BS EN 12814-4:2018

BSI Standards Publication

Testing of welded joints of thermoplastics semi-finished products

Part 4: Peel test

bsi.

National foreword

This British Standard is the UK implementation of EN 12814-4:2018. It supersedes BS EN 12814-4:2001, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee PRI/80, Welding thermoplastics.

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.

Published by BSI Standards Limited 2018

ISBN 978 0 580 94193 1

ICS 25.160.40

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

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 30 April 2018.

Amendments/corrigenda issued since publication

Date	Text affected

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 12814-4

April 2018

ICS 25.160.40

Supersedes EN 12814-4:2001

English Version

Testing of welded joints of thermoplastics semi-finished products - Part 4: Peel test

Essai des assemblages soudés sur produits semi-finis en thermoplastiques - Partie 4 : Essai de pelage

Prüfen von Schweißverbindungen aus thermoplastischen Kunststoffen - Teil 4: Schälversuch

This European Standard was approved by CEN on 10 December 2017.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels

Ref. No. EN 12814-4:2018: E

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European foreword

This document (EN 12814-4:2018) has been prepared by Technical Committee CEN/TC 249 “Plastics”, the secretariat of which is held by NBN.

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of an identical text or by endorsement, at the latest by October 2018, and conflicting national standards shall be withdrawn at the latest by October 2018.

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 12814-4:2001.

In comparison with the previous edition, the following technical modifications have been made:

— the procedures in the Clauses “T-peel test”, “Decohesion test”, “Crush test” have been detailed with specifications and consequently with the reference figures.

EN 12814, *Testing of welded joints of thermoplastics semi-finished products*, is composed with the following parts:

— *Part 1: Bend test;*

— *Part 2: Tensile test;*

— *Part 3: Tensile creep test;*

— *Part 4: Peel test;*

— *Part 5: Macroscopic examination;*

— *Part 6: Low temperature tensile test;*

— *Part 7: Tensile test with waisted test specimens;*

— *Part 8: Requirements.*

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 document specifies the dimensions, the method of sampling and the preparation of the test specimens, and also the conditions for performing the peel test perpendicular to the weld in order to determine the peel resistance and the failure behaviour.

A peel test can be used in conjunction with other tests (e.g. tensile creep, macroscopic examination...) to assess the performance of welded assemblies, made from thermoplastics materials.

Peel tests are applicable to overlap welded assemblies made from thermoplastics materials.

The T-peel test as defined in Clause 5 will be used only for assessing welded sheet assemblies. This test is not applicable to welded test pieces containing sheets of different nominal thickness.

The decohesion test as defined in Clause 6 will be used only for assessing electrofusion joints with nominal thickness of pipe/fitting greater than 10 mm.

For socket fusion and for electrofusion socket joints with nominal outside diameter less than or equal to 90 mm, a crush test will be used, as defined in Clause 7.

The crush test can also be used for electrofusion joints with outside diameters greater than 90 mm.

The crush test for electrofusion saddle joints will be performed in accordance with ISO 13955 [1].

NOTE A decohesion test is also defined in ISO 13954 [2].

The tests defined in this standard are not intended to be used for assessment and/or qualification of thermoplastic fittings that already have their own requirements, e.g. polyethylene fittings according to EN 1555-3 [3] and EN 12201-3 [4].

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5893, *Rubber and plastics test equipment — Tensile, flexural and compression types (constant rate of traverse) — Specification*

3 Terms and definitions

For the purposes of this document, the following term and definition apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— IEC Electropedia: available at http://www.electropedia.org/

— ISO Online browsing platform: available at http://www.iso.org/obp

3.1
peel resistance
P_l
arithmetic mean of the force values divided by the width of the test specimen (only relevant for T-peel test)

4 Symbols and designations

For the purposes of this document, the symbols and designations given in Table 1 apply.