

DIN EN ISO 24431:2017-07 (E)

Gas cylinders - Seamless, welded and composite cylinders for compressed and liquefied gases (excluding acetylene) - Inspection at time of filling (ISO 24431:2016)

| Contents | | Page |
|---|--|-----------|
| European foreword | | 3 |
| Foreword | | 4 |
| Introduction | | 5 |
| 1 Scope | | 6 |
| 2 Normative references | | 6 |
| 3 Terms and definitions | | 6 |
| 4 Identification of cylinder owner | | 9 |
| 5 Filling inspection | | 10 |
| 5.1 General..... | | 10 |
| 5.2 Verification of serviceable condition of individual cylinders before filling..... | | 10 |
| 5.2.1 General criteria..... | | 10 |
| 5.2.2 Exterior condition..... | | 10 |
| 5.2.3 Interior condition..... | | 12 |
| 5.2.4 Cylinder tare..... | | 12 |
| 5.2.5 Calculation of weight of gas to be filled into the cylinder..... | | 13 |
| 5.2.6 Provisions for visually inspecting cylinders fitted with coverings..... | | 13 |
| 5.2.7 Verification of the integrity of permanent attachments..... | | 14 |
| 5.2.8 Verification of valve integrity and suitability..... | | 14 |
| 5.2.9 Provisions for palletized cylinders..... | | 15 |
| 5.2.10 Rejected cylinders..... | | 15 |
| 5.3 Verification during filling..... | | 15 |
| 5.4 Verification after filling..... | | 15 |
| 5.4.1 General..... | | 15 |
| 5.4.2 Verification of gas tightness..... | | 15 |
| 5.4.3 Verification of correct filling pressure..... | | 16 |
| 5.4.4 Verification of correct filling weight..... | | 16 |
| 5.4.5 Verification of valve protection..... | | 16 |
| 5.4.6 Verification of correct product labelling..... | | 16 |
| 6 Cylinders rejected for filling | | 16 |
| Annex A (informative) Residual pressure check | | 17 |
| Annex B (informative) Example of a procedure to establish a correct tare | | 18 |
| Bibliography | | 19 |