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Plastics piping systems for the supply of gaseous fuels - Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing —

Part 6: Code of practice for design, handling and installation

Systèmes de canalisations en matières plastiques pour la distribution de combustibles gazeux — Systèmes de canalisations en polyamide non plastifié (PA-U) avec assemblages par soudage et assemblages mécaniques —

Partie 6: Code de pratique pour la conception, la manutention et l'installation

Reference number
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Contents

Page

Foreword ..... **v**

Introduction ..... **vii**

1 Scope **1**

2 Normative references **1**

3 Terms, definitions and abbreviated terms **2**
3.1 Terms and definitions 2
3.2 Symbols and abbreviated terms 3

4 Design **4**
4.1 General and regional requirements 4
4.1.1 General 4
4.1.2 Regional requirements 4
4.2 Materials, components and jointing equipment 5
4.3 Maximum operating pressure 5
4.3.1 General 5
4.3.2 Maximum operation pressure based on long-term hydrostatic strength 5
4.3.3 Maximum operation pressure based on rapid crack propagation 5
4.4 Assembly techniques 6
4.5 Squeeze-off properties 6

5 Construction **7**
5.1 Competence 7
5.2 Storage, handling and transport 7
5.2.1 General 7
5.2.2 Storage 7
5.2.3 Handling 8
5.2.4 Transport 9
5.3 Jointing 9
5.4 Laying 9
5.4.1 General 9
5.4.2 Trench 10
5.4.3 Drag forces 10
5.4.4 Valves 11
5.4.5 Connection to existing systems 11
5.4.6 Backfilling 11
5.4.7 Non-conventional installation 12
5.5 Pressure testing and commissioning 12

6 Quality control **12**
6.1 General 12
6.2 Inspection prior to laying 12
6.3 Inspection during laying 13
6.3.1 Laying 13
6.3.2 Joint integrity 13

Annex A (normative) **Butt fusion jointing procedure** **20**

Annex B (normative) **Electrofusion jointing** **25**

Annex C (normative) **Mechanical jointing** **31**

Annex D (informative) **Squeeze-off and re-rounding** **32**

Annex E (normative) **Derating coefficients for various operating temperatures** **35**

Annex F (informative) **Regional requirements for CEN member countries** **36**

Annex G (informative) **Additional information for demonstrating the fitness of PA-U piping systems for non-conventional installation techniques** **37**

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Bibliography **39**

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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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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 138, *Plastics pipes, fittings and valves for the transport of fluids*, Subcommittee SC 4, *Plastics pipes and fittings for the supply of gaseous fuels*.

This second edition cancels and replaces the first edition (ISO 16486-6:2012), which has been technically revised.

The main changes are as follows:

— the structure of the document has been modified in order to generally align with the structure of ISO/TS 10839:2022;

— the normative references have been updated;

— a new subclause 4.1.2 has been added, concerning regional requirements and with reference to a new Annex F, also about regional requirements for CEN member countries;

— subclause 4.3 has been subdivided into three further subclauses: general, MOP(LTHS) and MOP(p_c);

— a more detailed definition of MOP(p_c) has been included in subclause 4.3.3 for temperatures below zero;

— a reference to Annex G has been added to subclause 4.5;

— information from subclause 5.3 for jointing procedures has been moved to the new Annexes B, C and D;

— in subclause 5.4.1, the former drag force formula for PE with fixed limiting stress (F = 14 N) has been opened for PA-U;

— a new subclause 5.4.7 for non-conventional installation has been added;

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— for visual inspection of butt fusion joints, subclause 6.3.2.2.1 shows figures with the typical single bead shape, which replaces the previous double bead;

— a new informative Annex G has been added concerning the fitness of PA-U piping systems for non-conventional installation techniques;

— the Bibliography has been updated.

A list of all parts in the ISO 16486 series can be found on the ISO website.

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.

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Introduction

This document specifies the requirements for a piping system and its components made from unplasticized polyamide (PA-U), and which is intended to be used for the supply of gaseous fuels.

Requirements and test methods for material and components of the piping system are specified in ISO 16486-1, ISO 16486-2, ISO 16486-3 and ISO 16486-4.

Characteristics for fitness for purpose of the system and generic fusion parameters are covered in ISO 16486-5.

Recommended practice for installation is given in this document, which will not be implemented as a European Standard under the Vienna Agreement.

Assessment of conformity of the system is to form the subject of ISO/TS 16486-7.

Training and assessment of fusion operators is covered by ISO/TS 16486-8.

NOTE 1 For CEN member countries, the recommended practice for installation is given in CEN/TS 12007-6[3] and the qualification of welders is given by EN 13067[4].

NOTE 2 A list of imperial ASTM or PPI standards related to polyamide pipes and fittings for the supply of gas is given in References [5], [6], [7], [8], [9], [10] and [11].

NOTE 3 ISO 16486-1, ISO 16486-2, ISO 16486-3, ISO 16486-5 and ISO 16486-6 (this document) as well as ISO/TS 16486-7 and ISO/TS 16486-8 have been prepared by ISO/TC 138, SC 4. ISO 16486-4 has been prepared by ISO/TC 138, SC 7.

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Plastics piping systems for the supply of gaseous fuels - Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing —

Part 6: Code of practice for design, handling and installation

1 Scope

This document specifies a code of practice dealing with unplasticized polyamide (PA-U) pipes and fittings for buried pipeline systems outside buildings and designed to transport gaseous fuels (as defined in ISO 16486-1, e.g. methane, LPG, manufactured gas and hydrogen) within the temperature range –20 °C to +40 °C. This document also gives appropriate temperature-related requirements.

The code of practice covers mains and service lines whose components are prepared for fusion or mechanical jointing and gives instructions for the design, storage, handling, transportation, laying conditions and fusion quality control of PA-U pipes and fittings as well as subsequent joint testing, backfilling, pipe system testing and commissioning.

NOTE Principal information for rehabilitation can be found in ISO 11295 for classification, ISO 11299-1 and ISO 11299-2 for renovation, and ISO 21225-1 and ISO 21225-2 for trenchless replacement.

More detailed national standards or codes of practice can exist. This document is intended to be applied in association with such national standards or codes of practice related to the above-mentioned basic principles.

The jointing methods covered by this document are:

— butt fusion jointing (see Annex A);

— electrofusion jointing (see Annex B) and

— mechanical jointing (see Annex C).

In the case of ground movement or shaking (e.g. earthquakes, etc.) precautions mentioned in this document can need to be implemented following guidelines provided by authorities (e.g. EN 1998-4[17], EN 12007-1:2012, Annex A[18] etc.).

Workers' health and safety issues are outside the scope of this document

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.

ISO 12176-1, *Plastics pipes and fittings — Equipment for fusion jointing polyethylene systems — Part 1: Butt fusion*

ISO 12176-2, *Plastics pipes and fittings — Equipment for fusion jointing polyethylene systems — Part 2: Electrofusion*

ISO 12176-3, *Plastics pipes and fittings — Equipment for fusion jointing polyethylene systems — Part 3: Operator's badge*

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ISO 12176-4, *Plastics pipes and fittings — Equipment for fusion jointing polyethylene systems — Part 4: Traceability coding*

ISO 12176-5, *Plastics pipes and fittings — Equipment for fusion jointing polyethylene systems — Part 5: Two-dimensional data coding of components and data exchange format for PE piping systems*

ISO 13477, *Thermoplastics pipes for the conveyance of fluids — Determination of resistance to rapid crack propagation (RCP) — Small-scale steady-state test (S4 test)*

ISO 13478, *Thermoplastics pipes for the conveyance of fluids — Determination of resistance to rapid crack propagation (RCP) — Full-scale test (FST)*

ISO 13950, *Plastics pipes and fittings — Automatic recognition systems for electrofusion joints*

ISO 16486-1, *Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing — Part 1: General*

ISO 16486-2:2020, *Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing — Part 2: Pipes*

ISO 16486-3, *Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing — Part 3: Fittings*

ISO 16486-4, *Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing — Part 4: Valves*

ISO 16486-5, *Plastics piping systems for the supply of gaseous fuels — Unplasticized polyamide (PA-U) piping systems with fusion jointing and mechanical jointing — Part 5: Fitness for purpose of the system*

ISO 17885:2021, *Plastics piping systems — Mechanical fittings for pressure piping systems — Specifications*

EN 12327, *Gas supply systems — Pressure testing, commissioning and decommissioning procedures — Functional requirements*

3 Terms, definitions and abbreviated terms

For the purposes of this document, the terms and definitions given in ISO 16486-1, ISO 16486-5 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 Terms and definitions

3.1.1
butt fusion machine pressure
pressure indicated on the gauge or on a pressure display on a butt fusion machine, giving an indication of the interface force applied to the pipe and/or fitting ends

3.1.2
clearance
shortest distance between the outer limits of two objects

3.1.3
drag resistance
frictional resistance due to the weight of the length of pipe fixed in the moveable clamp at the point at which movement of the moveable clamp is initiated (peak drag), or the friction occurring during movement (dynamic drag)

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3.1.4
electrofusion control unit
equipment implementing the output fusion parameters of voltage or current and time or energy to execute the fusion cycle as specified by the electrofusion fitting manufacturer

3.1.5
frictional losses in the butt fusion machine
force necessary to overcome friction in the whole mechanism of a butt fusion machine

3.1.6
fusion operator
person trained to carry out fusion jointing between unplasticized polyamide (PA-U) pipes and/or fittings

Note 1 to entry: Fusion jointing is based on a written procedure agreed by the pipeline operator.

Note 2 to entry: The fusion operator is trained for one or more fusion–jointing procedures.

3.1.7
interface force
force between the fusion surfaces of the pipe(s) and/or fitting(s) during the fusion cycle, as specified in the fusion diagram

3.1.8
operator
person authorized to build PA-U systems from pipes and/or fittings, based on a written procedure agreed by the pipeline operator

3.1.9
overall service (design) coefficient
C
overall coefficient, with a value greater than 1, which takes into consideration service conditions as well as properties of the components of a piping system

3.1.10
pipeline operator
private or public organization authorized to design, construct or operate and maintain a gas supply system

3.1.11
soil cover
vertical distance between the top of a buried pipe and the normal surface after finishing work (e.g. including pavement)

3.2 Symbols and abbreviated terms

B	bead width
B_m	mean bead width
B_{max}	maximum bead width
B_{min}	minimum bead width
C	overall service (design) coefficient
d_e	external diameter of pipe or spigot fitting at any point
D_F	temperature derating coefficient

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