ISO 9809-2:2019 (E)

Gas cylinders — Design, construction and testing of refillable seamless steel gas cylinders and tubes — Part 2: Quenched and tempered steel cylinders and tubes with tensile strength greater than or equal to 1 100 MPa

Contents

Foreword

Introduction

1 Scope

2 Normative references

3 Terms and definitions

4 Symbols

5 Inspection and testing

6 Materials

6.1 General requirements
6.2 Controls on chemical composition
6.3 Heat treatment
6.4 Failure to meet test requirements

7 Design

7.1 General requirements
7.2 Limitation on tensile strength
7.3 Design of cylindrical shell thickness
7.4 Design of convex ends (heads and bases)
7.5 Design of concave base ends
7.6 Neck design
7.7 Foot rings
7.8 Neck rings
7.9 Design drawing

8 Construction and workmanship

8.1 General
8.2 Wall thickness
8.3 Surface imperfections
8.4 Ultrasonic examination
8.5 Out-of-roundness
8.6 Mean diameter
8.7 Straightness
8.8 Verticality and stability
8.9 Neck threads

9 Type approval procedure

9.1 General requirements
9.2 Prototype tests
9.2.1 General requirements
9.2.2 Verification of hardness/tensile correlation
9.2.3 Pressure cycling test
9.2.4 Flawed cylinder burst test
9.2.4.1 General
9.2.4.2 Details of flaw
9.2.4.3 Test procedure

9.2.4.4 Acceptance criteria for the flawed cylinder burst test
9.2.5 Flawed cylinder cycle test
9.2.5.1 Test conditions
9.2.5.2 Details of flaw
9.2.5.3 Acceptance criteria for the flawed cylinder cycle test
9.2.6 Base check
9.2.7 Bend test and flattening test
9.2.7.1 Bend test
9.2.7.2 Flattening test
9.2.7.3 Ring flattening test
9.2.8 Torque test for taper thread only
9.2.8.1 Procedure
9.2.8.2 Acceptance criteria
9.2.9 Shear stress calculation for parallel threads
9.2.9.1 Procedure
9.2.9.2 Acceptance criteria
9.3 Type approval certificate

10 Batch tests

10.1 General requirements
10.2 Tensile test
10.3 Impact test
10.4 Hydraulic bursting test
10.4.1 Test installation
10.4.2 Test conditions
10.4.3 Interpretation of test results

11 Tests/examinations on every cylinder

11.1 General
11.2 Hydraulic test
11.2.1 Proof pressure test
11.2.2 Volumetric expansion test
11.3 Hardness test
11.4 Leak test
11.5 Capacity check

12 Certification

13 Marking

Annex A (normative) Description and evaluation of manufacturing imperfections in seamless gas cylinders

A.1 Overview
A.2 General
A.3 Manufacturing imperfections and the procedure for their evaluation
A.4 Acceptance and rejection conditions

Annex B (normative) Ultrasonic examination

B.1 General
B.2 General requirements
B.3 Flaw detection of the cylindrical parts
B.3.1 Procedure
B.3.2 Reference standard
B.3.3 Calibration of equipment
B.4 Wall thickness measurement
B.5 Interpretation of results
B.6 Certification

Annex C (informative) Example of type approval certificate

Annex D (informative) Example of acceptance certificate

Annex E (informative) Bend stress calculation

Annex F (informative) An example of shear strength calculation for parallel threads