thermaflex®
District Heating Solutions

Pressure Test

Pressure testing according DIN1988-2 for pre-insulated piping system Flexalen®
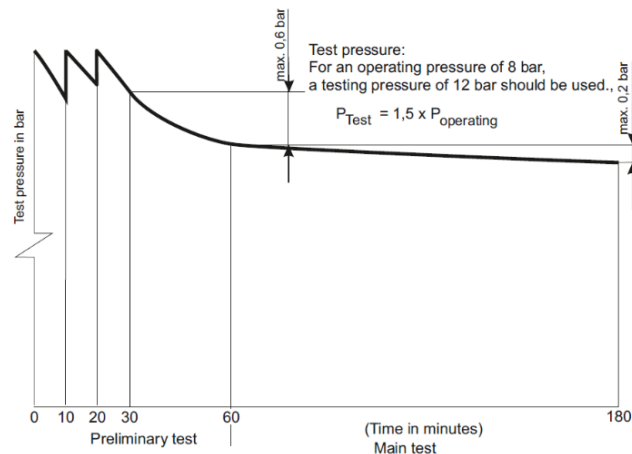
Required Tools

Pressure pump

Filling unit

Pressure gauge (with accessories)

Application Instruction

Application conditions and preparation

- Ambient temperature: >0°C
- All connections have been made & all welds have cooled down at least 2 hrs (24 hrs for fittings ≥125mm) ago
- All end points have been sealed or the valves to other system parts are closed and labeled with "do not operate/open"

Test pressure:
For an operating pressure of 8 bar, a testing pressure of 12 bar should be used.,

$$P_{Test} = 1,5 \times P_{operating}$$

max. 0,6 bar

max. 0,2 bar

Test pressure in bar

0   10 20 30   60   (Time in minutes)   180
        Preliminary test   Main test

01.
Perform **leak test** with potable water (max 0.5 bar). Measuring point is the lowest point in the pipe system. Start pressure test only after leak test is successful (there are no leakages)!

Note: use air for leak test only if necessary and only use compressor with oil separator

02.
Perform **preliminary pressure test** at 1.5 times the working pressure. The pressure must be checked every 10, 20 and 30 minutes and, if necessary, brought back to the same level (to 1.5 x working pressure). The pre-test is successful, if the pressure drop between 30 minutes and 1 hour is less than 0.6 bar.

03.
Perform **main pressure test** immediately after the preliminary test. The duration of the test is at least 2 hours (120 min). The main pressure test is successful if the pressure drop during the test is less than 0.2 bar over the entire system.

DURING THE PRESSURE TEST REPORT MUST BE FILLED IN (next page)

Pressure Test Report

Object: _____

Preliminary test

Starting Pressure
(1.5 x working pressure)   _____ bar

Pressure after 30 minutes   _____ bar

Pressure after 60 minutes
(max. pressure drop of 0.6 bar between 30 mins and 1hour)   _____ bar

Leakage   ☐ yes ☐ no

Main test

Starting Pressure
(End pressure of preliminary test)   _____ bar

Pressure after 120 minutes
(max. pressure drop of 0,2 bar since the beginning)   _____ bar

Leakage   ☐ yes ☐ no

Plumber / Company:

_____

_____   _____

Date   Signature