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**Gas cylinders - Non-refillable metallic gas cylinders -  
Specification and test methods (ISO 11118:2015)**

**EESTI STANDARDI EESSÕNA****NATIONAL FOREWORD**

See Eesti standard EVS-EN ISO 11118:2015 sisaldab Euroopa standardi EN ISO 11118:2015 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 11118:2015 consists of the English text of the European standard EN ISO 11118:2015.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 21.10.2015.	Date of Availability of the European standard is 21.10.2015.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

Tagasisidet standardi sisu kohta on võimalik edastada, kasutades EVS-i veebilehel asuvat tagasiside vormi või saates e-kirja meiliaadressile [standardiosakond@evs.ee](mailto:standardiosakond@evs.ee).

ICS 23.020.30

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EUROPEAN STANDARD

**EN ISO 11118**

NORME EUROPÉENNE

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English Version

## Gas cylinders - Non-refillable metallic gas cylinders - Specification and test methods (ISO 11118:2015)

Bouteilles à gaz - Bouteilles à gaz métalliques non  
rechargeables - Spécifications et méthodes d'essai (ISO  
11118:2015)

Gasflaschen - Metallische Einwegflaschen -  
Festlegungen und Prüfverfahren (ISO 11118:2015)

This European Standard was approved by CEN on 22 August 2015.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

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## European foreword

This document (EN ISO 11118:2015) has been prepared by Technical Committee ISO/TC 58 "Gas cylinders" in collaboration with the Technical Committee CEN/TC 23 "Transportable gas cylinders" the secretariat of which is held by BSI.

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 April 2016, and conflicting national standards shall be withdrawn at the latest by April 2016.

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 ISO 13340:2001 and EN 12205:2001.

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, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

### Endorsement notice

The text of ISO 11118:2015 has been approved by CEN as EN ISO 11118:2015 without any modification.

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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](http://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](http://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 on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary Information](#)

The committee responsible for this document is ISO/TC 58, *Gas cylinders*, Subcommittee SC 3, *Cylinder design*.

This second edition cancels and replaces the first edition (ISO 11118:1999) and ISO 13340:2001, which have been technically revised with the following changes:

- removed references to dissolved gases from the Scope;
- the edition aligns ISO 11118 and EN 12205;
- incorporates ISO 13340 in ISO 11118;
- incorporated new titles of ISO referenced documents;
- incorporated definitions and use of  $R_{ea}$ ,  $R_{eg}$ ,  $R_{ma}$ , and  $R_{mg}$ ;
- clarified requirements for the processing of carbon steel to avoid strain aging;
- added pierceable metal membranes to cylinder non-refillability;
- added test requirement for aluminium materials for intercrystalline corrosion for seamless and welded aluminium cylinders;
- included alternative temperatures for artificial aging of carbon steel cylinder prior to burst testing;
- modified markings to align with UN requirements;
- clarified inspection criteria for each cylinder;
- corrected references to correct Annexes;
- modified burst pressure to align with other ISO Standards;
- aligned test pressure requirement of non-refillable sealing device to the same as the cylinder;

- modified [Annex B](#) for completeness;
- deleted existing Annex C since it was not needed and inserted a new [Annex C](#) for accuracy;
- added new informative [Annex D](#) for informational purposes on yield point elongation (YPE).

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## Introduction

This International Standard addresses the general requirements on design, construction, and initial inspection and testing of non-refillable metallic gas cylinders and their non-refillable sealing devices of the United Nations Recommendations on the Transport of Dangerous Goods: Model Regulations. The purpose of this International Standard is to provide a specification for the design, manufacture, inspection, and testing of non-refillable metallic gas cylinders for worldwide safe use, handling, and transport.

The objective is to balance design and economic efficiency against international acceptance and universal utility.

This International Standard aims to eliminate the concern about climate, duplicate inspections, and restrictions currently existing because of lack of definitive International Standards. This International Standard does not reflect on the suitability of the practice of any nation or region.

# Gas cylinders — Non-refillable metallic gas cylinders — Specification and test methods

## 1 Scope

This International Standard specifies minimum requirements for the material, design, inspections, construction and workmanship, manufacturing processes, and tests at manufacture of non-refillable metallic gas cylinders of welded, brazed, or seamless construction for compressed and liquefied gases including the requirements for their non-refillable sealing devices and their methods of testing.

NOTE The specific gases permitted in cylinders constructed to this International Standard can be limited by national or international requirements.

This International Standard is applicable to cylinders where

- a) the test pressure does not exceed 250 bar (i.e.  $p_h \leq 250$  bar) for liquefied gases and 450 bar for compressed gases;
- b) the product of the test pressure and the water capacity does not exceed 1 000 bar·litres (i.e.  $p_h V \leq 1\,000$  bar L);
- c) the test pressure exceeds 45 bar and the water capacity does not exceed 5 l (i.e. for  $p_h > 45$  bar, then  $V \leq 5$  l).

## 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.

ISO 3651-2, *Determination of resistance to intergranular corrosion of stainless steels — Part 2: Ferritic, austenitic and ferritic-austenitic (duplex) stainless steels — Corrosion test in media containing sulfuric acid*

ISO 4706:2008, *Gas cylinders — Refillable welded steel cylinders — Test pressure 60 bar and below*

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

ISO 7866:2012, *Gas cylinders — Refillable seamless aluminium alloy gas cylinders — Design, construction and testing*

ISO 9329-1, *Seamless steel tubes for pressure purposes — Technical delivery conditions — Part 1: Unalloyed steels with specified room temperature properties*

ISO 9606-1, *Qualification testing of welders — Fusion welding — Part 1: Steels*

ISO 9809-1:2010, *Gas cylinders — Refillable seamless steel gas cylinders — Design, construction and testing — Part 1: Quenched and tempered steel cylinders with tensile strength less than 1 100 MPa*

ISO 9809-4:2014, *Gas cylinders — Refillable seamless steel gas cylinders — Design, construction and testing — Part 4: Stainless steel cylinders with an  $R_m$  value of less than 1 100 MPa*

ISO 10156, *Gases and gas mixtures — Determination of fire potential and oxidizing ability for the selection of cylinder valve outlets*

ISO 10297, *Gas cylinders — Cylinder valves — Specification and type testing*

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

ISO 11114-2, *Gas cylinders — Compatibility of cylinder and valve materials with gas contents — Part 2: Non-metallic materials*

ISO 15613, *Specification and qualification of welding procedures for metallic materials — Qualification based on pre-production welding test*

ISO 15614-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure test — Part 1: Arc and gas welding of steels and arc welding of nickel and nickel alloys*

ISO 20703:2006, *Gas cylinders — Refillable welded aluminium-alloy cylinders — Design, construction and testing*

### 3 Terms and definitions

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

#### 3.1 batch

quantity of completed and pressure tested cylinders made consecutively by the same manufacturer using the same manufacturing techniques to the same design, size, and material specifications using the same type of welding machines (when applicable), welding procedures (when applicable), and to the same heat treatment conditions (when applicable)

Note 1 to entry: See [Clause 10](#) for details.

#### 3.2 cylindrical shell

portion of the cylinder excluding the cylinder ends which is parallel to the centreline axis of the cylinder

#### 3.3 cylinder shell

empty cylinder before affixing the *non-refillable sealing device* ([3.12](#)), but including all other permanent attachments

#### 3.4 material certificate

document issued by the material manufacturer which certifies the chemical analysis, mechanical properties, heat treatment, processing techniques, or other properties/features if required

#### 3.5 burst pressure

highest pressure reached in a cylinder during the burst test

#### 3.6 test pressure

required pressure applied during the pressure test

#### 3.7 working pressure

settled pressure of compressed gas at a uniform reference temperature of 15 °C (288 K) in a full gas cylinder

#### 3.8 minimum operating temperature

minimum ambient temperature to which the cylinder contents can be exposed, but not exceeding –20 °C

Note 1 to entry: See [5.1.6](#).