

ISO 21009-1:2008-09 (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 Terms and definitions	2
4 Symbols	5
5 General requirements	7
6 Mechanical loads	7
6.1 General	7
6.2 Load during the pressure test	7
7 Chemical effects	8
8 Thermal conditions	8
9 Material	8
9.1 Selection of materials	8
9.2 Inspection certificate	9
9.3 Materials for outer jackets and service equipment	9
10 Design	9
10.1 Design options	9
10.2 Common design requirements	9
10.3 Design by calculation	16
11 Fabrication	43
11.1 General	43
11.2 Cutting	43
11.3 Cold forming	47
11.4 Hot forming	49
11.5 Manufacturing tolerances	50
11.6 Welding	53
11.7 Non-welded permanent joints	54
12 Inspection and testing	54
12.1 Quality plan	54
12.2 Production control test plates	56
12.3 Non-destructive testing	57
12.4 Rectification	60
12.5 Pressure testing	60
13 Marking and labelling	61
14 Final assessment	62
15 Periodic inspection	62
Annex A (normative) Elastic stress analysis	63
Annex B (normative) Additional requirements for 9 % Ni steel	72

Annex C (normative) Pressure strengthening of vessels from austenitic stainless steels	74
Annex D (informative) Pressure limiting systems	85
Annex E (normative) Further use of the material cold properties to resist pressure loads	86
Annex F (informative) Specific weld details	90
Annex G (normative) Additional requirements for flammable fluids	94
Annex H (informative) Relief devices	95
Annex I (normative) Outer jacket relief devices	96
Annex J (informative) Increased material property for austenitic stainless steel	97
Annex K (normative) Base materials	98
Annex L (normative) Cylindrical shells subject to external pressure (pressure on the convex surface) -- Calculation	107
Annex M (normative) Design of openings in cylinders, spheres and cones -- Calculation	112
Annex N (normative) Design of ends for internal pressure	122
Bibliography	124