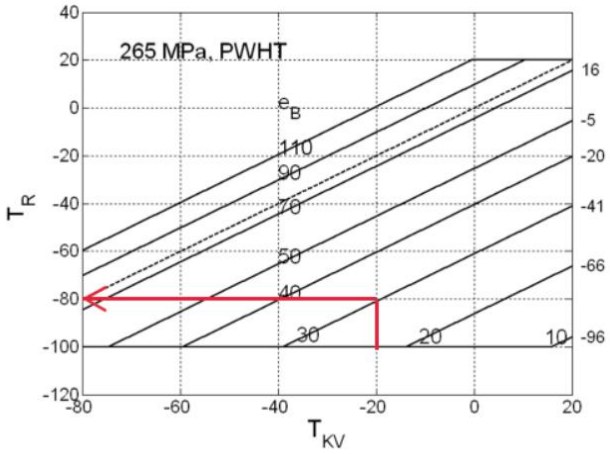
(3) Reference thickness (eB): 30mm

(4) Material Impact test temperature: -20°C

(5) Impact test result: more than 27J

Q3. With above given condition 2, the figure B.2-1 is applicable. According to the figure B.2-1, we can read TR value of -80°C at above given condition2. If the impact test had been conducted at -20 °C and test result was more than 27J, does it mean that the pipe can be used down to design temperature of -80°C according to figure B.2-1?

B.2.3.3 Nomograms for Method 2



Key
T_R design reference temperature
T_{KV} material impact test temperature
e_B reference thickness

Figure B.2-1 – METHOD 2: Design reference temperature and impact test temperature, post weld heat treated (PWHT) condition, for $R_e \leq 265$ N/mm² and $KV \geq 27$ J. Dashed line only to be used for $KV = 40$ J and for thickness from 75 mm up to and including 110 mm

Proposed answer(s): *

Q1: Yes, the material can be used down to the specified design reference temperature (T_R) listed in Tables B.2-2 to B.2-11, without requiring additional brittle fracture assessment.

Q2: Yes or No (I also expect CEN's guidance on the applicable section in EN 13480-2 for the assessment of material usage related to Condition 1).

Q3: Yes or No (I expect also CEN's guidance relevant to the corresponding case).

Answer from the MHD *(to be filled by MHD):* 2025-11-19
This question is out of the scope of the Maintenance Working Group which shall not offer any consulting services

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

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EN 13480 "Industrial piping and pipelines" Maintenance Group
Question form

Request reference number *(to be filled by MHD)*: **3-001-2025**			**Date**: **2025-04-05**	
Please fulfil the following				
Part: EN 13480-3	Issue: 2024	Page 49	Subclause 6.6.4	National Standard Reference --
Subject:				
Type of request: ☐ Technical clarification ☐ Technical comment		☒ Editorial correction ☐ Translation correction		
From : Company: CEA Name: Jorge MUÑOZ Postal address: CEA-Saclay, Gif-sur-Yvette		e-mail: jorge-enrique.munoz-garcia@cea.fr phone: + ...		
☐ Manufacturer	☐ User	☐ Other (please specify):		

Question/comment:

Tiny editorial correction concerning the edition year of 13445 standard, for the French edition only.

Proposed answer(s): *

6.6.4 Brides non normalisées

NOTE 2 L'algorithme donné dans l'EN 1591-1:2013 [4] ou l'EN 13445-3:20~~20~~21 tient compte des charges générées sur les tronçons.

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

Proposed answer by CEN/TC 267/WG 3 on 2025-09-22:

Agreed, correction to the French version only on EN 13480-3:2024

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

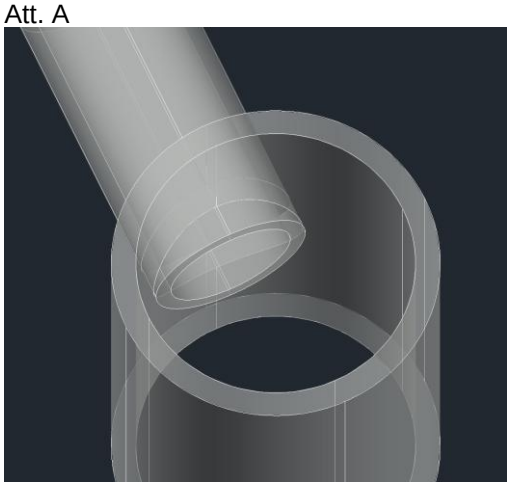
Request reference number *(to be filled by MHD):* **3-002-2025**				**Date: 2025-07-09**
Please fulfil the following				
Part: EN 13480-3	Issue: 2017	Page 91	Subclause 8.4.3	National Standard Reference --
Subject:				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	
From : Company:LM Engineering ..... Name:Yente Henry ..... Postal address:Evolis 11 Kortrijk, Belgium			e-mail:yhe@lmengineering.be..... phone:.....	
☐ Manufacturer	☒ User	☐ Other (please specify):		

Question/comment:

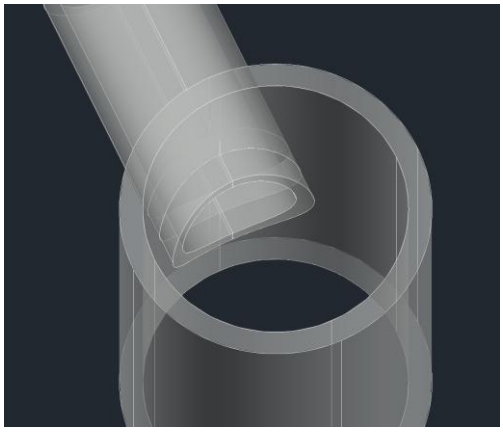
For set-through nozzles, in the longitudinal section for cylindrical and conical shells,a reinforcing length l'b is indicated (i.e. 8.4.3-1), and it is measured from the inside wall to the protruding edge. It is unclear however if this specific protrusion is required only at the longitudinal section (= branch pipe may be cut square, see attachment A) or if it has to persist along the intersection, as in attachment B. Since there's no clear normative explanation it has caused disagreements between fitters, designers and NoBo. Especially for lager di/Di ratios with a small l'b, the branch pipe's protruding edge intersects the internal shell wall when cut square, which means the reinforcement is only very local.

The lack of clarity is further complicated for non-radial branches in cylindrical shells (8.4.3 C refers to calculating the lateral section) and for oblique branches in spherical shells and dished ends, which also require calculation of the lateral section. 8.4.3-4 and 8.4.3-5 imply that the calculation had to be performed at 3 different points, as shown in attachment C, despite 8.4.3-5 showing a tapered protruding branch pipe that comes flush to the shell with no further explanation or calculation.

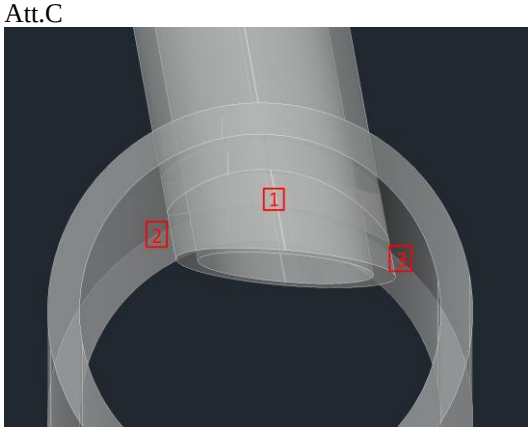
Att. A



Att. B



Att.C



Proposed answer(s): *

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Answer from the MHD *(to be filled by MHD):* 2025-11-19

Proposed answer by CEN/TC 267/WG 3 on 2025-09-22:
This aspect is already covered in EN 13480-3:2024, subclause 8.4.3 "Reinforced openings with $d_i/D_i < 0{,}8$" (see Figure 8.4.3-4).

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **3-003-2025** **Date: 2025-07-11**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13480-3	2024	105	9.3.2	--

Subject:

Type of request: ☐ Technical clarification ☐ Editorial correction

Technical clarification (and if needed Editorial correction)

From :

Company: Worley Engineers .....

Name: Richard van Laer .....

Postal address: Wilhelmina van Pruisenweg 2, 2595 AN | The Netherlands .....

e-mail: Richard.vanlaer@worley.com.....

phone: +31651220676 .....

☐ User

Question/comment:

1) Formula 9.3.2-3; where stands the symbol '*v*' for?

2) Formula 9.3.2-3; is '(1-v²)' correct? ==> (When 'v' value is 1, it creates a problem in the formula 9.3.2-3, **in one part the dividend will be zero**.)

.

Proposed answer(s): *

1) Is the correct description for 'v', "Weld efficiency" ? if not for what els?
2) Must the '(1-v²)' become '(1-v/2)' like in formula 9.3.3-3?

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

Proposed answer by CEN/TC 267/WG 3 on 2025-09-22:

1) This is Poisson's ratio (defined in Annex G of EN13480-3, in § G.2.5, and in Table 3.2.1 of EN13480-1).

2) No subject; we won't divide by zero with steel.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

European Committee for Standardization
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Europaïsches Komitee für Normung

EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **3-004-2025** **Date: 2025-08-21**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13480-3	2017	79	8.3.3	--

Subject: Weld of branch connection

Type of request: ☒ Technical clarification ☐ Editorial correction ☐ Technical comment ☐ Translation correction

From :
Company: PRODEVAL.....
Name: Sébastien JANIN.....
Postal address: 7 rue Anne-Marie Staub, Quartier du 45ème parallèle
26300 Chateauneuf-sur-Isère | BP 22145 - VALENCE CEDEX 9
FRANCE.....
e-mail: s.janin@prodeval.com.....
phone: +33 4 79 71 05 86 .....

☐ Manufacturer ☒ User ☐ Other (please specify):

Question/comment: Article 8.3.3 indicates that set-on or penetrating branch connection joined by sealing welds only shall not be considered as reinforcement and shall be calculated in accordance with 8.4.2.

For reference, the French version says (I don't have the English edition):

> Les tubulures posées ou pénétrantes assemblées par soudure d'étanchéité uniquement ne doivent pas être considérées comme un renforcement et doivent être calculées conformément à 8.4.2.

Article 8.4.2 provides an equation that must be satisfied so that a branch connection does not require reinforcement.

1) **Does sealing welds mean all welds except full penetration welds? I.e. fillet weld or partial penetration weld**
2) **Does this article prohibit the use of partial penetration welding on branch connection that do not comply with the condition set out in Article 8.4.2?**

Proposed answer(s): *

1) Yes
2) Indicate that the reinforcement calculations in Article 8 are only valid for full penetration welds

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

Proposed answer by CEN/TC 267/WG 3 on 2025-09-22:

1) No, fillet weld and partial penetration weld are acceptable where applicable in EN 13480 series and shall be designed accordingly.

2) No.

Note: A sealing weld is not a design element for a branch connection.

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EN 13480 "Industrial piping and pipelines" Maintenance Group
Question form

Request reference number *(to be filled by MHD):* **3-005-2025**				**Date: 2025-10-13**
Please fulfil the following				
Part: EN 13480-3	Issue: 2024	Page 310, 319	Subclause	National Standard Reference --
Subject:				
Type of request: ☒ Technical clarification ☐ Technical comment ☒ Editorial correction ☐ Translation correction				
From : Company: K+S AG..... Name: Marcus Kolbe..... Postal address: Bertha-von-Suttner-Straße 7 34131 Kassel				e-mail: marcus.kolbe@k-plus-s.com..... phone: +49 1525 6738049
☐ Manufacturer	☒ User	☐ Other (please specify):		

Question/comment:

Technical Clarification/Correction:

Consistency Check Between Expressions for e_s, DIN EN 13480 -3: 2024-12, Page 310

Given Expressions and Relationships:

1. First expression for e_s:

$$e_s = \frac{1}{c} \cdot \frac{p_c \cdot D_m}{2 \cdot f \cdot z} \cdot \sin(\varphi_b)^{-\frac{2}{3}}$$

(O.3.2-2), DIN EN 13480 -3: 2024-12, Page 310

2. Second expression for e_s:

$$e_s = \frac{1}{c} \cdot \frac{p_c \cdot D_i}{2 \cdot f \cdot z - p_c} \cdot \sin(\varphi_b)^{-\frac{2}{3}}$$

(O.3.2 -1), DIN EN 13480 -3: 2024-12, Page 310

3. Geometric relationships:

$$D_m = \frac{D_o + D_i}{2} \quad \text{and} \quad D_o = D_i + 2 \cdot e_s$$

Step 1: Substitute D_m in the first Expression:

From $D_o = D_i + 2 \cdot e_s$ compute D_m

$$D_m = \frac{D_i + 2 \cdot e_s + D_i}{2} = D_i + e_s \qquad (1)$$

Substitute (1) into the first expression:

$$e_s = \frac{1}{c} \cdot \frac{p_c \cdot (D_i + e_s)}{2 \cdot f \cdot z} \cdot \sin(\varphi_b)^{-\frac{2}{3}}$$

Step 2: Reformulate the First Expression

$$e_s \cdot c \cdot 2 \cdot f \cdot z \cdot \sin(\varphi_b)^{\frac{3}{2}} = p_c \cdot (D_i + e_s)$$

Multiply both sides by $2f \cdot z \cdot c \cdot \sin(\varphi_b)^{\frac{3}{2}}$, expand and rearrange the terms:

$$e_s = \frac{p_c \cdot D_i}{2 \cdot f \cdot z \cdot \sin(\varphi_b)^{-\frac{2}{3}} - p_c}$$

Step 3: Compare with the Second Expression (O.3.2 -1), DIN EN 13480 -3: 2024-12, Page 310

The second expression is:

$$e_s = \frac{1}{c} \cdot \frac{p_c \cdot D_i}{2 \cdot f \cdot z - p_c} \cdot \sin(\varphi_b)^{-\frac{3}{2}} = \frac{p_c \cdot D_i}{c \cdot (2 \cdot f \cdot z - p_c) \cdot \sin(\varphi_b)^{\frac{3}{2}}}$$

The first Expression for e_s is:

$$e_s = \frac{p_c \cdot D_i}{c \cdot 2 \cdot f \cdot z \cdot \sin(\varphi_b)^{\frac{3}{2}} - p_c}$$

For consistency, the denominators of both expressions for e_s must be equivalent:

$$2 \cdot f \cdot z \cdot c \cdot \sin(\varphi_b)^{\frac{3}{2}} - p_c = c \cdot (2 \cdot f \cdot z - p_c) \cdot \sin(\varphi_b)^{\frac{3}{2}}$$

Expand the right-hand side and substitude into the equation:

$$2 \cdot f \cdot z \cdot c \cdot \sin(\varphi_b)^{\frac{3}{2}} - p_c = 2 \cdot f \cdot z \cdot c \cdot \sin(\varphi_b)^{\frac{3}{2}} - c \cdot p_c \cdot \sin(\varphi_b)^{\frac{3}{2}}$$

Conclusion:

The two expressions for e_s are not consistent, thus:

the Equations O.3.2-2, O.3.2-3 and O.3.2-1 do not deliver the same result for p_c by given Values for e_s and e_b

Example:

	mm		N/mm²	Dm/es	21
Di	200		f 156,7	eb/es	0,5
di	100		=235,05/1,5		
Do	220			dm/Dm	0,5
do	110				
	mm				
Dm	210				
dm	105				

	mm		c = min [(Ax2 + Bx + C); 1]	5	Dm/es	*A*	*B*	*C*
e_{as}	10		c = 0,618392		20	1,5686	-1,8785	1,1708
e_{ab}	5				21	1,5792	-1,8980	1,1726
					40	1,7802	-2,2684	1,2067

In Table O.3.2-1 there are no given Values for Dm/es = 21. It is not clear how it should be dealt with in such cases.

The Standard must be clear whether it should be used the next given Value (in this case this would be the Value for Dm/es = 20) or the Values for A, B and C interpolated to match Dm/es = 21.

The same problem is, when e_b/e_s does not match the given ranges in picture O.3.2-1 to O 3.2-6 (0,2 ; 0,5 ; 0,8 ; 1,0 ; 1,2 ; 1,5)

For instance, when e_b/e_s is 0,35 , which Value should be used? 0,2 or 0,5? A Standard must be clear in such cases or provide the means to calculate the Values within.

In this example

$$f(x) = f_0 + \frac{f_1 - f_0}{x_1 - x_0}(x - x_0) = f_0 \frac{x_1 - x}{x_1 - x_0} + f_1 \frac{x - x_0}{x_1 - x_0}.$$

for linear Interpolation has been used to calculate the Values A, B and C for Dm/es = 21 in between the given Values for 20 and 40.

$e_s = \frac{1}{c}\left(\frac{p_c \cdot D\,i}{2 \cdot f \cdot z - p_c}\right)^{-\frac{3}{2}} \cdot \sin(\varphi_b)$ $p_c = \frac{2 \cdot f \cdot z}{\frac{D_i}{e_s \cdot c \cdot \sin(\varphi_b)^{\frac{3}{2}}} + 1}$	$e_b = \frac{1}{c}\left(\frac{p_c \cdot d\,i}{2 \cdot f \cdot z - p_c}\right)^{-\frac{3}{2}} \cdot \sin(\varphi_b)$ $p_c = \frac{2 \cdot f \cdot z}{\frac{d_i}{e_b \cdot c \cdot \sin(\varphi_b)^{\frac{3}{2}}} + 1}$
p_c=9,399579	p_c=9,399579

The Calculation-formula which contains Di and di deliver the same result.

$e_s = \frac{1}{c}\left(\frac{p_c \cdot D_m}{2 \cdot f}\right)^{-\frac{3}{2}} \cdot \sin(\varphi_b)$ $p_c = \frac{2 \cdot c \cdot e_s \cdot f \cdot z \cdot \sin(\varphi_b)^{\frac{3}{2}}}{D_m}$	$e_b = \frac{1}{c}\left(\frac{p_c \cdot d_m}{2 \cdot f}\right)^{-\frac{3}{2}} \cdot \sin(\varphi_b)$ $p_c = \frac{2 \cdot c \cdot e_b \cdot f \cdot z \cdot \sin(\varphi_b)^{\frac{3}{2}}}{d_m}$
p_c=9,228771	p_c=9,228771

The Calculation-formula which contains D_m and d_m deliver the same result, but different from the results for D_i and d_i.

$e_s = \frac{1}{c}\left(\frac{p_c \cdot D\,o}{2 \cdot f \cdot z + p_c}\right)^{-\frac{3}{2}} \cdot \sin(\varphi_b)$ $p_c = \frac{2 \cdot f \cdot z}{\frac{D_o}{e_s \cdot c \cdot \sin(\varphi_b)^{\frac{3}{2}}} - 1}$	$e_b = \frac{1}{c}\left(\frac{p_c \cdot d_m}{2 \cdot f}\right)^{-\frac{3}{2}} \cdot \sin(\varphi_b)$ $p_c = \frac{2 \cdot c \cdot e_b \cdot f \cdot z \cdot \sin(\varphi_b)^{\frac{3}{2}}}{d_m}$
p_c=9,06406169	p_c=8,5684342

The results for p_c which contain D_o and d_o do not match at all. Neither among each other nor with the results listed above.

The result for p_c should be the range p_c = 8,1 N/mm² calculated with formula 8.4.3-1, for attached nozzle

$p_c \cdot A_p \le \left(f_b - \frac{p_c}{2}\right) \cdot A_{f\,b} + \left(f_s - \frac{p_c}{2}\right) \cdot A_{f\,s}$ $p_c = \frac{f_b \cdot A_{fb} + f_s \cdot A_{fs}}{A_p + \frac{1}{2}\left(A_{fb} + A_{fs}\right)}$	$A_p = \left(l_s + e_{ab} + \frac{d_i}{2}\right) \cdot \left(l_b + e_{as} + \frac{D_i}{2}\right) - \left(l_s + e_{ab}\right) \cdot \left(l_b + e_{as}\right)$ $A_{fb} = l_b \cdot e_{ab}$ | $A_{fs} = \left(l_s + e_{ab}\right) \cdot e_{as}$

The result p_c = 8,1 N/mm² has been checked with the result from the Book “Walter Wagner, Festigkeitsberechnungen im Apparatebau” ISBN:978-3-8343-3527-2, which uses a similar approach. The values for e_b, e_s, f and the Diameters have been adopted.

Proposed answer(s): *

1. Suspend Amendment O until errors are solved!
2. Clarify how missing values for e_b/e_s; D_m/e_s must be calculated, or which values must be used, in case the needed value for e_b/e_s and D_m/e_s is missing.

Answer from the MHD *(to be filled by MHD):* 2025-11-19
CEN/TC 267/WG 3 answer on 2025-11-18

1. Annex O is linked to ESR 2.2.3 of the PED (see Table ZA.1 of EN 13480-3:2024), no suspension of this Annex. This topic will be further studied and clarified by experts of CEN/TC 267/WG 3. Subject to be considered for the subsequent draft amendment prA2. In the meantime take the most conservative result of the possibilities given in any situation.
2. This topic will be further studied and clarified by experts of CEN/TC 267/WG 3. Subject to be considered for the subsequent draft amendment prA2.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

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Comité Européen de Normalisation
Europaïsches Komitee für Normung

EN 13480 "Industrial piping and pipelines" Maintenance Group
Question form

Request reference number *(to be filled by MHD)*: **3-006-2025**	**Date: 2025-10-22**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13480-3	2024	105	9.3.3	--

Subject: The definition of k and pr are missing; Values for Δr

Type of request: ☒ Technical clarification ☐ Editorial correction ☐ Technical comment ☐ Translation correction

From :
Company: TÜV NORD Systems GmbH & Co. KG .....
Name: Hans-Jürgen König .....
Postal address: Am TUEV 1, 45307 Essen, Germany.
e-mail: hankoenig@tuev-nord.de .....
phone: +49 201 825 2560 .....

☐ Manufacturer ☒ User ☐ Other (please specify):

Question/comment:

a) The definition of **k** is missing for formula (9.3.3-2) and (9.3.3-4)

b) The formula for **pr** is missing. **pr** is listed in symbol list Table 9.2.1-1

c) How to get values for **Δr** ? (subclause 9.3.2 c)3

Proposed answer(s): *

a) **k** = 1,5 according in EN 13480+3: Issue 2017. Subclause 9.3.2 d)

b) **pr** according in EN 13480+3: Issue 2017. Subclause 9.3.2 c) +d) incl. Table 9.3.2-1

c) **Δr** = [maximum tolerance of D (outside diameter) + maximum tolerance of d (inside diameter)]/2
Tolerance values for example according to table 7 and 8 of EN 10216-2:2013+A1:2019

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Answer from the MHD *(to be filled by MHD):* 2025-11-19

CEN/TC 267/WG 3 answer on 2025-11-18

a) yes **k** = **ky** = 1,5 (**k** will be changed to **ky** in the current Draft amendment EN 13480-3:2024/prA1).
b) pr has been removed from subclause 9.3. It is still used in subclause 9.5.
c) Δr is the maximum deviation from mean radius (in mm) and this will be clarified in the upcoming Draft amendment EN 13480-3:2024/prA1 for CEN Enquiry, as indicated here after:

In 9.3.2, the first sentence of indent c) shall read as follows:

"c) Determine the onset of plastic deformation using the given external pressure and the radius tolerance $\frac{\Delta r}{R_{\mathrm{mean}}}$ of the manufacturing specification (e.g. $\frac{\Delta r}{R_{\mathrm{mean}}} = \frac{u}{2}$ using the out-of-roundness as specified in EN 13480-4:2024, Equation (7.4.1-1)):"

And in the whole Clause 9, R_{m} shall be replaced by R_{mean} everywhere it is specified.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

European Committee for Standardization
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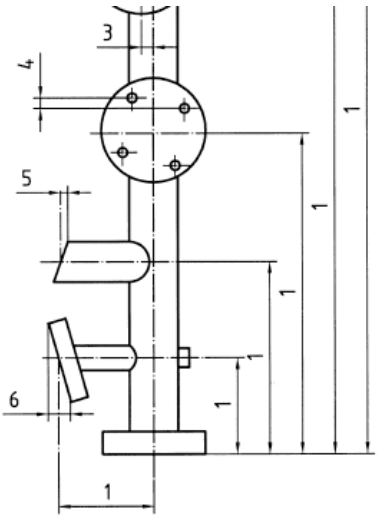
EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **4-001-2025**				**Date: 2025-07-02**
Please fulfil the following				
Part: EN 13480-4	Issue: 2017	Page 42+43	Subclause Annex B	National Standard Reference --
Subject: Pipe Flange Rotation Tolerance				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	
From : Company: Equans Name: Claire Glanville Postal address: Equinox North, Great Park Road, Bradley Stoke, Bristol, BS32 4QL			e-mail: claire.glanville@equans.com phone: +.....	
☐ Manufacturer	☐ User	☒ Other (please specify): Design + Manufacturing Contractor to end User		

Question/comment:

The flange in the schematic for piping spools has 4 bolt holes. For a flange with >4 bolt holes the standard does not state explicitly which bolt holes the rotational tolerance measurement applies.



Key

Dimension No 1:	face-to-face dimensions; centre-to-face dimensions; location of attachments; centre-to-centre dimensions.
Dimension No 2:	out-of-roundness of bends.
Dimension No 3:	lateral translation of branches or connections.
Dimension No 4:	rotation of flanges, from the indicated position, measured as shown.
Dimension No 5:	bevels on butt weld or plain ends – state diameter to which bevel applies.
Dimension No 6:	out-of-alignment of flanges from the indicated position, measured across the full gasket face diameter.

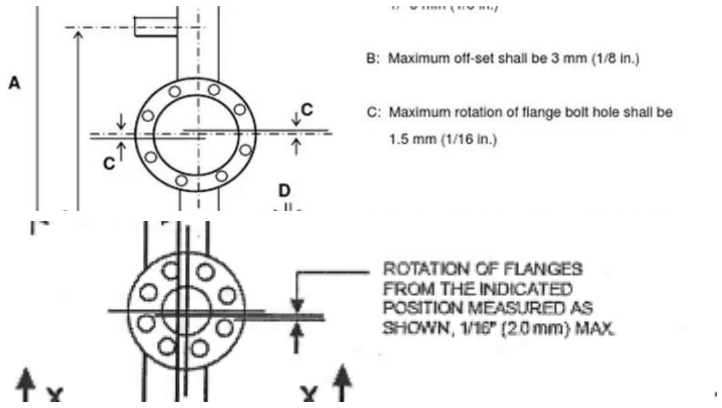
Figure B.1 — Dimensional details of spools

The tolerance is strictest when applied to the bolt holes closest to the centreline. Please confirm if this is where the tolerance applies or if it applies to the top two bolt holes only?

Proposed answer(s): *

The tolerance should be applied to the two bolt holes closest to the centreline.

This aligns the EN13480-4 standard with ASME B31.3 and PFI ES-3 Standards where the tolerance is specified at the centreline.



The schematic will be updated to show a flange with >4 bolt holes so there is no ambiguity.

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Answer from the MHD *(to be filled by MHD):* 2025-11-19 Yes, the tolerance should be applied to the two bolt holes closest to the centreline. The Annex B of EN 13480-4:2025 will be revised based on Figure 8.3.1-1. This modification needs to be carried out through the on-going Draft Amendment EN 13480-4:2024/prA1 under CEN Enquiry.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

European Committee for Standardization
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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **5-001-2025** **Date: 2025-05-01**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13480-5	2017	13	7.3.5	--

Subject: Inspection of built up pipe ends

Type of request: ☒ Technical clarification ☐ Editorial correction ☐ Technical comment ☐ Translation correction

From :
Company: Kiwa Sweden AB .....
Name: Adam Sobota .....
Postal address: .....
e-mail: adam.sobota@kiwa.com .....
phone: +46702327138 .....

☐ Manufacturer ☐ User ☒ Other (please specify): Notified Body 0409

Question/comment:

What does “Built up pipe ends mean”? Can you give an example? Is a cap a built up pipe end? And what is the technical reason for 100% NDT. I have asked Kiwa´s Lead Design Review Engineer and several manufacturers and none of them have been able to give a good answer.

Proposed answer(s): *

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

CEN/TC 267/WG 5 answer on 2025-11-18

Pipe ends may have to be built up by welding in some cases.
The most common being that the pipe cannot be fitted with a root gap in accordance with the welding procedure. When the root gap is too large this may be rectified by adding weld metal to the end of the pipe, building a sufficient thick layer of weld to obtain a weld preparation and root gap to suit the welding procedure.
Occasionally the end of a pipe may be built up by adding a corrosion resisting alloy, either to simplify the welding of carbon or clad pipe to a corrosion resisting pipe. This weld may, or may not, then be heat treated as required by the base material. This is more common on equipment nozzles when joining to corrosion resisting piping.
Such welds shall be inspected in accordance with 7.3.5.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

European Committee for Standardization
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Europaïsches Komitee für Normung

EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **5-002-2025**			**Date**: **2025-06-18**	
Please fulfil the following				
Part: EN 13480-5	Issue: 2024	Page -	Subclause 9.3.2.2	National Standard Reference --
Subject: Inspection of built up pipe ends				
Type of request:	☒ Technical clarification	☐ Editorial correction		
	☐ Technical comment	☐ Translation correction		

From :
Company: Standards Norway
Name: Ståle Prehn-Sletten .....
Postal address:
P.O. Box 242, NO-1326 Lysaker, Norway
Lilleakerveien 2A, NO-0283 Oslo

e-mail: spr@standard.no
phone: +47 408 62 614.....

☐ Manufacturer	☐ User	☒ Other (please specify): Standardization Body

Question/comment:

I have received a question regarding EN 13480-5 Clause 9.3.2.2 from one of our Norwegian Mirror Committee members. Could you please fromward this to the relevant WG? Question below.
Unclear definition of PS and what it relates to.

9.3.2.2.1

The test pressure shall be not less than the greater of the two values determined by the following:

$$P_t = 1{,}25 \cdot PS \cdot \frac{f_{test}}{f} \quad (9.3.2\text{-}1)$$

or

$$P_t = 1{,}43 \cdot PS \quad (9.3.2\text{-}2)$$

where

f	is the nominal design stress for design conditions at design temperature, in MPa (N/mm^2) (but limited to time-independent values, see paragraph before NOTE 1);
f_{test}	is the nominal design stress for design conditions at test temperature, in MPa (N/mm^2);
PS	is the maximum allowable pressure, in bar;
P_t	is the test pressure, in bar.

Are there any further works where the definition of PS is discussed (preparatory works or similar)?

The reason I ask is that among several of our suppliers and customers, conflicting claims are emerging:

1. PS must mean the maximum pressure allowed by the safety valve, e.g., 8 bar in a PN16 piping system.
2. PS must mean the design pressure in the system, i.e., 16 bar in a PN16 piping system.
3. PS must mean the pressure class of the component in the piping system with the highest pressure rating, regardless of the pipe's pressure class. For example, a component approved up to 25 bar in a 16 bar piping system.

As you can see, there are at least three different scenarios that could be argued for as the meaning of PS, and all would result in different test pressures (PT), respectively PT = 8 bar x 1.43, PT = 16 bar x 1.43, or PT = 25 bar x 1.43.

Proposed answer(s): *

Answer from the MHD *(to be filled by MHD):* 2025-11-19

PS follows the definition of the PED and refers to the safety valves.
EN 13480-1 refers to EN 764-1. PS is defined in EN 764-1, 3.2.87.

The PN of the standard flange is a different value. The piping may have different (higher) pressures at certain places of the routing (e.g. PS plus pressure produced by liquid weight at the bottom of a vertical routed piping).

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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **5-003-2025**	**Date: 2025-08-03**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13480-5	2024	20	9.3.2.1.2	--

Subject: clarification/more information on requirement

Type of request: ☒ Technical clarification ☐ Editorial correction ☐ Technical comment ☐ Translation correction

From :
Company: LRQA .....
Name: Chandrakant Ghude .....
Postal address: .....
e-mail: Chandrakant Ghude .....
phone: +971-588246704 .....

☐ Manufacturer ☐ User ☒ Other (please specify): Working on behalf of user as TPI

Question/comment:

Clause **9.3.2.1.2** All joints shall be left uninsulated and unlined and exposed for examination during pressure testing, except that joints and tubes previously tested in accordance with this standard can be insulated or covered. **A primer for corrosion protection shall be permitted, provided, it does not prevent the clear examination of the joint under test.**

No requirement for limitation of coating thickness stated anywhere.

Proposed answer(s): *

1.0 Weld joints can be prime coated with more than 100 microns.
2.0 Complete length of pipe can be top coated except weld which as per answer 1.

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

Q1 : In EN 13480-5 there is no requirement regarding corrosion protection thickness allowed prior to testing and final inspection.
Q2 : Yes, complete length of pipe can be top coated except weld which as per answer Q1.

Technical question forwarded to the relevant European working groups CEN/TC 267/WG 4 and WG 5 for further study in a next subsequent Draft Amendment.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

European Committee for Standardization
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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **5-004-2025**			**Date: 2025-07-21**	
Please fulfil the following				
Part: EN 13480-5	Issue: 2017	Page 15&20	Subclause 8.1.3 & 9.3.1	National Standard Reference --
Subject: NDT penalties on proof tested sections of piping lines.				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	

From:
Company: Entrepose Contracting
Name: Sébastien VICENS
Postal address: Bâtiment Java – 1973, boulevard de la Défense – CS 10268 – 92757 Nanterre Cedex
e-mail: sebastien.vicens@entrepose.com
phone: +33 6 33 74 36 37

☒ Manufacturer ☐ User ☐ Other (please specify):

Question/comment:

According to EN 13480-5, clause 8.1.3(e), if any of the two additional welds examined reveal unacceptable imperfections, all welds in the batch represented by the sample inspection shall be examined. On our project, sections of piping lines are progressively constructed and proof tested.

If, during subsequent construction on a different part of the same line within the same batch (same welder and WPS on the same line number), a defect is found that triggers clause 8.1.3(e), does this require re-examination (100% NDT) of previously accepted and proof-tested piping lines?

Context:

- The piping lines are long and constructed in stages, meaning there can be months between one section of a line being finalized and another being built.
- Each part of a piping line is proof tested as construction progresses.
- Clause 9.3.1 of EN 13480-5 states that all piping shall be subjected to a proof test to demonstrate the integrity of the finished product.
- Clause 8.1.3(e) does not explicitly address whether previously accepted and proof-tested sections of piping lines are exempt from further NDT if another section in the same batch triggers full inspection.

We seek confirmation that once a section of a piping line has been proof tested and accepted, it is considered as a final product and not subject to further NDT even if clause 8.1.3(e) is triggered later in the project on a different section of the line.

Proposed answer(s): *

Once a part of a line has been accepted and proof tested, it is considered finalized. Subsequent NDT findings on other parts of lines do not retroactively affect the acceptance status of previously tested and accepted line sections.

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

CEN/TC 267/WG 5 answer on 2025-11-18

The sample size is established by the manufacturer. It determines the number of re-examinations of all welds within this sample in the event of unacceptable defects as per section 8.1.3 e) of EN 13480-5. A sample may include welds that have already been pressure tested.

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EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **5-005-2024**			**Date: 2025-08-26**	
Please fulfil the following				
Part: EN 13480-5	Issue: 2017	Page 18	Subclause 8.4.4.3	National Standard Reference --
Subject: Volumetric NDT methods – PAUT on thin wall thicknesses.				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	

From:
Company: Entrepose Contracting
Name: Sébastien VICENS
Postal address: Bâtiment Java – 1973, boulevard de la Défense – CS 10268 – 92757 Nanterre Cedex

e-mail: sebastien.vicens@entrepose.com
phone: +33 6 33 74 36 37

☒ Manufacturer ☐ User ☐ Other (please specify):

Question/comment:

According to EN 13480-5 clause 8.4.4.3, methods of volumetric NDT shall be selected according to EN ISO 17635:2016, Table 3.

EN ISO 17635:2016 does not include a reference to ISO 20601 for phased array examination of wall thicknesses between 3.2 and 8.0 mm. As per ISO 17635:2016, phased array examination can only be performed in accordance with ISO 13588, meaning from 6mm onwards. This limitation significantly reduces the scope of PA examination that can be carried out on industrial plants.

ISO 17635:2025 includes a new table (A.10) referencing ISO 20601.

Proposed answer(s): *

Clause 8.4.4.3 will be updated to in the next revision to refer to ISO 17635: 2025 and allow the use of both Tables A.9 and A.10.

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

Proposal of answer from CEN/TC 267/WG 5 Convenor is to revise subclause 8.4.4.3 "*Volumetric testing*" of EN 13480-5:2024 within the frame of the current drafting of the draft amendment prA1 (WI 00267098), as follows:
"*Testing techniques shall be in accordance to EN ISO 17635:2025, Tables A.5 (RT-F), A.6 (RT-D), (RT-CR) or (DDA), A.7 (UT), A.8 (TOFD) and A.9 and A.10 (both PA-UT).*"

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

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

EN 13480 "Industrial piping and pipelines" Maintenance Group
Question form

Request reference number *(to be filled by MHD)*: **5-006-2025**			**Date: 2025-11-13**	
Please fulfil the following				
Part: EN 13480-5	Issue: 2024	Page	Subclause 8.4.2	National Standard Reference --
Subject: application of annex B of EN ISO 5817:2023 or not to be compliant with §8.4.2 EN13480-5:2024				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	
From : Company: FIVES NORDON Name: Patrick FORTERRE Postal address: FRANCE			e-mail: patrick.forterre@fivesgroup.com phone:	
☐ Manufacturer	☒ User	☐ Other (please specify):		

Question/comment:

According to §8.4.2 EN13480-5:2024, for piping in fatigue conditions, the quality level according to EN ISO 5817:2023 is B for surface imperfections and imperfections in joint geometry.

When we have to perform a calculation for fatigue because piping is subjected to fatigue, is the informative annex B of the EN ISO 5817:2023 mandatory to be taken into account ?

In the table 8.4.2.1 of EN13480-5, it goes from quality level C to B because of fatigue but there is no information concerning annex B EN ISO 5817:2023. If this annex B is applicable, what do you have to use : B90 or B125 ?

Proposed answer(s):

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

CEN/TC 267/WG 5 answer on 2025-11-18

EN 13480-5 has no reference to the informative Annex B of EN ISO 5817:2023.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*

European Committee for Standardization
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Europaïsches Komitee für Normung

EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **6-001-2025**			**Date: 2025-04-30**	
Please fulfil the following				
Part: EN 13480-6 :2024	Issue: 2024	Page 28-30	Subclause A.3.4	National Standard Reference --
Subject:				
Type of request:	☒ Technical clarification	☐ Editorial correction		
	☐ Technical comment	☐ Translation correction		

From :
Company: Linden Engineering GmbH .....
Name: Nobleaux, Gerd.....
Postal address: Bodenbacher Str. 80, 01277 Dresden, Germany .....
e-mail: gerd.nobleaux@linde.com .....
phone: +49351 250 3220.....

☐ Manufacturer	☒ User	☐ Other (please specify):

Question/comment:

In Chapter A.3.4 “Determination of the moments acting upon the piping” the determination of the moments and stresses is described. Unfortunately, the description is incomplete or incomprehensible to the user. Can you please create a sample calculation in which the calculation steps are shown in full?

Proposed answer(s): *

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

This question is out of the scope of the Maintenance Working Group.
Nevertheless, the Annex A of EN 13480-6:2024 will be revised within the frame of the next Draft Amendment EN 13480-6:2024/prA1. Action will be carried out by the European working group CEN/TC 267/WG 1 (supported by WG 3).

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

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Europaïsches Komitee für Normung

EN 13480 "Industrial piping and pipelines" Maintenance Group Question form

Request reference number *(to be filled by MHD)*: **6-002-2025**			**Date: 2025-04-30**	
Please fulfil the following				
Part: EN 13480-6	Issue: 2024-12	Page 7	Subclause 6.1	National Standard Reference DIN
Subject:				
Type of request:	xTechnical clarification	☐ Editorial correction		
	☐ Technical comment	☐ Translation correction		
From : Company:Caliqua AG..... Name:Roland Dietler ..... Postal address:Bruderholzstarsse 31, CH-4053 Basel.		e-mail:roland.dietller@caliqua.ch..... phone: +41613663510		
X Manufacturer	☐ User	☐ Other (please specify):		

Question/comment:

The sentence makes no sence “Die Wanddicke des Rohres darf den in Tabelle 1 angegebenen Wert nicht unterschreiten, außer wenn die Berechnungen zur Druckauslegung eine **größere** Wanddicke ergeben.(The wall thickness of the pipe must not be less than the value specified in Table 1, unless the pressure design calculations result in a **greate**r wall thickness.)”

Proposed answer(s): *

Correct: The wall thickness of the pipe must not be less than the value specified in Table 1, unless the pressure design calculations result in a **smaller** wall thickness.

Answer from the MHD *(to be filled by MHD)*: 2025-11-19

No, the minimum wall thickness shall comply with Table 1 of 6.1 "Minimum wall thickness for buried piping" of EN 13480-6:2024, and also with the pressure design calculation.

To be sent to EN 13480 Maintenance Group secretariat:	EN 13480 Maintenance Group secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France

***** *Please note that question with proposed answers will be dealt with as priority.*