

# Metallic materials — Tube — Ring-expanding test

The European Standard EN ISO 8495:2004 has the status of a  
British Standard

ICS 77.040.10

## National foreword

This British Standard is the official English language version of EN ISO 8495:2004. It is identical with ISO 8495:1998. It supersedes BS EN 10236:1994, which is withdrawn.

The UK participation in its preparation was entrusted by Technical Committee ISE/NFE/4, Mechanical testing of metals, to Subcommittee ISE/NFE/4/2, Ductility testing, which has the responsibility to:

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### Summary of pages

This document comprises a front cover, an inside front cover, the EN ISO title page, the EN ISO foreword page, the ISO title page, page ii, pages 1 to 3 and a back cover.

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## Metallic materials - Tube - Ring-expanding test (ISO 8495:1998)

Matériaux métalliques - Tubes - Essai de dilatation  
d'anneaux (ISO 8495:1998)

Metallische Werkstoffe - Rohr - Ringaufdornversuch (ISO  
8495:1998)

This European Standard was approved by CEN on 1 July 2004.

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## **Foreword**

The text of ISO 8495:1998 has been prepared by Technical Committee ISO/TC 164 "Mechanical testing of metals" of the International Organization for Standardization (ISO) and has been taken over as EN ISO 8495:2004 by Technical Committee EC/ISS/TC 29 "Steel tubes and fittings for steel tubes", the secretariat of which is held by UNI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2005, and conflicting national standards shall be withdrawn at the latest by January 2005.

This document supersedes EN 10236:1993.

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## **Endorsement notice**

The text of ISO 8495:1998 has been approved by CEN as EN ISO 8495:2004 without any modifications.

INTERNATIONAL  
STANDARD

**ISO**  
**8495**

Second edition  
1998-11-01

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**Metallic materials — Tube —  
Ring-expanding test**

*Matériaux métalliques — Tubes — Essai de dilatation d'anneaux*



Reference number  
ISO 8495:1998(E)

## Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 8495 was prepared by Technical Committee ISO/TC 164, *Mechanical testing of metals*, Subcommittee SC 2, *Ductility testing*.

This second edition cancels and replaces the first edition (ISO 8495:1986), of which it constitutes a technical revision.

# Metallic materials — Tube — Ring-expanding test

## 1 Scope

This International Standard specifies a method for a ring-expanding test on tubes, that is used to reveal defects both on the surfaces and within the tube wall by expanding the test piece using a conical mandrel until fracture occurs. It may be also used to assess the ability of tubes to undergo plastic deformation.

The ring-expanding test is applicable to tubes having an outside diameter from 18 mm up to and including 150 mm and wall thickness from 2 mm up to and including 16 mm.

## 2 Symbols, designations and units

Symbols, designations and units for the ring-expanding test are given in table 1 and are shown in figure 1.

Table 1

Symbol	Designation	Unit
$a^a$	Wall thickness of the tube	mm
$D$	Original outside diameter of the tube	mm
$D_{m\max.}$	Maximum diameter of the conical mandrel	mm
$D_{m\min.}$	Minimum diameter of the conical mandrel	mm
$D_u$	Maximum outside diameter of the expanded part of the test piece	mm
$k$	Length of the taper of the conical mandrel	mm
$L$	Length of the test piece before the test	mm

<sup>a</sup> The symbol  $T$  is also used in steel tube standards.

## 3 Principle

Expanding a ring cut from the end of a tube, over a conical mandrel until fracture, or until the expansion of the test piece reaches a value specified in the relevant product standard (see figure 1).

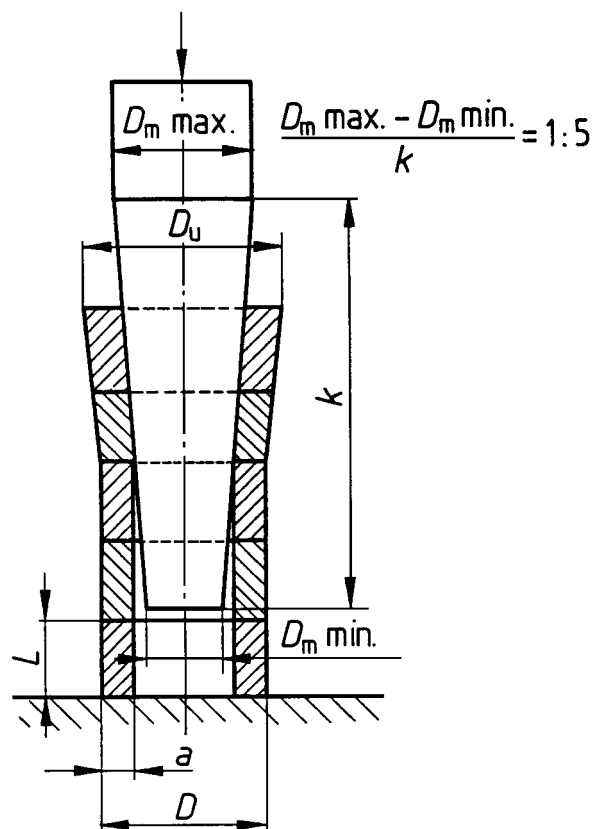


Figure 1

## 4 Apparatus

### 4.1 Variable-speed press or universal testing machine.

**4.2 Conical mandrel**, having a working length preferably tapered 1:5 as shown in figure 1, unless otherwise specified in the relevant product standard and its surface shall be of sufficient hardness, well-polished and free from scores.

## 5 Test piece

**5.1** The length of the test piece shall be between 10 mm and 16 mm. Test pieces shall be taken from the ends of deburred tubes as manufactured before they are cut to length. The rings shall be cut so that the planes of the end faces are parallel with each other and perpendicular to the axis of the tube.

**5.2** The edges of the test piece may be rounded by filing or chamfered by other methods.

NOTE — Non-rounded or non-chamfered edges are permissible, if the test result meets the test requirements.

**5.3** When welded tubes are subjected to the test, the internal weld flash may be removed.

## 6 Procedure

**6.1** In general, the test shall be carried out at ambient temperature within the limits of 10 °C to 35 °C. The test carried out under controlled conditions shall be made at a temperature of 23 °C ± 5 °C.



**6.2** Before testing, the rings and the conical mandrel may be lubricated. Rings of the same size and the same type of metal may be placed one on top of each other. The rings and the conical mandrel shall be concentric (see figure 1).

**6.3** Force the conical mandrel into the rings until the required expansion is reached or the rings fracture.

**6.4** The rate of penetration of the conical mandrel shall not exceed 30 mm/s.

**6.5** The relative expansion shall be calculated in accordance with the relevant product standard.

**6.6** Interpretation of the ring-expanding test shall be carried out in accordance with the requirements of the relevant product standard. When these requirements are not specified, the test piece shall be considered to have passed the test if no cracks are visible without the use of magnifying aids.

## 7 Test report

A test report shall be provided when so specified in the relevant product standard. In this case, the test report shall include at least the following information:

- a) reference to this International Standard, i.e. ISO 8495;
- b) identification of the test piece;
- c) dimensions of the test piece;
- d) degree of expansion;
- e) taper of the conical mandrel if different from that given in 4.2;
- f) result of the test.

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