

DIN EN ISO 18119:2024-12 (E)

Gas cylinders - Seamless steel and seamless aluminium-alloy gas cylinders and tubes - Periodic inspection and testing (ISO 18119:2018 + Amd 1:2021 + Amd 2:2024)

Contents		Page
European foreword.....		5
Ⓐ1	European foreword to Amendment A1 Ⓐ1	6
Ⓐ2	European foreword to Amendment A2 Ⓐ2	7
Foreword		8
Ⓐ1	Foreword to Amendment A1 Ⓐ1	9
Ⓐ2	Foreword to Amendment A2 Ⓐ2	10
Introduction		11
1	Scope	12
2	Normative references	12
3	Terms and definitions	12
4	Abbreviated terms and symbols	13
5	Intervals between periodic inspections and tests.....	14
6	List of procedures for periodic inspections and tests.....	14
7	Identification of cylinder and preparation for inspection and tests	15
8	Depressurization and de-valving procedures	15
8.1	General.....	15
8.2	Cylinders requiring de-valving.....	16
8.3	Cylinders not requiring de-valving.....	16
8.4	Cylinders requiring shot blasting.....	16
9	External visual inspection.....	16
9.1	Preparation	16
9.2	Inspection procedure.....	17
10	Inspection of cylinder neck	17
10.1	Cylinder-to-valve threads.....	17
10.2	Other neck surfaces.....	20
10.3	Damaged internal neck threads.....	20
10.4	Necking and collar attachment.....	20
11	Check of internal condition	20
11.1	General.....	20
11.2	Internal visual inspection	21
11.2.1	Preparation	21
11.2.2	Inspection requirements.....	21
11.2.3	Cylinders with footrings	22
11.2.4	Cylinders with internal coatings.....	22
12	Supplementary tests	22
12.1	General.....	22
12.2	Additional test for seamless aluminium-alloy cylinders possibly subjected to heat damage.....	22
12.3	Hammer test on cylinders with footrings.....	23

13	Cylinder repairs	23
14	Pressure test or UT.....	23
14.1	General	23
14.2	Proof pressure test.....	24
14.2.1	General	24
14.2.2	Test equipment.....	24
14.2.3	Test criteria	24
14.2.4	Acceptance criteria	25
14.3	Hydraulic volumetric expansion test	25
14.4	UT	25
14.4.1	General	25
14.4.2	Requirements.....	25
14.4.3	Calibration.....	30
14.4.4	Performing the examination	34
14.4.5	Interpretation of results	35
14.4.6	Records.....	36
15	Inspection of valve and other accessories.....	36
16	Replacement of cylinder parts.....	37
17	Final operations	37
17.1	Drying, cleaning and painting	37
17.1.1	Drying and cleaning.....	37
17.1.2	Painting and coating.....	37
17.2	Re-valving of the cylinder	38
17.3	Check of cylinder tare	38
17.4	Retest marking	39
17.4.1	General	39
17.4.2	Stamping	39
17.5	Reference to next periodic inspection and test date	39
17.6	Identification of contents.....	39
17.7	Records.....	39
18	Rejection and rendering cylinder unserviceable.....	40
18.1	General	40
18.2	Cylinders with a valve attached.....	40
18.3	Cylinders with no valves attached	40
	Annex A (informative) Periodic inspection and test periods	41
	Annex B (normative) Description, evaluation of defects and conditions for rejection of seamless steel and seamless aluminium-alloy cylinders at the time of periodic inspection	42
B.1	General	42
B.2	Physical or material defects.....	42
B.3	Corrosion	44
B.3.1	General	44
B.3.2	Types of corrosion.....	44
B.3.3	Technical basis for establishing maximum allowable imperfection sizes by UT	48
B.4	Neck and shoulder cracks.....	51
B.4.1	General	51
B.4.2	Neck cracks	51
B.4.3	Shoulder cracks.....	51
	Annex C (informative) $\overline{A_1}$ List of gases corrosive to steel cylinder material $\overline{A_1}$	53
	Annex D (informative) Volumetric expansion testing of cylinders	54
D.1	General	54
D.2	Test equipment.....	54

D.3 Water jacket volumetric expansion test..... 54

D.3.1 General..... 54

D.3.2 Water jacket volumetric expansion test — Levelling burette method..... 55

D.3.3 Water jacket volumetric expansion test — Fixed burette method 56

D.4 Non-water jacket volumetric expansion test..... 56

D.4.1 General..... 56

D.4.2 Requirement for testing..... 58

D.4.3 Test method..... 58

D.4.4 Calculation of compressibility of water 59

D.4.5 Calculation example 61

Annex E (informative) Test date rings for cylinders 62

Annex F (informative) Cleaning of seamless aluminium-alloy cylinders 63

F.1 Internal 63

F.2 External..... 63

Bibliography..... 64