



**SLOVENSKI STANDARD**  
**SIST EN 12863:2002/A1:2006**

01-marec-2006

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Transportable gas cylinders - Periodic inspection and maintenance of dissolved acetylene cylinders

Ortsbewegliche Gasflaschen - Wiederkehrende Prüfung und Instandhaltung von Gasflaschen für gelöstes Acetylen

Bouteilles a gaz transportables - Contrôle et entretien périodiques des bouteilles d'acétylene dissous

**Ta slovenski standard je istoveten z: EN 12863:2002/A1:2005**

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**ICS:**

23.020.30      V|æ} ^A [ • [ â^E] |â •\ ^      Pressure vessels, gas cylinders  
b\ | ^ } \ ^

**SIST EN 12863:2002/A1:2006**      en

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EUROPEAN STANDARD

EN 12863:2002/A1

NORME EUROPÉENNE

EUROPÄISCHE NORM

November 2005

ICS 23.020.30

English Version

## Transportable gas cylinders - Periodic inspection and maintenance of dissolved acetylene cylinders

Bouteilles à gaz transportables - Contrôle et entretien périodiques des bouteilles d'acétylène dissous

Ortsbewegliche Gasflaschen - Wiederkehrende Prüfung und Instandhaltung von Gasflaschen für gelöstes Acetylen

This amendment A1 modifies the European Standard EN 12863:2002; it was approved by CEN on 6 October 2005.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for inclusion of this amendment into the relevant national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This amendment 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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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

Management Centre: rue de Stassart, 36 B-1050 Brussels

EN 12863:2002/A1:2005 (E)

## Foreword

This European Standard (EN 12863:2002/A1:2005) has been prepared by Technical Committee CEN/TC 23 “Transportable gas cylinders”, the secretariat of which is held by BSI.

This Amendment to the European Standard EN 12863:2002 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2006, and conflicting national standards shall be withdrawn at the latest by May 2006.

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

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Details of the amendment:

**Replace 6.2.3 by the following text:**

### **6.2.3 Monolithic masses – Cracking, crumbling or cavitation**

The visual inspection shall verify that the porous mass shows:

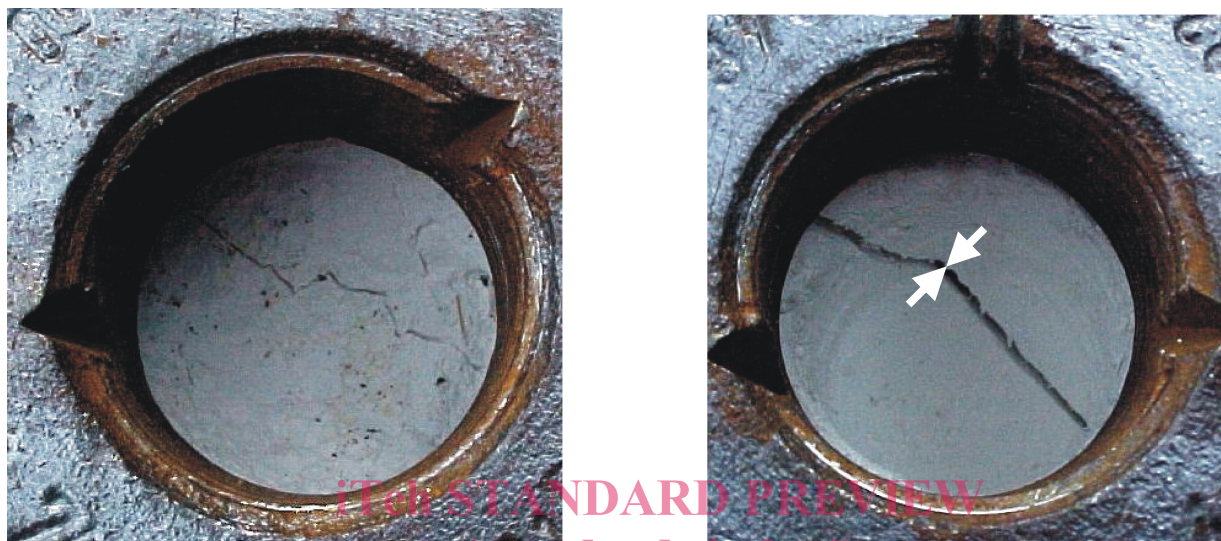
- a) no excessive top clearance (gap between the top of the cylinder and the monolithic porous mass);
  - The maximum gap between the top of the cylinder and the monolithic porous mass shall not exceed that in the type approval, if specified, for that cylinder. Those gaps up to the maximum used in the type approval tests shall apply. If at a later stage, cylinders with other gap sizes pass the requirements of the backfire test as in EN 1800, and are approved, then these gap sizes may also apply. If top clearance specification or guidance is not available for a given cylinder, the gap size shall not exceed 2 mm for an asbestos free porous mass and 5 mm for all other monolithic masses.
- b) no excessive cracking;
  - Only small cracks without visible flanks are acceptable for all masses, provided that they do not incorporate break outs and do not allow the mass to dislodge. This can be checked by applying a gentle lateral load with a gloved finger. Porous masses with cracks with visible flanks are not acceptable and shall be rejected (for examples see Annex F).
- c) no excessive crumbling;
  - Crumbling of the porous mass is acceptable if it is arising from the collar of the porous mass only and if it is so little that the maximum allowed gap is not exceeded at any point. Small break outs in the top of the cylinder neck/shoulder area are acceptable and may be repaired by a method validated and approved by the mass manufacturer, e.g. by backfire test. Cylinders with masses that show crumbling in excess of the allowable shall be rejected.
- d) no void or cavities.
  - The porous mass shall be checked to ensure that there are no voids or cavities between the porous mass and the cylinder wall by verifying there is no lateral movement. A cylinder that demonstrates lateral movement of porous mass shall be rejected.

If the cylinder is equipped with a wooden plug (see 5.4) it shall be checked, by applying a gentle load to ensure that the plug is firmly fixed in its position and there is no lateral movement of the wooden plug. There may be a tolerance of 1 mm between the porous mass and the wooden plug.

Add the new Annex F:

**Annex F**  
(normative)

**Cracks on porous masses**



**a) Hairline crack without visible flanks:**

**b) Crack with visible flanks:**

The cylinder may be further used provided there are no break-outs and the porous mass cannot be dislodged. SIST EN 12863:2002/A1:2006  
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The cylinder shall be rejected.

**Figure F.1 — Cracks on porous mass**