

DIN EN ISO 9809-1:2010-10 (E)

Gas cylinders - Refillable seamless steel gas cylinders - Design, construction and testing - Part 1: Quenched and tempered steel cylinders with tensile strength less than 1 100 MPa (ISO 9809-1:2010)

Contents	Page
Foreword	3
Introduction	5
1 Scope	6
2 Normative references	6
3 Terms and definitions	6
4 Symbols	7
5 Inspection and testing	8
6 Materials	8
7 Design	11
8 Construction and workmanship	16
9 Type approval procedure	18
10 Batch tests	20
11 Tests/examinations on every cylinder	29
12 Certification	30
13 Marking	30
Annex A (informative) Description and evaluation of manufacturing imperfections and conditions for rejection of seamless steel gas cylinders at time of final inspection by the manufacturer	31
Annex B (normative) Ultrasonic examination	37
Annex C (informative) Type approval certificate	43
Annex D (informative) Acceptance certificate	44
Annex NA (normative) Specific European requirements	46
Bibliography	48