DIN EN 13322-1:2024-07 (E)

Transportable gas cylinders - Refillable welded steel gas cylinders - Design and construction - Part 1: Carbon steel

Contents

Page

European foreword 3

Introduction 5

1 Scope 6

2 Normative references 6

3 Terms and definitions 7

4 Materials and heat treatment 10

5 Design 10

6 Construction and workmanship 14

7 New design tests 17

8 Batch tests 20

9 Tests on every cylinder 27

10 Failure to meet test requirements 27

11 Records 28

12 Marking 28

Annex A (normative) Cylinder shells for acetylene service made from longitudinal seam high frequency induction (HFI) welded tube by spinning of the end 29

Annex B (normative) Radiographic examination of welds 31

Annex C (normative) Description, evaluation of manufacturing defects and conditions for rejection of welded steel gas cylinders at time of visual inspection 34

Annex D (informative) Examples of design and batch test certificates 37

Bibliography 44