

ISO 9809-1:2019 (E)

Gas cylinders — Design, construction and testing of refillable seamless steel gas cylinders and tubes — Part 1: Quenched and tempered steel cylinders and tubes with tensile strength less than 1 100 MPa

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Symbols
5	Inspection and testing
6	Materials
6.1	General requirements
6.2	Controls on chemical composition
6.3	Typical steels
6.4	Heat treatment
6.5	Failure to meet test requirements
7	Design
7.1	General requirements
7.2	Limitation on tensile strength
7.3	Design of cylindrical shell thickness
7.4	Design of convex ends (heads and bases)
7.5	Design of concave base ends
7.6	Neck design
7.7	Foot rings
7.8	Neck rings
7.9	Design drawing
8	Construction and workmanship
8.1	General
8.2	Wall thickness
8.3	Surface imperfections
8.4	Ultrasonic examination
8.5	Out-of-roundness
8.6	Mean diameter
8.7	Straightness
8.8	Verticality and stability
8.9	Neck threads
9	Type approval procedure
9.1	General requirements
9.2	Prototype tests
9.2.1	General requirements
9.2.2	Pressure cycling test
9.2.3	Base check
9.2.4	Bend test and flattening test
9.2.4.1	Bend test
9.2.4.2	Flattening test

9.2.4.3	Ring flattening test
9.2.5	Torque test for taper thread only
9.2.5.1	Procedure
9.2.5.2	Acceptance criteria
9.2.6	Shear stress calculation for parallel threads
9.2.6.1	Procedure
9.2.6.2	Acceptance criteria
9.3	Type approval certificate
10	Batch tests
10.1	General requirements
10.2	Tensile test
10.3	Impact test
10.4	Hydraulic burst test
10.4.1	Test installation
10.4.2	Test conditions
10.4.3	Interpretation of test results
10.4.4	Acceptance criteria
11	Tests/examinations on every cylinder
11.1	General
11.2	Hydraulic test
11.2.1	Proof pressure test
11.2.2	Volumetric expansion test
11.3	Hardness test
11.4	Leak test
11.5	Capacity check
12	Certification
13	Marking
Annex A	(normative) Description and evaluation of manufacturing imperfections in seamless gas cylinders
A.1	Overview
A.2	General
A.3	Manufacturing imperfections and the procedure for their evaluation
A.4	Acceptance and rejection conditions
Annex B	(normative) Ultrasonic examination
B.1	General
B.2	General requirements
B.3	Flaw detection of the cylindrical parts
B.3.1	Procedure
B.3.2	Reference standard
B.3.3	Calibration of equipment
B.4	Wall thickness measurement
B.5	Interpretation of results
B.6	Certification
Annex C	(informative) Example of type approval certificate
Annex D	(informative) Example of acceptance certificate
Annex E	(informative) Bend stress calculation
Annex F	(informative) Chemical compositions of internationally-recognized steel
Annex G	(informative) An example of shear strength calculation for parallel threads