

ISO 24431:2016-11 (E)

Gas cylinders - Seamless, welded and composite cylinders for compressed and liquefied gases (excluding acetylene) - Inspection at time of filling

| Contents | | Page |
|-----------------------|--|-------------|
| Foreword | | iv |
| Introduction | | v |
| 1 | Scope | 1 |
| 2 | Normative references | 1 |
| 3 | Terms and definitions | 1 |
| 4 | Identification of cylinder owner | 4 |
| 5 | Filling inspection | 5 |
| 5.1 | General | 5 |
| 5.2 | Verification of serviceable condition of individual cylinders before filling | 5 |
| 5.2.1 | General criteria | 5 |
| 5.2.2 | Exterior condition | 5 |
| 5.2.3 | Interior condition | 7 |
| 5.2.4 | Cylinder tare | 7 |
| 5.2.5 | Calculation of weight of gas to be filled into the cylinder | 8 |
| 5.2.6 | Provisions for visually inspecting cylinders fitted with coverings | 8 |
| 5.2.7 | Verification of the integrity of permanent attachments | 9 |
| 5.2.8 | Verification of valve integrity and suitability | 9 |
| 5.2.9 | Provisions for palletized cylinders | 10 |
| 5.2.10 | Rejected cylinders | 10 |
| 5.3 | Verification during filling | 10 |
| 5.4 | Verification after filling | 10 |
| 5.4.1 | General | 10 |
| 5.4.2 | Verification of gas tightness | 10 |
| 5.4.3 | Verification of correct filling pressure | 11 |
| 5.4.4 | Verification of correct filling weight | 11 |
| 5.4.5 | Verification of valve protection | 11 |
| 5.4.6 | Verification of correct product labelling | 11 |
| 6 | Cylinders rejected for filling | 11 |
| Annex A (informative) | Residual pressure check | 12 |
| Annex B (informative) | Example of a procedure to establish a correct tare | 13 |
| Bibliography | | 14 |