

ISO 24431:2016-11 (E)

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

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Identification of cylinder owner	4
5	Filling inspection	5
5.1	General	5
5.2	Verification of serviceable condition of individual cylinders before filling	5
5.2.1	General criteria	5
5.2.2	Exterior condition	5
5.2.3	Interior condition	7
5.2.4	Cylinder tare	7
5.2.5	Calculation of weight of gas to be filled into the cylinder	8
5.2.6	Provisions for visually inspecting cylinders fitted with coverings	8
5.2.7	Verification of the integrity of permanent attachments	9
5.2.8	Verification of valve integrity and suitability	9
5.2.9	Provisions for palletized cylinders	10
5.2.10	Rejected cylinders	10
5.3	Verification during filling	10
5.4	Verification after filling	10
5.4.1	General	10
5.4.2	Verification of gas tightness	10
5.4.3	Verification of correct filling pressure	11
5.4.4	Verification of correct filling weight	11
5.4.5	Verification of valve protection	11
5.4.6	Verification of correct product labelling	11
6	Cylinders rejected for filling	11
Annex A (informative)	Residual pressure check	12
Annex B (informative)	Example of a procedure to establish a correct tare	13
Bibliography		14