PD CEN/TS 13259:2023

BSI Standards Publication

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

bsi.

National foreword

This Published Document is the UK implementation of CEN/TS 13259:2023. It supersedes PD CEN/TR 13259:2013, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee WEE/18, Gas welding and cutting appliances.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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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 Sonderbrenner und Maschinenbrenner für industrielle Prozesse zum Flammwärmen, Flammlöten und für verwandte Prozesse

This Technical Specification (CEN/TS) was approved by CEN on 22 October 2023 for provisional application.

The period of validity of this CEN/TS is limited initially to three years. After two years the members of CEN will be requested to submit their comments, particularly on the question whether the CEN/TS can be converted into a European Standard.

CEN members are required to announce the existence of this CEN/TS in the same way as for an EN and to make the CEN/TS available promptly at national level in an appropriate form. It is permissible to keep conflicting national standards in force (in parallel to the CEN/TS) until the final decision about the possible conversion of the CEN/TS into an EN is reached.

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European foreword

This document (CEN/TS 13259:2023) 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 shall not be held responsible for identifying any or all such patent rights.

This document supersedes CEN/TR 13259:2013.

The main changes compared to the previous edition CEN/TR 13259:2013 are listed below:

— the type of deliverable was changed to CEN/TS;

— the wording of the whole document was updated and clarified;

— in Clause 2 the normative references were updated;

— 5.4 and Figure 9 were added;

— with 11.6.2 an extinguishing behaviour test was added;

— with 11.6.4 a nozzle flow velocity test was added.

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 announce this Technical Specification: 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, Türkiye and the United Kingdom.

Introduction

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of CEN/TC 121/WG 19 via national standardization body.

1 Scope

This document 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 5172:2006[1] and EN ISO 9012:2011.

This document does not apply to manual and machine cutting blowpipes according to EN ISO 5172:2006[1].

This document 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 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 ISO 5172:2006[1], *Gas welding equipment — Blowpipes for gas welding, heating and cutting — Specifications and tests (ISO 5172:2006)*

EN ISO 9012:2011, *Gas welding equipment — Air-aspirated hand blowpipes — Specifications and tests (ISO 9012:2008)*

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

EN ISO 15296, *Gas welding equipment — Vocabulary (ISO 15296)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN ISO 5172:2006[1], EN ISO 9012:2011, EN ISO 15296 and the following apply.

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

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

3.1
manual blowpipe
blowpipe, manually ignited, monitored and guided by the operator or fixed to a mechanical device

3.2
machine blowpipe
blowpipe, which for operation is fixed to a mechanical device and guided by it; it is manually monitored, wherein specific operating elements may have been mechanized

3.3
automatic machine blowpipe
blowpipe, which is operated and monitored by PLC (Programmable Logic Controller) devices

[1] As impacted by EN ISO 5172:2006/A1:2012 and EN ISO 5172:2006/A2:2015.