ISO 9809-1:2010-04 (E)

Gas cylinders - Refillable seamless steel gas cylinders - Design, construction and t esting - Part 1: Quenched and tempered steel cylinders with tensile strength less than 1100 MPa

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Terms and definitions 2

4 Symbols 2

5 Inspection and testing 3

6 Materials 4

7 Design 7

8 Construction and workmanship 11

9 Type approval procedure 13

10 Batch tests 15

11 Tests/examinations on every cylinder 24

12 Certification 25

13 Marking 25

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 26

Annex B (normative) Ultrasonic examination 32

Annex C (informative) Type approval certificate 38

Annex D (informative) Acceptance certificate 39

Bibliography 41