

Version
July 2025

Translation of Dutch version

Approval requirement 209

Steel press fittings for steel pipes



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Preface Kiwa

This, translated from Dutch, approval requirement (AR), is approved by the Board of Experts (BoE) GASTEC QA. in which relevant parties in the field of gas related products are represented. This Board of Experts supervises the certification activities and where necessary require the GASTEC QA approval requirement to be revised. All references to Board of Experts in this GASTEC QA approval requirement pertain to the above-mentioned Board of Experts.

This, translated from Dutch, AR will be used by Kiwa Nederland BV in conjunction with the GASTEC QA general requirements and the KIWA regulations for certification.

Kiwa has a method which is established in the certification procedure for the execution of:

- The investigation for provisioning and maintaining a GASTEC QA product certificate based on this AR.
- The periodic evaluations of the certified products for the purpose of maintaining a provided GASTEC QA product certificate based on this AR.

This AR, translated from Dutch, is used as supporting document. In case of doubt of interpretation of this AR, the Dutch version is leading.

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1 Introduction

1.1 General

This GASTEC QA approval requirement (AR) in combination with the GASTEC QA general requirements, is applied by Kiwa as the basis for the issuing and maintaining the GASTEC QA product certificate for steel press fittings for steel pipes.

With this product certificate, the certificate holder can demonstrate to his or her customers that an expert independent organization monitors the production process of the certificate holder, the quality of the product and the related quality assurance.

Next to the requirements established in this AR and the general requirements, Kiwa has additional requirements in the sense of general procedural requirements for certification, as laid down in the internal certification procedures.

This GASTEC QA approval requirement replaces the version of November 2024.

List of changes:

- List of definitions has been extended.
- Paragraph 3.1 has changed, the requirements for corrosion have been specified.
- In chapter 4, the requirement for uniform corrosion resistance has been added and therefore the paragraphs have shifted a number.
- The chapter division has been adjusted
- The list of reference standards has been adjusted

The product requirements have changed.

1.2 Scope

This AR applies to steel press fittings for use in combination with heavy wall thickness steel pipes in accordance with EN 10255, EN 10216-1, EN 10217-1 with a maximum outer diameter of 114.3 mm (4").

The press fitting is joined by means of a press machine which is prescribed by the fitting manufacturer. The press fittings are intended to be used for indoor gas installations for 2nd and 3rd family gases according to EN 437 with a maximum operation pressure of 5 bar (MOP) at an ambient temperature of -20 °C to +70 °C.

Note: Dutch installation guidelines shall be consulted for the conditions for using steel pipes in gas installations.

2 Definitions

In this approval requirement, the following definitions are applicable:

Board of Experts (BoE): The Board of Experts GASTEC QA.

Fitting: Product to be used in a piping system for permanently connecting pipes to each other.

Fitting assembly: Steel press fitting with steel pipes.

Leak tight: A product is considered leak tight under the following conditions:

- if the test fluid is a liquid, visually detectable leakage from any external surface is not permitted.
- If the test fluid is a gas:
 - no bubbles from any external surface and breaking the surface of the water are permitted.
 - no continuous formation of bubbles is permitted when the product is coated with a leak detection fluid.

Maximum operating pressure (MOP): Maximum pressure that a component is capable of withstanding continuously in service under normal operating conditions.

Nominal diameter: Nominal diameter of the fitting expressed as nominal outside diameter of the connection pipe.

Pipe size: Outside diameter of the pipe expressed in mm or inch according to table below.

Metric	10.2	13.5	17.2	21.3	26.9	33.7	42.4	48.3	60.3	76.1	88.9	114.3
Inch	1/8"	1/4"	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"

Test piece: fitting under test.

Uniform corrosion: Type of corrosion due to a natural interaction between a material and its environment. Oxygen corrosion is the most visible form of corrosion.

See also the definitions mentioned in the GASTEC QA general requirements.

3 Material and product requirements

This chapter contains the material and product requirements that the raw materials, materials and products used shall meet.

3.1 Material requirements

The material shall be demonstrable suitable for its application (pressure, ambient temperature range, long term behaviour) and shall be specified according to the relevant material standard.

The suitability of the material can be demonstrated by providing test reports or by reference to relevant product standards of similar products in which the material is specified as being suitable for use.

The fittings, plated/coated, shall be resistant against uniform corrosion and shall be assessed according to paragraph 4.2.

In case the fittings are used in aggressive environments, additional corrosion protection is recommended, and the manufacturer shall be consulted in this case.

3.2 Surface condition

When visually inspected, fittings shall be free from sharp edges, burrs or signs of corrosion.

3.3 Plated or coated surfaces

Plated or coated surfaces shall not impair the performance of the fitting and shall be made of a material that ensures that the fitting will not be impacted by corrosion.

3.4 Adaptor fittings

The fitting may be provided with a threaded connection on one side of the fitting. Threaded connections are allowed up to 2" thread size and shall comply with EN 10226-1.

Alternative connections are allowed as long as they are in compliance with relevant standards and common practice in Dutch gas installations.

3.5 Rubber sealing

Rubber parts used for sealing shall comply with EN 549 type A2 or EN 682 type GAL or GBL.

3.6 Tube abutment

The fitting shall be provided with an abutment to limit the pipe insertion and to ensure that the pipe is past the clamping and sealing part of the fitting.

3.7 Pipe size

The fittings shall be suitable for the following dimensions:

Metric	10.2	13.5	17.2	21.3	26.9	33.7	42.4	48.3	60.3	76.1	88.9	114.3
Inch	1/8"	1/4"	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"

4 Performance requirements and test methods

This chapter contains the performance requirements and associated test methods that the products shall meet. This chapter also specifies the limit values, if applicable.

4.1 General

Tests shall be performed at an ambient temperature 23 ± 2 °C unless otherwise stated.

All tests shall be performed per size group on three sample of one size unless otherwise stated.

In case the pipe diameters are specified in inches, the closest size in millimetres shall be chosen.

4.1.1 Size groups

Fittings are divided in the following size groups:

Size group	1	2	3	4
Fitting size (mm)	10.2 – 17.2	17.2 – 33.7	33.7 – 60.3	60.3 – 114.3

Table 1

4.1.2 Samples

Samples shall be mounted according to the instruction of the manufacturer using pressing equipment supplied by the manufacturer. In case the manufacturer states that the mounting can be done with several pressing profiles, samples shall be mounted with each of these profiles and tested separately.

The test shall be performed using the steel pipes as specified by the manufacturer by reference to the applicable EN standard. If multiple types of steel pipe are specified, the tests shall be performed using these types of pipes.

Test shall be performed with the minimum wall thickness of the steel pipe as specified by the manufacturer of the fitting.

4.2 Uniform corrosion resistance

The uniform corrosion shall be assessed by performing the salt spray test according to ISO 9227, with a liquid according to paragraph 5.2.2 and a test duration of 168h.

The couplings will be exposed to the salt spray test assembled with the corresponding pipe.

After completion of the salt spray test, the leak tightness will be assessed according to paragraph 4.4. The sample will pass if the product leak tight.

4.3 Hydrostatic strength

The press fitting shall be able to withstand a pressure of 24 bar for 48 hours without deformation or displacement between fitting and pipe.

The test piece shall consist of the fitting or fittings to be tested connected to a pipe of 200 mm on both sides of the fitting. One end of the pipe shall be fitted with an end cap to seal of the assembly.

The pipe is marked to verify displacement after testing.

The assembly is filled with water and the test pressure shall be applied to the assembly.

After the test the assembly is visually checked for displacement and deformation.

4.4 Leak tightness

At an internal air pressure of 25 mbar, 110 mbar and 1.1 x maximum operating pressure (MOP) with a minimum of 3 bar the press fitting assembly shall be leak tight for 10 minutes.

The test piece shall consist of the fitting or fittings to be tested connected to a pipe of 200 mm on both sides of the fitting. One end of the pipe shall be fitted with an end cap to seal of the assembly.

Apply the test pressure to the test assembly. During the duration of the test the assembly is visually inspected for leakage. The test is repeated with the second and third test pressure.

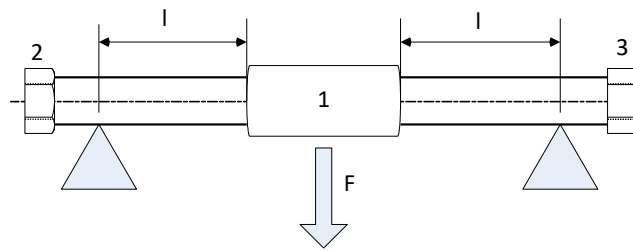
4.5 Leak tightness under static flexural strength

After being submitted to a bending force (see table 2) the fitting assembly shall be leak tight and shall show no deforming and displacement between pipe and fitting. The bending force shall be applied for 1 hour. During the test the fitting assembly shall be pressurized to 1.1 x maximum operating pressure (MOP) with a minimum of 3 bar and remain leak tight.

Pipe size (mm)	10.2	13.5	17.2	21.3	26.9	33.7	42.4	48.3	60.3	76.1	88.9	114.3
Pipe size (inch)	1/8"	1/4"	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"
Force F (N)	80	110	131	172	229	297	384	442	562	720	850	1105

Table 2

The test set up shall be according to figure 1.



- 1 fitting
- 2 connection for supply gas pressure
- 3 end cap
- l 1000 mm

Figure 1

During the test the assembly is visually inspected for leakage. After removing the bending force, the assembly is visually checked for displacement and deformation, the leak tightness is determined according to paragraph 4.4.

4.6 Resistance to pull-out

After being submitted to an axial tensile force the fitting assembly shall be leak tight and shall show no deformation and displacement between pipe and fitting.

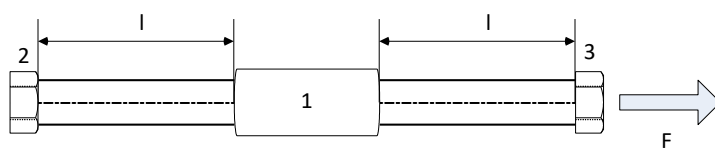
Calculation of the tensile force:

$$F = \frac{\pi \times d_n^2 \times p_D \times 1,5}{4}$$

- F force expressed in newton (N)
- d_n nominal diameter of the pipe in millimetres (mm)
- P_D maximum operation pressure MOP in megapascal (MPa)

The tensile force shall be applied for 1 hour. During the test the fitting assembly shall be pressurized to 1.1 x maximum operating pressure (MOP) with a minimum of 3 bar.

The test piece shall be according to figure 2.



- 1 fitting
- 2 connection for supply gas pressure
- 3 end cap
- l 200 mm

Figure 2

After removing the pulling force, the assembly is visually checked for displacement and deformation, the leak tightness is determined according to paragraph 4.4.

4.7 Leak tightness after temperature cycling

Using an oven, a fitting assembly is submitted to a temperature of 50 °C for one hour after which it is cooled down to room temperature. This cycle is repeated 6 times. Following the 6 cycles the fitting assembly is placed at -15 °C for 24 hours after which it is brought back to room temperature.

After being submitted to a temperature cycle test the fitting assembly shall be leak tight and shall show no displacement between pipe and fitting. The test piece shall be according to figure 2.

After the temperature cycling the leak tightness is determined according to paragraph 4.4.

4.8 Resistance to dynamic load

The fitting assembly shall be submitted to a dynamic load of 1×10^6 cycles with a frequency of 20 ± 1 Hz and an amplitude according to table 3.

Pipe diameter (mm)	Amplitude (mm)
≤ 42.4	5 ± 0.5
> 42.4	3.5 ± 0.5

Table 3

After being submitted to the dynamic load the fitting assembly shall be leak tight and shall show no displacement between fitting and pipe.

The test pieces and test set up shall be according to figure 3. The dynamic load shall be applied. During the test the test piece shall be pressurised up to 300 mbar.

After the test the test pieces are visually checked for displacement and the leak tightness of the complete test pieces is determined according to paragraph 4.4.

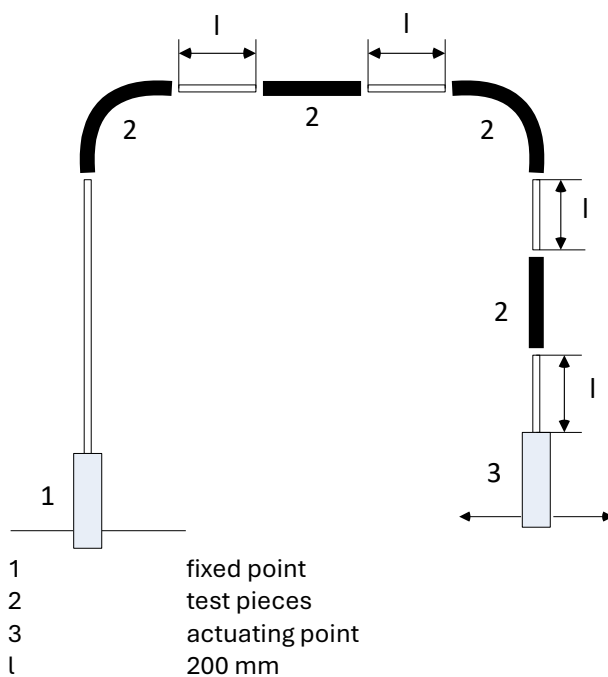


Figure 3

4.9 Resistance against torsion

The fitting assembly shall be submitted to 10.000 circumferential displacements of $4 \pm 1^\circ$ with a frequency of 1 Hz. After being submitted to the circumferential displacements the fitting assembly shall be leak tight and shall show no displacement between fitting and pipe.

The test piece and test set up shall be according to figure 4. The torsion load shall be applied. During the test the test piece shall be pressurised up to 300 mbar.

After the assembly is visually checked for displacement and the leak tightness of the complete test piece is determined according to paragraph 4.4.

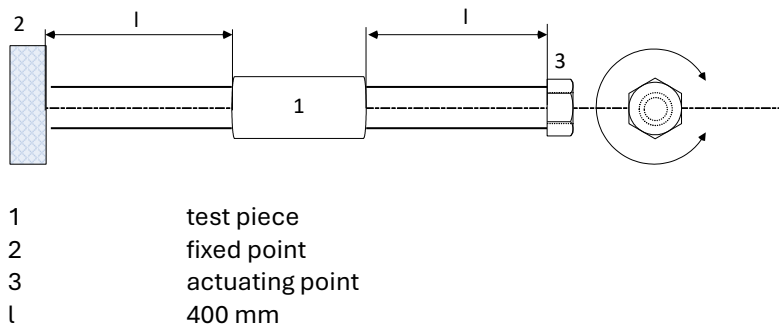


Figure 4

4.10 Leak before press

When according to manufacturer's specification the fitting shall leak before pressing the following test shall be performed.

At an internal pressure of 25 mbar, 110 mbar and $1.1 \times$ maximum operating pressure (MOP) with a minimum of 3 bar the press fitting assembly shall clearly show signs of leakage when using a leak detection fluid.

The test piece shall be according to figure 2.

Apply the test pressure to the test assembly. During the duration of the test the assembly is visually inspected for leakage. The test is repeated with the second and third test pressure.

5 Marking, instructions and packaging

5.1 Marking

The fitting shall be durably marked with the following information:

- GASTEC QA, GASTEC QA logo or punch mark*
- The name or trademark of the manufacturer.
- The external diameter of the pipe which is to be connected. *
- The production date (this may be in code).
- The word mark GAS or a yellow marking.
- Maximum operating pressure.

* This information may be placed on the smallest packaging in which the fittings are packed.

5.2 Instructions

The supplier shall provide user instructions in the Dutch language and in the language of the country in which the product will be used. The instructions shall contain information about:

- The use and installation of the product.
- The type of pipes including minimum wall thickness for which the press fittings are suitable.
- The type (jaw type and pressing equipment) of equipment that shall be used for pressing.
- The conditions under which it shall be used.
- How it can be determined if the product is correctly installed.
- The way the product shall be stored.

5.3 Packaging

The product including the associated components required for its assembly shall be packaged individually.

Special storage or handling conditions shall be specified on the packaging.

The packaging shall protect the product from dirt, dust and other contaminants during transport and storage until the point of use where the packaging will be removed.

6 Quality system requirements

The requirements for the quality system are described in the GASTEC QA general requirements. An important part of this are the requirements for drawing up a risk analysis (e.g., an FMEA) of the product design and the production process in accordance with chapters 3.1.1.1 and 3.1.2.1. This risk analysis shall be available for inspection by Kiwa.

7 Summary of evaluation

This chapter contains a summary of the evaluation to be carried out during:

- The initial product assessment;
- The periodic product verification;

7.1 Evaluation matrix

Description of requirement	Clause	Investigation within the scope of		
		Initial product assessment	Product verification	
			Inspection	Frequency
Product requirements	3			
Material requirements	3.1	X		
Surface condition	3.2	X	X	Once a year
Plated or coated surfaces	3.3	X	X	Once a year
Adaptor fittings	3.4	X	X	Once a year
Rubber sealing	3.5	X	X	Once a year
Tube abutment	3.6	X		
Performance requirements	4			
Uniform corrosion resistance	4.2	X		
Hydrostatic strength	4.3	X		
Leak tightness	4.4	X	X	Once a year
Leak tightness under static flexural strength	4.5	X		
Resistance to pull-out	4.6	X	X	Once a year
Leak tightness after temperature cycling	4.7	X		
Resistance to dynamic load	4.8	X		
Resistance against torsion	4.9	X	X	Once a year
Leak before press	4.10	X		
Marking	5			
Marking	5.1	X	X	Once a year
Instruction	5.2	X	X	Once a year
Packaging	5.3	X	X	Once a year

8 List of referenced documents and source

8.1 Standards/ normative documents

Number	Title	Version *
EN 549:	Rubber materials for seals and diaphragms for gas appliances and gas equipment	2019 + A2: 2024
EN 682:	Elastomeric seals – materials requirements for seals used in pipes and fittings carrying gas and hydrocarbon fluids	2002 + A1: 2005
EN 10216-1:	Seamless steel tubes for pressure purposes – technical delivery conditions – part 1: non-alloy steel tubes with specified room temperature properties	2013
EN 10217-1:	Welded steel tubes for pressure purposes – technical delivery conditions – part 1: non-alloy steel tubes with specified room temperature properties.	2019
EN 10226-1:	Pipe threads where pressure tight joint are made on the thread – part 1 taper external threads and parallel internal threads- dimensions, tolerances and designation	2004
EN 10255:	Non-alloy steel tubes for welding or threading – technical delivery conditions	2004 + A1: 2007
ISO 9227:	Corrosion tests in artificial atmospheres – Salt spray tests	2022

*) If no date of issuance is specified in this column, the current version of the document applies.

8.2 Source of informative documents

Number	Title	Version *
EN 437:	Test gases- test pressure – appliance categories	2021
EN 1254-7:	Copper and copper alloys - Plumbing fittings - Part 7: Press fittings for use with metallic tubes	2021
DVGW G5614:	Unlösbare Rohrverbindungen für metallene Gasleitungen; Pressverbinder	2013

General requirements GASTEC QA

*) If no date of issuance is specified in this column, the current version of the document applies.