

400	3.0
500	4.0
600	4.0

#### 7.6.1 Pipes from stainless steel

Pipe work for aquatic, biogas and air media shall be stainless steel 1.4404 (AISI 316L) pipes if not otherwise stated. Material shall be according to requirements for stainless steel specified in section 7.3.4.

Pipes shall be according to EN 10217-7. Pumping mains and pressure pipes shall minimum be rated for PN 10.

#### 7.6.2 Pressure test of pipes

The Contractor shall perform pressure tests according to the following instructions for all pressure piping.

The Contractor shall advise the Engineer in due and shall provide and mount all for the pressure tests necessary equipment.

If pressure tests are made against closed valves the guidelines from the manufacturer of the valves regarding the highest single side pressure against closed valve shall be complied with.

Hydraulic pressure tests shall be carried out by the use of potable water.

During pressure tests a minimum of 1.5 times maximum allowed operating pressure shall be maintained. Water shall be forced into the pipes by means of a force pump fitted with a pressure gauge to indicate the pressure at the lowest point in the section under test. Pipelines will not be accepted until they have withstood the required pressure for 30 minutes without leaking and without the pressure dropping.

Pressure tests shall be according to API 5L, TS 10217 and DIN 1626.

The Contractor shall prior to pressure testing verify on the spot that the piping is fully evacuated from air.

After successful and approved pressure test the piping shall be emptied and the pressure test fluid shall be disposed of.

If it is not possible to perform visual inspection of leaks of all welded joints, the piping shall be tested according to the following guidelines:

- Piping is tested with a test pressure of minimum 1.5 times maximum allowed operating pressure. The pressure shall be held for at least four hours.
- During the pressure hold period no water shall be allowed to be added, and
- All visible welding joints, flange joints and glands on valves and pumps shall be inspected.