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

EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-01-02**			**Date: 2016-09-07**	
Please fulfil the following				
Part: EN 13445-1	Issue: 2014 Issue 3	Page 37c	Subclause Table X.3	National Standard Reference --
Subject: Simplification possible or data error?				
Type of request:	☐ Technical clarification ☐ Technical comment		X Editorial correction ☐ Translation correction	
From : Company: UcoTek AB ..... Name: Ulf Malmström ..... Postal address: 1, Irisdal, SE-14461 Rönninge, Sweden			e-mail:ulf@ucotek.se ..... phone: +46707686690	
☐ Manufacturer	☐ User	X Other (please specify): Consultant		
Question/comment: The table pretends that ESR 3.1 for aluminium vessels (Part 8) is covered by subclause 7.2 in Part 6. This is incorrect. Proposed answer(s): Delete reference.				
Answer from the MHD *(to be filled by MHD):* Adressed to TC54, should be agreed and validated by CEN consultant.				
To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr			

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

European Committee for Standardization
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EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)
Question form

Request reference number *(to be filled by MHD):* **(2014)-02-02** **Date: 2016-03-18**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-2	2014	14	4.2.5	NS-EN 13445-2:2014

Subject: Specified minimum tensile strength of bar material of ferritic and martensitic steel for bolts

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

From :
Company: Det Norske Veritas B.V. - PCNL
Name: Peter van der Wel
Postal address: P.O. Box 9599, 3007 AN Rotterdam
e-mail: peter.van.der.wel@dnvgl.com
phone: +31653827616

☐ **Manufacturer** ☐ **User** ☒ **Other (please specify): Notified Body 0427**

Question/comment:

According EN 13445-2, paragraph 4.2.5, specified minimum tensile strength of bar material of ferritic and martensitic steel for bolts shall **not exceed 1000 MPa**.

According EN 13445-2 Table B.2-1 and Table B.2-9, start material of bolts and nuts can be made according material standard EN 10269. In this standard, material grades are stated with specified minimum tensile strengths **above 1000 MPa**. EN 10269 is a PED harmonised standard.

Are bolts and nuts allowed with a specified minimum tensile strength above 1000MPa?

For general information: 10.9 bolts according ISO 898-1:2013 have a minimum specified tensile strength of 1040 MPa.

Proposed answer(s): *

There is a conflict in EN 13445-2 regarding the requirements of the specified minimum tensile strength for bolts. If bolts are in compliance with EN 13445-2:2014 paragraph B.2.2.4 (including table B.2-9), bolts are in compliance with EN 13445. This means EN 13445 allows to use bolts with a specified minimum tensile strength higher than 1000 MPa.

Answer from the MHD *(to be filled by MHD):*

There is no conflict between EN 10269 and EN13445, EN13445-2 limit tensile strength of bar material of ferritic and martensitic steel for bolts to 1000 MPa, which is more restrictive than EN 10269.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

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

European Committee for Standardization
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EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)
Question form

Request reference number *(to be filled by MHD):* **(2014)-02-04** **Date: 2016-xx-xx**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-2	2014	42		

Subject:

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

From :
Company: Apave .....
Name: Charles Jarboui .....
Postal address: .....
e-mail: charles.jarboui@apave.com.....
phone: +.....

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

Question/comment:

There is a discrepancy between Table B.3-2 and the above text (Table title). In the text we are dealing with reduced thickness (so called “sub-sized specimens”) and the title states “thicker sections”.

Table B.3–2 — Equivalent impact energy requirements when sub-sized specimens are extracted from thicker sections

Required impact energy	Specimen geometry	Sub-sized specimen requirement		
KV J	mm	*KV* J	Specimen geometry mm	Shift of impact test temperature °C

Proposed answer(s): *

Change Table B.3-2 title “Equivalent impact energy requirements when sub-sized specimens are extracted from ~~thicker~~ thinner sections”

Answer from the MHD *(to be filled by MHD):*

There no discrepancies, the shift of impact test temperature takes into account the fact that sub-sized specimen is extracted from thicker section.

To be sent to EN 13445 Maintenance Help Desk secretariat:

EN 13445 MHD secretariat c/o UNM
Standardization Office on behalf of AFNOR
F 92038 Paris La Défense Cedex – France
e-mail: en13445@unm.fr

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

European Committee for Standardization
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EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-03-08** **Date: 2016-03-05**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-3	2015	142	10.5.1.2	--

Subject:

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

From :
Company: Inspecta Tarkastus Oy .....
Name: Juha Purje .....
Postal address: PO Box 7, FI-00441 Helsinki, Finland
e-mail: juha.purje@inspecta.com .....
phone: +358 50 52 51 180 .....

☐ Manufacturer ☐ User X Other (please specify): Notified Body no 0424

Question/comment:

The issue 2 of EN 13445-3:2014 corrected the error in subclause 10.5.1.1 line a) but the text in clause 10.5.1.2 still refers to figures b) to d) of Figure 10.5-1.

The subfigures of Figure 10.5-1 are marked with numbers, not with letters.

Proposed answer(s): *

Proper text in subclause 10.5.1.2 is

The thickness of the flanged extension, see Figures 10.5-1, 2 to 4 and Figure 10.5-2, may …

Answer from the MHD *(to be filled by MHD):*
Agreed with the proposed corrections, to be updated in 2017 version.

To be sent to EN 13445 Maintenance Help Desk secretariat:

EN 13445 MHD secretariat c/o UNM
Standardization Office on behalf of AFNOR
F 92038 Paris La Défense Cedex – France
e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD)*: **(2014)-03-09** **Date: 2016-05-24**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-3	2014	126	9.7.3 a)	VSR-

Subject:

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

From :
Company SANT'AMBROGIO Servizi Industriali srl
Name: Fernando Lidonnici
Postal address: Piazza C.Donegani 8 – I 20133 Milano
e-mail: lidonnici@sant-ambrogio.it
phone: +390270603113

☐ Manufacturer ☐ User X☐ Other (please specify): Engineering company

Question/comment: In case of a nozzle in a torispherical or elliptical end entirely contained into a circle with a diameter equal to 80% De, the reinrforcing length provided by subclause 9.7.3 a) becomes 0 in case the nozzle is tangent to that circle. Looking at the figures and at the equations, it seems that the opening check is to be made considering both Aps and Afs from one side only of the nozzle axis, that is the most unfavourable side. Therefore in the case where ls=w=0, there is no contribution of the knuckle area (which on the contrary is provided in the Italian code VSR, which is using the same basic philosophy). In most cases of large openings which are very close or tangent to 0,8 De, according to the present rules the opening is not reinforced. However, if the end is sufficiently thick, it is sufficient to displace the opening outwards by a very small distance, so that the nozzle will cross the limit circle: in so doing the opening comes into the knuckle region, and therefore the reinforcement philosophy changes, so that it may be reinforced according to the rules of Clause 7, par. 7.7 (Nozzles which encroach into the knuckle region): with the unreasonable result that a displacement towards the knuckle zone of the same nozzle, not adequately reinforced if it is entirely contained in the spherical part of the end, will satisfy the reinforcement check. Note that, apart the peculiar case described above, if a nozzle is located close to a discontinuity, the reinforcing length is generally reduced only from one side, but may not be reduced from the opposite side: therefore the idea of considering Afs and Aps from the worst side only may be greatly penalizing. Note that for the combined reinforcement of a pair of openings, when the area of the ligament is not sufficient, it is allowed to consider for Aps and Afs also the area located externally.

Proposed answer(s): At the end of par. 9.7.3 add the following sentence: "In the case that in the section where the reinforcing check is to be made a discontinuity is limiting the reinforcing length from one side of the nozzle, but no such limitation exists in the opposite side, it is allowed to extend the calculation to a larger cross sectional area, thus considering together both sides of the opening for the calculation of both Afs and Aps, each one on the basis of the relevant value of ls0. In the case where a nozzle in a domed end located inside a circle equal to 80% of the end diameter De is not adequately reinforced by the preceding rules because the reinforcing length ls0 is limited by the knuckle region, it may still be considered adequately reinforced in case the end thickness satisfies the rules of Clause 7, par. 7.7.

Answer from the MHD *(to be filled by MHD):*

This query is addressed under a specific amendment to be circulated under CEN/TC54.

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

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-03-10** **Date: 2016-05-31**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-	2015		I.1.4	--

Subject:

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

From :
Company: HELBIO S.A.
Name: Mr Andreas Stavrakas
Postal address:
e-mail: stavrakas@helbio.com
phone: +30 2610 911564

☒ Manufacturer ☐ User ☐ Other (please specify):

Question/comment:

We would like to ask your opinion in a design issue which occurred during the study of a fixed tubesheet heat exchanger under En13445.
More specific we are designing a stainless steel (347H-1.4961) vessel operating in the creep zone (750oC) for the tube and tubesheet and lower temperature (500oC) in the shell. We have a significant linear thermal expansion of γ=9,6mm. We provide continuous life monitoring. The issue we have deals with the assumptions for the loading cases under EN13445-3 annex I par. I.1.4. We have defined the loading conditions for normal, exceptional and pressure test conditions as in table I.1.4-1 and for each one the Pt,Ps,γ,T,Tt,Ts,Tc. In these conditions we have listed a loading case corresponding to number 3 in 13.5.4.1 (tube side pressure Pt and shell pressure Ps acting simultaneously without thermal expansion (γ=0)), but in the operational, which is lower than design, temperature that this case occurs for shell, tubes and tubesheets. The question is if in loading cases 1-3 we should always consider the shell, tube and tubesheet in the higher design temperature or in the actual, lower in our implementation operating temperature that the loading case may occur.
As you understand considering in loading case 3 the design temperature which is higher than the operating temperature for this loading case leads to lower nominal stresses and subsequently thicker parts.
In TEMA and ASMEVIII div. 1 there is a definite distinction of Design loading cases (table UHX-13.4-1) and operating loading cases (table UHX-13.4-2) where in the following calculation procedure (UHX-13.5.5 step 5 γ=0 for design loading cases and the design stresses S are derived at T which is the design temperature (UG-23).
The later methodology in ASME has similarities with section I.1.5 of Annex I EN13445-3 “simplified procedure for normal operating conditions”, where also under table I.1.5.-1 the temperature assumed is the design maximum temperature of all components.

Summarizing, the methodology described in section I.1.4 of Annex I in EN13445-3 “opens” a window of considering a different, and in our case lower, temperature for each loading case and specifically the loading cases as number 3 without linear expansion? Or we have misunderstood the procedure and we shall always use the loading case 3 with the maximum design temperature?

Proposed answer(s):

Answer from the MHD *(to be filled by MHD):*

Annex I is an informative Annex, however for each pressure there is a corresponding temperature, for each of these pairs calculations have to be made according to 13.5.4 in EN 13445-3.

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To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

European Committee for Standardization
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Europaïsches Komitee für Normung

EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD)*: **(2014)-0x-0x**			**Date: 2016-09-16**	
Please fulfil the following				
Part: EN 13445-3	Issue: 2014	Page 32	Subclause 7.5.3.2	National Standard Reference - EN 13445-3:2014-
Subject:				
Type of request:	☐ Technical clarification		☐ Editorial correction	
	☒ Technical comment		☐ Translation correction	

From : Company: Inspecta Sweden AB Name: Pasi Nieminen Postal address: P.O.Box 30100, SE-10425 Stockholm Sweden	e-mail: pasi.nieminen@inspecta.com phone: +46 10 479 3044

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

Question/comment:

May formula [7.5-5] be used for cold spun welded austenitic stainless ends subjected to full NDT prior to forming ?

Proposed answer(s):

No.

Equation [7.5-5] denotes seamless heads with:

- no imperfections from welding /1/ /2/
- no residual stresses from welding /3/

Imperfections and residual stresses may limit the resistance to pressure of a head.

/1/ Welded heads in practice will have initial geometric imperfections in them that are random in nature

/2/ Austenitic stainless weld deposits has likewise less ductility (and toughness) than the base material and might bring about initial geometric imperfections at spinning.

/3/ Residual stresses is expected to decrease head resistance to pressure

Answer from the MHD *(to be filled by MHD):*

Correct, Formula 7.5-5 only deals with austenitic stainless steel head without welds.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

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Europaïsches Komitee für Normung

EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD)*: **(2014)-03-12**			**Date: 2016-09-22**	
Please fulfil the following				
Part: EN 13445-3	Issue: 2016	Page 142	Subclause 10.5.1.2	National Standard Reference --
Subject:				
Type of request:	☐ Technical clarification		X Editorial correction	
	☐ Technical comment		☐ Translation correction	

From :
Company: Inspecta Tarkastus Oy .....
Name: Juha Purje .....
Postal address: PO Box 7, FI-00441 Helsinki, Finland
e-mail: juha.purje@inspecta.com .....
phone: +358 50 52 51 180 .....

☐ Manufacturer	☐ User	X Other (please specify): Notified Body no 0424

Question/comment:

The issue 2 of EN 13445-3:2014 corrected the error in subclause 10.5.1.1 line a) but the text in clause 10.5.1.2 still refers to figures b) to d) of Figure 10.5-1.

The subfigures of Figure 10.5-1 are marked with numbers, not with letters.

Proposed answer(s): *

Correct text in subclause 10.5.1.2 is

The thickness of the flanged extension, see Figures 10.5-1, 2 to 4 and Figure 10.5-2, may …

Answer from the MHD *(to be filled by MHD):*

Agreed with the proposal, will be updated in issue 4.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

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

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EN 13445 "Unfired pressure vessels"
Form for question

Reserved to MHD			
Registration number (2014)-03-13	Date of submission	Target date for answer	Date of acceptance
Part number: EN13445-3	Page number: 671	Subclause number: G.6.5.1	Reference of the national standard used *NF EN 13445-3 V2:2015-07*

Question:

In its annex G, standard EN13445-3 deals with "Alternative calculation rules for flanges and flanged joint assemblies" It states in chapter G.1 Purpose that "This annex is based on EN 1591-1: 2001, Flanges and their joints - Calculation rules for circular flange assemblies with gasket. " When comparing the equation (G.6-10) of chapter G.6.5.1 page 671 of EN13445-3, and equation (51) of chapter 5.4.1 page 29 of EN 1591 -1, we note that the term PQRI is missing in the first equation. Is it an oversight ?

Proposed answer(s): *

This will be transferred to WG53 in charge of EN 13445-3

Question from:

Company:QUIRI ECHANGES THERMIQUES — e-mail:jean.lucien.hauck@quiri.com
Name: Jean-Lucien HAUCK — phone: ++33(0)3.90.20.04.38
Postal address:46, route de Bischwiller CS30190 — fax: ++33(0)3.88.81.20.32
F-67304 Schiltigheim Cédex — date: 2014/11/25
Manufacturer [X] User [X] Other [ ] (please specify) .....

* please note that questions with proposed answer(s) will be dealt with as prioritary

To be sent to EN 13445 MHD secretariat

e-mail : EN13445@unm.fr
fax : 33 1 47 17 67 99
address : EN 13445 MHD secretariat
c/o UNM
F – 92038 PARIS LA DEFENSE CEDEX

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Comité Européen de Normalisation
Europaïsches Komitee für Normung

EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD)*: **(2014)-03-14**			**Date**: **2016-12-07**	
Please fulfil the following				
Part: EN 13445-3	Issue: 2014	Page 162	Subclause 11.5.1	National Standard Reference --
Subject:				
Type of request:	☒ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	

From :

Company: Výskumný ústav zváračský – Priemyselný inštitút SR

Name: Martin Čapičík

Postal address: Račianska 71, 832 59 Bratislava; Slovakia

e-mail: capicikm@vuz.sk

phone: +421 908 840 683

☐ Manufacturer	☒ User	☐ Other (please specify):

Question/comment:

In subclause 11.5.1. General there are proposed three methods of stress calculation. We are not sure about conditions of applicability of Loose method b). EN 13 445-3 says: "The loose method shall only be applied, except for loose flanges in lap joints, if all of the following requirements are met: …".
We understand this statement as follows: The loose method shall be applied for loose flanges without hub in lap joint (without necessity of meeting requirements) and to other types of flanges, but requirements must be met.

Do we understand this statement correctly?

Proposed answer(s): *

Clearer explanation.
The loose method shall be applied for loose flanges in lap joints without restrictions and for other types of flanges if all the following requirements are met: …

Answer from the MHD *(to be filled by MHD):*

The loose method shall be applied for loose flanges in lap joints without restrictions and for other types of loose flanges if all requirements given under 11.5.1 b) are met.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-04-03** **Date: 2016-08-12**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-	2014	22	7.8	--

Subject: Qualification requirements for Attachment, supports and stiffeners

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

From :
Company: Voestalpine Grobblech GmbH
Name: Stefan Eder
Postal address: Voestalpine Straße 3, 4020 Linz, Austria
e-mail: stefan.eder@voestalpine.com
phone: +43/50304/15-4546

☒ Manufacturer ☐ User ☐ Other (please specify):

Question/comment: 1.) Does the terms "qualified welders" and "qualified procedure" mean the manufacturer can issue and approve such qualification documents by himself (without 3rd party/NoBo approval)?
2.) Are also other Codes than EN Standards allowed for qualification of welders/procedures (e.g. ASME IX, AWS D1.1, DNV OS C401)?

Proposed answer(s): * 1.) Yes
2.) Yes

Answer from the MHD *(to be filled by MHD):*

This is not under MHD competence, please refer to PED and relevant Guidelines.

To be sent to EN 13445 Maintenance Help Desk secretariat:

EN 13445 MHD secretariat c/o UNM
Standardization Office on behalf of AFNOR
F 92038 Paris La Défense Cedex – France
e-mail: en13445@unm.fr

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

European Committee for Standardization
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EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)
Question form

Request reference number *(to be filled by MHD):* **(2014)-5-01** **Date: 2015-03-25**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-5	2014	77	Annex Y	--

Subject:

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

From :
Company: Inspecta Tarkastus Oy
Name: Juha Purje
Postal address: PO Box 7, FI-00441 Helsinki, Finland
e-mail: juha.purje@inspecta.com
phone: 00358505251180

☐ Manufacturer ☐ User ☒ Other (please specify): Notified Body no 0424

Question/comment:

The abbreviation CND (contrôles non destructifs) in the original French version has not been translated into English and German versions. The reader of the English or German version can not understand what the sentences “increase in the range of CND” or “die Erhöhung des CND-Bereichs” mean.

Proposed answer(s)/correction(s)*:

The abbreviation CND shall be corrected as

NDT in English version

and

ZfP in German version.

Answer from the MHD *(to be filled by MHD):*

Accepted

Issue 2, July 2015, to be corrected accordingly.

To be sent to EN 13445 Maintenance Help Desk secretariat:

EN 13445 MHD secretariat c/o UNM
Standardization Office on behalf of AFNOR
F 92038 Paris La Défense Cedex - FRANCE
e-mail: en13445@unm.fr

* *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-05-10** **Date: 2016-01-25**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-5	2015	22-23		--

Subject: Translation difference in table 6.6.2-1 German and English version.

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

From :
Company: BASF Antwerpen N.V.
Name: Sander Laenen
Postal address: Scheldelaan 600, 2040 Antwerpen, Belgium
e-mail: sander.laenen@basf.com
phone: +32 3 561 53 18 .....

☐ Manufacturer X User ☐ Other (please specify):

Question/comment:

There is a difference between the English and German translation of 13445-5 table 6.6.2-1.
In the English version it's stated that for weld types 3A, 3B: di > 150 mm **or** e > 16 mm
In the German version it's stated that for weld types 3A, 3B: di > 150 mm **und** e > 16 mm.

In the English version it's stated that for weld type 15: di > 150 mm **or** e > 16 mm
In the German version it's stated that for weld type 15: di > 150 mm **und** e > 16 mm.

In the English version it's stated that for weld type 16: di ≤ 150 mm **and** e ≤ 16 mm
In the German version it's stated that for weld type 16: di ≤ 150 mm **oder** e ≤ 16 mm.

Can I assume that the English translation is the correct one? As the German version does not make sense at this point?

For example
Type 3a/3b: di > 150 mm und e > 16 mm
Type 4: di ≤ 150 mm und e ≤ 16 mm
=> a butt weld in a nozzle di = 300mm with e = 10mm is undefined at this point in the German version.

Proposed answer(s): *

Change the German version according to the English version.

Answer from the MHD *(to be filled by MHD):*
Agreed with the proposed corrections, to be updated in 2017 version.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

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

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EN 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)
Question form

Request reference number *(to be filled by MHD):* **(2014)-05-11** **Date: 2016-03-05**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-5	2015 (German version only)	23	Line 21 in Tabelle 6.6.2-1	--

Subject:

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

From :
Company: Inspecta Tarkastus Oy .....
Name: Juha Purje .....
Postal address: PO Box 7, FI-00441 Helsinki, Finland
e-mail: juha.purje@inspecta.com .....
phone: +358 50 52 51 180 .....

☐ Manufacturer ☐ User X Other (please specify): Notified Body no 0424

Question/comment:

With the publication of EN 13445-5:2014 issue 2 the extent of surface inspection (MT or PT) in Table 6.6.2-1 line 21 column 2a has been decreased from 100 % to 10 %.

This modification is technically justified but I'd like to remark that the proper procedures for a modification of the standard hasn't been followed. I do not consider such a modification to be only an editorial correction. However, that is not the reason for my comment ☺.

In the German version the upper note f in line 21, Dauerhaft angeschweißte Anbauteile[f] remains.

Proposed answer(s): *

Delete the upper note f, proper text in line 21 in the German version is

Dauerhaft angeschweißte Anbauteile

Answer from the MHD *(to be filled by MHD):*
Agreed with the proposed corrections, to be updated in 2017 version.

To be sent to EN 13445 Maintenance Help Desk secretariat:

EN 13445 MHD secretariat c/o UNM
Standardization Office on behalf of AFNOR
F 92038 Paris La Défense Cedex – France
e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-0x-0x** **Date: 201X-xx-xx**

Please fulfil the following

Part:	Issue:	Page	Subclause	National Standard Reference
EN 13445-5	2014 Issue 3	24 37 (2x) 50	Table 6.6.2-1 Table 10.2.3.3.1-1 A.7.2.1	--

Subject: Simplification possible or data error?

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

From :
Company: UcoTek AB .....
Name: Ulf Malmström .....
Postal address: 1, Irisdal, SE-14461 Rönninge, Sweden
e-mail:ulf@ucotek.se .....
phone: +46707686690 .....

☐ Manufacturer ☐ User X Other (please specify): Consultant

Question/comment: Standard contains four references to table 6.6.3-1, but that table does not exist.

Proposed answer(s): Change reference to whatever is correct reference.

Answer from the MHD *(to be filled by MHD):*

Partially correct, for Table 6.6.2-1, sentence with reference to table 6.6.3-1 will be deleted in issue 4.
Table 10.2.3.3.1-1: Replace the two sentences "e_w < 50 % of allowed value given in Table 6.6.3-1" by sentences

"e_w < 50 % of allowed value of EN ISO 5817:2014 Quality level C",

A.7.2.1 a): Replace the sentence "whole length of governing welds shall be 100 % tested by UT or RT with the acceptance criteria given in Table 6.6.3-1." by

"whole length of governing welds shall be 100 % tested by UT or RT with the acceptance criteria given in EN ISO 17635:2010, Tables A.5 (RT-F) and A.8 (UT)."

To be sent to EN 13445 Maintenance Help Desk secretariat:

EN 13445 MHD secretariat c/o UNM
Standardization Office on behalf of AFNOR
F 92038 Paris La Défense Cedex – France
e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD)*: **(2014)-05-13**			**Date: 2016-09-22**	
Please fulfil the following				
Part: EN 13445-5	Issue: 2016	Pages 24, 37, 50	Subclauses Table 6.6.2-1 note j Table 10.2.3.3.1-1 A.7.2.1 a)	National Standard Reference -
Subject:				
Type of request:	☐ Technical clarification		X Editorial correction	
	☐ Technical comment		☐ Translation correction	

From :
Company: Inspecta Tarkastus Oy .....
Name: Juha Purje .....
Postal address: PO Box 7, FI-00441 Helsinki, Finland

e-mail: juha.purje@inspecta.com .....
phone: +358 50 52 51 180 .....

☐ Manufacturer	☐ User	X Other (please specify): Notified Body no 0424

Question/comment:

When the NDT-requirements and text of clause 6.6.3 were modified in 2013 by publishing the amendment EN 13445-5/A4:2013 the Table 6.6.3-1 was deleted and replaced by reference to standard EN ISO 17635.

Unfortunately the Table 6.6.3-1 is still referenced on 4 cases on pages 24, 37 and 50.

Proposed answer(s): *

All references to Table 6.6.3-1 shall be deleted or replaced by correct references like

Table 6.6.2-1 Note j: Delete the sentence “See Table 6.6.3-1 for other circumstances for use of both techniques.”

Table 10.2.3.3.1-1: Replace the two sentences “e_w < 50 % of allowed value given in Table 6.6.3-1” by sentences “e_w < 50 % of allowed value of EN ISO 5817:2014 Quality level C”,

A.7.2.1 a): Replace the sentence “whole length of governing welds shall be 100 % tested by UT or RT with the acceptance criteria given in Table 6.6.3-1.” by

“whole length of governing welds shall be 100 % tested by UT or RT with the acceptance criteria given in EN ISO 17635:2010, Tables A.5 (RT-F) and A.8 (UT).”

Answer from the MHD *(to be filled by MHD):*

Agreed with the proposal, will be updated in issue 4.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-05-14**			**Date: 2016-10-20**	
Please fulfil the following				
Part: EN 13445-5	Issue: 2016	Page 23	Subclause	National Standard Reference --
Subject: interpretation of the word "collar" for weld type 9,10,11,12,13,14				
Type of request:	x☐ Technical clarification		☐ Editorial correction	
	☐ Technical comment		☐ Translation correction	
From : Company:Kooiman Apparatenbouw bv ..... Name:J. Dijkstra..... Postal address:Baanhoek 196 3361GN Sliedrecht NL			e-mail:jd@kooimanbv.nl ..... phone: +31(0) 184422833	
x☐ Manufacturer	☐ User	☐ Other (please specify):		

Question/comment: Is the word "collar" as used in the above mentioned type of welds also used/applicable to as example vacuumrings around a shell. (Detail "vacuumring" is not shown on fig 6-6.2.3

Proposed answer(s): No " collar" only used to indicate slip-on or lap joint type flange and not for attachments to the shell.

Answer from the MHD *(to be filled by MHD):*

No " collar" only used to indicate slip-on or lap joint type flange and not for attachments to the shell which are joints type 21 in Table 6.6.2-1, and Figure 6.6.2-3.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-06-01**			**Date: 2016-09-06**	
Please fulfil the following				
Part: EN 13445-6	Issue: 2014 Issue 3	Page 31	Subclause D.5.3	National Standard Reference --
Subject: Clarification of sub-clause				
Type of request:	X Technical clarification ☐ Technical comment		X Editorial correction ☐ Translation correction	
From : Company: UcoTek AB ..... Name: Ulf Malmström ..... Postal address: 1, Irisdal, SE-14461 Rönninge, Sweden			e-mail:ulf@ucotek.se ..... phone: +46707686690	
☐ Manufacturer	☐ User	X Other (please specify): Consultant		

Question/comment: The 1st sentence seems to make no sense at all. The problem is the same in the German version – I have not checked the French version.

Proposed answer(s): Delete the 1st sentence. In the remaining sentence possibly add 'cast' after 'Any'.

Answer from the MHD *(to be filled by MHD):*

Question addressed to WG56 in charge of EN13445-6.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-06-02**			**Date: 2016-09-07**	
Please fulfil the following				
Part: EN 13445-6	Issue: 2014 Issue 3	Page 7	Subclause 1 Note 2	National Standard Reference --
Subject: Incorrect reference				
Type of request:	☐ Technical clarification		X Editorial correction	
	☐ Technical comment		☐ Translation correction	

From :
Company: UcoTek AB .....
Name: Ulf Malmström .....
Postal address: 1, Irisdal, SE-14461 Rönninge, Sweden
e-mail:ulf@ucotek.se .....
phone: +46707686690 .....

☐ Manufacturer	☐ User	X Other (please specify): Consultant

Question/comment: The note refers to tables 3 and 4 which do not exist. The problem is the same in the German version – I have not checked the French version.

Proposed answer(s): Replace with references to tables 5.1-1 och 5.1-2.

Answer from the MHD *(to be filled by MHD):*
Proposed answer is correct, this will be updated in 2017 version.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

***** *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 13445 "Unfired pressure vessels" Maintenance Help Desk (MHD)

Question form

Request reference number *(to be filled by MHD):* **(2014)-06-03**			**Date: 2016-09-07**	
Please fulfil the following				
Part: EN 13445-6	Issue: 2014 Issue 3	Page 40	Subclause Table D.2	National Standard Reference --
Subject: Simplification possible or data error?				
Type of request:	☐ Technical clarification X Technical comment		☐ Editorial correction ☐ Translation correction	
From : Company: UcoTek AB ..... Name: Ulf Malmström ..... Postal address: 1, Irisdal, SE-14461 Rönninge, Sweden			e-mail:ulf@ucotek.se ..... phone: +46707686690	
☐ Manufacturer	☐ User	X Other (please specify): Consultant		

Question/comment: The table contains two columns for 'Constants of curve $\Delta\sigma R$ – N'. However, the values in the two columns are identical (Cf. table D.1 where the data are different)

This would make it possible to simplify the table by consolidating these two columns. Or could it be that the data in one of the columns is wrong?

Proposed answer(s):

Answer from the MHD *(to be filled by MHD):*

Question addressed to WG56 in charge of EN13445-6.

To be sent to EN 13445 Maintenance Help Desk secretariat:	EN 13445 MHD secretariat c/o UNM Standardization Office on behalf of AFNOR F 92038 Paris La Défense Cedex – France e-mail: en13445@unm.fr

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