



SLOVENSKI STANDARD

oSIST prEN 12493:2019

01-oktober-2019

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

Ta slovenski standard je istoveten z: prEN 12493

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<https://standards.iteh.ai/catalog/standards/sist/ffe210f-93bd-4d25-a09e-7a93956132a6/osist-pren-12493-2019>

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**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.

If this draft becomes a European Standard, 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.

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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.

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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].

prEN 12493:2019 (E)**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)*

prEN 12493:2019 (E)**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 °C to $+50\text{ °C}$.

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 °C to $+50\text{ °C}$.

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.