
Oprema in pribor za utekočinjeni naftni plin (UNP) - Varjene tlačne posode cestnih cistern iz jekla za UNP - Konstruiranje in proizvodnja

LPG equipment and accessories - Welded steel pressure vessels for LPG road tankers - Design and manufacture

Flüssiggas-Geräte und Ausrüstungsteile - Geschweißte Druckbehälter aus Stahl für Straßentankwagen für Flüssiggas (LPG) - Auslegung und Herstellung

Équipements pour GPL et leurs accessoires - Réservoirs sous pression en acier soudés des camions-citernes pour GPL - Conception et construction

<https://standards.iteh.ai/catalog/standards/sist/1ef2101-93bd-4d25-a09e-7a93956132a6/sist-en-12493-2021>

Ta slovenski standard je istoveten z: prEN 12493

ICS:

23.020.35	Plinske jeklenke	Gas cylinders
43.080.10	Tovornjaki in priklopniki	Trucks and trailers

oSIST prEN 12493:2019

en,fr,de

EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

DRAFT
prEN 12493

September 2019

ICS 23.020.30; 23.020.35

Will supersede EN 12493:2013+A2:2018

English Version

**LPG equipment and accessories - Welded steel pressure
vessels for LPG road tankers - Design and manufacture**

Équipements pour GPL et leurs accessoires -
Réservoirs sous pression en acier soudés des camions-
citernes pour GPL - Conception et construction

Flüssiggas-Geräte und Ausrüstungsteile - Geschweißte
Druckbehälter aus Stahl für Straßentankwagen für
Flüssiggas (LPG) - Auslegung und Herstellung

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 286.

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COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Contents	Page
European foreword.....	6
Introduction	7
1 Scope.....	8
2 Normative references.....	8
3 Terms and definitions	10
4 Materials.....	11
4.1 Environmental.....	11
4.2 Suitability	11
4.3 Pressure retaining parts.....	11
4.4 Non-pressure retaining parts	11
4.5 Welding consumables.....	11
4.6 Non-metallic materials (gaskets)	12
4.7 Inspection documents for materials	12
5 Pressure vessel design	12
5.1 Design conditions.....	12
5.2 Minimum thickness	12
5.3 Surge plates.....	13
5.4 Doubler plates.....	13
5.5 Stresses due to motion	13
5.6 Self-supporting pressure vessels.....	14
5.7 Vacuum conditions	14
5.8 Pressure vessel mountings.....	14
5.9 Internal pipework.....	14
6 Openings.....	14
6.1 General.....	14
6.2 Reinforcement of openings.....	15
6.3 Threaded connections.....	15
6.4 Manhole	15
7 Non-pressure retaining parts	15
7.1 Attachment welds	15
7.2 Position of attachment welds	15
8 Workmanship and construction.....	15
8.1 General.....	15
8.2 Environment.....	16
8.3 Control of materials.....	16
8.4 Acceptable weld details	16
8.5 Heat treatment and forming	17
8.5.1 Cold forming.....	17
8.5.2 Hot forming	17
8.5.3 Testing of formed parts.....	17
8.5.4 Visual examination and control of dimensions.....	18
8.5.5 Marking.....	18
8.6 Welding.....	18
8.6.1 General.....	18
8.6.2 Longitudinal welds	18
8.6.3 Welding procedure specification (WPS).....	19

8.6.4	Qualification of WPS	19
8.6.5	Qualification of welders and welding operators	19
8.6.6	Preparation of edges	19
8.6.7	Attachments and fastenings	19
8.6.8	Preheat	19
8.7	Post-weld heat treatment	20
8.8	Manufacturing tolerances	20
8.9	Repairs to pressure envelope and direct attachment welds	20
8.9.1	General requirements	20
8.9.2	Repair of surface imperfections in the parent metal	20
8.9.3	Repair of weld imperfections	20
9	Construction and workmanship of internal pipework	21
10	Manufacturing tests and examinations	21
10.1	General	21
10.2	Mechanical testing	21
10.2.1	Production test plates	21
10.2.2	Longitudinal welds	21
10.2.3	Circumferential welds	21
10.2.4	Mechanical tests	21
10.2.5	Test requirements	21
10.3	Non-destructive testing	22
10.3.1	General	22
10.3.2	Internal imperfections	23
10.3.3	Surface imperfections	23
10.4	Non-destructive testing for welds	23
10.4.1	Radiographic testing	23
10.4.2	Marking and identification of radiographs	23
10.4.3	Ultrasonic testing	23
10.4.4	Magnetic particle testing	23
10.4.5	Penetrant testing	24
10.5	Qualification of non-destructive testing personnel	24
10.6	Visual examination of welds	24
10.7	Acceptance criteria	24
10.8	Safety precautions at the hydraulic test	24
11	External corrosion protection and finishing	24
11.1	External protection	24
11.2	Finishing operations	24
12	Marking	24
13	Records and documentation	25
13.1	Documentation obtained by the manufacturer	25
13.2	Records prepared by the manufacturer	25
13.3	Retention and supply of documents	25
Annex A (normative)	Guidance on selection of material grades	26
Annex B (normative)	Reference temperatures for design	27
B.1	Introduction	27
B.2	General	27
B.3	Developed pressure	27
B.4	Filling	27

Annex C (informative) Alternative reference temperatures for design	28
C.1 Introduction	28
C.2 General	28
C.3 Developed pressure	28
C.4 Filling	28
Annex D (normative) Design	29
D.1 Design stresses	29
D.1.1 D.1.1 The nominal design stress, f, shall be the lesser of Formula (D.1) or Formula (D.2):	29
D.1.2 D.1.2 The following units shall be used in the formulae in this annex:	29
D.2 Design pressure	29
D.3 Design formulae	29
D.3.1 Cylindrical shell calculation	29
D.3.2 Dished ends	30
D.3.2.1 Minimum thickness	30
D.3.2.2 Torispherical end calculation	30
D.3.2.3 Ellipsoidal end calculation	31
D.3.2.4 Hemispherical ends	31
D.3.2.5 Formulae for calculating β	32
D.3.3 Conical shell calculations	33
D.3.3.1 General requirements	33
D.3.3.2 Thickness of conical shell	33
D.3.3.3 Junction between large end of a cone and a cylinder without a knuckle	34
D.3.3.4 Junction between the small end of a cone and a cylinder	35
D.4 Nozzle reinforcement	37
D.5 Nozzle reinforcement by pads or flanges	39
D.6 Nozzle reinforcement by branches	40
Annex E (informative) Example of joints	44
Annex F (normative) Allowable tolerances	48
F.1 Pressure vessels	48
F.1.1 External diameter	48
F.1.2 Out of roundness	48
F.1.3 Deviation of straightness	48
F.1.4 Irregularities in profile	49
F.2 Dished end tolerance	49
F.2.1 Thickness of material	49

F.2.2	Profile.....	49
F.3	Assembly tolerances.....	50
F.3.1	Middle line alignment	50
F.3.2	Surface alignment.....	50
F.4	Attachments, nozzles and fittings	51
F.5	Overall length.....	51
	Annex G (normative) Heat treatment.....	52
G.1	Method of post-weld heat treatment.....	52
G.2	Temperature control.....	52
G.3	Temperature limit.....	52
G.4	Temperature measurement	52
	Annex H (informative) Typical method for measurement of shell peaking.....	53
H.1	Profile gauge.....	53
H.2	Peaking survey	53
	Annex I (informative) Choice of non-destructive test methods for welds	56
I.1	Internal imperfections.....	56
I.2	Surface imperfections	56
	Annex J (normative) Hydraulic pressure test.....	57
J.1	Temporary fittings	57
J.2	Pressure gauges	57
J.3	Pressurizing agent.....	57
J.4	Avoidance of shock.....	57
J.5	Applied pressure.....	57
	Bibliography	58

prEN 12493:2019 (E)**European foreword**

This document (prEN 12493:2019) has been prepared by Technical Committee CEN/TC 286 “Liquefied petroleum gas equipment and accessories”, the secretariat of which is held by NSAI.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 12493:2013+A2:2018.

This document supports the EU Directive 2008/68/EC and the associated Transport of Dangerous Goods Regulation, notably the RID and the ADR.

This document has been submitted for reference into the technical annexes of the ADR [15].

NOTE These regulations take precedence over any clause of this document. It is emphasized that RID/ADR/ADN are being revised regularly at intervals of two years which could lead to temporary non-compliances with the clauses of this document.

The following main changes have been introduced during this revision:

- removal of Annex I, *Welding imperfections and test specimens*;
- addition of normative reference to EN 12972.

It is a **STANDARD PREVIEW**
(standards.itech.ai)

SIST EN 12493:2021

<https://standards.itech.ai/catalog/standards/sist/ffef210f-93bd-4d25-a09e-7a93956132a6/sist-en-12493-2021>

Introduction

This document calls for the use of substances and procedures that could be injurious to health and/or the environment if adequate precautions are not taken. It refers only to technical suitability: it does not absolve the user from their legal obligations at any stage.

Protection of the environment is a key political issue in Europe and elsewhere. For CEN/TC 286 this is covered in CEN/TS 16765 [9] *LPG equipment and accessories — Environmental considerations for CEN/TC 286 standards*; which should be read in conjunction with this document. The Technical Specification provides guidance on the environmental aspects to be considered regarding equipment and accessories produced for the LPG industry and the following is addressed:

- a) design;
- b) manufacture;
- c) packaging;
- d) use and operation;
- e) disposal.

It is recommended that manufacturers develop an environmental management policy. For guidance, see EN ISO 14000 series (see [11], [12] and [13]).

Provisions need to be restricted to a general guidance. Limit values are specified in national laws.

It has been assumed in the drafting of this document that the execution of its provisions is entrusted to appropriately qualified and experienced people.

All pressures are gauged unless otherwise stated.

NOTE This document requires measurement of material properties, dimensions and pressures. All such measurements are subject to a degree of uncertainty due to tolerances in measuring equipment, etc. It might be beneficial to refer to the leaflet “measurement uncertainty leaflet” SP INFO 2000 27 [18].

1 Scope

This document specifies minimum requirements for materials, design, construction and workmanship procedures, and tests for welded LPG road tanker pressure vessels and their welded attachments manufactured from carbon, carbon/manganese and micro alloy steels.

There is no upper size limit as this is determined by the gross vehicle weight limitation.

This document does not cover pressure vessels for pressure vessel containers.

NOTE 1 In the context of this document, the term “road tanker” is understood to mean “fixed tanks” and “demountable tanks” as defined in ADR.

NOTE 2 The equipment for the pressure vessels and the inspection and testing after assembly is covered by EN 12252 and EN 14334, respectively.

NOTE 3 The design type of the road tanker is subject to approval by the competent authority, as required by ADR.

NOTE 4 This document is intended for LPG only; however, for other liquefied gases see EN 14025.

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.

EN 837-2, *Pressure gauges — Part 2: Selection and installation recommendations for pressure gauges*

EN 10025-2, *Hot rolled products of structural steels — Part 2: Technical delivery conditions for non-alloy structural steels*

EN 10028-2, *Flat products made of steels for pressure purposes — Part 2: Non-alloy and alloy steels with specified elevated temperature properties*

EN 10028-3, *Flat products made of steels for pressure purposes — Part 3: Weldable fine grain steels, normalized*

EN 10204, *Metallic products — Types of inspection documents*

EN 12972:2018, *Tanks for transport of dangerous goods — Testing, inspection and marking of metallic tanks*

EN 13445-3, *Unfired pressure vessels — Part 3: Design*

EN 14717, *Welding and allied processes — Environmental check list*

EN ISO 148-1, *Metallic materials — Charpy pendulum impact test — Part 1: Test method (ISO 148-1)*

EN ISO 3452-1, *Non-destructive testing — Penetrant testing — Part 1: General principles (ISO 3452-1)*

EN ISO 3834-2, *Quality requirements for fusion welding of metallic materials — Part 2: Comprehensive quality requirements (ISO 3834-2)*

EN ISO 4136, *Destructive tests on welds in metallic materials — Transverse tensile test (ISO 4136)*

EN ISO 5173, *Destructive tests on welds in metallic materials — Bend tests (ISO 5173)*

EN ISO 5178, *Destructive tests on welds in metallic materials — Longitudinal tensile test on weld metal in fusion welded joints (ISO 5178)*

EN ISO 5579, *Non-destructive testing — Radiographic testing of metallic materials using film and X- or gamma rays — Basic rules (ISO 5579)*

EN ISO 5817, *Welding — Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) — Quality levels for imperfections (ISO 5817)*

EN ISO 6520-1, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 1: Fusion welding (ISO 6520-1)*

EN ISO 6520-2, *Welding and allied processes — Classification of geometric imperfections in metallic materials — Part 2: Welding with pressure (ISO 6520-2)*

EN ISO 9016, *Destructive tests on welds in metallic materials — Impact tests — Test specimen location, notch orientation and examination (ISO 9016)*

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

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

EN ISO 14732, *Welding personnel — Qualification testing of welding operators and weld setters for mechanized and automatic welding of metallic materials (ISO 14732)*

EN ISO 15609-1, *Specification and qualification of welding procedures for metallic materials — Welding procedure specification — Part 1: Arc welding (ISO 15609-1)*

EN 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 15614-1)*

EN ISO 17636-1, *Non-destructive testing of welds — Radiographic testing — Part 1: X- and gamma-ray techniques with film (ISO 17636-1)*

EN ISO 17636-2, *Non-destructive testing of welds — Radiographic testing — Part 2: X- and gamma-ray techniques with digital detectors (ISO 17636-2)*

EN ISO 17637, *Non-destructive testing of welds — Visual testing of fusion-welded joints (ISO 17637)*

EN ISO 17638, *Non-destructive testing of welds — Magnetic particle testing (ISO 17638)*

EN ISO 17639, *Destructive tests on welds in metallic materials — Macroscopic and microscopic examination of welds (ISO 17639)*

EN ISO 17640, *Non-destructive testing of welds — Ultrasonic testing — Techniques, testing levels, and assessment (ISO 17640)*

EN ISO 19232-1, *Non-destructive testing — Image quality of radiographs — Part 1: Determination of the image quality value using wire-type image quality indicators (ISO 19232-1)*

EN ISO 19232-2, *Non-destructive testing — Image quality of radiographs — Part 2: Determination of the image quality value using step/hole-type image quality indicators (ISO 19232-2)*

3 Terms and definitions

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

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

3.1

liquefied petroleum gas

LPG

low pressure liquefied gas composed of one or more light hydrocarbons which are assigned to UN 1011, UN 1075, UN 1965, UN 1969 or UN 1978 only and which consists mainly of propane, propene, butane, butane isomers, butene with traces of other hydrocarbon gases

3.2

yield strength

upper yield strength R_{eH} or, for steels that do not exhibit a definite yield (non-proportional elongation), the 0,2 % proof strength

3.3

cold forming

forming at temperatures not less than 25 °C below the maximum permissible temperature for stress relieving, in accordance with the applicable material specifications

3.4

hot forming

forming at temperatures above the temperature for stress relieving as stated in the material specifications

3.5

sun shield

shield covering not less than the upper third but not more than the upper half of the shell surface, separated from the shell by an air gap of at least 40 mm

3.6

pressure vessel

assembly of the pressure-retaining envelope (including the openings and their closures) and non-pressure-retaining parts attached directly to it

Note 1 to entry: Also referred to as “tank” in the ADR.

3.7

competent authority

authority or authorities or any other body or bodies designated as such in each State and in each specific case in accordance with domestic law

3.8

inspection body

independent inspection and testing body approved by the competent authority

3.9

competent person

person which by combination of appropriate qualification, training, experience, and resources, is able to make objective judgments on the subject

4 Materials

4.1 Environmental

The manufacturer shall endeavour to acquire materials and components from suppliers who have a declared environmental policy, see EN ISO 14021, EN ISO 14024 and EN ISO 14025.

4.2 Suitability

4.2.1 Unless otherwise specified by the design documents, the design temperature range shall be $-20\text{ }^{\circ}\text{C}$ to $+50\text{ }^{\circ}\text{C}$.

4.2.2 The materials of construction shall be suitable for operating within the envisaged temperature range. If the pressure vessel could be subjected to more severe lower ambient or product temperatures, the design temperature range shall be $-40\text{ }^{\circ}\text{C}$ to $+50\text{ }^{\circ}\text{C}$.

4.2.3 Guidance on selection of material grades is given in Annex A.

4.2.4 If additional impact testing is required, it shall be carried out in accordance with EN ISO 148-1 to achieve the impact values specified in 10.2.5.5.

4.2.5 The materials of the pressure receptacle which are in contact with the contents shall not contain substances liable to substantially weaken the material. The steel grades specified in EN 10028-2 and EN 10028-3, listed in Table A.1, are considered compatible with LPG complying with the limitations on corrosiveness as specified in ISO 9162.

4.3 Pressure retaining parts

Pressure-retaining materials shall be of appropriate steels conforming to EN 10028-2 or EN 10028-3 or shall conform to specifications agreed with the competent authority. All materials shall conform to 10.2.4 and the ratio of the specified yield strength (R_{eH}) to minimum tensile strength (R_m) shall not exceed 0,85 (i.e. $R_{eH}/R_m \leq 0,85$). The percentage elongation at fracture shall be not less than 10 000 divided by the actual tensile strength in N/mm^2 , and in any case shall be not less than 16 % for fine grained steels and not less than 20 % for other steels. Where fine grain steels are used, the guaranteed yield strength, R_{eH} shall not exceed $460\text{ N}/\text{mm}^2$ and the upper tensile strength, R_m , shall not exceed $725\text{ N}/\text{mm}^2$.

4.4 Non-pressure retaining parts

Non-pressure retaining parts that are directly welded to pressure retaining parts shall be of suitable materials conforming to EN 10025-2 or materials with characteristics approved by a competent authority. All materials used for non-pressure retaining parts shall be compatible with the material of pressure retaining parts, and shall conform to the impact requirements of 10.2.5.5, tested in accordance with the method specified in EN ISO 148-1.

4.5 Welding consumables

Welding consumables shall be able to provide consistent welds with properties at least equal to those specified for the parent materials in the finished pressure vessel.

4.6 Non-metallic materials (gaskets)

Non-metallic materials (gaskets) shall be compatible with both phases of LPG over the range of pressures and temperatures for which the road tanker is designed (see 4.2, Annex B and Annex C).

4.7 Inspection documents for materials

Pressure retaining parts and non-pressure retaining parts directly welded to the pressure vessel shall be provided with the material manufacturers' certificates conforming to EN 10204 certificate type 3.1. Other parts shall have certificates conforming to EN 10204 certificate type 2.2.

5 Pressure vessel design

5.1 Design conditions

5.1.1 Unless authorized by a national competent authority for use within its territory, in accordance with the provision of EU Council Directive 2008/68/EC [16], the reference temperatures shall conform to Annex B.

5.1.2 Design calculations shall be carried out in accordance with Annex D.

5.1.3 Account shall be taken of the fatigue loading on all component parts of the pressure vessel and its attachments by conducting an assessment or through proven operating experience.

5.1.4 The design of the pressure vessel should take into account the following:

- minimizing the use of materials;
- fittings required for efficient operation of the pressure vessel;
- minimizing the environmental impact of in service maintenance and end of life disposal.

5.2 Minimum thickness

5.2.1 The minimum thickness for pressure vessels not exceeding a diameter of 1,8 m shall be 5 mm of reference steel (as defined by ADR) or of an equivalent thickness if in a different steel.

5.2.2 For pressure vessels exceeding a diameter of 1,8 m, the minimum thickness shall be 6 mm of reference steel (as defined by ADR) or of an equivalent thickness if in a different steel.

5.2.3 The equivalent thickness shall be calculated using Formula (1):

$$e_1 = \frac{464e_0}{\sqrt[3]{(R_{m1}A_1)^2}} \quad (1)$$

where

- A_1 minimum elongation at fracture (%) of steel chosen under tensile stress;
- e_1 minimum shell thickness in chosen steel, in mm;
- e_0 minimum thickness in reference steel, in mm;
- R_{m1} minimum tensile strength of steel chosen, in N/mm².

5.2.4 The minimum shell thickness will not be less than calculated in accordance with the ADR.

5.3 Surge plates

5.3.1 Where it is intended that pressure vessels will be operated in excess of 20 % full or less than 80 % full, surge plates shall be fitted. The surge plates shall be designed to permit full internal inspection of the pressure vessel. The volume between any two plates or a plate and the end of the pressure vessel shall not exceed 7 500 l.

5.3.2 The distance between surge plates shall not exceed 4 m.

5.3.3 The area of each surge plate shall be at least 70 % of the cross-sectional area of the pressure vessel in which the plates are fitted.

5.3.4 Surge plates shall be able to withstand the load imposed by a full capacity liquid content of the section between the plates in either direction.

5.3.5 Surge plates shall be at least 2 mm thick.

5.3.6 Provision shall be made for communication and drainage between sections.

5.4 Doubler plates

To reduce stress concentration on the pressure vessel, load-carrying attachments shall incorporate a doubler plate between the attachment and the pressure vessel shell.

Non-circular doubler plates shall be designed with as generous as practicable corner radii (minimum radius 25 mm) to reduce stress concentrations.

Doubler plates shall be provided with vent holes or test sockets which shall be closed after testing.

5.5 Stresses due to motion

Pressure vessels and their permanent attachments shall be able to absorb, under maximum permissible load, forces exerted by the design pressure, and the following dynamic forces:

- in the direction of travel: twice the total mass;
- at right-angles to the direction of travel: the total mass;
- vertically upwards: the total mass;
- vertically downwards: twice the total mass.

Under the forces defined above, the stresses in the pressure vessel and its fastenings shall not exceed the following:

- a) general membrane stress in the shell, remote from the supports:
 - the normal design stress as defined in D.1;
- b) stresses local to the supports, determined either by experimental analysis or calculation/special analysis:
 - the limits specified in EN 13445-3.