BS EN 1555-1:2010

BSI Standards Publication

Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE)

Part 1: General

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National foreword

This British Standard is the UK implementation of EN 1555-1:2010. It supersedes BS EN 1555-1:2002 which is withdrawn. Together with BS EN 1555-2:2010 and BS EN 1555-5:2010, it supersedes BS 7281:1990 which is withdrawn.

The UK participation in its preparation was entrusted by Technical Committee PRI/88, Plastics piping systems, to Subcommittee PRI/88/2, Plastics piping for pressure applications.

A list of organizations represented on this subcommittee can be obtained on request to its secretary.

NOTE 1 *There is no Part 6 in the EN 1555 series. Instead users of this standard should refer to EN 12007-2, Gas supply systems – Pipelines for maximum operating pressure up to and including 16 bar – Part 2: Specific functional recommendations for polyethylene (MOP up to and including 10 Bar). Users of this standard are also referred to the guidance issued by National Grid, for example T/PR/ML/4 - Work procedure for pipe system construction.*

NOTE 2 *Part 7 of the EN 1555 series has been prepared as a CEN/TS to allow further development. CEN/TS 1555-7 is not mandatory under the Public Procurement Directives (2004/18/EC and 2004/17/EC).*

Users should be aware of any appropriate safety precautions relating to pipework for combustable gas, such as the National Grid Gas document *T/PR/ML/4, Work procedure for pipe system construction Module 4 – PE main laying up to an including 630 mm diameter at pressures up to and including 2 bar*. It is assumed in the drafting of a standard that the execution of its provisions is entrusted to appropriately qualified and competent people.

National Annex NA provides additional information on the selection and installation of piping systems and components in the UK.

Attention is drawn to the following statutory regulation: Health & Safety at Work etc. Act 1974, and subsequent regulations.

The UK Committee would like to emphasise that compliance with this British Standard does not necessarily mean that products are fit for the purpose of conveying gaseous fuels in the UK. The EN 1555 series of standards are not fully compatible with existing UK practice in terms of applicable pressure tiers, preferred colours for gas pipe recognition, jointing and installation methods.

The requirements contained in the EN 1555 series of standards are not necessarily indicative of all the performance requirements, or the suitability of pipework for the service conditions, likely to be encountered in the UK.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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Compliance with a British Standard cannot confer immunity from legal obligations.

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This European Standard was approved by CEN on 30 July 2010.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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Management Centre: Avenue Marnix 17, B-1000 Brussels

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Foreword

This document (EN 1555-1:2010) has been prepared by Technical Committee CEN/TC 155 “Plastics piping and ducting systems”, the secretariat of which is held by NEN.

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 March 2011, and conflicting national standards shall be withdrawn at the latest by March 2011.

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 1555-1:2002.

It has been prepared in liaison with Technical Committee CEN/TC 234 "Gas infrastructure".

System Standards are based on the results of the work being undertaken in ISO/TC 138 "Plastics pipes, fittings and valves for the transport of fluids", which is a Technical Committee of the International Organization for Standardization (ISO).

They are supported by separate standards on test methods to which references are made throughout the System Standard.

The System Standards are consistent with general standards on functional requirements and on recommended practice for installation.

EN 1555 consists of the following parts:

— EN 1555-1, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 1: General* (this standard);

— EN 1555-2, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 2: Pipes*;

— EN 1555-3, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 3: Fittings*;

— prEN 1555-4, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 4: Valves*;

— EN 1555-5, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 5: Fitness for purpose of the system*;

— CEN/TS 1555-7, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 7: Guidance for assessment of conformity*.

NOTE EN 12007-2:2000 [1] prepared by CEN/TC 234 “Gas infrastructure” deals with the recommended practice for installation of plastics pipes system in accordance with EN 1555 (all parts).

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.

Introduction

The System Standard, of which this is Part 1, specifies the requirements for a piping system and its components made from polyethylene (PE) and which is intended to be used for the supply of gaseous fuels.

Requirements and test methods for components of the piping system are specified in EN 1555-2, EN 1555-3 and prEN 1555-4.

Characteristics for fitness for purpose are covered in EN 1555-5 [6]. CEN/TS 1555-7 [2] gives guidance for assessment of conformity. Recommended practice for installation is given in EN 12007-2:2000 [1], prepared by CEN/TC 234.

This part of EN 1555 covers the general aspects of the plastics piping system.

1 Scope

This part of EN 1555 specifies the general aspects of polyethylene (PE) piping systems in the field of the supply of gaseous fuels.

It also specifies the test parameters for the test methods referred to in this standard.

In conjunction with Parts 2 to 5 of EN 1555 it is applicable to PE pipes, fittings, and valves, their joints and to joints with components of other materials intended to be used under the following conditions:

a) a maximum operating pressure, MOP, up to and including 10 bar [1)];

b) an operating temperature of 20 °C as reference temperature.

NOTE 1 For other operating temperatures, derating coefficients should be used, see EN 1555-5 [6].

EN 1555 (all parts) covers a range of maximum operating pressures and gives requirements concerning colours and additives.

NOTE 2 It is the responsibility of the purchaser or specifier to make the appropriate selections from these aspects, taking into account their particular requirements and any relevant national regulations and installation practices or codes.

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 1555-2:2010, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 2: Pipes*

EN 1555-3, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 3: Fittings*

prEN 1555-4, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 4: Valves*

EN 12099, *Plastics piping systems — Polyethylene piping materials and components — Determination of volatile content*

EN ISO 472:2001, *Plastics — Vocabulary (ISO 472:1999)*

EN ISO 1043-1:2001, *Plastics — Symbols and abbreviated terms — Part 1: Basic polymers and their special characteristics (ISO 1043-1:2001)*

EN ISO 1133, *Plastics — Determination of the melt mass-flow rate (MFR) and the melt volume-flow rate (MVR) of thermoplastics (ISO 1133:2005)*

EN ISO 1167-1:2006, *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 1: General method (ISO 1167-1:2006)*

EN ISO 1167-2, *Thermoplastics pipes, fittings and assemblies for the conveyance of fluids — Determination of the resistance to internal pressure — Part 2: Preparation of pipe test pieces (ISO 1167-2:2006)*

EN ISO 1183-1, *Plastics — Methods for determining the density of non-cellular plastics — Part 1: Immersion method, liquid pyknometer method and titration method (ISO 1183-1:2004)*

1) 1 bar = 0,1 MPa.

EN ISO 1183-2, *Plastics — Methods for determining the density of non-cellular plastics — Part 2: Density gradient column method (ISO 1183-2:2004)*

EN ISO 6259-1, *Thermoplastics pipes — Determination of tensile properties — Part 1: General test method (ISO 6259-1:1997)*

prEN ISO 9080, *Plastics piping and ducting systems - Determination of the long-term hydrostatic strength of thermoplastics materials in pipe form by extrapolation (ISO/DIS 9080:2010)*

EN ISO 12162, *Thermoplastics materials for pipes and fittings for pressure applications — Classification, designation and design coefficient (ISO 12162:2009)*

EN ISO 13477, *Thermoplastics pipes for the conveyance of fluids — Determination of resistance to rapid crack propagation (RCP) — Small-scale steady-state test (S4 test) (ISO 13477:2008)*

EN ISO 13478, *Thermoplastics pipes for the conveyance of fluids — Determination of resistance to rapid crack propagation (RCP) — Full-scale test (FST) (ISO 13478:2007)*

EN ISO 13479, *Polyolefin pipes for the conveyance of fluids — Determination of resistance to crack propagation — Test method for slow crack growth on notched pipes (ISO 13479:2009)*

EN ISO 15512, *Plastics — Determination of water content (ISO 15512:2008)*

EN ISO 16871, *Plastics piping and ducting systems — Plastics pipes and fittings — Method for exposure to direct (natural) weathering (ISO 16871:2003)*

ISO 6259-3, *Thermoplastics pipes — Determination of tensile properties — Part 3: Polyolefin pipes*

ISO 6964, *Polyolefin pipes and fittings — Determination of carbon black content by calcination and pyrolysis — Test method and basic specification*

ISO 11357-6, *Plastics — Differential scanning calorimetry (DSC) — Part 6: Determination of oxidation induction time (isothermal OIT) and oxidation induction temperature (dynamic OIT)*

ISO 11413:2008, *Plastics pipes and fittings — Preparation of test piece assemblies between a polyethylene (PE) pipe and an electrofusion fitting*

ISO 11414:2009, *Plastics pipes and fittings — Preparation of polyethylene (PE) pipe/pipe or pipe/fitting test piece assemblies by butt fusion*

ISO 13953, *Polyethylene (PE) pipes and fittings — Determination of the tensile strength and failure mode of test pieces from a butt-fused joint*

ISO 13954, *Plastics pipes and fittings — Peel decohesion test for polyethylene (PE) electrofusion assemblies of nominal outside diameter greater than or equal to 90 mm*

ISO 18553, *Method for the assessment of the degree of pigment or carbon black dispersion in polyolefin pipes, fittings and compounds*

3 Terms and definitions, symbols and abbreviations

3.1 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 472:2001 and EN ISO 1043-1:2001 and the following apply.

3.1.1 Geometrical definitions

3.1.1.1
nominal size DN/OD
numerical designation of the size of a component, other than a component designated by thread size, which is a convenient round number, approximately equal to the manufacturing dimension in millimetres (mm) and related to the outside diameter

3.1.1.2
nominal outside diameter
d_n
specified outside diameter, in millimetres, assigned to a nominal size DN/OD

3.1.1.3
outside diameter at any point
d_e
value of the measurement of the outside diameter through its cross-section at any point of the pipe, rounded to the next greater 0,1 mm

3.1.1.4
mean outside diameter
d_{em}
value of the measurement of the outer circumference of the pipe or spigot end of a fitting in any cross-section divided by π (= 3,142), rounded to the next greater 0,1 mm

3.1.1.5
minimum mean outside diameter
$d_{em,min}$
minimum value for the mean outside diameter as specified for a given nominal size

3.1.1.6
maximum mean outside diameter
$d_{em,max}$
maximum value for the mean outside diameter as specified for a given nominal size

3.1.1.7
out-of-roundness
ovality
difference between the maximum and the minimum outside diameter in the same cross-section of a pipe or spigot

3.1.1.8
nominal wall thickness
e_n
numerical designation of the wall thickness of a component, which is a convenient round number, approximately equal to the manufacturing dimension in millimetres (mm)

NOTE For thermoplastics components conforming to the different parts of EN 1555, the value of the nominal wall thickness, e_n, is identical to the specified minimum wall thickness at any point, e_{min}.

3.1.1.9
wall thickness at any point
e
wall thickness at any point around the circumference of a component rounded to the next greater 0,1 mm

NOTE The symbol for the wall thickness of the fittings and valves body at any point is E.

3.1.1.10
minimum wall thickness at any point
e_{min}
minimum value for the wall thickness at any point around the circumference of a component, as specified

3.1.1.11
maximum wall thickness at any point
e_{max}
maximum value for the wall thickness at any point around the circumference of a component, as specified

3.1.1.12
mean wall thickness
e_m
arithmetical mean of a number of measurements of the wall thickness, regularly spaced around the circumference and in the same cross-section of a component, including the measured minimum and the measured maximum values of the wall thickness in that cross-section

3.1.1.13
tolerance
permitted variation of the specified value of a quantity, expressed as the difference between the permitted maximum and the permitted minimum value

3.1.1.14
wall thickness tolerance
t_y
permitted difference between the wall thickness at any point, e, and the nominal wall thickness, e_n

NOTE $e_n \leq e \leq e_n + t_y$

3.1.1.15
standard dimension ratio
SDR
numerical designation of a pipe series, which is a convenient round number, approximately equal to the dimension ratio of the nominal outside diameter, d_n, and the nominal wall thickness, e_n

3.1.1.16
pipe series
S
number for pipe designation conforming to ISO 4065 [7]

NOTE The relationship between the pipe series S and the standard dimension ratio SDR is given by the following equation as specified in ISO 4065 [7].

$$S = \frac{SDR - 1}{2}$$

3.1.2 Material definitions

3.1.2.1
virgin material
material in a form such as granules that has not been subjected to use or processing other than that required for its manufacture and to which no reprocessable or recyclable materials have been added

3.1.2.2
own reprocessable material
material prepared from clean rejected unused pipes, fittings or valves, including trimmings from the production of pipes, fittings or valves, that will be reprocessed in a manufacturer's plant after having been previously processed by the same manufacturer in the production of components by, for example, injection-moulding or extrusion

3.1.2.3
compound
homogenous extruded mixture of base polymer (PE) and additives, i.e. anti-oxidants, pigments, carbon black, UV-stabilisers and others, at a dosage level necessary for the processing and use of components conforming to the requirements of this standard

3.1.3 Definitions related to material characteristics

3.1.3.1
lower confidence limit of the predicted hydrostatic strength
σ_{LPL}
quantity, with the dimensions of stress, which represents the 97,5 % lower confidence limit of the predicted hydrostatic strength at a temperature θ and time t

NOTE It is expressed in megapascals.

3.1.3.2
minimum required strength
MRS
value of σ_{LPL} at 20 °C and 50 years, rounded down to the next smaller value of the R10 series when σ_{LPL} is below 10 MPa, or to the next lower value of the R20 series when σ_{LPL} is 10 MPa or greater

NOTE The R10 series conforms to ISO 3 [3] and the R20 series conforms to ISO 497 [4].

3.1.3.3
design coefficient
C
coefficient with a value greater than 1, which takes into consideration service conditions as well as properties of the components of a piping system other than those represented in the lower confidence limit

3.1.3.4
design stress
σ_S
allowable stress for a given application at 20 °C, that is derived from the MRS by dividing it by the coefficient C, i.e.:

$$\sigma_S = \frac{MRS}{C}$$

NOTE It is expressed in megapascals.

3.1.3.5
melt-mass flow rate
MFR
value relating to the viscosity of the molten material at a specified temperature and load, expressed in grams per 10 min (g/10 min)

3.1.4 Definitions related to service conditions

3.1.4.1
gaseous fuel
fuel which is in gaseous state at a temperature of 15 °C, at the atmospheric pressure

3.1.4.2
maximum operating pressure
MOP
maximum effective pressure of the fluid in the piping system, expressed in bar, which is allowed in continuous use

NOTE It is expressed in bar and takes into account the physical and the mechanical characteristics of the components of a piping system and it is calculated using the following equation:

$$\mathrm{MOP} = \frac{20 \times \mathrm{MRS}}{C \times (\mathrm{SDR} - 1)}$$

3.1.4.3
reference temperature
temperature for which the piping system is designed

NOTE It is used as the base for further calculation when designing a piping system or parts of a piping system for operating temperatures different from the reference temperature.

3.1.5 Definitions related to joints

3.1.5.1
butt fusion joint using heated tool
joint made by heating the planed ends of pipes or spigot end fittings, the surfaces of which match by holding them against a flat heating plate until the PE material reaches fusion temperature, removing the heating plate quickly and pushing the two softened ends against one another

3.1.5.2
fusion compatibility
ability of two similar or dissimilar polyethylene materials to be fused together to form a joint which conforms to the performance requirements of this standard

3.1.5.3
electrofusion joint
joint between a PE electrofusion socket or saddle fitting and a pipe or a spigot end fitting

NOTE The electrofusion fittings are heated by the Joule effect of the heating element incorporated at their jointing surfaces, causing the material adjacent to them to melt and the pipe and fitting surfaces to fuse.

3.2 Symbols

For the purposes of this document, the following symbols apply.

C : design coefficient

d_e : outside diameter (at any point)

d_{em} : mean outside diameter

$d_{em,max}$: maximum mean outside diameter

$d_{em,min}$: minimum mean outside diameter

d_n : nominal outside diameter

E : wall thickness (at any point) of a fitting and valve body

e_m : mean wall thickness

e_{max} : maximum wall thickness (at any point)

e_{min} : minimum wall thickness (at any point)

e_n : nominal wall thickness

t_y : wall thickness tolerance

σ_s : design stress

3.3 Abbreviations

DN/OD : nominal size, outside diameter related

LPL : lower predicted limit

MFR : melt mass-flow rate

MOP : maximum operating pressure

MRS : minimum required strength

PE : polyethylene

R : series of preferred numbers, conforming to the Renard series

SDR : standard dimension ratio

4 Material

4.1 Material of the components

The pipes, fittings and valves shall be made of polyethylene compound conforming to this document.

4.2 Compound

4.2.1 Additives

The compound shall be made by adding to the polyethylene base polymer only those additives, pigments or carbon black, necessary for the manufacture of pipes, fittings and valves conforming to EN 1555-2, EN 1555-3 or prEN 1555-4, as applicable, and for their fuseability, storage and use.

All additives used shall take into account national legislation.

4.2.2 Colour

The colour of the compound shall be yellow (PE 80), orange (PE 100), or black (PE 80 and PE 100). The carbon black used in the production of black compound shall have an average (primary) particle size of 10 nm to 25 nm.

NOTE In some countries pipes made out of non-pigmented compound in conjunction with an external peelable layer are permitted, providing the compound conforms to the requirements of this document. If this is allowed in a country, this should be clearly stated in the national foreword.

4.2.3 Characteristics

4.2.3.1 Characteristics of the compound in the form of granules

The compound in the form of granules used for the manufacture of pipes, fittings and valves shall have characteristics conforming to the requirements given in Table 1.

Table 1 — Characteristics of the compound in the form of granules

Characteristic	Requirements [a]	Test parameters		Test method
		Parameter	Value	
Compound density	≥ 930 kg/m^3	Test temperature Number of samples [b]	23 °C Shall conform to EN ISO 1183-1 and EN ISO 1183-2	EN ISO 1183-1 and EN ISO 1183-2
Oxidation induction time (Thermal stability)	> 20 min	Test temperature Number of test pieces [b] Test atmosphere Sample weight	200 °C [c] 3 Oxygen 15 +/-2 mg	ISO 11357-6
Melt mass-flow rate (MFR)	(0,2 ≤ MFR ≤ 1,4) g/10 min Maximum deviation of ± 20 % of the nominated value [d]	Loading mass Test temperature Time Number of test pieces [b]	5 kg 190 °C 10 min Shall conform to EN ISO 1133	EN ISO 1133
Volatile content	≤ 350 mg/kg	Number of test pieces [b]	1	EN 12099
Water content [e]	≤ 300 mg/kg (Equivalent to < 0,03 % by mass)	Number of test pieces [b]	1	EN ISO 15512
Carbon black content [f]	(2 to 2,5) % (by mass)	Shall conform to ISO 6964		ISO 6964
Carbon black dispersion [f]	Grade ≤ 3 Rating of dispersion A1, A2, A3 or B	Preparation of test pieces Number of test pieces [b]	Free [g] Shall conform to ISO 18553	ISO 18553
Pigment dispersion [h]	Grade ≤ 3 Rating of dispersion A1, A2, A3 or B	Preparation of test pieces Number of test pieces [b]	Free [g] Shall conform to ISO 18553	ISO 18553

[a] Conformity to these requirements shall be proved by the compound producer.
[b] The numbers of test pieces given indicate the numbers required to establish a value for the characteristic described in the table. The numbers of test pieces required for factory production control and process control should be listed in the manufacturer's quality plan. For guidance, see CEN/TS 1555-7 [2].
[c] Test may be carried out at 210 °C or 220 °C providing that there is a clear correlation has been established. In case of dispute the reference temperature shall be 200 °C.
[d] Nominated value given by the compound manufacturer.
[e] Only applicable, if the measured volatile content is not in conformity to its specified requirement. In case of dispute the requirement for water content shall be used. As an alternative method, ISO 760 [5] may apply. The requirement applies to the compound producer at the stage of manufacturing and to the compound user at the stage of processing (if the water content exceeds the limit, drying is required prior to use).
[f] Only for black compound.
[g] In case of dispute, the test pieces shall be prepared by the compression method.
[h] Only for non-black compounds.

4.2.3.2 Characteristics of the compound in the form of pipe

Unless otherwise specified by the applicable test method, the test pieces shall be conditioned at (23 ± 2) °C before testing in accordance with Table 2.

The compound in the form of pipe used for the manufacture of pipes, fittings and valves, shall have characteristics conforming to the requirements given in Table 2.

Table 2 — Characteristics of compound in the form of pipe

Characteristic	Requirements [a]	Test parameters		Test method
		Parameter	Value	
Resistance to gas condensate	No failure during the test period of all test pieces	End caps Test temperature Orientation Number of test pieces [b] Circumferential (hoop) stress Pipe dimensions: d_n e_n Type of test Test period Conditioning period (pipe filled with condensate)	Type A of EN ISO 1167-1:2006 80 °C Free 3 2,0 MPa 32 mm 3 mm Synthetic condensate [c] in water 20 h 1 500 h in air at 23 °C	EN ISO 1167-1 and EN ISO 1167-2
Resistance to weathering [d]	The weathered test pieces shall fulfil the requirements of the following characteristics:	Preconditioning (weathering): Cumulative radiant exposure Number of test pieces [b]	≥ 3,5 GJ/m^2 See below	EN ISO 16871
a) de-cohesion of an electrofusion joint, (d_n: 110 mm SDR 11)	a) Sample prepared in accordance with ISO 11413:2008, Jointing condition 1: 23 °C; ≤ 33% brittle failure			a) ISO 13954
b) hydrostatic strength (1000 h at 80 °C);	b) shall conform to Table 4 of EN 1555-2:2010			b) EN ISO 1167-1 and EN ISO 1167-2
c) elongation at break	c) shall conform to Table 4 of EN 1555-2:2010			c) EN ISO 6259-1 and ISO 6259-3
Resistance to rapid crack propagation (Critical pressure, p_c) ($e \geq 15$ mm)	$P_c \geq 1,5$ MOP with $p_c = 3,6\ p_{c,s4} + 2,6$ [e]	Test temperature Number of test pieces [b]	0 °C Shall conform to EN ISO 13477	EN ISO 13477
Resistance to slow crack growth (d_n: 110 mm SDR 11)	No failure during the test period	Test temperature Internal test pressure: for PE 80 PE 100 Test period Type of test Number of test pieces [b]	80 °C 8,0 bar 9,2 bar 500 h Water-in-water Shall conform to EN ISO 13479	EN ISO 13479

[a] Conformity to these requirements shall be proved by the compound producer.

[b] The numbers of test pieces given indicate the numbers required to establish a value for the characteristic described in the Table. The numbers of test pieces required for factory production control and process control should be listed in the manufacturer's quality plan. For guidance, see CEN/TS 1555-7 [2].

[c] 50 % (by mass) n-decane and 50 % (by mass) 1-3-5 trimethylbenzene.

[d] Only for non-black compounds.

[e] Full scale/S4 correlation factor is equal to 3,6 and is defined as the full scale/S4 critical absolute pressure ratio: $(p_{c,\text{full scale}} + 1) = 3,6\ (p_{c,s4} + 1)$.

If the requirement is not met or S4 test equipment not available, then (re)testing by using the full scale test shall be performed in accordance with EN ISO 13478. In this case: $p_c = p_{c,\text{full scale}}$.

NOTE Attention is drawn to the fact that the correlation factor may be modified, when revising this Standard, according to the result of work of ISO/TC 138/SC4 "Plastics pipes, fittings and valves for the supply of gaseous fuels".

4.3 Fusion compatibility

4.3.1 The compounds conforming to Table 1 shall be fusible. This shall be demonstrated by the compound manufacturer for each compound of his own product range by checking that the requirement for the failure mode in a tensile test given in Table 3 is fulfilled for a butt fusion joint prepared by using the parameters as specified in Annex A of ISO 11414:2009 at an ambient temperature of (23 ± 2) °C from pipes both manufactured from that compound.

4.3.2 Compounds conforming to Table 1 are considered fusible to each other. If requested, the compound manufacturer shall demonstrate this by checking that the requirement for the failure mode in a tensile test given in Table 3 is fulfilled for a butt fusion joint prepared by using the parameters as specified in Annex A of ISO 11414:2009 at an ambient temperature of (23 ± 2) °C from two pipes manufactured from the compounds from his own range covered by this request.

Table 3 — Characteristic of compound in the form of butt fusion joint

Characteristic	Requirement [a]	Test parameters		Test method
		Parameter	Value	
Determination of the failure mode in a tensile test on buttfusion weld (d_n : 110 mm SDR 11)	Test to failure: Ductile – pass Brittle – fail	Test temperature Number of test pieces [b]	23 °C Shall conform to ISO 13953	ISO 13953

[a] The conformity to these requirements shall be proven by the compound producer.
[b] The numbers of test pieces given indicate the numbers required to establish a value for the characteristic described in the Table. The numbers of test pieces required for factory production control and process control should be listed in the manufacturer's quality plan. For guidance, see CEN/TS 1555-7 [2].

4.4 Classification and designation

Compounds shall be designated by the type of PE material. The minimum required strength (MRS) shall conform to Table 4 when tested in the form of pipe.

Table 4 — Classification and designation of compounds

Classification by MRS MPa	Designation
8,0	PE 80
10,0	PE 100

The compound shall be evaluated in accordance with prEN ISO 9080 from pressure tests on pipe in accordance with EN ISO 1167-1 and EN ISO 1167-2 performed on pipe at least at three temperatures, where two of the temperatures are fixed to 20 °C and 80 °C, and a third temperature is free between 30 °C and 70 °C, to find the σ_{LPL}. The MRS-value shall be derived from the σ_{LPL} and the compound shall be classified by the compound producer in accordance with EN ISO 12162.

At 80 °C, there shall be no knee detected in the regression curve at t < 5000 h.

The conformity of the designation of the compound to the classification given in Table 4 shall be demonstrated by the compound producer.

Where fittings are manufactured from the same compound as pipes, then the material classification shall be the same as for pipes.

For the classification of a compound intended only for the manufacture of fittings, test pieces in the form of extruded pipe made from the compound shall be used.

4.5 Design coefficient and design stress

The design coefficient, C, for pipes, fittings and valves for the supply of gaseous fuels shall be greater or equal to 2.

The maximum value for the design stress, σ_s, shall be for PE 80, 4,0 MPa and for PE 100, 5,0 MPa.

Bibliography

[1] EN 12007-2:2000, *Gas supply systems — Gas pipelines for maximum operating pressure up to and including 16 bar — Part 2: Specific functional recommendations for polyethylene (MOP up to and including 10 bar)*

[2] CEN/TS 1555-7, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 7: Guidance for assessment of conformity*

[3] ISO 3, *Preferred numbers — Series of preferred numbers*

[4] ISO 497, *Guide to the choice of series of preferred numbers and of series containing more rounded values of preferred numbers*

[5] ISO 760, *Determination of water — Karl Fischer method (General method)*

[6] EN 1555-5, *Plastics piping systems for the supply of gaseous fuels — Polyethylene (PE) — Part 5: Fitness for purpose of the system*

[7] ISO 4065, *Thermoplastics pipes -- Universal wall thickness table*

National Annex (informative)

Additional information on the selection and installation of piping systems and components in the UK

The responsible UK committee gives the following advice concerning the selection and installation of piping systems and components conforming to this British Standard.

a) Gas supply companies and other entities deemed to be within the scope of the Public Procurement Directives (PPD) are obliged to use EN 1555-1, EN 1555-2, EN 1555-3, EN 1555-4 and EN 1555-5, produced under EC/U mandate, if they wish to purchase PE pipe systems or components within the PPD scope.

b) CE marking against the Construction Products Directive and the Pressure Equipment Directive does not apply to pipes and fittings within the scope of EN 1555-1, EN 1555-2 and EN 1555-3. However, CE marking may apply to valves within the scope of EN 1555-4.

c) Where there are options, care should be taken to ensure that agreement is established between suppliers and purchasers, e.g. in terms of colour, size, physical characteristics and Quality Assurance.

d) For colour, it is the practice of UK gas companies to use yellow PE pipes to facilitate identification of buried gas pipelines, in accordance with the recommendations of the National Joint Utilities Group (NJUG) concerning the colour coding of pipelines and other services. For UK public gas supply applications, the pipes should also be marked in accordance with the relevant standards of the national network distributors[1] (i.e. GIS/PL2 Part 4 and GIS/PL2 Part 8).

e) To comply with health and safety requirements for safe handling of PE pipes supplies as coils or on drums, guidance should be sought from the national network distributors.

f) This British Standard requires the critical pressure for rapid crack propagation (RCP) as measured in accordance with ISO 13477 to be equal to or greater than 1,50 maximum operation pressure (MOP) in BS EN 1555-1, Table 2. It is current practice of UK gas companies to use a value of 2.0 instead of 1.5 times MOP.

g) Requirements for slow crack growth (SCG) are specified in BS EN 1555-2, Table 4. The PE pipe compound is to be tested in pipe form in accordance with EN ISO 13479, with a test period of 500 h. It is established practice in the UK to use a test period of 1000 h.

h) Clause **4.5** specifies a minimum overall service (design) coefficient, C. Information regarding the value of *C*, used in the design of UK gas distribution systems, should be sought from the national network distributors.

[1] The national network distributers are a group of companies that operate the pipelines in the UK. There are 5 companies that make up this group: National Grid; Wales and West Utilities; Northern Gas Networks; Scotia Gas South; and Scotia Gas North.

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