ISO 21009-1:2022-08 (E)

Cryogenic vessels - Static vacuum-insulated vessels - Part 1: Design, fabrication, inspection and tests

Contents

Page

Foreword v

1 Scope 1

2 Normative references 1

3 Termsanddefinitions 2

4 Symbols 5

5 General requirements 7

6 Mechanical loads 7
6.1 General 7
6.2 Load during the pressure test 8

7 Chemical effects 8

8 Thermal conditions 8

9 Material 9
9.1 General 9
9.2 Selection of materials 9
9.3 Inspection certificate 9
9.4 Materials for outer jackets and service equipment 9

10 Design 9
10.1 Design options 9
10.1.1 General 9
10.1.2 Design by calculation 9
10.1.3 Design by calculation when adopting pressure strengthening (if allowed) 10
10.1.4 Design of components by calculation supplemented with experimental methods 10
10.2 Common design requirements 10
10.2.1 General 10
10.2.2 Design specification and documentation 10
10.2.3 Design loads 11
10.2.4 Inspection openings 14
10.2.5 Pressure relief 14
10.2.6 Valves 16
10.2.7 Filling ratio 16
10.2.8 Electrical continuity 16
10.3 Design by calculation 16
10.3.1 General 16
10.3.2 Inner vessel 16
10.3.3 Outer jacket 18
10.3.4 Supports and lifting points 20
10.3.5 Piping and accessories 20
10.3.6 Calculation formulae 20
10.3.7 Calculations for operating loads 27

11 Fabrication 48

11.1 General ... 48
11.2 Cutting ... 48
11.3 Cold forming ... 49
11.3.1 Austenitic stainless steel ... 49
11.3.2 Ferritic steel ... 49
11.4 Hot forming ... 50
11.4.1 General ... 50
11.4.2 Austenitic stainless steel ... 50
11.4.3 Ferritic steel ... 50
11.5 Manufacturing tolerances ... 52
11.5.1 General ... 52
11.5.2 Plate alignment ... 53
11.5.3 Thickness ... 53
11.5.4 Dished ends ... 53
11.5.5 Cylinders ... 53
11.6 Welding ... 55
11.6.1 General ... 55
11.6.2 Qualification ... 55
11.6.3 Temporary attachments ... 55
11.6.4 Welded joints ... 56
11.7 Non-welded permanent joints ... 56

12 Inspection and testing ... 57
12.1 Quality plan ... 57
12.1.1 General ... 57
12.1.2 Inspection stages during manufacture of an inner vessel ... 57
12.1.3 Additional inspection stages during manufacture of a static cryogenic vessel ... 57
12.2 Production control test plates ... 58
12.2.1 Requirements ... 58
12.2.2 Extent of testing ... 58
12.3 Non-destructive testing ... 59
12.3.1 General ... 59
12.3.2 Extent of examination for surface imperfections ... 59
12.3.3 Extent of examination for weld imperfections ... 59
12.3.4 Acceptance levels ... 60
12.4 Rectification ... 61
12.4.1 General ... 61
12.4.2 Manually welded seams ... 61
12.4.3 Seams produced using automatic welding processes ... 61
12.5 Pressure testing ... 61

13 Marking and labelling ... 62

14 Final assessment ... 63

15 Periodic inspection ... 63

Annex A (normative) Elastic stress analysis ... 64

Annex B (normative) Additional requirements for 9 % Ni steel ... 73

Annex C (normative) Pressure strengthening of vessels from austenitic stainless steels ... 75

Annex D (informative) Pressure limiting systems ... 88

Annex E (normative) Further use of the material cold properties to resist pressure loads ... 89

Annex F (informative)Specificwelddetails ... 93

Annex G (normative)Additionalrequirementsforflammablefluids ... 97

Annex H (informative) Flammable gas vents and relief systems 98

Annex I (normative) Outer jacket relief devices 99

Annex J (normative) Increased material property for austenitic stainless steel 100

Annex K (informative) Base materials 101

Annex L (normative) Cylindrical shells and dished ends subject to external pressure(pressure on the convex surface) -- Calculation 109

Annex M (normative) Design of openings in cylinders, spheres and cones -- Calculation 114

Annex N (normative) Design of ends for internal pressure 123

Bibliography 125