



itasteel

Via Valsugana 98-36022 Cassola (VI)- Tel. 0424 582999 – Fax. 0424 232023- Mail: info@itasteel.it

www.itasteel.it

tolleranze di espansione tubi

11.4.4 Drift expanding test

The test shall only be carried out for tubes having an outside diameter $D < 150$ mm and a wall thickness $T < 10$ mm.

The test shall be carried out according to EN ISO 8493.

The tube section shall be expanded with a 60° conical tool until the % increase in outside diameter D shown in Table 15 is reached.

After testing, the test piece shall excluding the fracture point be free from cracks or breaks. However, slight incipient cracks at its edges shall not be regarded as justification for rejection.

Table 15 - Drift expanding test requirements

% increase in outside diameter for d/D^a		
$\leq 0,6$	$> 0,6$ $\leq 0,8$	$> 0,8$
9	15	17
^a $d = D - 2T$		