



KE 201-A1
June 2014



GASTEC QA

Approval Requirements 201

Amendment A1

for the GASTEC QA product certificate for
Gas service lines to residences and buildings



Foreword and introduction

These GASTEC QA Approval requirements amendment is accepted by the Board of Experts of the GASTEC QA Quality Mark, wherein all the relevant parties in the field of gas related products are represented. This Board of Experts also supervises the certification activities and, where necessary, revise the GASTEC QA Approval requirements. All references to Board of Experts in these GASTEC QA Approval requirements pertain to the above mentioned Boards of Experts.

These GASTEC QA Approval requirements will be used by Kiwa Nederland B.V. in conjunction with the “Kiwa regulation for product certification”. This regulation details the method employed by Kiwa Nederland B.V. for conducting the necessary investigations prior to issuing the (technical approval-with) product certificate and the method of external control. The inspection frequency is determined by the above mentioned Boards of Experts.

Approved by Board of Experts : 18th June 2014

Accepted by Kiwa Nederland B.V. : 18th June 2014

Kiwa Nederland B.V.

Wilmersdorf 50
7327 AC Apeldoorn
Postbus 137
7300 AC Apeldoorn
The Netherlands

Tel. +31 55 539 33 93
Fax +31 55 539 34 94
www.kiwa.nl

© 2012 Kiwa Nederland B.V.

All rights reserved. No part of this book may be reproduced, stored in a database or retrieval system, or published, in any form or in any way, electronically, mechanically, by print, photoprint, microfilm or any other means without prior written permission from the publisher.
The use of this evaluation guideline by third parties, for any purpose whatsoever, is only allowed after a written agreement is made with Kiwa to this end.

Contents

1	Introduction	4
1.1	General	4
1.2	Scope	4
2	Product Requirements	5
2.1	General	5
2.7.3	Welding	5
2.7.3.1	Welding of parts of PE with diameters ≥ 50 mm.	5
2.7.3.2	Welding of parts of PE with diameters < 50 mm.	5
2.7.3.2.1	Bead width dimensions	5
2.7.3.2.2	Mismatch of joint faces	5
3	Test methods	6
3.1	General	6
3.2.1	Determining dimensions of the butt welding bead	6

1 Introduction

1.1 General

This amendment is an addition to the current KE 201 GASTEC QA Approval Requirements 201 for the GASTEC QA product certificate for Gas service lines to residences and buildings, dated April 2013.

1.2 Scope

In Approval Requirements 201, article 2.7.3, a reference is made to NEN 7200 and requirements for welding are described. However in NEN 7200 the requirements of the butt fusion joints of diameters smaller than 50 mm are not described and / or in practice difficult demonstrable for these small diameters.

Therefore this amendment describes the requirements regarding the dimensions of butt fusion joints smaller than 50 mm in addition to Approval Requirements 201.

2 Product Requirements

2.1 General

The following product requirements replaces the existing requirement 2.7.3 of Approval Requirements 201.

2.7.3 Welding

If the product consists (partly) of parts of PE – not gas bearing, like the casing tube – with welds made by butt welding, these welds shall meet the requirements of the elongation test according to NEN 7200, article 6.2, by elongating a specimen in accordance with ISO 527-2. The visual test of NEN 7200, article 6.1, as mentioned in NEN 7200, article 6.2, shall not be performed. Dirt, cracks or other damages shall not be visible in the welding area. The shapes of the weld beads shall be uniform.

For weldings of PE, produced in series and at one production location, the aspects of welding procedure which can have influence on the quality of the welding shall be demonstrably ensured.

Welding in PEX is not allowable.

2.7.3.1 Welding of parts of PE with diameters ≥ 50 mm.

If the product consists (partly) of PE with butt welds, all the requirements as mentioned in NEN 7200 shall be met.

2.7.3.2 Welding of parts of PE with diameters < 50 mm.

If the product consists (partly) of PE parts with butt welds all the requirements as mentioned in NEN 7200 shall be met with exception of the bead width and de mismatch of joint faces.

In deviation from the NEN 7200, the following requirements shall be met:

2.7.3.2.1 Bead width dimensions

The bead width shall be in the range of 3 mm up to including 6 mm.

Locally, at the flow line of injection molded parts, the bead width may be 0.7 x the minimal bead width.

2.7.3.2.2 Mismatch of joint faces

The centerline of the bearing clamping tools shall be aligned with a maximum deviation of 0.2 mm.

3 Test methods

3.1 General

The following text shall be added to the existing article 3.2 of Approval Requirements 201.

3.2.1 Determining dimensions of the butt welding bead

For weldings of PE parts with diameters < 50 mm the butt welding bead shall be measured with an accuracy of 0.1 mm.

Measured values are rounded to 1 mm.