
**Nuclear energy — Packagings for the
transport of uranium hexafluoride
(UF₆)**

*Energie nucléaire — Emballages pour le transport de l'hexafluorure
d'uranium (UF₆)*



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 85, *Nuclear energy, nuclear technologies, and radiological protection*, Subcommittee SC 5, *Nuclear installations, processes and fuel technologies, WG4, Transport of radioactive material*.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

This third edition cancels and replaces the second edition (ISO 7195:2005), which has been technically revised. The main changes compared to the previous edition are:

- The title of the document has been slightly changed to better reflect its scope;
- The general structure of the document has been partly reorganized to enhance clarity and to ease comparison with ANSI N14.1;
- The cylinder model 48G has been removed and the cylinder model 30C added;
- The socket head plugs for 30 in and 48 in cylinders have been added (alternative to hex head plugs);
- The list of references and the list of terms and definitions used have been updated;
- “Quality assurance programme” has been replaced by “management system”;
- Clauses related to manufacture, periodic inspection and recertification have been redrafted for better clarity;
- The possibility for 30B, 48X and 48Y cylinders to use non-destructive examinations as an alternative to hydrostatic testing during their periodic inspections, with the condition that additional examinations are carried out at the time of their manufacturing, has been introduced;
- The use of leak test methods other than the specified one is now permitted;

- The existing tie down requirements have been replaced by a reference to the new Appendix IV of IAEA SSG-26;
- The reuse of valves and plugs removed from cylinders is no longer permitted;
- All the figures have been revised to correct errors, increase clarity and add missing information.

Introduction

The transport of uranium hexafluoride (UF_6) is an essential operation in the nuclear industry. The packaging and transport of UF_6 is subject to the relevant transport regulations for dangerous goods of each of the countries through or into which the material is transported. This document does not take precedence over applicable regulations, nor does it relieve the consignor and other parties from compliance with these regulations. For more detailed information, the user of this document is encouraged to consult the appropriate regulatory document.

According to IAEA Regulations for the Safe Transport of Radioactive Material (SSR-6), and all regulations based on, except as allowed in its para. 634, uranium hexafluoride in quantities of 0,1 kg or more is required to be packaged and transported in accordance with the provisions of this document.

ANSI N14.1 has been used internationally as an industry reference and the standard cylinders included in ANSI N14.1 have been used widely for international transport of UF_6 . However, in some cases minor adaptations of the American standard were required to meet local conditions in a particular country. For example, equivalent materials may have been used instead of the materials specified. Moreover, the certification of cylinders as pressure vessels can have required equivalent authorization procedures appropriate in the countries concerned, rather than the US procedure specified.

This document presents primarily information on UF_6 packagings (including cylinders and valve protection). It is intended to provide for compatibility of UF_6 cylinders among different users within the nuclear industry. It has been developed from ANSI N14.1, but with incorporation of, and allowance for, other equivalent materials and national certification procedures.

Throughout this document and in conformity with standard ISO practice, SI metric units are used in preference to imperial units (which are given in parenthesis for information). However, generic cylinder designations are based on the diameter expressed in imperial units (48" for instance).

If a common, commercially available component uses features that are defined in an appropriate non-SI metric-based Standard document, only the relevant base units are quoted.

Nuclear energy — Packagings for the transport of uranium hexafluoride (UF₆)

1 Scope

This document provides the following:

- specifications for cylinders for the transport of uranium hexafluoride (UF₆) to provide compatibility among different users,
- description of cylinder designs, but is not intended to develop new designs,
- fabrication requirements for the procurement of new cylinders designed for the transport of 0,1 kg or more of uranium hexafluoride,
- fabrication requirements for the procurement of new valve protections, valves and plugs, and
- requirements for cylinders and valve protections in service.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitute requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 263, *ISO inch screw threads — General plan and selection for screws, bolts and nuts — Diameter range 0,06 to 6 in*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method*

ISO 9712, *Non-destructive testing — Qualification and certification of NDT personnel*

ISO 12807, *Safe transport of radioactive materials — Leakage testing on packages*

ANSI/ASME B1.1, *Unified Inch Screw Threads (UN and UNR Thread Form)*

ANSI/ASME B1.5, *Acme Screw Threads*

ANSI/ASME B1.20.1, *Pipe Threads, General Purpose (Inch)*

ANSI/ASME B16.11, *Forged Steel Fittings, Socket-Welding and Threaded*

ANSI/AWS A5.8M/A5.8, *Specification for Filler Metals for Brazing and Braze Welding*

ANSI/AWS A5.14/A5.14M, *Specification for Nickel and Nickel-Alloy Bare Welding Electrodes and Rods*

ANSI/AWS D1.1/D1.1M, *Structural Welding Code — Steel*

ANSI/CGA V-1, *Standard for Compressed Gas Cylinder Valve Outlet and Inlet Connections*

ASTM A20/A20M, *Standard Specification for General Requirements for Steel Plates for Pressure Vessels*

ASTM A36/A36M, *Standard Specification for Carbon Structural Steel*

ASTM A53/A53M, *Standard Specification for Pipe, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless*

ASTM A105/A105M, *Standard Specification for Carbon Steel Forgings for Piping Applications*

ASTM A106/A106M, Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service

ASTM A108, Standard Specification for Steel Bar, Carbon and Alloy, Cold-Finished

ASTM A131/A131M, Standard Specification for Structural Steel for Ships

ASTM A193/A193M, Standard Specification for Alloy-Steel and Stainless Steel Bolting Materials for High Temperature or High Pressure Service and Other Special Purpose Applications

ASTM A234/A234M, Standard Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperature Service

ASTM A240/A240M, Standard Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels and for General Applications

ASTM A285/A285M, Standard Specification for Pressure Vessel Plates, Carbon Steel, Low and Intermediate-Tensile Strength

ASTM A354, Standard Specification for Quenched and Tempered Alloy Steel Bolts, Studs, and Other Externally Threaded Fasteners

ASTM A516/A516M, Standard Specification for Pressure Vessel Plates, Carbon Steel for Moderate- and Lower-Temperature Service

ASTM A574, Standard Specification for Alloy Steel Socket-Head Cap Screws

ASTM A575, Standard Specification for Steel Bars, Carbon, Merchant Quality, M-Grades

ASTM B16/B16M, Standard Specification for Free-Cutting Brass Rod, Bar and Shapes for Use in Screw Machines

ASTM B32, Standard Specification for Solder Metal

ASTM B127, Standard Specification for Nickel-Copper Alloy (UNS N04400) Plate, Sheet, and Strip

ASTM B150/B150M, Standard Specification for Aluminum Bronze Rod, Bar, and Shapes

ASTM B160, Standard Specification for Nickel Rod and Bar

ASTM B161, Standard Specification for Nickel Seamless Pipe and Tube

ASTM B162, Standard Specification for Nickel Plate, Sheet, and Strip

ASTM B164, Standard Specification for Nickel-Copper Alloy Rod, Bar, and Wire

ASTM B165, Standard Specification for Nickel-Copper Alloy (UNS N04400) Seamless Pipe and Tube

ASTM B209, Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate

ASTM B211, Standard Specification for Aluminum and Aluminum-Alloy Bar, Rod, and Wire

ASTM B249/B249M, Standard Specification for General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, Shapes and Forgings

ASTM B366/B366M, Standard Specification for Factory-Made Wrought Nickel and Nickel Alloy Fittings

ASTM E2375, Standard Practice for Ultrasonic Examination of Wrought Products

IAEA SSR-6, Regulations for the Safe Transport of Radioactive Material

SAE J512, Automotive Tube Fittings

SAE J513, Refrigeration Tube Fittings — General Specifications

NUREG/CR-6407, *Classification of Transportation Packaging and Dry Spent Fuel Storage System Components According to Importance to Safety*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in the IAEA SSR-6 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

NOTE 1 Units are those of the International System, with other units shown in brackets for information.

NOTE 2 Throughout this document, the words *suggested* and *typical* denote an example for weld constructions, dimensions and/or layout, and means that other solutions may be used provided they comply with the requirements in the code and this document, as appropriate.

NOTE 3 Throughout this document, the words *nominal* and *Schedule* qualify a thickness of a material from stock (plate, bar, pipe, etc.), for which the tolerance is according to the standard specification for the relevant material.

3.1

authorized inspector

individual who is qualified by the jurisdictional authority/inspection authority as requested by the code

3.2

clean and washed out cylinder

cylinder that has been previously used and has been cleaned to remove residual quantities of uranium and other contaminants

3.3

code

pressure vessel code that is acceptable to the transport competent authority

EXAMPLE Section VIII of ANSI/ASME Boiler and Pressure Vessel Code is an example.

3.4

competent authority

national or international regulatory body or authority designated or otherwise recognized as such for any purpose in connection with the relevant transport regulations for dangerous goods

3.5

competent inspector

individual who is qualified according to the owner's requirements regarding inspection activities as detailed in its quality assurance program

3.6

cylinder

pressure vessel, equipped with its valves and plugs, as applicable

3.7

fabricator

manufacturer, repairer, or modifier of cylinders and valve protection

3.8

heel

residual amount of UF₆ and/or non-volatile reaction products of uranium