

# DIN EN ISO 9809-3:2020-02 (E)

## Gas cylinders - Design, construction and testing of refillable seamless steel gas cylinders and tubes - Part 3: Normalized steel cylinders and tubes (ISO 9809-3:2019)

<b>Contents</b>		<b>Page</b>
European foreword.....		4
Foreword.....		5
Introduction.....		6
<b>1</b>	<b>Scope</b> .....	<b>7</b>
<b>2</b>	<b>Normative references</b> .....	<b>7</b>
<b>3</b>	<b>Terms and definitions</b> .....	<b>7</b>
<b>4</b>	<b>Symbols</b> .....	<b>9</b>
<b>5</b>	<b>Inspection and testing</b> .....	<b>10</b>
<b>6</b>	<b>Materials</b> .....	<b>10</b>
6.1	General requirements.....	10
6.2	Controls on chemical composition.....	11
6.3	Heat treatment.....	12
6.4	Failure to meet test requirements.....	12
<b>7</b>	<b>Design</b> .....	<b>13</b>
7.1	General requirements.....	13
7.2	Design of cylindrical shell thickness.....	13
7.3	Design of convex ends (heads and bases).....	14
7.4	Design of concave base ends.....	16
7.5	Neck design.....	16
7.6	Foot rings.....	17
7.7	Neck rings.....	17
7.8	Design drawing.....	17
<b>8</b>	<b>Construction and workmanship</b> .....	<b>17</b>
8.1	General.....	17
8.2	Wall thickness.....	17
8.3	Surface imperfections.....	17
8.4	Ultrasonic examination.....	18
8.5	Out-of-roundness.....	18
8.6	Mean diameter.....	18
8.7	Straightness.....	18
8.8	Verticality and stability.....	18
8.9	Neck threads.....	19
<b>9</b>	<b>Type approval procedure</b> .....	<b>19</b>
9.1	General requirements.....	19
9.2	Prototype tests.....	20
9.2.1	General requirements.....	20
9.2.2	Hydraulic burst test.....	21
9.2.3	Pressure cycling test.....	24
9.2.4	Base check.....	24
9.2.5	Bend test and flattening test.....	25
9.2.6	Torque test for taper thread only.....	26
9.2.7	Shear stress calculation for parallel threads.....	26
9.3	Type approval certificate.....	27

<b>10</b>	<b>Batch tests</b> .....	<b>27</b>
	10.1 General requirements .....	27
	10.2 Tensile test .....	28
	10.3 Impact test .....	29
<b>11</b>	<b>Tests/examinations on every cylinder</b> .....	<b>31</b>
	11.1 General .....	31
	11.2 Hydraulic test .....	31
	11.2.1 Proof pressure test .....	31
	11.2.2 Volumetric expansion test .....	31
	11.3 Hardness test .....	32
	11.4 Leak test .....	32
	11.5 Capacity check .....	32
<b>12</b>	<b>Certification</b> .....	<b>33</b>
<b>13</b>	<b>Marking</b> .....	<b>33</b>
	<b>Annex A (normative) Description and evaluation of manufacturing imperfections in seamless gas cylinders</b> .....	<b>34</b>
	<b>Annex B (normative) Ultrasonic examination</b> .....	<b>48</b>
	<b>Annex C (informative) Example of type approval certificate</b> .....	<b>53</b>
	<b>Annex D (informative) Example of acceptance certificate</b> .....	<b>54</b>
	<b>Annex E (informative) Bend stress calculation</b> .....	<b>57</b>
	<b>Annex F (informative) An example of shear strength calculation for parallel threads</b> .....	<b>58</b>
	<b>Bibliography</b> .....	<b>60</b>