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BSI Standards Publication

Industrial valves - Butt welding ends for steel valves

bsi.

National foreword

This British Standard is the UK implementation of EN 12627:2017. It supersedes BS EN 12627:1999, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee PSE/18/1, Industrial valves, steam traps, actuators and safety devices against excessive pressure - Valves - Basic standards.

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

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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English Version

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Robinetterie industrielle - Extrémités à souder en bout pour appareils de robinetterie en acier

Industriearmaturen - Anschweißenden für Armaturen aus Stahl

This European Standard was approved by CEN on 18 September 2017.

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European foreword

This document (EN 12627:2017) has been prepared by Technical Committee CEN/TC 69 “Industrial valves”, the secretariat of which is held by AFNOR.

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of an identical text or by endorsement, at the latest by May 2018, and conflicting national standards shall be withdrawn at the latest by May 2018.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 12627:1999.

The main changes compared to the previous edition are:

a) change of the tolerance value and diameter for DN 65 in Table 2;

b) introduction of angle α in Figures 2, 3, 4, 5 and 6.

c) editorial revision of this standard;

d) deletion of Annex A giving the basis document from which the previous edition was taken.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

1 Scope

This European Standard specifies the dimensions of butt welding ends of steel valves DN 8 to DN 1 400 designed to be butt welded to standardized pipes.

NOTE The outside diameters and wall thickness of standardized pipes are in accordance with ISO 4200.

2 Normative references

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

EN 736-1, *Valves — Terminology — Part 1: Definition of types of valves*

EN 736-2, *Valves — Terminology — Part 2: Definition of components of valves*

EN 736-3, *Valves — Terminology — Part 3: Definition of terms*

EN 1092-1, *Flanges and their joints — Circular flanges for pipes, valves, fittings and accessories, PN designated — Part 1: Steel flanges*

ASME B16.25, *Buttwelding Ends*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 736-1, EN 736-2 and EN 736-3 apply.

4 Symbols

The symbols used in this standard are as follows:

$\emptyset A$ is the outside diameter of the valve butt welding end, in mm (see Table 2);

$\emptyset B$ is the inside diameter of the pipe, in mm;

T is the wall thickness of the pipe, in mm;

t_D is the thickness of the valve butt welding end, in mm;

t_n is the transition, in mm.

5 Requirements

5.1 Selection of angle α

Angle α shall be selected from Table 1.

Table 1 — Selection of angle α

Type of weld-end	α	Deviation	Referred basic standard
A	30°	+5	EN 1092-1
B	37,5°	±2,5	ASME B16.25