

DIN EN 13110:2023-02 (E)

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

Contents		Page
European foreword		5
Introduction		6
1	Scope	7
2	Normative references	7
3	Terms, definitions and symbols	8
3.1	Terms and definitions	8
3.2	Symbols	9
4	Materials	10
5	Design	11
5.1	General requirements	11
5.2	Calculation of cylindrical wall thickness	11
5.3	Design of ends concave to pressure	12
5.4	Other shapes of ends	12
5.5	Minimum wall thickness	13
5.6	Design of openings	13
5.7	Neck design	13
5.8	Stability	17
5.9	Valve protection	17
6	Construction and workmanship	17
6.1	Environment	17
6.2	Welding qualification	17
6.3	Plates and pressed parts	18
6.4	Welded joints	18
6.5	Tolerances	18
6.5.1	Out of roundness	18
6.5.2	Wall thickness	18
6.5.3	Straightness	18
6.5.4	Verticality	18
6.6	Non-pressure bearing attachments	18
6.7	Heat treatment	19
6.8	Closure of openings	19
7	Testing and examination	20
7.1	General	20
7.2	Types of test and evaluation of test results	20
7.3	Test specimens and related tests and examinations	21
7.3.1	Two piece cylinders	21
7.3.2	Three piece cylinders	21
7.3.3	Valve boss welds	21
7.4	Tensile test	23
7.4.1	General	23
7.4.2	Parent material	23
7.4.3	Welds	23
7.5	Bend test	23

7.5.1	Bend test on parent material	23
7.5.2	Bend test across the welds	24
7.5.3	Nick-break test across the welds	24
7.6	Macroscopic examination of welds	26
7.6.1	Procedure	26
7.6.2	Requirements	26
7.7	Burst test under hydraulic pressure	27
7.7.1	Procedure	27
7.7.2	Requirements	28
7.8	Fatigue test	28
7.8.1	Procedure	28
7.8.2	Requirements	29
7.9	Drop test	29
7.9.1	Procedure	29
7.9.2	Requirements	29
7.10	Visual examination	30
7.10.1	Procedure	30
7.10.2	Requirements	30
7.11	Radiographic examination	30
7.11.1	Procedure	30
7.11.2	Assessment	30
7.11.3	Requirements	30
7.12	Pressure test	30
7.12.1	Procedure	30
7.12.2	Requirements	31
8	Technical requirements for type approval	32
8.1	New cylinder design	32
8.2	Extent of testing	32
8.3	Type approval certificate	33
9	Production testing and examination requirements	33
9.1	Tests and examinations applicable to all cylinders	33
9.2	Radiographic examination	34
9.3	Macro examination	34
9.4	Examination of valve boss weld	34
9.5	Examination of non-pressure containing attachment welds	34
9.6	Unacceptable imperfections found by radiographic or macro examinations	34
9.7	Production batch testing (mechanical/burst tests)	35
9.7.1	Production batch	35
9.7.2	Inspection lots	36
9.7.3	Rate of sampling	36
9.7.4	Additional checks	37
9.8	Failure to meet mechanical and burst test requirements	37
9.8.1	Mechanical	37
9.8.2	Burst	37
9.8.3	Production batch retest	37
9.8.4	Resubmission of a production batch	38
9.8.5	Weld repairs	38
10	Marking	38
Annex A (normative)	Corrosion tests	39
A.1	Test for assessing susceptibility to intercrystalline corrosion	39
A.1.1	Specimens	39
A.1.2	Pre-treatment of the specimen before corrosive etching	39
A.1.3	Corrosive etching process	40
A.1.4	Preparation of specimens for examination - Method	41
A.1.5	Micrographic examination of specimens	41
A.1.6	Interpretation of the micrographic examination	41
A.2	Tests for assessing susceptibility to stress corrosion	41

A.2.1	Specimens	41
A.2.2	Surface preparation before test	41
A.2.3	Method	42
A.2.4	Interpretation of the results	46
A.2.5	Metallographical examination (additional examination)	46
A.3	Conclusion of corrosion tests	46
A.4	Test report	46
	Bibliography	47