

DIN EN 12807:2019-09 (E)

LPG equipment and accessories - Transportable refillable brazed steel cylinders for liquefied petroleum gas (LPG) - Design and construction

| Contents | | Page |
|-------------------------|-------------------------------------------------------------------------------------|-------------|
| European foreword | | 4 |
| Introduction | | 5 |
| 1 | Scope | 6 |
| 2 | Normative references | 6 |
| 3 | Terms, definitions and symbols | 7 |
| 3.1 | Terms and definitions | 7 |
| 3.2 | Symbols | 7 |
| 4 | Materials | 8 |
| 5 | Design | 9 |
| 5.1 | General requirements | 9 |
| 5.2 | Calculation of cylindrical shell thickness | 10 |
| 5.3 | Design of torispherical and semi-ellipsoidal ends concave to pressure | 10 |
| 5.4 | Design of ends of shapes other than torispherical and semi-ellipsoidal | 14 |
| 5.5 | Minimum wall thickness | 14 |
| 5.6 | Design of openings | 15 |
| 5.7 | Valve protection | 15 |
| 5.8 | Non-pressure containing attachments | 15 |
| 6 | Construction and workmanship | 15 |
| 6.1 | Brazing qualification | 15 |
| 6.2 | Plates and pressed parts | 16 |
| 6.3 | Brazed joints | 16 |
| 6.4 | Tolerances | 16 |
| 6.4.1 | Out of roundness | 16 |
| 6.4.2 | Straightness | 17 |
| 6.4.3 | Verticality | 17 |
| 6.5 | Heat treatment | 17 |
| 6.6 | Protective coating | 17 |
| 6.7 | Closure of openings | 17 |
| 7 | Tests and examinations | 17 |
| 7.1 | General | 17 |
| 7.2 | Types of test and evaluation of the test results | 17 |
| 7.3 | Material testing | 18 |
| 7.4 | Tensile test | 19 |
| 7.4.1 | Parent material | 19 |
| 7.4.2 | Joints | 20 |
| 7.5 | Bend test | 20 |
| 7.5.1 | Procedure | 20 |
| 7.5.2 | Requirements | 21 |
| 7.6 | Burst test under hydraulic pressure | 22 |
| 7.6.1 | Procedure | 22 |
| 7.6.2 | Requirements | 23 |
| 7.7 | Pressure test | 24 |
| 7.7.1 | Procedure | 24 |

| | | |
|--------|--------------------------------------------------------------------------------|----|
| 7.7.2 | Requirements | 24 |
| 7.8 | Ultrasonic examination | 24 |
| 7.8.1 | Procedure | 24 |
| 7.8.2 | Assessment | 24 |
| 7.8.3 | Requirements | 24 |
| 7.9 | Macro examination | 24 |
| 7.9.1 | Procedure | 24 |
| 7.9.2 | Requirements | 25 |
| 7.10 | Visual examination of the surface of the joint | 25 |
| 7.10.1 | Procedure | 25 |
| 7.10.2 | Requirements | 25 |
| 7.11 | Fatigue test | 25 |
| 7.11.1 | Procedure | 25 |
| 7.11.2 | Requirement | 25 |
| 8 | Technical requirements for type approval | 25 |
| 8.1 | Extent of testing | 25 |
| 8.2 | Cylinder types | 26 |
| 8.3 | Type approval certificate | 26 |
| 9 | Production testing and examination requirements | 27 |
| 9.1 | Tests and examinations applicable to all cylinders | 27 |
| 9.2 | Ultrasonic examination | 27 |
| 9.3 | Macro examination | 27 |
| 9.4 | Examination of the valve boss joint | 27 |
| 9.5 | Examination of non-pressure containing joints | 27 |
| 9.6 | Unacceptable imperfections found by the ultrasonic or macro examinations | 28 |
| 9.7 | Batch testing (Mechanical / Burst tests) | 28 |
| 9.7.1 | Batch | 28 |
| 9.7.2 | Inspection lots | 28 |
| 9.7.3 | Rate of sampling | 28 |
| 9.7.4 | Additional checks | 29 |
| 9.8 | Failure to meet mechanical and burst test requirements | 30 |
| 9.8.1 | Mechanical | 30 |
| 9.8.2 | Burst | 30 |
| 9.8.3 | Re-test | 30 |
| 9.8.4 | Resubmission of an inspection lot | 30 |
| 10 | Marking | 31 |
| 11 | Certificates | 31 |
| | Bibliography | 32 |