ISO 3821:2019-08 (E)

Gas welding equipment - Rubber hoses for welding, cutting and allied processes

Contents

Page

Foreword v

1 Scope 1

2 Normative references 1

3 Termsanddefinitions 2

4 Abbreviated terms 2

5 Application 2

6 Hose designation 2

7 Materials 3
7.1 Construction 3
7.1.1 Light and normal duty hoses 3
7.1.2 Flux fuel gas hose 3
7.1.3 Twin hose 3
7.2 Manufacture 3

8 Dimensions and tolerances 3
8.1 Inside diameters 3
8.2 Outside diameters 4
8.3 Wall thickness 4
8.4 Concentricity (total indicator reading) 5
8.5 Cut lengths and tolerances 5
8.6 Disclosure of inside diameter and outside diameter 5

9 Requirements and type tests 5
9.1 General 5
9.2 Basic requirements 5
9.2.1 Tensile strength and elongation at break 5
9.2.2 Accelerated ageing 5
9.2.3 Adhesion 5
9.2.4 Hydrostatic requirements 6
9.2.5 Flexibility at ambient temperature 6
9.2.6 Low-temperature flexibility 6
9.2.7 Protection against incandescent particles and hot surfaces 6
9.2.8 Ozone resistance 6
9.3 Special requirements 6
9.3.1 Non-ignition requirement for oxygen hoses 6
9.3.2 Resistance to acetone and dimethylformamide for acetylene hoses 7
9.3.3 Resistance to n-pentane for propane hoses 7
9.3.4 Resistance to azeotrope of trimethylborate with methanol for flux fuel gas hoses 7
9.3.5 Flexibility of flux fuel gas hoses 8
9.3.6 Permeability to LPG, MPS, and natural gas of methane hoses, universal fuel gas hoses, and flux fuel gas hoses 8
9.3.7 Requirements for twin hoses 8
9.3.8 Requirements for universal fuel gas hose 8

10 Hosecolourandgasidentification 8

10.1 General 8
10.2 Gas identification 8
10.3 Marking 9

Annex A (normative) Method of test for non-ignition 10

Annex B (normative) Method of test for resistance to n-pentane 12

Annex C (normative) Method of test for resistance to incandescent particles and hot surfaces 13

Annex D (normative) Summary of requirements and type tests 15

Annex E (normative) Alternative oxygen gas colour codes 16

Bibliography 17