SLOVENSKI STANDARD
SIST EN 13322-1:2003/A1:2006

01-maj-2006

Premične plinske jeklenke – Ponovno polnljive jeklenke – Načrtovanje in izdelava - 1. del: Jeklenke iz ogljičnega jekla

Transportable gas cylinders - Refillable welded steel gas cylinders - Design and construction - Part 1: Carbon steel

Ortsbewegliche Gasflaschen - Wiederbefüllbare geschweißte Flaschen aus Stahl - Gestaltung und Konstruktion - Teil 1: Flaschen aus Kohlenstoffstahl

Bouteilles a gaz transportables - Bouteilles a gaz rechargeables soudées en acier - Conception et construction - Partie 1: Acier au carbone

Ta slovenski standard je istoveten z: **EN 13322-1:2003/A1:2006**

ICS:

23.020.35	Plinske jeklenke	Gas cylinders

SIST EN 13322-1:2003/A1:2006 **en**

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN 13322-1:2003/A1

February 2006

ICS 23.020.30

English Version

Transportable gas cylinders - Refillable welded steel gas cylinders - Design and construction - Part 1: Carbon steel

Bouteilles à gaz transportables - Bouteilles à gaz rechargeables soudées en acier - Conception et construction - Partie 1: Acier au carbone

Ortsbewegliche Gasflaschen - Wiederbefüllbare geschweißte Flaschen aus Stahl - Gestaltung und Konstruktion - Teil 1: Flaschen aus Kohlenstoffstahl

This amendment A1 modifies the European Standard EN 13322-1:2003; it was approved by CEN on 5 January 2006.

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, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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

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Ref. No. EN 13322-1:2003/A1:2006: E

Foreword

This European Standard (EN 13322-1:2003/A1:2006) 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 13322-1:2003 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 2006, and conflicting national standards shall be withdrawn at the latest by August 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, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

Details of the amendment

1 In Clause 2, Normative references, between EN 10120 and EN 10208-2, add:

prEN 10130, *Cold-rolled low carbon steel flat products for cold forming — Technical delivery conditions*

2 In 4.1.1 between EN 10120 and EN 10208-2, add:

prEN 10130

3 Replace the existing Table B.1 with a new Table B.1 as follows:

Table B.1 — Requirements for radiographic examination

Cylinder type	Type of weld	Stress reduction factor, *J*	Control frequency	Zone of inspection
2 pieces	Circumferential weld with joggle joint	*J* = 1	1 cylinder at the beginning and 1 cylinder at the end of each shift period and for each machine [a]	100 mm minimum of the circumferential weld, which shall include the overlapping zone
2 pieces	Circumferential weld with butt weld	*J* = 1	10 % of cylinders. The cylinders shall be randomly selected. Some of these cylinders should be selected at the beginning and end of each shift	100 mm minimum of the circumferential weld, which shall include the overlapping zone
3 pieces	Circumferential weld with joggle joint	*J* = 1	1 cylinder at the beginning and 1 cylinder at the end of each shift period and for each machine [a]	As shown in Figure B.1
	Longitudinal Weld	*J* = 0,9		
3 pieces	Circumferential weld with joggle joint	*J* = 1	10 % of cylinders. The cylinders shall be randomly selected. Some of these cylinders should be selected at the beginning and end of each shift	As shown in Figure B.1
	Longitudinal Weld	*J* = 1		
3 pieces	Circumferential weld with butt joint	*J* = 1	100 % of cylinders	As shown in Figure B.1
	Longitudinal Weld	*J* = 0,9		
2 pieces or 3 pieces	Bung butt weld	*J* = 1	1 cylinder at the beginning and 1 cylinder at the end of each shift period and for each machine [a]	100 %

[a] In the case of continuous production, this may be limited to 1 per shift. A new examination shall be made in the case of adjustment of any of the welding machines or machine parameters.