

STN	Fľaše na plyny Navrhovanie, konštrukcia a skúšanie znovuplniteľných bezšvových oceľových fliaš na plyny a túb Časť 2: Fľaše zo zošľachtenej ocele s pevnosťou v ťahu 1 100 MPa alebo väčšou (ISO 9809-2: 2019)	STN EN ISO 9809-2 07 8521
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Gas cylinders - Design, construction and testing of refillable seamless steel gas cylinders and tubes - Part 2: Quenched and tempered steel cylinders and tubes with tensile strength greater than or equal to 1 100 MPa (ISO 9809-2:2019)

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 03/20

Obsahuje: EN ISO 9809-2:2019, ISO 9809-2:2019

Oznámením tejto normy sa ruší
STN EN ISO 9809-2 (07 8521) z augusta 2010

130163

EUROPEAN STANDARD

EN ISO 9809-2

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2019

ICS 23.020.35

Supersedes EN ISO 9809-2:2010

English Version

Gas cylinders - Design, construction and testing of
refillable seamless steel gas cylinders and tubes - Part 2:
Quenched and tempered steel cylinders and tubes with
tensile strength greater than or equal to 1 100 MPa (ISO
9809-2:2019)

Bouteilles à gaz - Conception, construction et essais des
bouteilles à gaz et des tubes rechargeables en acier
sans soudure - Partie 2: Bouteilles et tubes en acier
trempé et revenu ayant une résistance à la traction
supérieure ou égale à 1 100 MPa (ISO 9809-2:2019)

Gasflaschen - Auslegung, Herstellung und Prüfung von
wiederbefüllbaren nahtlosen Gasflaschen aus Stahl -
Teil 2: Flaschen aus vergütetem Stahl mit einer
Zugfestigkeit größer als oder gleich 1 100 MPa (ISO
9809-2:2019)

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EN ISO 9809-2:2019 (E)

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European foreword

This document (EN ISO 9809-2:2019) has been prepared by Technical Committee ISO/TC 58 "Gas cylinders" in collaboration with 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of an identical text or by endorsement, at the latest by April 2020, and conflicting national standards shall be withdrawn at the latest by April 2020.

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

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This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association.

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Endorsement notice

The text of ISO 9809-2:2019 has been approved by CEN as EN ISO 9809-2:2019 without any modification.

**INTERNATIONAL
STANDARD****ISO
9809-2**Third edition
2019-08

**Gas cylinders — Design, construction
and testing of refillable seamless steel
gas cylinders and tubes —****Part 2:
Quenched and tempered steel
cylinders and tubes with tensile
strength greater than or equal to
1 100 MPa***Bouteilles à gaz — Conception, construction et essais des bouteilles à gaz et des tubes rechargeables en acier sans soudure —**Partie 2: Bouteilles et tubes en acier trempé et revenu ayant une résistance à la traction supérieure ou égale à 1 100 MPa*Reference number
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Published in Switzerland

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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 58, *Gas cylinders*, Subcommittee SC 3, *Cylinder design*.

This third edition cancels and replaces the second edition (ISO 9809-2:2010), which has been technically revised. The changes compared to the previous edition are as follows:

- water capacity extended from below 0,5 l and up to and including 450 l;
- batch size for tubes now introduced;
- bend test retained only for prototype tests;
- test requirements for check analysis (tolerances modified);
- new test requirements for threads introduced including an informative [Annex F](#);
- original European Annexes now incorporated into the body of this document;
- [Annex A](#) "Manufacturing imperfections" now aligned with ISO/TR 16115.

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.

ISO 9809-2:2019(E)**Introduction**

This document provides a specification for the design, manufacture, inspection and testing of a seamless steel cylinder and tube. The objective is to balance design and economic efficiency against international acceptance and universal utility.

ISO 9809 (all parts) aims to eliminate existing concern; about climate, duplicate inspections and restrictions because of a lack of definitive International Standards.

This document is intended to be used under a variety of regulatory regimes, and has been written so that it is suitable to be referenced in the UN Model Regulations^[1].

Gas cylinders — Design, construction and testing of refillable seamless steel gas cylinders and tubes —

Part 2:

Quenched and tempered steel cylinders and tubes with tensile strength greater than or equal to 1 100 MPa

1 Scope

This document specifies minimum requirements for the material, design, construction and workmanship, manufacturing processes, examination and testing at time of manufacture for refillable seamless steel gas cylinders and tubes with water capacities up to and including 450 l.

It is applicable to cylinders and tubes for compressed, liquefied and dissolved gases and for quenched and tempered steel cylinders and tubes with an actual tensile strength $R_{ma} \geq 1\,100$ MPa.

It is not applicable to cylinders and tubes with $R_{ma, max} > 1\,300$ MPa for diameters >140 mm and guaranteed wall thicknesses $a' \geq 12$ mm and for cylinders and tubes with $R_{ma, max} > 1\,400$ MPa for diameters ≤ 140 mm and guaranteed wall thicknesses $a' \geq 6$ mm because, beyond these limits, additional requirements can apply.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes 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 148-1, *Metallic materials — Charpy pendulum impact test — Part 1: Test method*

ISO 6506-1, *Metallic materials — Brinell hardness test — Part 1: Test method*

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

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

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

ISO 10286, *Gas cylinders — Terminology*

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

ISO 11114-4, *Transportable gas cylinders — Compatibility of cylinder and valve materials with gas contents — Part 4: Test methods for selecting steels resistant to hydrogen embrittlement*

ISO 13341, *Gas cylinders — Fitting of valves to gas cylinders*

ISO 13769, *Gas cylinders — Stamp marking*

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