
**Refrigerating systems and heat
pumps — Valves — Requirements,
testing and marking**

*Systèmes de réfrigération et pompes à chaleur — Robinetterie —
Exigences, essais et marquage*





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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO TC 86, *Refrigeration and air-conditioning*, Subcommittee SC 1, *Safety and environmental requirements for refrigerating systems*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 182, *Refrigerating systems, safety and environmental requirements*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This first edition is based on EN 12284:2003.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

This document is intended to describe the safety requirements, safety factors, test methods, test pressures used, and marking of valves and other components with similar bodies for use in refrigerating systems.

Refrigerating systems and heat pumps — Valves — Requirements, testing and marking

1 Scope

This document specifies safety requirements, certain functional requirements, and marking of valves and other components with similar bodies, hereinafter called valves, for use in refrigerating systems including heat pumps.

This document includes requirements for valves with extension pipes.

This document describes the procedure to be followed when designing valve parts subjected to pressure as well as the criteria to be used in the selection of materials.

This document describes methods by which reduced impact values at low temperatures may be taken into account in a safe manner.

This document applies to the design of bodies and bonnets for pressure relief devices, including bursting disc devices, with respect to pressure containment but it does not apply to any other aspects of the design or application of pressure relief devices.

In addition, this document is applicable to valves with a maximum operating temperature not exceeding 200 °C and a maximum allowable pressure not exceeding 160 bar¹⁾.

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 148-1, *Metallic materials. Charpy pendulum impact test — Part 1: Test method*

ISO 5149-1, *Refrigerating systems and heat pumps — Safety and environmental requirements — Part 1: Definitions, classification and selection criteria*

ISO/TR 15608, *Welding — Guidelines for a metallic material grouping system*

EN 12516-2, *Industrial valves — Shell design strength — Part 2: Calculation method for steel valve shells*

EN 13445-3, *Unfired pressure vessels — Part 3: Design*

EN 14276-2:2020, *Pressure equipment for refrigerating systems and heat pumps — Part 2: Piping — General requirements*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 5149-1 and the following apply.

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

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

1) 1 bar = 0,1 MPa.

3.1 valve

device with a pressure enclosure and an intended additional functionality, such as influencing the fluid flow by opening, closing or partially obstructing the passage of the flow or by diverting or mixing the fluid flow, indicating moisture content or filtering the fluid flow

Note 1 to entry: A device with a pressure enclosure and an intended additional functionality is designated as pressure accessory according to the European Pressure Equipment Directive 2014/68/EU.

3.2 extension pipe

pipework connected to a valve by the valve manufacturer, which does not influence the pressure strength of the valve itself

Note 1 to entry: Extension pipes often have different diameters in two ends.

Note 2 to entry: The application of extension pipes is determined by the manufacturer and has the advantage that the pressure strength verification of the extension pipes becomes independent of the safety factors used for the verification of the valve.

3.3 valve assembly

combination of a valve and one or more extension pipes

EXAMPLE An example of a valve assembly is given in Clause H.6.

3.4 operating range

combination of temperature and pressure conditions at which the valve can safely be operated

3.5 nominal size

DN

alphanumeric designation of size for components of a pipework system, which is used for reference purposes comprising the letters *DN* followed by a dimensionless whole number which is indirectly related to the physical size, in millimetres, of the bore or outside diameter of the end connections

Note 1 to entry: The number following the letters *DN* does not represent a measurable value and should not be used for calculation purposes except where specified in this document.

Note 2 to entry: Where the nominal size is not specified, for the purpose of this document it is assumed to be the internal diameter of the pipe or component in mm (DN/ID).

Note 3 to entry: Nominal size is not the same as port size which is commonly used for the size of the valve seat opening.

Note 4 to entry: For additional information regarding the *DN* system, see [Annex I](#).

[SOURCE: ISO 6708:1995, 2.1, modified — Notes to entry added.]

3.6 nominal pressure

PN

numerical designation which is a convenient rounded number for reference purposes

Note 1 to entry: All equipment of the same nominal size (DN) designated by the same PN number shall have compatible mating dimensions.

[SOURCE: ISO 7268:1983/Amd.1:1984, modified]

3.7 corrosion

all forms of material waste (e. g. oxidation, erosion, wear and abrasion)

3.8**maximum operating temperature**

highest temperature that can occur during operation or standstill of the refrigerating system or during testing under test conditions

3.9**minimum operating temperature**

lowest temperature that can occur during operation or standstill of the refrigerating system or during testing under test conditions

3.10**pressure bearing part**

part, which is subject to stress due to internal pressure greater than 50 kPa (0,5 bar) gauge

3.11**main pressure bearing part**

part, which constitute the envelope under pressure, essential for the integrity of the equipment

Note 1 to entry: Examples are bonnets, housings, end covers and flanges.

[SOURCE: EN 13445-1:2014]

3.12**seat tightness class**

letter from A to G indicating the internal tightness of the valve across the valve seat(s)

3.13**competent body**

third party organisation which has recognized competence in the assessment of quality systems for the manufacture of materials and in the technology of the materials concerned

Note 1 to entry: National legislation can place additional requirements on the competent body depending on the market for which the valve is intended.

3.14**type of valve connection**

standard and size of the valve connection to other equipment directly fixed to the valves end

Note 1 to entry: Possible types of valve connection are e.g.

- a) *NPS* 2, i.e. a butt-welding connection to ASME/ANSI B 36.10 2 inch steel pipe,
- b) *NPT* ½, i.e. a screwed connection with ½ inch male end according to ASME/ANSI B 1.20.1,
- c) EN 1092-1/11/C/DN 200 x 6,3/PN 40, i.e. a flange type 11 with facing type C (tongue) of nominal size *DN* 200, wall thickness 6,3 mm, *PN* 40.

3.15**pressure sensitive part**

part of a valve which will not have a reliable function after exposure to the greater of 1,5 times *PS* and 1,25 times *PS₀*

Note 1 to entry: Examples include bellows, diaphragms or float balls.

3.16**spindle**

part of the valve which actuates the intended functionality, e.g. opening or closing for influencing the fluid flow

Note 1 to entry: A valve does not necessarily need to incorporate a spindle.

3.17**maximum allowable pressure***PS*

maximum pressure for which the valve or valve assembly is designed, as specified by the manufacturer

3.18**maximum allowable pressure at ambient temperature (–10 °C to + 50 °C)***PS₀*

maximum pressure for which the valve or valve assembly is designed, as specified by the manufacturer, at ambient temperature (–10 °C to + 50 °C)

4 List of symbolsSymbols used in this document are given in [Table 1](#):**Table 1 — List of symbols**

A_L	Elongation after fracture where the measured length is equal or greater than 0,4 times of diameter of the rod	mm
A_5	Elongation after fracture where the measured length is equal to 5 times of diameter of the rod	%
a	Lifetime in years for calculating effect of corrosion; typically 20 years	—
C_Q	Factor to compensate for the quality of a casting	—
D	Diameter of the hand-wheel	mm
δ_e	Negative wall thickness tolerance	mm
e_{act}	Actual wall thickness at given measuring points of the valve to be tested	mm
e_B	Reference thickness is the minimum material thickness needed to give adequate strength to pressure bearing parts	mm
e_c	Reduction in wall thickness caused by occurrence of corrosion	mm
e_{con}	Component wall thickness as specified in the design drawing	mm
F	Operating manual force to size the manual operating element	N
F_s	Maximum manual force to size the manual operating element	N
KV	Impact rupture energy	J
KV_0	Threshold value of impact rupture energy, where the impact rupture energy is defined as independent of the temperature	J
KV_0^t	Standard value of impact rupture energy at standard temperature of the material	J
$KV_{TS\ min}$	Impact rupture energy at minimum operating temperature TS_{min}	J
K_{VS}	Rate of flow of water in cubic metres per hour for a differential pressure Δp of 1 bar (0,1 MPa) at the rated full opening	m ³ /h
L	Leakage in percent of K_{VS}	%
l	Length of the lever or radius of the crank circle	mm
P_F	Maximum allowable design test pressure	bar
PS	Maximum allowable pressure	bar
PS_0	Maximum allowable pressure at ambient temperature (–10 °C to + 50 °C)	bar
$PS_{TS\ max}$	Maximum allowable pressure at maximum operating temperature	bar
$PS_{TS\ min}$	Maximum allowable pressure at minimum operating temperature	bar
P_{Test}	Minimum burst test pressure (greater than P_F)	bar
p_1	Upstream pressure	bar
p_2	Downstream pressure	bar
Δp	Differential pressure	bar

NOTE 1 bar = 0,1 MPa.

Table 1 (continued)

p'	Testing pressure of each valve after production	bar
Q_M	Mass flow rate	kg/h
Q_V	Downstream volume flow rate	m ³ /h
$R_{e\ 1,0}$	Yield strength, 1,0% offset	MPa, N/mm ²
$R_{e\ 1,0\ TS\ max}$	Yield strength, 1,0% offset at maximum operating temperature	MPa, N/mm ²
$R_{e\ 0,2}$	Yield strength, 0,2% offset at ambient temperature	MPa, N/mm ²
$R_{p\ 0,2}$	Proof strength, 0,2% offset at ambient temperature	MPa, N/mm ²
$R_{p\ 0,2\ TS\ min}$	Proof strength, 0,2% offset at minimum operating temperature	MPa, N/mm ²
$R_{p\ 0,2/t}$	Proof strength, 0,2% offset at temperature t	MPa, N/mm ²
$R_{p\ 0,2\ TS\ max}$	Proof strength, 0,2% offset at maximum operating temperature	MPa, N/mm ²
$R_{p\ 1,0}$	Proof strength, 1,0% offset at ambient temperature	MPa, N/mm ²
R_{eH}	Upper yield strength	MPa, N/mm ²
$R_{eH\ TS\ max}$	Upper yield strength at maximum operating temperature	MPa, N/mm ²
R_m	Tensile strength	MPa, N/mm ²
$R_{m\ TS\ max}$	Tensile strength at maximum operating temperature	MPa, N/mm ²
$R_{m\ act}$	Actual tensile strength of the material of the valve to be tested	MPa, N/mm ²
$R_{m\ con}$	Tensile strength used for the design	MPa, N/mm ²
ρ	Density of the actual fluid	kg/m ³
ρ_0	Density of water at 15,5 °C	kg/m ³
ρ_1	Upstream density	kg/m ³
ρ_2	Downstream density	kg/m ³
S_C	Factor to compensate effects of corrosion	—
S_{con}	Factor for the calculation of the burst test pressure taking into account the tensile strength according to Table A.1	—
S_F	Factor to allow for forming	—
$S_{TS\ min}$	Factor taking into consideration the impact rupture energy reduction due to minimum operating temperature	—
$S_{TS\ max}$	Factor to allow for the reduction in strength due to the maximum operating temperature	—
S_σ	Factor to allow for the test pressure	—
σ_{con}	Initial design stress	MPa, N/mm ²
σ_{corr}	Allowable stress values derived from σ_{con}	MPa, N/mm ²
$t_{min\ 25}$	Lowest temperature at which pressure bearing parts can be used, if their load amounts to 25 % of the allowable design stress at 20 °C, taking the safety factors according to Table A.1 into account	°C
$t_{min\ 75}$	Lowest temperature at which pressure bearing parts can be used, if their load amounts to 75 % of the allowable design stress at 20 °C, taking the safety factors according to Table A.1 into account	°C
$t_{min\ 100}$	Lowest temperature at which pressure bearing parts can be used, if their load amounts to 100 % of the allowable design stress at 20 °C, taking the safety factors according to Table A.1 into account	°C
T_R	Design reference temperature is the minimum operating temperature TS_{min} adjusted. Used when determining TS_{min} based on reference thickness e_B	
T_S	Temperature adjustment of the design reference temperature T_R	
T_{KV}	Impact test temperature	
TS	Operating temperature	°C
TS_{min}	Lowest operating temperature	°C

NOTE 1 bar = 0,1 MPa.

Table 1 (continued)

$TS_{\max}$	Maximum operating temperature	°C
τ	Torque, under specified conditions, to operate the valve	Nm
τ_s	Maximum torque, under specified conditions, to seat or unseat the obturator or to overcome temporary intermediate dynamic conditions	Nm
V	Inner volume of a valve	l
X	Correction of the actual wall thickness relative to the wall thickness of the design	—
K	assigns the value $\frac{\Delta p}{P_1}$	—
Y	Correction on the basis of current strength values of the test sample relative to the strength parameters for the design of valves	—
Z	Factor to allow for the quality of a joint (e.g. welded joint)	—
∂	Wall thickness reduction per year	mm
NOTE 1 bar = 0,1 MPa.		

5 General requirements

5.1 Installation and operation

Valves and valve assemblies shall be designed for the operational loads and conditions as specified in the relevant refrigerating system safety standard.

Relevant refrigerating system safety standards include:

- a) ISO 5149-1, ISO 5149-2 and ISO 5149-4,
- b) IEC 60335-2-40,
- c) ANSI/ASHRAE Standard 15,
- d) EN 378-1, EN 378-2 and EN 378-4.

The application of extension pipes is determined by the manufacturer.

NOTE 1 When extension pipes are applied, the finished device is a valve assembly (see [3.3](#)) consisting of a valve (see [3.1](#)) and extension pipes (see [3.2](#)).

NOTE 2 The application of extension pipes has the advantage that the pressure strength verification of the pipes becomes independent of the safety factors used in the verification of the valve body.

The lowest operating temperature ($TS_{\min}$), maximum operating temperature ($TS_{\max}$), and the maximum allowable pressure (PS) shall be the same for extension pipes and valve assemblies as for the valve incorporated in the valve assembly.

The manufacturer shall classify the category of the valve, extension pipe, and valve assembly according to [Annex H](#) as appropriate.

5.2 Components under pressure

All parts of the valve or valve assembly shall be designed and manufactured to remain leak proof and to withstand the pressures which may occur during operation, standstill and transportation, taking into account the thermal, physical and chemical stresses to be expected.

5.3 Excessive mechanical stress

After installation, valves and valve assemblies, especially valves for hot gas defrosting, shall not be under excessive mechanical stress from fitting of the pipe or from temperature variations during operation.

NOTE Hot gas defrosting can produce hydraulic shocks resulting in transient pressures in excess of *PS*.

5.4 Tightness

The valve or valve assembly shall not leak to the outside when tested as described in [9.2](#). Valve seats shall seal to a degree specified in [9.3](#).

5.5 Functioning of hand-operated valves

Proper functioning of hand-operated valves shall be ensured for the entire operating range up to the allowable pressure *PS* and the associated allowable temperature *TS*.

5.6 Functioning of actuator-operated valves

Proper functioning of actuator-operated valves operated by the fluid or by energy from an external source, shall be ensured for the entire operating range, which is to be specified by the manufacturer.

6 Materials

6.1 General

6.1.1 Using metallic materials

Metallic materials, included welding filler metals, solders, brazing metals and sealants, shall allow for the thermal, chemical and mechanical stresses arising in system operation. Materials shall be resistant to the refrigerants, solvents (in absorption systems) and refrigerant-oil mixtures used in each particular case.

NOTE A list of suitable materials is found in [Annex E](#) of this document. Steel information can also be found in EN 13445-2 or ASME B 31.5, along with other useful information.

If material properties are changed during the method of manufacture (e.g. through welding or deep drawing) to such an extent that the strength and/or Charpy notch energies, according to ISO 148-1, are reduced, these reduced values shall be taken into consideration by corrections or shall be subject to suitable compensatory material treatment (e.g. heat treatment).

Residual stress can e.g. decrease impact strength and increase stress corrosion (see [Annex L](#)). Where relevant, it shall be verified that the residual stress does not impose adverse implications.

Materials with a deformation higher than 2 % shall be heat treated with the respective material specifications. Alternatively, the proof against inner pressure shall be verified by test, if no heat treatment is used.

6.1.2 Using non-metallic materials

It is permitted to use non-metallic materials, e.g. for gaskets, coatings, insulating materials, and sightglasses, provided that they are compatible with other materials, refrigerants and lubricants.

The compatibility of rubber and thermoplastic sealing materials and flat gaskets shall be evaluated according to [Annex K](#).

6.2 Requirements for materials to be used for pressure bearing parts

Materials listed in this document (see [Annex E](#)) have been identified for use in valves.

Lamellar cast iron shall not be used but nodular cast iron can be used down to temperatures at which it can be proved to achieve overall levels of safety equivalent to alternative materials.

NOTE EN 1563 contains information on nodular cast iron.

Free-cutting steel generally does not have the impact strength, KV_0 , required for pressure bearing parts. It may be used for pressure bearing parts where pressure is not a significant design factor.

Where new materials are proposed, the design shall be carried out using [Annexes A](#) to [D](#) provided the yield strength or proof strength, as applicable, at the maximum operating temperature and the impact rupture energy at the lowest operating temperature are known. If these properties are not known the material shall not be used.

6.3 Compatibility of connections

Materials which are to be physically joined shall be suitable for an effective connection, depending on the particular materials used and on the dimensions of the piping specified.

6.4 Ductility

Materials which are to be considerably deformed shall be sufficiently ductile and capable of being heat treated where necessary.

6.5 Ageing

Materials for pressurized parts shall not be significantly affected by ageing.

6.6 Castings

Castings shall exhibit a low stress level. If they are not subjected to stress relief heat treatment, controlled cooling shall be ensured after the casting process and after any heat treatment which may have been applied.

6.7 Forged and welded components

Forged and welded components shall be fabricated from suitable materials (e.g. weldable close grain low carbon steel) and shall be heat treated where the combination of operating temperature, operating pressure and wall thickness indicates by calculation that heat treatment is necessary.

Free-cutting steel is not qualified for welding.

6.8 Nuts, bolts and screws

Materials for nuts, bolts and screws for joining housing parts subject to pressure loads shall exhibit the correct characteristics for the material over the full range of the application limits for the nuts, bolts and screws defined by the operating temperature, whereby the following minimum values for the elongation at fracture and notched impact rupture energy shall be achieved. The test piece for impact rupture energy measurements shall be taken parallel to the drawing or rolling direction, and the notch orientation shall be perpendicular to the drawing or rolling direction.

- a) for ferritic materials an elongation at fracture $A_5 \geq 14 \%$;
- b) for cold formed austenitic materials an elongation at fracture $A_L \geq 0,4 \times d$;

- c) for lowest operating temperature $TS_{\min} \geq -10$ °C: a notched impact rupture energy KV at 20 °C for tempered alloyed steels of at least 52 J and of at least 40 J for tempered carbon steels (ISO V test-piece);
- d) for lowest operating temperature of $TS_{\min} < -10$ °C: a notched impact rupture energy KV at $TS_{\min}$ of at least 40 J for tempered carbon steels and tempered alloyed steels (V test-piece).

NOTE Some suitable materials are given in [Annex E](#) of this document.

6.9 Spindles

Material for spindles shall be corrosion-resistant to ensure safe operation, and shall exhibit appropriate material characteristics over the complete operating temperature range.

6.10 Glass materials

Glass shall be free from listers, crystalline enclosures and surface irregularities.

Thermal reinforcement (tempering) of glass should only be applied for strength reasons.

6.11 Requirements for documentation

Material test certificates shall be provided by the manufacturer to ensure that the material used conforms with the required specification and that it is traceable from receipt through production up to the final test, preferably at the time of delivery and not later than the time of commissioning. Any required inspection certificate shall be prepared on behalf of and signed by the competent person who carried out the inspection, test, or checking.

Each certificate shall be one of the following 3 types:

- Certificate type 1: A certificate declaring compliance with the order.
- Certificate type 2: A test report showing compliance with the order. The material tested may be from a different batch than the material supplied.
- Certificate type 3: A certificate declaring compliance with the order and in which test results are supplied. The material tested shall be from the same batch as the material supplied.

NOTE 1 ISO 10474 inspection documents type 2.1, 2.2, and 3.1 are examples of certificate types 1, 2, and 3 respectively for steel and steel products.

NOTE 2 EN 10204 inspection documents type 2.1, 2.2, and 3.1 are examples of certificate types 1, 2, and 3 respectively for all metallic materials.

The requirements for material test certificates depend on the category of the valve, as defined in [Annex H](#), and the function of the material in the valve.

Certificate type 1 or higher is required for materials used in:

- valves and extension pipes of category less than I, and
- for non pressure bearing parts.

Certificate type 2 or higher is required for materials used in:

- Pressure bearing parts of category I valves and extension pipes, and
- Nuts, bolts and screws of valves of category II to IV, unless its failure would result in a sudden discharge of pressure energy.

Certificate type 3 is required for materials used in main pressure bearing parts of category II, III and IV valves and extension pipes, and for nuts, bolts and screws where its failure would result in a

sudden discharge of pressure energy. These certificates shall be verified by a competent body, or the manufacture shall be approved for doing this verification by a competent body.

NOTE 1 Nuts, bolts and screws are typically used in a way where the failure of a single nut, bolt or screw will result in a leak, but not result in a sudden discharge of pressure energy.

NOTE 2 European Pressure Equipment Directive 2014/68/EU allows “attachments” of category 1 valves to use inspection type 2.1, and for higher categories to use type 2.2. For simplicity the requirements in this document are slightly higher.

6.12 Impact energy *KV* measurement on sub-sized specimens

If full size Charpy specimen cannot be extracted from components and welds, sub-sized specimens shall be tested. Impact tests should be performed on the maximum thickness which can be extracted from the component under consideration.

The required energies for sub-sized specimens are given in [Table 2](#). To represent the behaviour of a full thickness specimen a lower impact test temperature shall be applied. The temperature shifts shall be in accordance with [Table 2](#).

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

Required impact energy	Specimen cross-sectional geometry	Sub-sized specimen requirement		
<i>KV</i> [J]	[mm × mm]	<i>KV</i> [J]	Specimen cross-sectional geometry [mm × mm]	Impact test temperature
27	10 × 10	20	7,5 × 10	$T_{KV} - 5\text{ K}$
27	10 × 10	14	5 × 10	$T_{KV} - 20\text{ K}$
40	10 × 10	30	7,5 × 10	$T_{KV} - 5\text{ K}$
40	10 × 10	24	5 × 10	$T_{KV} - 20\text{ K}$
20	7,5 × 10	14	5 × 10	$T_{KV} - 15\text{ K}$
30	7,5 × 10	20	5 × 10	$T_{KV} - 15\text{ K}$
14	5 × 10	—	—	—
20	5 × 10	—	—	—

7 Design

7.1 General

The construction of a valve or valve assembly shall be suitable for using a valve or valve assembly at the pressure and temperature specified by the manufacture.

The design requirements herein cover parts subject to pressure constructed of materials defined in [Clause 6](#).

Particular attention shall be paid to smooth concave transitions of cross sections of the body design, as sharp edges are liable to increase stress and may directly result in fracture or in stress corrosion cracking (see [Annex L](#)).

Pressure enclosures using glass as material shall be in accordance with requirements of [Annex I](#).

The valve design shall be so that any liquid trapped internally shall be safely relieved or contained.

7.2 Maximum allowable pressure

The maximum allowable pressure PS shall be defined by the manufacturer and the valve or valve assembly strength shall be verified taking the PS into account.

NOTE ISO 5149-2 does not allow the system to exceed the maximum allowable pressure PS except during the short period of time necessary for the pressure relief device to operate with a maximum value of 1,1 times PS .

A valve or valve assembly can have a PS which depends on the operating temperature. See [Table 6](#).

7.3 Valve and valve assembly strength design

The valve and valve assembly design shall be verified for sufficient strength in the entire operating range.

There are two methods of verification for valves:

- a) By calculation according to [Annex A](#), [C](#) and [D](#), or
- b) By experimental method according to [Annex B](#), [C](#) and [D](#).

[Annexes A](#) and [B](#) are used to verify the maximum allowable pressure at ambient temperatures PS_0 , [Annex C](#) is used to determine PS_0 based on the maximum allowable pressure PS at higher temperatures and [Annex D](#) is used to determine PS_0 based on the maximum allowable pressure PS at lower temperatures. [Annex F](#) provides background information for the methods of [Annex D](#).

The verification required depends on the category of the valve, as defined in [Annex H](#). For valves of category I or higher:

- For valves categorized by nominal size (DN) in [Annex H](#): Where PS times DN is less than 3 000 the verification shall be done either by calculation or by experimental method. Where PS times DN is 3 000 or more the verification shall be done by calculation.
- For valves categorized by volume (V) in [Annex H](#): Where PS times V is less than 6 000 the verification shall be done either by calculation or by experimental method. Where PS times V is 6 000 or more the verification shall be done by calculation.

For valves of category less than I the verification shall be done either by calculation or by experimental method.

NOTE National legislation can place additional requirements on design approval.

For valves materials with reduced ductility at low temperatures the allowed stress shall be reduced according to [Annex D](#).

In addition to the verification of the valve incorporated in a valve assembly, the valve assembly shall be verified for sufficient strength according to [Annex G](#).

EXAMPLE [Figure 1](#) illustrates the relation between PS_0 and PS . A PS_0 value of 28 bar has been verified in the operating range -10 °C to 50 °C, the maximum allowable pressure at 150 °C has been verified using [Annex C](#), and the maximum allowable pressures at 60 °C and -80 °C have been verified using [Annex D](#).

From this verification the manufacture can choose to state PS as a function of temperature (e.g. PS option 1 in [Figure 1](#)), or any other value of PS (e.g. PS option 2 or 3 in [Figure 1](#)), as long as it doesn't exceed the values which have been verified.

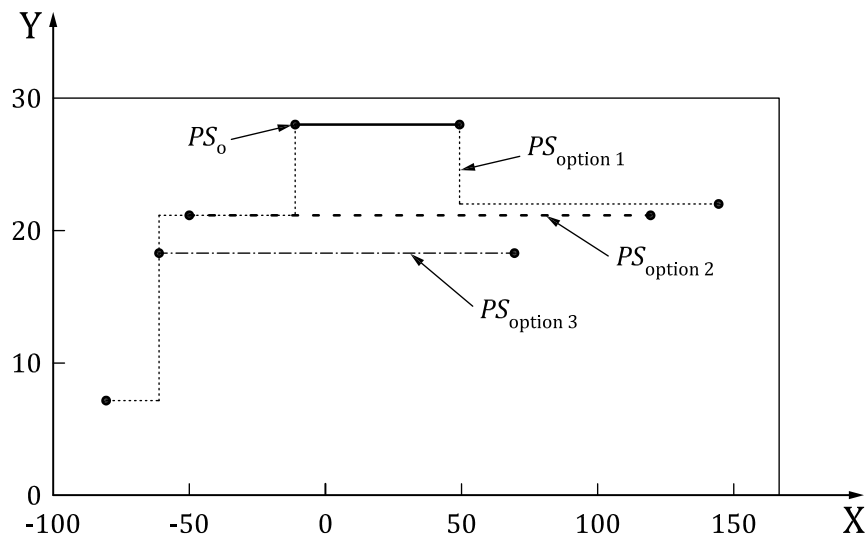


Figure 1 — Example: relationship between PS_0 and PS

7.4 Bodies and bonnets

The strength design of bodies and bonnets subjected to pressure shall be verified by the procedure in [7.3](#).

Spindles and gland seals are not subject to these calculations or tests.

Screwed bonnets shall be so constructed that it is impossible to screw the bonnet out of the valve body without removing a locking device.

7.5 Nuts, bolts, screws, fasteners and seals

The complete temperature range (from TS_{min} to TS_{max}) shall be taken into consideration in the design of screws, fasteners, nuts and seals.

In order to prevent breaking caused by freezing water, no moisture shall be allowed to penetrate into bellows seals.

Where soft materials are used for seals the material shall be fixed and restrained.

7.6 Seat tightness

7.6.1 General

Where internal seat tightness is a design feature, the seat tightness shall be classified according to [Table 3](#).

Table 3 — Test requirements for seat tightness

Seat tightness class	Type test ^a
A	Zero bubbles or equivalent measured during one minute ^b
B	Zero bubbles or equivalent measured during one minute
C	0,1% of K_{VS}
D	0,25% of K_{VS}
E	0,5% of K_{VS}
F	1% of K_{VS}
G	— ^c
^a For type test the manufacturer shall measure the leakage at ambient temperature covering the whole differential pressure range. For manual valves, see Table 4 for suggested upper limits to the maximum differential pressure. ^b For safety valves the manufacturer shall measure the leakage up to $0,85 \times$ set pressure of the valve. ^c For seat tightness class G, testing shall be conducted to verify the seat tightness specified in the technical literature.	

The required seat tightness class depends on the intended application of the valve:

- a) Valves leading to the atmosphere permanently shall be seat tightness class A.
- b) Valves leading to the atmosphere during service shall be seat tightness class A or B.
- c) For other valves, seat tightness classes with lower requirements are allowed.

Components with several valve seats, may have several seat tightness classes.

NOTE Safety valves are examples of valves where seat tightness class A is required, while most stop valves will require seat tightness classes A or B.

For manually closed valves, when testing the seat tightness, the seat shall be closed before the test applying the prescribed closing force.

For valves of the double seating type such as many gate, plug, and ball valves, the test pressure shall be applied successively to each end of the closed valve and tightness to the opposite end checked.

As alternate methods for valves with independent double seating (such as double disc or split wedge gate valves), at the option of the manufacturer, the pressure may be applied inside the bonnet (or body) of the closed valve and each seat checked for tightness at the valve ports, or the pressure may be applied to the valve ports and the sum of seat leakage measured at the bonnet (or body). These alternate methods may be used at the option of the manufacturer for valves with single discs (such as solid or flexible wedge gate valves) provided a supplementary closure member test across the disc is performed.

For other valve types, the test pressure shall be applied across the closure member in the direction producing the most adverse seating condition. For example, a globe valve shall be tested with pressure under the disc. A check valve, or other valve type designed, sold, and marked as a one-way valve, requires a closure test only in the appropriate direction. A stop check valve requires both tests.

7.6.2 Seat tightness: type test

The leakage rate L is specified as a percentage of the K_{VS} value in the flow directions for which the valve is designed to shut off the flow.

The manufacturer shall measure the leakage covering the whole differential pressure range for which the valve is designed using gas (for instance air or nitrogen). The leakage rate L shall not exceed the limits given in [Table 3](#) for type test.

For seat tightness class G the leakage rate L shall be specified in the technical literature.

Two-directional valves shall be measured in both directions. The greatest value measured is used for calculating L by means of [Formula \(1\)](#) or [\(2\)](#).

When measuring the leakage rate of the seat, the seat shall be closed before the test applying the prescribed closing force.

The leakage rate L can be determined by:

$$L = 100 \% \times \frac{Q_M / \rho_2}{K_{VS}} \quad (1)$$

or

$$L = 100 \% \times \frac{Q_V}{K_{VS}} \quad (2)$$

where

Q_M is the mass flow rate in kilograms per hour of leaked air;

Q_V is the downstream volume flow rate in cubic metre per hour of leaked air;

K_{VS} is the rate of flow of water in cubic metres per hour for a differential pressure Δp of 1 bar at the rated full opening;

ρ_2 is the downstream density in kilograms per cubic metre.

NOTE The calculation of the acceptable leak rate is independent of the pressure used when measuring the leak.

EXAMPLE 1 A valve has K_{VS} equal to 4,6 m³/h and the maximum seat leakage Q_V measured downstream of 15 mm³ air per minute is measured i.e. $Q_V = 0,0009$ m³/h. L can be calculated: $L = 100\% \times 0,0009 / 4,6 = 0,02 \%$.

EXAMPLE 2 A valve has K_{VS} equal to 300 m³/h and the maximum seat leakage Q_V measured downstream of 1 000 mm³ (1 cm³) air per minute is measured i.e. $Q_V = 0,06$ m³/h. L can be calculated: $L = 100\% \times 0,06 / 300 = 0,02 \%$.

Valves with back seat shall be checked to ascertain that the back seat is sufficiently tight to allow change of valve packing without danger to the operator.

7.7 Screwed spindles and shafts

Spindles and shafts shall be secured against unintentional unscrewing.

The valve spindle shall be designed to avoid additional stresses within the valve so there is no risk if the spindle fails under excessive torque.

Valve spindles shall be designed to avoid scuffing between the spindle, the bonnet and the thread piece, if any. This can be achieved by selecting materials which are compatible in respect of low frictional forces.

Valve spindles shall be manufactured from such materials, which are resistant against corrosion caused by refrigerant and its oil as well as the surrounding conditions (see [Annex E](#)).

7.8 Design of glands

It shall be impossible for any part of the gland assembly or the gland assembly as a whole to be unscrewed and thus ejected by internal pressure. One method of achieving this is by using screw threads of a different pitch whereby the screw thread of the gland nut is of the minor pitch.

Special design features are required in the case of temperatures below about $-40\text{ }^{\circ}\text{C}$ in order to ensure proper functioning over the whole range of allowable temperatures. One method of achieving this is by providing a heated or thermally insulated extension of the bonnet.

Elevated temperatures require special design features to ensure a proper function of the valve.

7.9 Valve seats

Valves with seat diameters above 25 mm shall be designed so as to prevent sliding friction occurring between the valve plate and the seat in the body, e.g. by providing a spindle capable of rotating against a non-rotating valve plate. This does not apply for ball valves.

Where soft materials are used for seats and valve plates the material shall be fixed and restrained.

7.10 Caps

Caps acting as seals shall be designed for adequate strength.

The body or bonnet may be provided with a seal cap where the spindle passes through the gland. Screwed caps which are intended to act as a seal shall remain tight up to the allowable pressure P_S and shall be so designed that the internal pressure decreases on opening before the screw thread ceases to be capable of sustaining the load.

Methods of achieving this include a relief bore in either the cap or the valve body (see [Figure 2](#)).

Caps of valves which are not, in normal circumstances, to be used shall be capable of being provided with a seal wire and a seal to allow only operation by authorized persons.

Screw threads on valve caps shall be right-handed.

Valves intended for manual operation during infrequent maintenance operations shall be fitted with a sealing cap in addition to the normal sealing of the valve unless the valve may be required during an emergency.

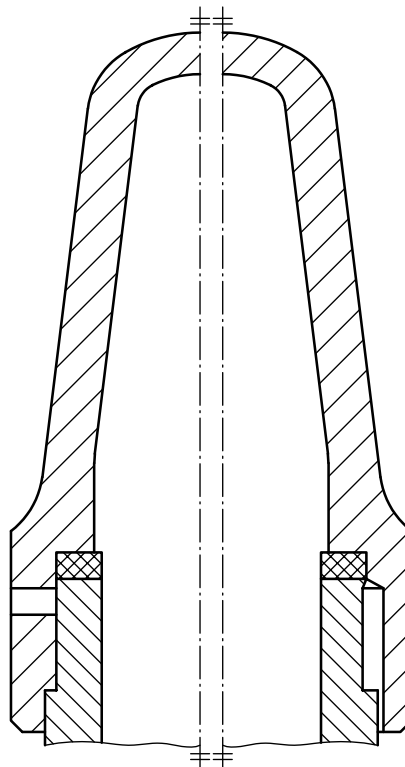


Figure 2 — Example: Relief bore (left) and relief slot (right)

7.11 Hand operated valves

Attention shall be paid to the need to equalize differential pressure if the valve nominal size and the pressure difference are sufficiently high to require it. Equalization may be by external or internal bypass. Please see [Table 4](#) for information on maximum differential pressure for closing by hand. Valves with *DN* less than 50 can be operated by hand with differential pressure up to 90 bar.

The manual forces and sizing of the operating element (hand-wheel or lever) shall be according to [Annex M](#).

Table 4 — Hand operated valves — Maximum differential pressure for closing by hand

<i>DN</i>	50	65	80	100	125	150	200	250	300	350	400
Maximum differential pressure [bar] ^a	90	70	60	44	33	21	14	9	6	4,5	3,5
^a 1 bar = 0,1 MPa											

Valves to be used for strength testing of pressure vessels, piping sections, or as valves for future extensions, shall be leak tight in both directions. If the differential pressure is greater than given in [Table 4](#) the required closing torques shall be stated by the manufacturer.

The opening characteristics of hand operated regulating valves shall be so designed that the opening of the seat commences at about two complete turns of the spindle (e.g. by providing a cylindrical base on the cone), and that the open flow cross section increases progressively.

For hand operated valves used at extreme temperatures provisions shall be taken to avoid the operator getting burned or getting frost bite by the extreme temperatures.

7.12 Corrosion protection

Unless valves and valve assemblies are made of non-corroding materials, surfaces which are exposed to corrosion, e.g. flange surfaces, screw threads or the interior, shall be provided with an anti-corrosive agent or otherwise protected for dry storage at ambient temperature; this protection shall remain effective for at least one year under dry storage conditions.

Painting, coating, surface refinement and colour shall be at the manufacturer's discretion, unless such treatments have been ordered by the purchaser.

The marking, as specified in [Clause 10](#), shall remain durably legible.

8 Appropriate manufacturing procedures

There shall be no imperfections impairing safety, proper function or installation of the valves or valve assembly. This applies particularly to jointing surfaces.

The contact faces on body and bonnet, on the gland and on the valve head and on the seat faces shall be sufficiently smooth to ensure sealing.

All the internal surfaces and components likely to come into contact with the refrigerant shall be free of any foreign matter, such as rust, scale, dirt, chips and the like. After completion of manufacture and testing, the valve shall contain no liquid, except that required for corrosion protection, any such liquid being without adverse effect on the refrigerant circuit.

9 Production testing

9.1 Strength pressure testing

After production each valve and/or valve assembly shall be tested at a pressure p' not less than the greater of 1,5 times PS and 1,25 times PS_0 . This also applies to valve components tested separately.

For series produced valves of category I and less and series produced valve assemblies of category I and less, as defined in [Annex H](#), the production strength pressure test may be performed on a statistical basis. The statistical method shall be documented.

NOTE The European legislation for pressure equipment allows production strength pressure tests on a statistical basis for category I, but it is state of the art not to use this for category I.

EXAMPLE 1 A valve is designed with a PS of 21 bar, a minimum operating temperature $TS_{\min}$ -30 °C and PS_0 of 28 bar. The test pressure is the greater of

- $1,5 \times 21 \text{ bar} = 31,5 \text{ bar}$ and
- $1,25 \times 28 \text{ bar} = 35 \text{ bar}$.

I.e. the test pressure for production testing at ambient temperature is at least 35 bar.

EXAMPLE 2 A valve designed with a PS depending on the the operating temperature (see [Table 6](#)), and the maximum value of PS is 28 bar. The value of PS_0 is also 28 bar. The test pressure is the greater of

- $1,5 \times 28 \text{ bar} = 42 \text{ bar}$ and
- $1,25 \times 28 \text{ bar} = 35 \text{ bar}$.

I.e. the test pressure for production testing at ambient temperature is at least 42 bar.

When testing valves or valve assemblies which are fitted with pressure sensitive parts, the test may be carried out at 1,1 times the maximum allowable pressure at ambient temperature PS_0 , provided that tests according to [B.1.4](#) are carried out on a statistical basis.

Strength pressure tests may be performed without internal parts which would not withstand the test pressure.

Under the test pressure, maintained for sufficient time to give reliable results, the specimen shall show no visible defects.

If the strength pressure test is carried out using gas (e.g. air or nitrogen) then provisions shall be taken to avoid risk when a valve is bursting. For instance, conducting the test either in a special chamber strong enough to contain the effect of valve bursting or under water in a tank equipped with means to prevent the ejection of fragments or using other suitable protection devices.

If the strength pressure test is carried out using a liquid, the valve shall be thoroughly dried after completion of the test or at least drained if this adequately satisfies the requirements given in [Clause 8](#).

9.2 Tightness testing

A tightness test shall be conducted, but only after the valve or valve assembly has been verified for sufficient pressure strength.

If a strength pressure test is conducted, the tightness test shall follow the strength pressure test.

Tightness testing may however be combined with the strength pressure test described in [9.1](#).

The test shall be carried out using gas (e.g. air or nitrogen), the test pressure being equal to the maximum allowable pressure PS at ambient temperature.

During the test, no bubbles shall form over a period of at least one minute when the specimen is immersed in water with low surface tension.

The test shall be carried out with the valve partially open, or with the pressure applied to both sides simultaneously.

Equivalent tests, for example a helium leakage detection test, are permitted. If any changes are made to the test procedure as described above (e.g. in the case of a helium leakage detection test) the test shall be carried out in a manner which ensures a reliable assessment. It shall be documented that the tightness test achieves at least the same performance as the bubble test.

For environmental and safety reasons, nitrogen, helium, and carbon dioxide are preferred test media. Radioactive tracers can be added to the test gases. Air and gas mixtures should be avoided as certain mixtures can be dangerous. Air can be used if the hazard of ignition is eliminated and the safety of the workers is ensured. Oxygen shall not be used for tightness tests.

After testing, care shall be taken to ensure that the test medium is relieved safely.

9.3 Seat sealing capacity

Where internal seat tightness is a design feature the following applies.

For seat tightness class A to F as defined in 7.6.1 each valve shall be tested.

A leak shall not be detectable when tested at the differential pressure, Δp , given in Table 5 with measuring equipment being able to detect a leak given in Table 5.

If any changes are made to the test procedure as described above (e.g. in the case of a helium leakage detection test) the test shall be carried out in a manner which ensures a reliable assessment.

Table 5 — Production test requirements for seat tightness

Seat tightness class	Minimum test pressure	Leak detection ability
A	Maximum differential pressure ^{a, b}	Zero bubbles or equivalent measured during one minute
B	Maximum differential pressure ^a	0,02% of K_{VS}
C	5,5 bar	0,1% of K_{VS}
D	5,5 bar	0,25% of K_{VS}
E	5,5 bar	0,5% of K_{VS}
F	5,5 bar	1% of K_{VS}
G ^c	—	—
^a For manual valves, see Table 4 for suggested upper limits to the maximum differential pressure. ^b For safety valves, the maximum differential pressure shall be the to $0,85 \times$ set pressure of the valve. ^c For seat tightness class G, testing should be carried out to verify the seat tightness specified in the technical literature. For instance, by statistical methods.		

9.4 Caps

Caps acting as seals shall be checked for the presence of a pressure relieving arrangement.

10 Marking and additional information

10.1 General

Marking of valves or valve assemblies of category I or greater, as defined in Annex H, shall include at least the information specified in 10.2 and 10.4.

Marking of valves or valve assemblies of category lower than I shall include at least the information a), b), g) and h) specified in [10.2](#).

The marking shall be durably marked on the body or the flange or shall be given on a plate or label permanently attached to the valve or valve assembly.

Valve assemblies shall be marked according to the category of the valve assembly. Valves incorporated in a valve assembly need not be marked.

10.2 Marking

- a) Manufacturer's trade mark;
- b) Type identification;
- c) Year of manufacture;
- d) Maximum allowable pressure (PS) in bar and corresponding temperature range ($TS_{\min}$ and $TS_{\max}$). If the maximum allowable pressure PS is a function of the temperature, then the relationship shall be marked;
- e) Nominal size DN , together with Nominal pressure PN if appropriate;
- f) Volume (in L) if used for categorization according to [Annex H](#);
- g) Indication for type of valve or valve assembly connection;
- h) Arrow indicating the direction of flow, if applicable.

10.3 Example how to mark the allowable limits of pressure and temperature

[Table 6](#) provides an example of how to give the pressure as a function of the temperature.

Table 6 — Maximum allowable pressure as a function of operating temperature (example)

PS bar	TS °C
22	50,1 to 150
28	-10,0 to 50,0
21	-10,1 to -60,0
7	-60,1 to -85

10.4 Hand-operated regulating valves

Hand operated regulating valves shall additionally be marked with either:

- a) letter 'R' (denoting regulating valve) on upper body flange, or
- b) a plate or label with the inscription 'regulating valve' under the handwheel nut.

10.5 Caps

Caps with a free net internal volume of 1 litre or greater which act as a seal shall be marked with the allowable maximum pressure PS .

NOTE These caps are typically category I or larger, according to [Annex H](#), when the free net internal volume is considered as a pressure vessel.

11 Documentation

11.1 General

For valves of category I or greater, as defined in [Annex H](#), the manufacturer shall be able to supply the documentation specified in [11.2](#).

For valves of category less than I, as defined in [Annex H](#), the manufacturer shall at least be able to supply the documentation specified in [11.2](#) a), b), c), e), f), g), h), i), j), l), and m).

For valve assemblies, the manufacturer shall be able to supply the documentation specified in [11.3](#) in addition to the documentation for the valve as specified above.

11.2 Documentation for valves

For valves of category I or greater, as defined in [Annex H](#), the manufacturer shall be able to supply the following documentation containing information relevant to safety:

- a) assembly and installation instructions;
- b) adequate instruction for use;
- c) intended use of the device;
- d) maintenance and user inspection instructions;
- e) information requested in [Clause 10](#);
- f) drawings and diagrams necessary to understand the instructions;
- g) warnings against possible dangers caused by misuse of the valve;
- h) reference to this document, i.e. ISO 21922;
- i) refrigerants for which the device is suitable;
- j) K_{VS} value where appropriate;
- k) material designation in respect of body parts subject to pressure;
- l) maximum allowable pressure (PS), which may be indicated as a function of the temperature;
- m) lowest operating temperature (TS_{min}) and maximum operating temperature (TS_{max});
- n) detailed information on type of valve connection.

Material certificates may be inspected at the premises of the valve manufacturer (see [6.11](#)).

NOTE For certain applications a copy of the material certificates is needed by the costumer.

11.3 Additional documentation for valve assemblies

The manufacturer shall be able to supply the following documentation containing information relevant to safety:

- a) Detailed information on type of valve assembly connection;
- b) for valve assemblies of category I or greater, material designation of extension pipes.

For valve assemblies of category less than I, the detailed information on type of valve connection can be omitted for the incorporated valve. The type of valve assembly connection cannot be omitted.

Material certificates may be inspected at the premises of the valve manufacturer (see [6.11](#)).

Annex A (normative)

Procedure for the design of a valve by calculation

A.1 Calculation method

A.1.1 General

This Annex defines the allowable design stress value σ_{corr} to be used for the calculation of strength at the maximum allowable pressure PS . Calculation methods includes design by formula (DBF) to withstand a load caused by static internal pressure and design calculation by analysis (DBA) by means of a more sophisticated method based on fracture mechanics or the finite element method.

The calculation method shall incorporate appropriate safety coefficients using comprehensive methods which are known to incorporate adequate safety margins against all relevant failure modes in a consistent manner.

The calculation methods described in the following standards are considered appropriate:

- EN 12516-2;
- EN 13445-3.

Alternatively, other recognized methods, such as ASME Section VIII, Div. 1 and ASME B 31.5, with appropriate safety factors and of equivalent validity may be used.

Further reaction forces or moments which are relevant to the strength, as well as the weakening of the valve due to other influences (e.g. corrosion) shall also be taken into consideration.

The Annex also gives safety factors for use with the experimental design method of [Annex B](#).

A.1.2 Strength values for the design calculation

The strength values (i.e. 0,2 % proof strength $R_{p0,2}$, tensile strength R_m) for the design calculation can be taken from the material standards. In [Annex E](#), standards which correspond to the listed materials are given. If the strength values are not taken from the material standards, these shall be verified by means of material certificates in accordance with [6.11](#).

A.1.3 Documentation

The strength values used for the calculation, e.g. for the tensile strength or proof strength, as well as the consideration of additional stress or other influences (e.g. corrosion), shall be recorded in the design documents.

A.2 Design stress to be used for the calculation

A.2.1 Design stress for main pressure bearing parts

The allowable design stress value σ_{corr} to be used for the calculation shall be determined as follows:

$$\sigma_{\text{corr}} = \sigma_{\text{con}} / (S_C \times Z \times C_Q) \quad (\text{A.1})$$

where

σ_{corr} is the allowable stress values derived from σ_{con} ;

σ_{con} is the initial design stress;

S_C is the factor to compensate effects of corrosion;

Z is the factor to compensate for the quality of a joint (e.g. welded joint) (according to Table A.2 only for the material with number 1 to 8 at [Table A.1](#) (otherwise $Z = 1,0$));

C_Q is the factor, to compensate for the quality of casting (according to Table A.3 only for the material with number 9 at [Table A.1](#) (otherwise $C_Q = 1,0$)).

Table A.1 — Design stress σ_{con} as quotient of characteristic strength value and indicated numerical value (safety factor S_{con})

No.	Material ^a	σ_{con}		S_{con}	S_{σ}
		Yield strength ^{b c}	Tensile strength ^{b d}		
1 ^e	Steel group 1.1 and 1.2	$\text{MIN} \{ R_{p0,2} / 1,5 ; R_m / 2,4 \}$ $R_{p0,2} / 1,5$	$R_m / 2,4$	2,4	1,43
2	Steel group 8.1 at $A_5 \geq 30 \%$	$R_{p1,0} / 1,5$	$R_m / (0,5 + R_m / R_{p1,0})$	$0,5 + R_m / R_{p1,0}$	1,43
3	at $A_5 \geq 35 \%$	$\text{MAX} \{ \text{MIN} [R_m / 3 ; R_{p1,0} / 1,2] ; R_{p1,0} / 1,5 \}$		3,0	1,43
4 ^e	Cast steel group 1.1 and 1.2	$\text{MIN} \{ R_{p0,2} / 1,9 ; R_m / 3 \}$ $R_{p0,2} / 1,9$	$R_m / 3,0$	3,0	1,43
5	Aluminium group 21	$R_{eH} / 1,5$	$R_m / (0,5 + R_m / R_{eH})$	$0,5 + R_m / R_{eH}$	1,43
6 ^e	Aluminium groups 22 to 26	$\text{MIN} \{ R_{p0,2} / 1,5 ; R_m / 2,4 \}$ $R_{p0,2} / 1,5$	$R_m / 2,4$	2,4	1,43
7 ^e	Copper groups 31 to 38	$\text{MIN} \{ R_{p0,2} / 1,5 ; R_m / 3,5 \}$ $R_{p0,2} / 1,5$	$R_m / 3,5$	3,5	1,57
8	Titanium tube group 51	—	$R_m / 3,0$	3,0	1,35
9	Spheroidal graphite cast iron group 72.2	$R_{p0,2} / 2,4$	$R_m / 3,8$	3,8	1,80
10	Free-cutting steel	$R_{p0,2} / 2,5$	$R_m / 4,0$	4,0	1,80

^a The classification into groups of materials shall be carried out in accordance with ISO/TR 15608. Materials from these groups are contained in [Annex E](#).

^b Stress values at a temperature of 20 °C or 25 °C shall be used. As a deviation, stress values within the temperature range from –10 °C to +50 °C can be used. Stress values at other temperatures may not be used in connection with these safety factors.

^c For steel (ferritic and austenitic, as well as cast steel), $R_{p0,2}$ can be estimated by reducing $R_{p1,0}$ by 25 MPa.

^d The values and terms of the denominator is used for determining S_{con} .

^e For σ_{con} , the upper line shall be used if both $R_{p0,2}$ and R_m are available. If they are not both available the lower line shall be used.

Table A.2 — Factor to compensate for the quality of a joint

Scope of test or inspection	Factor Z
No welding, or destructive and non-destructive tests which confirm that the whole series of joints show no significant defects	1,0
Random destructive or non-destructive test (1/0,85)	1,18
Visual test (1/0,70)	1,43

Table A.3 — Factor to compensate for the casting quality (spheroidal graphite cast iron)

Scope of test or inspection	Factor C_Q
No casting, or 100 % non-destructive test	1,0
Visual test and random non-destructive test	1,1
Visual test	1,25

A.2.2 Design calculation of screws, fasteners, nuts and bolts

Screws, fasteners, nuts and bolts shall be dimensioned with design stresses of no more than the allowable stresses of [Table A.4](#) (utilization 100 %).

Modifications in length as a result of the temperature difference between the lowest and the highest temperature of the intended temperature range, shall be taken into consideration during the design of screws, fasteners, nuts and seals.

Table A.4 — Allowable stresses for the design calculation or testing at test pressure of screws and fasteners

Material	Allowable stress at maximum allowable pressure P_S	Allowable stress at design test pressure P_F
Non-austenitic steel	$\text{MIN} \{ R_{m t} / 4,0; R_{p0,2 t} / 3,0 \}$	$\text{MIN} \{ R_{m t} / 2,67; R_{p0,2 t} / 2,0 \}$
Austenitic steel	$R_{m t} / 4,0$	$R_{m t} / 2,67$

Index t: The lower of the material strength values at the minimum and the maximum operating temperature shall be used.
The allowable stress shall not be exceeded within the operating temperature range.

Annex B (normative)

Experimental design method for valves

B.1 Experimental design method

B.1.1 General

With the experimental design method, the resistance of a sample valve against internal pressure in relation to a given choice of material is verified; other reaction forces or moments (e.g. through the spindle in the valve seat or sealing forces transmitted by the spindle in the valve seat or spindle mounting, sealing forces on flange gaskets or retention forces of driving appliances) as well as material weakening or loss due to other influences (i.e. corrosion) shall also be taken into account.

B.1.2 Choice and verification of material properties

It shall be proven that the valve to be tested undergoes the same manufacturing process with respect to material properties (e.g. heat treatment) as is used for series production.

B.1.3 Procedure for the experimental design method

The design testing as well as the strength testing of the valve is carried out at ambient temperature (20 ± 5 °C). The respective pressure applied for the purpose of testing shall be maintained for 15 minutes.

By testing with P_F and P_{Test} at least three samples shall be used. The less favourable tests shall be recorded as the result. The following two tests shall be passed:

- a) testing of an original component in completely assembled condition at test pressure P_F according to the definitions in [B.2](#) and
- b) testing of the valve at a test pressure P_{Test} according to the definitions of [B.3](#). This pressure is close to that in force when failure of the valve occurs.

B.1.4 Testing at maximum allowable design test pressure P_F

This test is carried out on an original component in the completely assembled condition. However, it is allowed to disassemble or replace pressure sensitive parts, provided they are not pressure bearing parts.

For the verification of the strength and external tightness at a pressure equal to the maximum allowable design test pressure P_F , the pressure in the valve is applied by gas (e.g. nitrogen, air, helium), whereby the valve opening during the test is such that the pressures before and after the valve seat are equal. Alternatively, the pressure shall be applied simultaneously on both sides. The pressure is increased gradually up to the maximum allowable design test pressure P_F . The pressure shall be held at 10 minutes at the maximum allowable design test pressure P_F .

Although generally, at this pressure level, no rupturing of the valve body is to be expected, reference is made to [9.1](#) of this document according to which special precautions shall be taken when pressure testing using gas.

Until the testing pressure P_F is reached and during the time of exposure to this pressure, there shall be no plastic deformation of the pressure bearing parts. However, for pressure sensitive parts plastic deformation is allowed, provided they do not leak.