

ISO 11513:2011-09 (E)

Gas cylinders - Refillable welded steel cylinders containing materials for sub-atmospheric gas packaging (excluding acetylene) - Design, construction, testing, use and periodic inspection

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms, definitions and symbols	2
3.1	Terms and definitions	2
3.2	Symbols	2
4	Inspection and testing	3
5	Materials and stress relieving	3
6	Design	4
6.1	General	4
6.2	Calculation of cylindrical wall thickness	5
6.3	Design of cylinder ends	5
6.4	Minimum wall thickness	6
6.5	Pressure relief device	7
7	Construction and workmanship	7
7.1	General	7
7.2	Welding qualification	8
7.3	Welding seams of pressure containing parts	8
7.4	Valve protection	8
7.5	Boss threads	8
7.6	Visual examination	8
8	Technical requirements for type approval testing (new design tests)	11
8.1	General	11
8.2	Verifications and tests	11
8.3	Description of verification tests	12
9	Batch tests	13
9.1	General	13
9.2	Information	13
9.3	Checks and verifications	13
9.4	Tensile test	14
9.5	Bend test	15
9.6	Macroscopic examination of weld cross-sections	16
9.7	Radiographic examination of welds	16
10	Tests on every cylinder	16
11	Failure to meet verification and test requirements	17

12	Marking	17
13	Certification	17
	Annex A (normative) Inspection at time of fill	18
	Annex B (normative) Periodic inspection and test	20
	Annex C (informative) Gases currently being transported	21
	Bibliography	23