



SLOVENSKI STANDARD

SIST EN 1920:2001

01-januar-2001

Premične plinske jeklenke - Jeklenke za stisnjene pline (razen acetilena) - Nadzor v času polnjenja

Transportable gas cylinders - Cylinders for compressed gases (excluding acetylene) - Inspection at time of filling

Ortsbewegliche Gasflaschen - Gasflaschen für verdichtete Gase (ausgenommen Acetylen) - Prüfung zum Zeitpunkt des Füllens

Bouteilles a gaz transportables - Bouteilles a gaz comprimés (a l'exclusion de l'acétylene) - Contrôle au moment du remplissage

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Ta slovenski standard je istoveten z: **EN 1920:2000**

ICS:

23.020.30	Tlačne posode, plinske jeklenke	Pressure vessels, gas cylinders
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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 1920

July 2000

ICS 23.020.30

English version

Transportable gas cylinders - Cylinders for compressed gases
(excluding acetylene) - Inspection at time of filling

Bouteilles à gaz transportables - Bouteilles à gaz
comprimés (à l'exclusion de l'acétylène) - Contrôle au
moment du remplissage

Ortsbewegliche Gasflaschen - Gasflaschen für verdichtete
Gase (ausgenommen Acetylen) - Prüfung zum Zeitpunkt
des Füllens

This European Standard was approved by CEN on 2 July 2000.

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

CEN members are the national standards bodies of Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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

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Foreword

This European Standard has been prepared by 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 January 2001 and conflicting national standards shall be withdrawn at the latest by January 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, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

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Introduction

This Standard covers requirements which reflect current practice and experience.

Each transportable gas cylinder is inspected at time of filling in order to establish that:

- it has no defects such that the cylinder is unsafe for filling or continued use;
- it can be identified and complies with the relevant requirements with regard to marking, labelling, colour coding and completeness of its accessories;
- its valve functions satisfactorily.

The cylinder filling inspection shall be carried out only by persons who are trained and competent in the subject, for the purpose of ensuring that a cylinder is safe for continued use.

Annex A is for information only and is not a mandatory part of this standard.

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1 Scope

This standard:

- specifies the inspection requirements at the time of filling and applies to seamless or welded transportable gas cylinders made of steel or aluminium alloy for compressed gases (excluding acetylene) of water capacity from 0,5 litre up to 150 litres. It also applies, as far as practicable, to cylinders of less than 0,5 litre water capacity;
- does not apply to manifolded bundles or manifolded trailer cylinders.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

prEN 1802:1998	Transportable gas cylinders – Periodic inspection and testing of seamless aluminium alloy gas cylinders <small>https://standards.iteh.ai/catalog/standards/sist/en-1920-2001/5ef358f6383a/sist-en-1920-2001</small>
prEN 1803:1998	Transportable gas cylinders – Periodic inspection and testing of welded carbon steel gas cylinders (excluding LPG)
prEN 1968:1998	Transportable gas cylinders - Periodic inspection and testing of seamless steel gas cylinders
EN ISO 11114-1	Transportable gas cylinders – Compatibility of cylinder and valve materials with gas contents – Part 1: Metallic materials (ISO 11114-1:1997)
prEN ISO 11114-2:1999	Transportable gas cylinders – Compatibility of cylinder and valve materials with gas contents – Part 2: Non-metallic materials (ISO/FDIS 11114-2:1999)

3 Terms and definitions

For the purpose of this standard the following terms and definitions apply:

3.1

filling pressure

pressure to which a cylinder is filled at the time of filling.

NOTE: It varies according to the gas temperature in the cylinder, which is dependent on the charging parameters and the ambient conditions.

3.2

compressed gas

gas, which, when packaged under pressure for transport, is entirely gaseous at all temperatures above $-50\text{ }^{\circ}\text{C}$.

NOTE: All gases with a critical temperature below $-50\text{ }^{\circ}\text{C}$ belong to this category.

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3.3

working pressure

settled pressure at a uniform temperature of 288 K ($15\text{ }^{\circ}\text{C}$) for a full gas cylinder.

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3.4

filler

person or persons responsible for inspection prior to, during and immediately after filling and who has received an appropriate level of training for the work involved, and has access to all necessary data for the cylinder, valve and all other fittings used [EN 1919:2000].

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3.5

pallet

device for handling several cylinders at the same time.

4 Filling inspection

Each cylinder shall be submitted to an inspection prior to, during and immediately after filling. The following items shall be covered by a filling inspection:

- verification of serviceable condition (see 5.1);
- identification of cylinder for suitability for filling (see 5.2);
- identification of cylinder owner, if required (see 5.3);

- verification of internal cylinder condition (see 5.4);
- verification of integrity of neck ring/threaded boss (see 5.5);
- verification of valve integrity and suitability (see 5.6);
- check for correct filling pressure (see 5.7).

5 Description of inspection items

5.1 Verification of serviceable condition

It shall be established that each cylinder whether individual or palletised is in a serviceable condition. Cylinders which have been found to be non-serviceable shall be clearly identified according to written procedures in the filling company.

a) *Individual cylinder*

Before a cylinder is filled it shall be established that the cylinder is clean and free of foreign material (i.e. such that the cylinder can be assessed for mechanical damage that would prevent it from being filled safely) and does not exhibit any abnormalities such as arc burns, bulging, severe corrosion, heat/fire damage or significant mechanical damage. In case of doubt, rejection criteria described in prEN 1968:1998, prEN 1802:1998 or prEN 1803:1998, as appropriate, shall be applied.

NOTE: It is particularly important that the base of each welded cylinder is inspected for corrosion or rusting. Cylinders exhibiting such evidence should not be filled until properly evacuated, cleaned and painted.

b) *Palletised cylinder*

A filler may only submit a pallet for filling, without unloading the cylinders, if a written procedure exists within the filling company and its representatives which ensures that only cylinders in a serviceable condition are filled (see a)).

5.2 Identification of cylinder for suitability for filling

Before filling a cylinder, it shall be established that:

- the cylinder has not passed its due date for retest;
- the cylinder is compatible with the intended gas content and filling pressure;
- the cylinder is permitted for filling in the country of the filling station;