

<b>STN</b>	<b>Zvárané tvarovky pre potravinársky a chemický priemysel</b> <b>Zátky, kolená a redukcie na zváranie</b>	<b>STN</b> <b>EN 10374</b>  42 5726
------------	---	--

Welded fittings for the food and chemical industries - Tees, bends and reducers for welding

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 12/21

Obsahuje: EN 10374:2021

**134013**

EUROPEAN STANDARD

**EN 10374**

NORME EUROPÉENNE

EUROPÄISCHE NORM

August 2021

ICS 23.040.40

English Version

## Welded fittings for the food and chemical industries - Tees, bends and reducers for welding

Raccords soudés pour l'industrie alimentaire et chimique - Tés, coudes et réductions à souder

Formstücke zum Anschweißen in der Lebensmittel- und chemischen Industrie - T-Stücke, Bogen und Reduzierstücke zum Anschweißen

This European Standard was approved by CEN on 11 July 2021.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



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

**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

**EN 10374:2021 (E)**

<b>Contents</b>	<b>Page</b>
<b>European foreword</b> .....	<b>3</b>
<b>1 Scope</b> .....	<b>4</b>
<b>2 Normative references</b> .....	<b>4</b>
<b>3 Terms and definitions</b> .....	<b>4</b>
<b>4 Symbols and abbreviated terms</b> .....	<b>6</b>
<b>5 Designation of fittings and steel grades</b> .....	<b>7</b>
<b>5.1 Designation of fittings</b> .....	<b>7</b>
<b>5.2 Elbow</b> .....	<b>7</b>
<b>5.3 Reducer</b> .....	<b>7</b>
<b>5.4 T-piece</b> .....	<b>7</b>
<b>5.4.1 T-piece form TL and form TS</b> .....	<b>7</b>
<b>5.4.2 T-piece form TRL and form TRS</b> .....	<b>7</b>
<b>5.5 Designation of steel grades</b> .....	<b>7</b>
<b>6 Information to be supplied by the purchaser</b> .....	<b>8</b>
<b>6.1 Mandatory information</b> .....	<b>8</b>
<b>6.2 Options</b> .....	<b>8</b>
<b>6.3 Examples of an order</b> .....	<b>8</b>
<b>7 Requirements</b> .....	<b>9</b>
<b>7.1 Material</b> .....	<b>9</b>
<b>7.2 Manufacturing Process</b> .....	<b>9</b>
<b>7.2.1 General</b> .....	<b>9</b>
<b>7.2.2 Welding</b> .....	<b>9</b>
<b>7.2.3 Heat treatment</b> .....	<b>11</b>
<b>7.2.4 Surface finish and cleanliness</b> .....	<b>11</b>
<b>8 Dimensions and tolerances</b> .....	<b>11</b>
<b>8.1 Dimensions</b> .....	<b>11</b>
<b>8.1.1 General</b> .....	<b>11</b>
<b>8.1.2 Elbow</b> .....	<b>11</b>
<b>8.1.3 Reducer</b> .....	<b>18</b>
<b>8.1.4 T-piece</b> .....	<b>22</b>
<b>8.2 Tolerances</b> .....	<b>26</b>
<b>8.2.1 Dimensional tolerances</b> .....	<b>26</b>
<b>8.2.2 Form tolerances</b> .....	<b>28</b>
<b>9 Inspection</b> .....	<b>32</b>
<b>9.1 Inspection criteria</b> .....	<b>32</b>
<b>9.2 Inspection documents</b> .....	<b>32</b>
<b>10 Marking</b> .....	<b>33</b>
<b>11 Packaging and transport</b> .....	<b>33</b>
<b>Annex A (informative) Supplementary information related to additional ordering information on fabrication options</b> .....	<b>34</b>
<b>Annex B (informative) List of stainless steel grades for fittings</b> .....	<b>35</b>
<b>Bibliography</b> .....	<b>36</b>

## **European foreword**

This document (EN 10374:2021) has been prepared by Technical Committee CEN/TC 459/SC 10 “Steel tubes and fittings for steel tubes”, the secretariat of which is held by UNI.

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 February 2022, and conflicting national standards shall be withdrawn at the latest by February 2022.

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.

Any feedback and questions on this document should be directed to the users’ national standards body. A complete listing of these bodies can be found on the CEN website.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

## EN 10374:2021 (E)

### 1 Scope

This document specifies dimensions, tolerances, internal and external surface characteristics and marking of welded fittings for the food and chemical industry.

### 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.

EN 10028-7, *Flat products made of steels for pressure purposes - Part 7: Stainless steels*

EN 10088-1, *Stainless steels - Part 1: List of stainless steels*

EN 10088-2, *Stainless steels - Part 2: Technical delivery conditions for sheet/plate and strip of corrosion resisting steels for general purposes*

EN 10204, *Metallic products - Types of inspection documents*

EN 10216-5, *Seamless steel tubes for pressure purposes - Technical delivery conditions - Part 5: Stainless steel tubes*

EN 10217-7, *Welded steel tubes for pressure purposes - Technical delivery conditions - Part 7: Stainless steel tubes*

EN 10253-4, *Butt-welding pipe fittings - Part 4: Wrought austenitic and austenitic-ferritic (duplex) stainless steels with specific inspection requirements*

EN 10357, *Austenitic, austenitic-ferritic and ferritic longitudinally welded stainless steel tubes for the food and chemical industry*

EN 13018, *Non-destructive testing - Visual testing - General principles*

EN 13480 (series), *Metallic industrial piping*

EN ISO 1127, *Stainless steel tubes - Dimensions, tolerances and conventional masses per unit length (ISO 1127)*

EN ISO 4288, *Geometrical product specifications (GPS) - Surface texture: Profile method - Rules and procedures for the assessment of surface texture (ISO 4288)*

EN ISO 6520-1, *Welding and allied processes - Classification of geometric imperfections in metallic materials - Part 1: Fusion welding (ISO 6520-1)*

ISO 13715, *Technical product documentation - Edges of undefined shape - Indication and dimensioning*

**koniec náhľadu – text ďalej pokračuje v platenej verzii STN**