

DIN EN 14893:2014-09 (E)

LPG equipment and accessories - Transportable Liquefied Petroleum Gas (LPG) welded steel pressure drums with a capacity between 150 litres and 1000 litres

Contents		Page
Foreword		5
Introduction		6
1	Scope	7
2	Normative references	7
3	Terms and definitions	9
4	Materials	11
4.1	Suitability	11
4.2	Pressure retaining parts	11
4.3	Non-pressure retaining parts	11
4.4	Welding consumables	12
4.5	Non-metallic materials (gaskets)	12
4.6	Certification of materials	12
5	Design	13
5.1	General	13
5.2	Design conditions	13
5.2.1	Calculation pressure	13
5.2.2	Design temperature	13
5.2.3	Vacuum conditions	13
5.3	Calculation of thicknesses	14
5.3.1	Calculation	14
5.3.2	Minimum thickness for handling	14
5.4	Support loadings	14
5.5	Lifting lug loadings	15
5.6	Openings	15
5.6.1	General	15
5.6.2	Reinforcement	15
5.6.3	Position of welds	15
5.6.4	Fittings connections	15
5.6.5	Fittings	15
5.7	Protection of fittings	16
5.7.1	General	16
5.7.2	End shrouds	16
5.7.3	Protective frame	16
5.7.4	Local protection	16
5.8	Rolling hoops	16
5.9	Ventilation openings	16
6	Workmanship and manufacture	17
6.1	General	17
6.2	Environment	17
6.3	Control and traceability of materials	17
6.4	Manufacturing tolerances	17
6.5	Acceptable weld details	18
6.5.1	General	18
6.5.2	Longitudinal welds	18

6.5.3	Joggle joints	18
6.6	Formed pressure parts	18
6.6.1	General	18
6.6.2	Heat treatment after forming	19
6.6.3	Testing of formed parts	19
6.6.4	Repeated tests	20
6.6.5	Visual examination and control of dimensions	20
6.6.6	Marking	20
6.6.7	Inspection certificate	20
6.7	Welding	20
6.7.1	General	20
6.7.2	Welding procedure specification (WPS)	21
6.7.3	Qualification of WPS	21
6.7.4	Qualification of welders and welding personnel	21
6.7.5	Preparation of edges to be welded	21
6.7.6	Execution of welded joints	21
6.7.7	Attachments and supports	22
6.7.8	Preheating	22
6.8	Post weld heat treatment	22
6.9	Repairs	22
6.9.1	Repairs of surface imperfections in the parent metal	22
6.9.2	Repair of weld imperfections	22
6.10	Examination of welds	23
6.10.1	Visual examination of welds	23
6.10.2	Non-destructive testing (NDT)	23
6.11	Non-destructive testing techniques	24
6.11.1	General	24
6.11.2	Radiographic techniques	24
6.11.3	Ultrasonic techniques	25
6.11.4	Magnetic particle techniques	25
6.11.5	Dye penetrant techniques	25
6.12	Marking for all non-destructive testing techniques	25
6.13	Qualification of personnel	25
6.14	Acceptance criteria	25
6.15	Production test plates (coupon plates)	26
6.16	Impact tests	27
7	Initial inspection and testing	27
7.1	General	27
7.2	Pressure test	28
7.3	Lifting lug test	28
7.4	Final examination of drum	28
7.5	Leak tightness test	29
7.6	Tare mass	29
7.7	Verification on conformity	29
8	Surface treatment and finishing	29
8.1	General	29
8.2	Finishing operations	29
9	Marking	30
10	Conformity assessment	30
10.1	General	30
10.2	Fatigue test	30
10.3	Burst test	30
10.4	Drop test	31
10.5	Lifting lugs	31
11	Design type testing	31
12	Records and documentation	31

12.1	Records to be obtained by the manufacturer	31
12.2	Documents to be provided by the manufacturer	31
Annex A (informative) Guidance on selection of material grades		33
Annex B (normative) Tolerances on drums		34
B.1	Mean external diameter	34
B.2	Out of roundness	34
B.3	Deviation from the straight line	34
B.4	Irregularities in circular profile	34
B.5	Thickness tolerance	35
B.6	Profile	35
B.7	Surface alignment	36
B.8	Attachments, nozzles and fittings	36
Annex C (normative) Hydraulic pressure test		37
C.1	Temporary fittings	37
C.2	Pressure gauges	37
C.3	Pressurising agent	37
C.4	Avoidance of shocks	37
C.5	Test procedure	37
Annex D (normative) Imperfections of welded joints		38
Annex E (normative) Design formulae for drums		41
E.1	Allowable stresses	41
E.2	Design formulae	41
E.3	Nozzle reinforcement	44
Annex F (informative) Measurement of shell peaking		52
F.1	Profile gauge	52
F.2	Peaking survey	52
Annex G (informative) Examples of welded joints		55
Annex H (informative) Environmental checklist		59
Bibliography		60