

STN	Ropný a plynárenský priemysel vrátane nízkouhlíkovej energie Bezšvové produkty z koróziovzdorných zliatin používané na obloženie rúrok, sústavy rúrok, spájacie väzby a pomocný materiál Technické dodacie podmienky (ISO 13680: 2024)	STN EN ISO 13680 45 2228
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Oil and gas industries including lower carbon energy - Corrosion-resistant alloy seamless products for use as casing, tubing, coupling stock and accessory material - Technical delivery conditions (ISO 13680:2024)

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. 01/26

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English Version

Oil and gas industries including lower carbon energy -
Corrosion-resistant alloy seamless products for use as
casing, tubing, coupling stock and accessory material -
Technical delivery conditions (ISO 13680:2024)

Industries du pétrole et du gaz y compris les énergies à faible teneur en carbone - Produits sans soudure en acier allié résistant à la corrosion utilisés comme tubes de cuvelage, tubes de production, tubes-ébauches pour manchons et matériau pour accessoires - Conditions techniques de livraison (ISO 13680:2024)

Öl- und Gasindustrie einschließlich kohlenstoffarmer Energieträger - Nahtlose Rohre aus korrosionsbeständigen Legierungen zur Verwendung als Futter- oder Steigrohre sowie Muffenvorrohre und Zusatzmaterial - Technische Lieferbedingungen (ISO 13680:2024)

This European Standard was approved by CEN on 12 October 2025.

This European Standard was corrected and reissued by the CEN-CENELEC Management Centre on 03 December 2025.

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EN ISO 13680:2025 (E)

Contents	Page
European foreword.....	3

European foreword

The text of ISO 13680:2024 has been prepared by Technical Committee ISO/TC 67 "Oil and gas industries including lower carbon energy" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 13680:2025 by Technical Committee CEN/TC 12 "Oil and gas industries including lower carbon energy" the secretariat of which is held by NEN.

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International Standard

ISO 13680

Oil and gas industries including lower carbon energy — Corrosion- resistant alloy seamless products for use as casing, tubing, coupling stock and accessory material — Technical delivery conditions

Industries du pétrole et du gaz y compris les énergies à faible teneur en carbone — Produits sans soudure en acier allié résistant à la corrosion utilisés comme tubes de cuvelage, tubes de production, tubes-ébauches pour manchons et matériau pour accessoires — Conditions techniques de livraison

**Fifth edition
2024-05**

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Contents

Page

Foreword	vi
1 Scope	1
2 Normative references	1
3 Terms, definitions, abbreviated terms and symbols	4
3.1 Terms and definitions.....	4
3.2 Abbreviated terms.....	6
3.3 Symbols.....	7
4 General	8
4.1 Dual normative references.....	8
4.2 Units of measurement.....	8
5 Information supplied by the purchaser	8
6 Manufacturing process	10
6.1 Melting practices.....	10
6.2 Product manufacturing process.....	10
6.3 Pipe end sizing.....	11
6.4 Straightening.....	11
6.5 Processes requiring validation.....	11
6.6 Traceability.....	12
6.7 Manufacturing procedure qualification test.....	12
6.8 Process for update of alloys and/or grades.....	12
7 Material requirements	12
7.1 Chemical composition.....	12
7.2 Tensile properties.....	13
7.3 Hardness properties.....	13
7.4 Charpy V-notch test properties — General requirements.....	13
7.4.1 Evaluation of test results.....	13
7.4.2 Critical thickness.....	13
7.4.3 Specimen size, orientation and hierarchy.....	13
7.4.4 Alternative size impact test specimens.....	14
7.4.5 Sub-size test specimens.....	14
7.4.6 Test temperature.....	14
7.5 Charpy V-notch — Absorbed energy requirements for coupling stock and accessory material — All grades.....	14
7.5.1 General.....	14
7.5.2 Requirements for all grades.....	14
7.6 Charpy V-notch — Absorbed energy requirements for pipe — All grades.....	15
7.7 Flattening requirements.....	16
7.8 Charpy V-notch test properties at low temperature for group 2.....	16
7.8.1 General.....	16
7.8.2 Evaluation of test results.....	16
7.8.3 Selection of test specimens.....	17
7.8.4 Test temperature.....	17
7.8.5 Absorbed energy requirements.....	17
7.9 Corrosion properties.....	17
7.9.1 General.....	17
7.9.2 Pitting corrosion properties for group 2.....	17
7.10 Microstructure properties.....	17
7.10.1 Group 1.....	17
7.10.2 Group 2.....	17
7.10.3 Groups 3 and 4.....	18
7.11 Surface condition.....	18
7.12 Defects.....	18
7.12.1 Pipe.....	18

ISO 13680:2024(en)

	7.12.2	Coupling stock and accessory material.....	19
	7.12.3	Process control plan.....	19
8		Dimensions, masses and tolerances.....	19
	8.1	Outside diameter, wall thickness and mass.....	19
	8.2	Length.....	19
	8.3	Tolerances.....	19
	8.3.1	Tolerance on outside diameter, wall thickness and mass.....	19
	8.3.2	Inside diameter, <i>d</i>	20
	8.3.3	Straightness.....	20
	8.3.4	Drift requirements.....	20
	8.4	Product ends.....	20
9		Inspection and testing.....	20
	9.1	Test equipment.....	20
	9.2	Type and frequency of tests.....	20
	9.3	Testing of chemical composition.....	20
	9.3.1	Chemical analysis.....	20
	9.3.2	Test method.....	21
	9.3.3	Chromium depletion test — Groups 2, 3 and 4.....	21
	9.4	Testing of mechanical characteristics.....	21
	9.4.1	Test lot.....	21
	9.4.2	Selection and preparation of samples and test pieces.....	21
	9.5	Tensile test.....	21
	9.5.1	Orientation and size of test pieces.....	21
	9.5.2	Test method.....	21
	9.5.3	Invalidation of test.....	22
	9.5.4	Retest.....	22
	9.6	Hardness test.....	22
	9.6.1	Test pieces.....	22
	9.6.2	Test method.....	22
	9.6.3	Invalidation of tests.....	23
	9.6.4	Periodic checks of hardness-testing machines.....	23
	9.6.5	Verification of hardness-testing machines and indenters.....	24
	9.6.6	Retests.....	25
	9.7	Impact or flattening test.....	25
	9.7.1	Test pieces.....	25
	9.7.2	Frequency of testing.....	25
	9.7.3	Impact test method.....	26
	9.7.4	Flattening test method.....	26
	9.7.5	Impact test retest.....	26
	9.7.6	Flattening test retest.....	27
	9.7.7	Invalidation of tests.....	27
	9.8	Impact test at low temperature for group 2.....	27
	9.9	Pitting corrosion test for group 2.....	27
	9.10	Microstructural examination.....	28
	9.10.1	Test pieces.....	28
	9.10.2	Test method.....	28
	9.10.3	Retest.....	29
	9.11	Dimensional testing.....	29
	9.11.1	General.....	29
	9.11.2	Outside diameter.....	29
	9.11.3	Wall thickness at end of products.....	29
	9.11.4	Wall thickness of product body.....	30
	9.12	Drift test.....	30
	9.12.1	Non-upset and external upset pipe.....	30
	9.12.2	Internal upset pipe.....	30
	9.12.3	Drift mandrel coating.....	30
	9.13	Length.....	30
	9.14	Straightness.....	30

ISO 13680:2024(en)

9.15	Mass determination.....	30
9.16	Visual inspection.....	30
	9.16.1 General.....	30
	9.16.2 Pipe body, coupling stock and accessory material.....	31
	9.16.3 Pipe ends.....	31
	9.16.4 Disposition.....	31
9.17	Non-destructive examination.....	31
	9.17.1 General.....	31
	9.17.2 NDE personnel.....	32
	9.17.3 Products.....	32
	9.17.4 Pup joints.....	32
	9.17.5 Untested ends.....	32
	9.17.6 Upset ends.....	33
	9.17.7 Reference standards.....	33
	9.17.8 NDE system capability records.....	33
	9.17.9 All product group 1.....	34
	9.17.10 Full-body NDE of product — Groups 2, 3 and 4.....	34
	9.17.11 Pipe, coupling stock and accessory material requiring further evaluation.....	34
	9.17.12 Evaluation of indications (prove-up).....	35
	9.17.13 Disposition of pipe containing defects.....	35
	9.17.14 Disposition of coupling stock and accessory material containing defects.....	36
9.18	Positive material identification.....	37
10	Surface treatment.....	37
	10.1 Group 1.....	37
	10.2 Groups 2, 3 and 4.....	37
11	Marking.....	38
	11.1 General.....	38
	11.2 Colour-code identification.....	38
	11.3 Marking content and sequence.....	38
	11.4 Marking for couplings, pup joints and accessories after threading.....	39
12	Surface protection — Group 1.....	39
13	Documents.....	40
	13.1 Electronic media.....	40
	13.2 Retention of records.....	40
	13.3 Test certificates.....	40
14	Handling, packaging and storage.....	41
	14.1 General.....	41
	14.2 Handling.....	41
	14.3 Packaging.....	41
	14.3.1 General.....	41
	14.3.2 Identification.....	41
	14.4 Storage.....	42
	Annex A (normative) Tables in SI units.....	43
	Annex B (normative) Figures in SI (USC) units.....	66
	Annex C (normative) Tables in USC units.....	71
	Annex D (normative) Purchaser inspection.....	94
	Annex E (normative) Cleanliness requirements.....	95
	Annex F (normative) Coupling blanks and accessory material from bar.....	97
	Annex G (normative) Product specification level 2 (PSL-2).....	111
	Annex H (normative) Standardized manufacturing procedure qualification test.....	113
	Annex I (informative) Photographic examples of microstructures, groups 2, 3 and 4.....	117
	Bibliography.....	121

ISO 13680:2024(en)**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 document 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).

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This document was prepared by Technical Committee ISO/TC 67, *Oil and gas industries including lower carbon energy*, Subcommittee SC 5, *Casing, tubing and drill pipe*.

This fifth edition cancels and replaces the fourth edition (ISO 13680:2020), which has been technically revised.

The main changes are as follows:

- adjustment of the scope and title to make it clear that bar material is now included (removal of the word "tubular");
- update of normative references;
- review of straightening requirements, including addition of [Figure B.9](#);
- clarification on the use of alternative method for visual inspection;
- clarification of PMI requirements;
- clarification of marking content and sequence;
- extension of records retention period to five years;
- review of [Annex H](#).

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.

Oil and gas industries including lower carbon energy — Corrosion-resistant alloy seamless products for use as casing, tubing, coupling stock and accessory material — Technical delivery conditions

WARNING — It is the purchaser's responsibility to specify the product specification level (PSL), corrosion-resistant alloy (CRA) group, category, grade, delivery conditions and any other requirement in addition to those specified herewith to ensure that the product is adequate for the intended service environment. The ISO 15156 series or NACE MR0175 should be considered when making specific requirements for H₂S-containing environments; see [Annex G](#). It is the product user's responsibility to ensure that the product is suitable for the intended application with consideration of all environmental degradation threats during both normal operation and system upsets. There are other sources of hydrogen besides H₂S-containing environments, which are not addressed by the ISO 15156 series or NACE MR0175. Not all PSL-1 categories and grades can be made cracking resistant in accordance with the ISO 15156 series or NACE MR0175 and are, therefore, not included in PSL-2.

1 Scope

This document specifies the technical delivery conditions for corrosion-resistant alloy seamless products for casing, tubing, coupling stock and accessory material (including coupling stock and accessory material from bar) for two product specification levels:

- PSL-1, which is the basis of this document;
- PSL-2, which provides additional requirements for a product that is intended to be both corrosion and cracking resistant for the environments and qualification method specified in [Annex G](#) and in the ISO 15156 series or NACE MR0175.

This document contains no provisions relating to the connection of individual lengths of pipe. Demonstration of conformance to ISO 15156-3:2020 or NACE MR0175-2021 of material affected by end sizing, connection manufacture or welding operations is outside the scope of this document.

This document contains provisions relating to marking of tubing and casing after threading.

This document is applicable to the following five groups of products:

- a) group 1, which is composed of stainless alloys with a martensitic or martensitic/ferritic structure;
- b) group 2, which is composed of stainless alloys with a ferritic-austenitic structure, such as duplex and super-duplex stainless alloy;
- c) group 3, which is composed of stainless alloys with an austenitic structure (iron base);
- d) group 4, which is composed of nickel-based alloys with an austenitic structure (nickel base);
- e) group 5, which is composed of bar only ([Annex F](#)) in age-hardened (AH) nickel-based alloys with austenitic structure.

2 Normative references

The following documents, as applicable for the product, 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

ISO 13680:2024(en)

applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 377, *Steel and steel products — Location and preparation of samples and test pieces for mechanical testing*

ISO 404, *Steel and steel products — General technical delivery requirements*

ISO 525, *Bonded abrasive products — General requirements*

ISO 643, *Steels— Micrographic determination of the apparent grain size*

ISO 3452-1, *Non-destructive testing — Penetrant testing — Part 1: General principles*

ISO 4885, *Ferrous materials — Heat treatments — Vocabulary*

ISO 4948-1, *Steels — Classification — Part 1: Classification of steels into unalloyed and alloy steels based on chemical composition*

ISO 4948-2, *Steels — Classification — Part 2: Classification of unalloyed and alloy steels according to main quality classes and main property or application characteristics*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method*

ISO 6508-2, *Metallic materials — Rockwell hardness test — Part 2: Verification and calibration of testing machines and indenters*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 6892-2, *Metallic materials — Tensile testing — Part 2: Method of test at elevated temperature*

ISO 6929, *Steel products — Vocabulary*

ISO 8501-1, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings*

ISO 9712, *Non-destructive testing — Qualification and certification of NDT personnel*

ISO 9934-1, *Non-destructive testing — Magnetic particle testing — Part 1: General principles*

ISO 10423, *Petroleum and natural gas industries — Drilling and production equipment — Wellhead and tree equipment*

ISO 10474, *Steel and steel products — Inspection documents*

ISO 10893-2, *Non-destructive testing of steel tubes — Part 2: Automated eddy current testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of imperfections*

ISO 10893-3, *Non-destructive testing of steel tubes — Part 3: Automated full peripheral flux leakage testing of seamless and welded (except submerged arc-welded) ferromagnetic steel tubes for the detection of longitudinal and/or transverse imperfections*

ISO 10893-4, *Non-destructive testing of steel tubes — Part 4: Liquid penetrant inspection of seamless and welded steel tubes for the detection of surface imperfections*

ISO 10893-5, *Non-destructive testing of steel tubes — Part 5: Magnetic particle inspection of seamless and welded ferromagnetic steel tubes for the detection of surface imperfections*

ISO 10893-8, *Non-destructive testing of steel tubes — Part 8: Automated ultrasonic testing of seamless and welded steel tubes for the detection of laminar imperfections*

ISO 10893-10, *Non-destructive testing of steel tubes — Part 10: Automated full peripheral ultrasonic testing of seamless and welded (except submerged arc-welded) steel tubes for the detection of longitudinal and/or transverse imperfections*

ISO 13680:2024(en)

ISO 10893-12, *Non-destructive testing of steel tubes — Part 12: Automated full peripheral ultrasonic thickness testing of seamless and welded (except submerged arc-welded) steel tubes*

ISO 11484, *Steel products — Employer's qualification system for non-destructive testing (NDT) personnel*

ISO 14284, *Steel and iron — Sampling and preparation of samples for the determination of chemical composition*

ISO 15156 (all parts), *Petroleum and natural gas industries — Materials for use in H₂S-containing environments in oil and gas production*

ISO 15156-3:2020, *Petroleum and natural gas industries — Materials for use in H₂S-containing environments in oil and gas production — Part 3: Cracking-resistant CRAs (corrosion-resistant alloys) and other alloys*

ISO 21920-2, *Geometrical product specifications (GPS) — Surface texture: Profile — Part 2: Terms, definitions and surface texture parameters*

ISO 80000-1, *Quantities and units — Part 1: General*

API RP 578, *Guidelines for a Material Verification Program (MVP) for New and Existing Assets*

API Spec 6A, *Specification for Wellhead and Christmas Tree Equipment*

API Standard 6ACRA, *Age-hardened Nickel-based Alloys for Oil and Gas Drilling and Production Equipment*

ASNT SNT-TC-1A, *Recommended Practice — Non-Destructive Testing*

ASTM A370, *Standard Test Methods and Definitions for Mechanical Testing of Steel Products*

ASTM A604/A604M, *Standard Practice for Macroetch Testing of Consumable Electrode Remelted Steel Bars and Billets*

ASTM A941, *Standard Terminology Relating to Steel, Stainless Steel, Related Alloys and Ferroalloys*

ASTM E18, *Standard Test Methods for Rockwell Hardness of Metallic Materials*

ASTM E21, *Standard Test Methods for Elevated Temperature Tension Tests of Metallic Materials*

ASTM E23, *Standard Test Methods for Notched Bar Impact Testing of Metallic Materials*

ASTM E29, *Standard Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications*

ASTM E45, *Standard Test Methods for Determining the Inclusion Content of Steel*

ASTM E110, *Standard Test Method for Rockwell and Brinell Hardness of Metallic Materials by Portable Hardness Testers*

ASTM E112, *Standard Test Methods for determining the average Grain Size*

ASTM E165, *Standard Practice for Liquid Penetrant Examination for General Industry*

ASTM E213, *Standard Practice for Ultrasonic Testing of Metal Pipe and Tubing*

ASTM E309, *Standard Practice for Eddy-Current Examination of Steel Tubular Products Using Magnetic Saturation*

ASTM E340, *Standard Test Method for Macroetching Metals and Alloys*

ASTM E381, *Standard Method of Macroetch Testing Steel Bars, Billets, Blooms, and Forgings*

ASTM E562, *Standard Test Method for Determining Volume Fraction by Systematic Manual Point Count*

ASTM E570, *Standard Practice for Flux Leakage Examination of Ferromagnetic Steel Tubular Products*

ISO 13680:2024(en)

ASTM E1245, *Standard Practice for Determining the Inclusion or Second-Phase Constituent Content of Metals by Automatic Image Analysis*

ASTM E1476, *Standard Guide for Metals Identification, Grade Verification, and Sorting*

ASTM E3024, *Standard Practice for Magnetic Particle Testing for General Industry*

ASTM G48, *Standard Test Methods for Pitting and Crevice Corrosion Resistance of Stainless Steels and Related Alloys by Use of Ferric Chloride Solution*

NACE MR0175, *Petroleum and Natural Gas Industries — Materials for Use in H₂S-containing Environments in Oil and Gas Production*

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