



RI.
SE

Provning av fogar

Produktstandard, strukturväggsrör

- EN 13476-2, exvis spirallindade rör, Typ A
- EN 13476-3, korrugerade rör, Typ B

Utdrag ur EN 13476-2 och -3

		Duration	1 min	
Tensile test of welded or fused joints	No break in the joint	Minimum tensile force	Shall conform to Table 15	EN ISO 13262 ^f
^a The following requirements apply: - vertical deformation: $\leq 9\%$; - deviation from surface evenness in bottom: $\leq 3\text{ mm}$; - radius of bottom: $\geq 80\%$ of original; - opening of weld line: $\leq 20\%$ of wall thickness; - tightness at 0,35 bar/15 min: No leakage allowed. ^b Only for components in accordance with this document with DN/OD ≤ 315 and DN/ID ≤ 300 and marked UD. ^c Only for components in accordance with this document with DN/OD ≤ 200 and DN/ID ≤ 180 and marked UD. ^d Only for fabricated fittings made from more than one piece. A sealing ring retaining component is not considered as a piece. ^e If it is not practical to carry out the test with water, air can be used at either positive or negative pressures. ^f This test is applicable for all pipe and fitting constructions when jointed by fusion or welding. The test pieces shall be cut longitudinally in the fusion area. The length of the test piece shall include the joint plus a length at each end sufficient to ensure a proper grip in the tensile testing machine. ^g If it is not practical to be carried out with water. Air to be considered at either positive or negative pressures.				

**Plaströrssystem av termoplast för avlopp i mark – Spiralformade
lättnviktsrör av termoplast – Bestämning av draghållfasthet hos
en söm (ISO 13262:2010)**

**Thermoplastics piping systems for non-pressure underground
drainage and sewerage – Thermoplastics spirally-formed
structured-wall pipes – Determination of the tensile strength of a
seam (ISO 13262:2010)**

Provning enligt EN ISO 13262

Provstav tvärs svetsen

Bredd 15 mm, om möjligt

Dragprov

Resultat anges som N/15 mm bredd

x

Provning enligt EN ISO 13262

Krav: Inget brott i svetsen

samt

Table 15 — Minimum tensile strength of seam

Nominal size DN/ID or DN/OD	Minimum tensile force N
DN < 400	380
$400 \leq \text{DN} < 600$	510
$600 \leq \text{DN} < 800$	760
DN $\geq$ 800	1020