

ISO 10460:2018 (E)

Gas cylinders — Welded aluminium-alloy, carbon and stainless steel gas cylinders — Periodic inspection and testing

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Intervals between periodic inspection and testing
5	Periodic inspection and testing procedures
5.1	General
5.2	Depressurization and devalving procedures
5.2.1	Depressurization
5.2.2	Devalving
5.3	External visual inspection
5.3.1	General
5.3.2	Preparation
5.3.3	Procedure
5.3.4	Inspection result
5.4	Internal visual inspection
5.4.1	General
5.4.2	Preparation
5.4.3	Cleaning
5.4.4	Inspection result
5.5	Cylinder neck inspection
5.5.1	Cylinder-to-valve threads
5.5.1.1	All cylinders
5.5.1.2	Cylinders used in toxic or corrosive service
5.5.2	Other neck surfaces
5.5.3	Neckring and/or collar attachment
5.6	Pressure test
5.6.1	General
5.6.2	Test equipment
5.6.3	Test criteria
5.6.4	Acceptance criteria
5.7	Cylinder repair
5.7.1	General
5.7.2	Major repairs
5.7.3	Minor repairs
5.8	Inspection of valve and other accessories
5.9	Final operations
5.9.1	Drying, cleaning, painting and coating
5.9.1.1	Drying and cleaning
5.9.1.2	Painting and coating
5.9.2	Cylinder revalving
5.9.3	Cylinder tare check
5.9.4	Cylinder marking after periodic inspection and testing
5.9.4.1	General
5.9.4.2	Retester identification and periodic inspection and testing date
5.9.4.3	Stamp marks

- 5.9.5** Reference to next periodic inspection and testing date
- 5.9.6** Reports
- 5.10** Rejection and rendering cylinders unserviceable

Annex A (informative) Intervals between periodic inspections and tests

Annex B (informative) Gas cylinder periodic inspection date rings

Annex C (normative) Description and evaluation of imperfections and conditions for rejection at visual inspection

- C.1** General
- C.2** Physical or material imperfections
- C.3** Corrosion
 - C.3.1** General
 - C.3.2** Types of corrosion

Annex D (informative) Gases corrosive to carbon steel cylinders

Page count: 22