



BSI Standards Publication

**Gas welding equipment —
Industrial manual and
machine blowpipes for flame
heating, flame brazing and
allied processes**

National foreword

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English Version

**Gas welding equipment - Industrial manual and machine
blowpipes for flame heating, flame brazing and allied processes**

Matériel de soudage aux gaz - Chalumeaux manuels et automatiques à usage industriel, pour le chauffage à la flamme, le brasage à la flamme et les techniques connexes

Gasschweißgeräte - Handgeführte Sauerbrenner und Maschinenbrenner für industrielle Prozesse zum Flammwärmen, Flammlöten und für verwandte Prozesse

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Foreword

This document (CEN/TR 13259:2013) has been prepared by Technical Committee CEN/TC 121 "Welding and allied processes", the secretariat of which is held by DIN.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

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Introduction

Requests for official interpretations of any aspect of this Technical Report should be directed to the Secretariat of CEN/TC 121/SC 7 via the National Standards Body.

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1 Scope

This Technical Report refers to manual blowpipes and stationary machine blowpipes with free burning flames for heat treatment of work pieces. These blowpipes are, due to their type of construction, designed for special applications and do not fall under the scope of EN ISO 5172 and EN ISO 9012.

This Technical Report contains technical regulations, specifications and tests.

Blowpipes are intended for gaseous fuels in connection with oxygen, compressed air or aspirated air.

Flow rates are not expressly limited and depend on the thermal process to be performed.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN ISO 5172:2006, *Gas welding equipment — Blowpipes for gas welding, heating and cutting — Specifications and tests (ISO 5172:2006)*

EN 29090, *Gas tightness of equipment for gas welding and allied processes (ISO 9090)*

EN ISO 9539, *Gas welding equipment — Materials for equipment used in gas welding, cutting and allied processes (ISO 9539)*

ISO 15296, *Gas welding equipment — Vocabulary — Terms used for gas welding equipment*