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