

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

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 13110:2012+A1:2017 sisaldab Euroopa standardi EN 13110:2012+A1:2017 ingliskeelset teksti.	This Estonian standard EVS-EN 13110:2012+A1:2017 consists of the English text of the European standard EN 13110:2012+A1:2017.
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English Version

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

Equipements pour gaz de pétrole liquéfiés et leurs
accessoires - Bouteilles soudées transportables et
rechargeables en aluminium pour gaz de pétrole
liquéfié (GPL) - Conception et construction

Flüssiggas-Geräte und Ausrüstungsteile -
Ortsbewegliche wiederbefüllbare geschweißte
Flaschen aus Aluminium für Flüssiggas (LPG) -
Auslegung und Bau

This European Standard was approved by CEN on 13 April 2012 and includes Amendment 1 approved by CEN on 3 January 2017.

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Contents

Page

European foreword.....	5
Introduction	5
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.....	9
5 Design	11
5.1 General requirements	11
5.2 Calculation of cylindrical wall thickness	11
5.3 Design of ends concave to pressure.....	11
5.4 Other shapes of ends.....	12
5.5 Minimum wall thickness.....	12
5.6 Design of openings.....	12
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
6.6 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	29
7.10.1	Procedure	29
7.10.2	Requirements.....	29
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.....	30
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	36
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	37
9.8.5	Weld repairs	38
10	Marking	38
11	Certificate of Conformity.....	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.1.2.1 Chemicals required	39
A.1.2.2 Method	39
A.1.3 Corrosive etching process	40
A.1.3.1 Chemicals required	40
A.1.3.2 Method	40
A.1.4 Preparation of specimens for examination	41
A.1.4.1 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.2.3.1 Preparation of the corrosive solution	42
A.2.3.2 Applying the stress to the specimen.....	44
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.....	48

European foreword

This document (EN 13110:2012+A1:2017) has been prepared by Technical Committee CEN/TC 286 “Liquefied petroleum gas equipment and accessories”, the secretariat of which is held by NSAI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by July 2017, and conflicting national standards shall be withdrawn at the latest by July 2017.

This document includes Amendment 1 approved by CEN on 03 January 2017.

This document supersedes A1 EN 13110:2012 A1.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 13110:2002.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association, and supports essential requirements of EU Directive(s).

This standard has been submitted for reference into the RID and/or in the technical annexes of ADR (see [9] and [8]).

The main technical changes to this revision include the addition of:

- reference to the latest welding standards;
- the introduction of radioscopy as a permitted alternative to radiographic examination of welds;
- simplification of the marking requirements by reference to EN 14894; and
- environmental considerations recorded in Annex B.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Introduction

This European Standard calls for the use of substances and procedures that may be injurious to health and/or the environment if adequate precautions are not taken. It refers only to technical suitability: it does not absolve the user from their legal obligations at any stage.

A1 Protection of the environment is a key political issue in Europe and elsewhere. For CEN/TC 286, this is covered in CEN/TS 16765. This Technical Specification should be read in conjunction with this European Standard. **A1**

It is recommended that manufacturers develop an environmental management policy. For guidance see ISO 14000- series.

Provisions need to be restricted to a general guidance. Limit values are specified in national laws.

It has been assumed in the drafting of this European Standard that the execution of its provisions is entrusted to appropriately qualified and experienced people.

All pressures are gauged unless otherwise stated.

NOTE This European Standard requires measurement of material properties, dimensions and pressures. All such measurements are subject to a degree of uncertainty due to tolerances in measuring equipment etc. It may be beneficial to refer to the leaflet "measurement uncertainty leaflet" SP INFO 2000 27 [11].

1 Scope

This European Standard specifies minimum requirements for material, design, construction and workmanship, testing and examination during the manufacture of transportable refillable welded aluminium liquefied petroleum gas (LPG) cylinders, having a water capacity from 0,5 l up to and including 150 l, exposed to ambient temperature.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10204:2004, *Metallic products - Types of inspection documents*

EN 12816, *LPG equipment and accessories - Transportable refillable LPG cylinders - Disposal*

EN 14717, *Welding and allied processes - Environmental check list*

EN 14784-1, *Non-destructive testing - Industrial computed radiography with storage phosphor imaging plates - Part 1: Classification of systems*

EN 14784-2, *Non-destructive testing - Industrial computed radiography with storage phosphor imaging plates - Part 2: General principles for testing of metallic materials using X-rays and gamma rays*

EN 14894, *LPG equipment and accessories - Cylinder and drum marking*

EN ISO 4136, *Destructive tests on welds in metallic materials - Transverse tensile test (ISO 4136)*

EN ISO 5173, *Destructive tests on welds in metallic materials - Bend tests (ISO 5173)*

EN ISO 5178, *Destructive tests on welds in metallic materials - Longitudinal tensile test on weld metal in fusion welded joints (ISO 5178)*

EN ISO 6892-1, *Metallic materials - Tensile testing - Part 1: Method of test at room temperature (ISO 6892-1)*

EN ISO 9606-2, *Qualification test of welders - Fusion welding - Part 2: Aluminium and aluminium alloys (ISO 9606-2)*

EN ISO 9712:2012, *Non-destructive testing - Qualification and certification of NDT personnel (ISO 9712:2012)*

EN ISO 10042:2005, *Welding - Arc-welded joints in aluminium and its alloys - Quality levels for imperfections (ISO 10042:2005)*

EN ISO 11114-1, *Gas cylinders - Compatibility of cylinder and valve materials with gas contents - Part 1: Metallic materials (ISO 11114-1)*

EN ISO 11117:2008, *Gas cylinders - Valve protection caps and valve guards - Design, construction and tests (ISO 11117:2008)*

EN ISO 11363-1, *Gas cylinders - 17E and 25E taper threads for connection of valves to gas cylinders - Part 1: Specifications (ISO 11363-1)*

EN ISO 14731, *Welding coordination - Tasks and responsibilities (ISO 14731:2006)*

Ⓐ EN ISO 14732, *Welding personnel — Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials (ISO 14732) Ⓐ*

EN ISO 15607, *Specification and qualification of welding procedures for metallic materials - General rules (ISO 15607)*

EN ISO 15609-1, *Specification and qualification of welding procedures for metallic materials - Welding procedure specification - Part 1: Arc welding (ISO 15609-1)*

EN ISO 15614-2, *Specification and qualification of welding procedures for metallic materials - Welding procedure test - Part 2: Arc welding of aluminium and its alloys (ISO 15614-2)*

Ⓐ EN ISO 17636-1:2013, *Non-destructive testing of welds — Radiographic testing — Part 1: X- and gamma-ray techniques with film (ISO 17636-1:2013)*

EN ISO 17636-2:2013, *Non-destructive testing of welds - Radiographic testing - Part 2: X- and gamma-ray techniques with digital detectors (ISO 17636-2:2013) Ⓐ*

EN ISO 17637, *Non-destructive testing of welds - Visual testing of fusion-welded joints (ISO 17637)*

Ⓐ EN ISO 17639, *Destructive tests on welds in metallic materials Macroscopic and microscopic examination of welds (ISO 17639)*

EN ISO 19232-1, *Non-destructive testing - Image quality of radiographs - Part 1: Determination of the image quality value using wire-type image quality indicators (ISO 19232-1)*

EN ISO 19232-2, *Non-destructive testing - Image quality of radiographs - Part 2: Determination of the image quality value using step/hole-type image quality indicators (ISO 19232-2) Ⓐ*

3 Terms, definitions and symbols

3.1 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1.1

liquefied petroleum gas

LPG

low pressure liquefied gas composed of one or more light hydrocarbons which are assigned to UN 1011, UN 1075, UN 1965, UN 1969 or UN 1978 only and which consists mainly of propane, propene, butane, butane isomers, butene with traces of other hydrocarbon gases

3.1.2

cylinder

Ⓐ transportable pressure receptacle with a water capacity not exceeding 150 l Ⓐ