
**Plinske jeklenke - Jeklenke in velike jeklenke iz kompozitnih materialov -
Periodični pregledi in preskusi (ISO/DIS 11623:2022)**

Gas cylinders - Composite cylinders and tubes - Periodic inspection and testing (ISO/DIS 11623:2022)

Gasflaschen – Verbundbauweise (Composite-Bauweise) – Wiederkehrende Inspektion und Prüfung (ISO/DIS 11623:2022)

Bouteilles à gaz - Bouteilles et tubes composites - Contrôles et essais périodiques (ISO/DIS 11623:2022)

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Contents

Page

Foreword	v
Introduction	vi
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Due dates for periodic inspection and testing	3
5 Procedures for periodic inspection and testing	4
5.1 List of procedures	4
5.2 Heat exposure	5
6 Identification of cylinder and preparation for periodic inspection and testing	5
7 External visual inspection	5
7.1 Preparation	5
7.1.1 General	5
7.1.2 Permanent protective attachments	8
7.1.3 Sleeves	8
7.1.4 Cleaning	8
7.2 Inspection procedures	9
7.3 Damage	9
7.3.1 General	9
7.3.2 Damage levels	9
7.3.3 Types of external damage	10
7.4 Repairs	11
8 Internal visual inspection	11
8.1 Safe removal of valve	11
8.2 Internal inspection and cleaning	11
8.2.1 General	11
8.2.2 Metallic liners	11
8.2.3 Linerless and non-metallic liners	12
8.3 Types of internal damage	12
8.3.1 Bulge outward	12
8.3.2 Inward bulging liner (Type 4 cylinders with non-metallic liners)	12
8.3.3 Dented liner (Types 2 and 3 cylinders)	12
8.3.4 Blistered liners	12
8.3.5 Cracking	12
8.3.6 Indications of chemical attack	13
8.3.7 Indications of melting	13
8.3.8 Discoloured interior	13
8.3.9 Composite matrix (Type 5 cylinders) shows deterioration and/or loose fibres	13
8.3.10 Crease	13
8.3.11 Excess resin droplets (Type 5 cylinders)	13
8.4 Inspection of cylinder neck	13
8.5 Inspection criteria	13
9 Pressure test	14
10 Leak test	15
11 Inspection of valve	16
12 Final operations	16
12.1 Drying and cleaning	16
12.2 Painting	16

ISO/DIS 11623:2022(E)

12.3	Cylinder re-valving	16
12.4	Check of cylinder tare	16
12.5	Retest marking	17
12.6	Reference to next periodic inspection and test date	17
12.7	Identification of contents	17
12.8	Records	18
13	Rejection and rendering cylinders unserviceable	18
Annex A	(informative) Intervals between periodic inspection and testing	25
Annex B	(normative) Damage criteria for steel wire wound, aluminium-alloy cylinders	28
Annex C	(normative) Internal inspection of translucent cylinders	29
Annex D	(informative) List of gases corrosive to steel liners and steel bosses	30
Annex E	(informative) Cleaning of seamless aluminium-alloy liners	31
Annex F	(informative) Test date rings for cylinders	32
Bibliography	33

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 58, *Gas cylinders*, Subcommittee SC 4, *Operational requirements for gas cylinders*.

This third edition cancels and replaces the second edition (ISO 11623:2015), which has been technically revised.

The main changes compared to the previous edition are as follows:

- revised scope to include cylinders and tubes with a water capacity up to 3 000 l;
- modification of [Table 1](#) to separate abrasion damage based on water capacity of the cylinder;
- clarification that a transparent sleeve may be left in place during inspection ([7.1.3](#)); and
- clarification on the use of tare during inspection.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

The principal aim of periodic inspection and testing is that at the completion of the test, the cylinders can be reintroduced into service. It is not possible to identify all considerations for periodic inspection and testing of composite cylinders in this document. In such cases or where there is doubt, questions regarding specific cylinders should be directed to the manufacturer or owner.

This document is intended to be used under a variety of national regulatory regimes but has been written so that it is suitable for the application of the UN *Model Regulations* [1].

This document also gives other requirements concerning preparation, finishing and maintenance of composite cylinders and tubes as well as the safety precautions for the personnel performing this work. These requirements can be mandatory under other regulations.

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Gas cylinders — Composite cylinders and tubes — Periodic inspection and testing

CAUTION — Some of the tests specified in this document involve the use of processes that could lead to a hazardous situation.

1 Scope

This document specifies the requirements for periodic inspection and testing and to verify the integrity for further service of hoop-wrapped and fully wrapped composite transportable gas cylinders and tubes, with aluminium-alloy, steel or non-metallic liners or of linerless construction (Types 2, 3, 4, and 5), intended for compressed, liquefied or dissolved gases under pressure, of water capacity from 0,5 l up to 3 000 l.

This document is written to address the periodic inspection and testing of composite cylinders and tubes constructed to ISO 11119-1, ISO 11119-2, ISO 11119-3, ISO 11119-4 and ISO 11515 standards and can be applied to other composite cylinders and tubes designed to comparable standards when authorized by the competent authority.

As far as practicable, this document also can be applied to cylinders of less than 0,5 l water capacity when authorized by the manufacturer.

NOTE Unless noted by exception, the use of the word “cylinder” in this document refers to both cylinders and tubes.

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.

ISO 10286, *Gas cylinders — Vocabulary*

ISO 11114-2, *Gas cylinders — Compatibility of cylinder and valve materials with gas contents — Part 2: Non-metallic materials*

ISO 11621, *Gas cylinders — Procedures for change of gas service*

ISO 18119, *Gas cylinders — Seamless steel and seamless aluminium-alloy gas cylinders and tubes — Periodic inspection and testing*

ISO 13341, *Gas cylinders — Fitting of valves to gas cylinders*

ISO 13769, *Gas cylinders — Stamp marking*

ISO 22434, *Transportable gas cylinders — Inspection and maintenance of cylinder valves*

ISO 25760, *Gas cylinders — Operational procedures for the safe removal of valves from gas cylinders*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 10286 and the following apply.

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

— ISO Online browsing platform: available at <https://www.iso.org/obp>

ISO/DIS 11623:2022(E)

— IEC Electropedia: available at <https://www.electropedia.org/>

3.1

composite overwrap

fibres (3.3) and *matrix* (3.15) taken together as a combined unit

3.2

exterior coating

layer of material applied to the cylinder as a protective coating not intended to be removed or for cosmetic purposes

EXAMPLE Gel coat and paint.

Note 1 to entry: Not all composite cylinders will have a special exterior coating.

3.3

fibre

load-carrying part of the *composite overwrap* (3.1)

EXAMPLE Glass, aramid or carbon.

3.4

Type 5 cylinder

fully wrapped cylinder without a liner and with composite reinforcement on both the cylindrical portion and dome ends

3.5

Type 4 cylinder

fully wrapped cylinder with a non-load sharing *liner* (3.11) and composite reinforcement on both the cylindrical portion and the dome ends

3.6

Type 3 cylinder

fully wrapped cylinder with a load sharing metal *liner* (3.11) and composite reinforcement on both the cylindrical portion and the dome ends

3.7

Type 2 cylinder

hoop wrapped cylinder with a load-sharing metal *liner* (3.11) and composite reinforcement on the cylindrical portion only

3.8

translucent cylinder

cylinder that permits the passage of light

3.9

identification label

label containing the permanent markings required by the relevant design specification

3.10

design life

maximum life (in number of years) to which a composite cylinder or tube is designed and approved in accordance with the applicable standard

3.11

liner

inner portion of the composite cylinder designed both to contain the gas and transmit the gas pressure to the *composite overwrap* (3.1)

3.12

non-metallic liner

liner (3.11) made from thermoplastic, thermosetting, or elastomeric material

3.13**sleeve**

transparent or non-transparent cover fitted to the outside surface of the cylinder

3.14**repair**

minor refurbishment to return the cylinder to its acceptable condition

EXAMPLE Adding resin.

3.15**matrix**

material used to bind and hold the *fibres* (3.3) in place

Note 1 to entry: The matrix is sometimes called resin.

3.16**rejected cylinder**

cylinder not fit for service or which needs to be set aside for further evaluation or testing in its present condition

3.17**bulge**

visible swelling of the wall

3.18**crack**

split or separation in the material, typically appearing as a line on the surface

3.19**crease**

off-colour linear or non-linear feature formed as a result of previous localized over-stressing

3.20**protective attachment**

component connected to the cylinder that prevents or resists damage to the composite cylinder

EXAMPLE Casing.

Note 1 to entry: Some protective attachments are designed to be removed at the time of periodic inspection and testing.

3.21**permanent protective attachment**

integral part of the cylinder design permanently affixed to composite cylinders (Types 2 to 5) covering part of or the entire surface of the cylinder, providing additional functions during handling, transport and use

3.22**stoving**

treat by heating (e.g. in an oven) in order to apply a desired surface coating

4 Due dates for periodic inspection and testing

A cylinder shall be due for periodic inspection and testing on its first receipt by a filler following the expiry of the interval established in accordance with the requirements of national or international regulations or, in the absence of regulations, in accordance with the UN *Model Regulations* [1].

NOTE [Annex A](#) provides guidance regarding the intervals between periodic inspection and testing.

ISO/DIS 11623:2022(E)

The expiry date is based on the last test date shown on the cylinder. Other means of indicating the expiry date are permitted.

Provided the cylinder has not been subjected to abusive and abnormal conditions such as being involved in an accident, heat exposure or other severe conditions that would render it unsafe, there is no requirement for the user to return a cylinder before the contents have been used even though the periodic inspection and testing interval has lapsed.

When the design life has expired, the cylinder shall not be refilled and shall be removed from service when presented for the next filling (see [Clause 13](#)).

In some jurisdictions, it is the responsibility of the owner or user to submit cylinders used for emergency purposes for periodic inspection and testing within the specified interval.

5 Procedures for periodic inspection and testing

5.1 List of procedures

The inspection, testing and repair of composite cylinders shall be carried out only by competent persons in suitable facilities for cylinders of the size and type being requalified. Care shall be taken to ensure that during the retest procedure, cylinders are handled carefully, particularly with respect to loading. When moving from handling pallets or other transport frames, processes shall be developed to ensure cylinders are not dropped or impacted during movement. Special handling methods and tooling may be required to safely handle cylinders.

Handling procedures shall be available at the authorized inspection site.

Tests and examinations performed to demonstrate compliance shall be conducted using instruments calibrated before being put into service and thereafter according to an established programme.

Each cylinder shall be submitted to periodic inspection and testing. The following procedures form the requirements for this periodic inspection and testing and are explained more fully in this document in the noted Clauses:

- Identification of cylinder and preparation for periodic inspection and testing (see [Clause 6](#));
- External visual inspection (see [Clause 7](#));
- Safe removal of valve (see [8.1](#));
- Internal inspection and cleaning (see [8.2](#));
- Pressure test (see [Clause 9](#));
- Leak test (see [Clause 10](#));
- Inspection of valve (see [Clause 11](#));
- Final operations (see [Clause 12](#)); and
- Rejection and rendering cylinders unserviceable (see [Clause 13](#)).

The external and internal visual examination (see [Clauses 7](#) and [8](#)) shall be carried out prior to the pressure test (see [Clause 9](#)). It is recommended that the other tests are performed in the sequence listed above; however, when a valve has to be removed, the requirements in ISO 25760 shall be followed.

Cylinders that fail inspection or testing shall be rejected (see [Clause 13](#)). When a cylinder passes the above-listed procedures but the condition of the cylinder remains in doubt, additional testing shall be performed to confirm its suitability for continued service or the cylinder shall be rendered unserviceable. Depending on the reason for the rejection, cylinders may be recovered and/or repaired (see [7.4](#)).

5.2 Heat exposure

When cylinders are refurbished during periodic inspection, it might be necessary to expose them to heat, for example, during initial cleaning, or as part of a stoving operation when painting or powder coating the cylinder. This heat exposure can affect the mechanical properties of the liners and/or the finished composite cylinder.

It is therefore essential that information on precise heat-effect temperatures from the cylinder manufacturer be available; in the absence of this information, cylinders shall not be exposed to a temperature exceeding 70 °C during refurbishment. If the cylinder manufacturer confirms (i.e. either on a cylinder label or through documentation) that the allowable temperature is greater than 70 °C, then the manufacturer's recommendations shall be followed during refurbishment.

6 Identification of cylinder and preparation for periodic inspection and testing

Before any work is carried out, the relevant cylinder marks (e.g. see ISO 13769) and the gas contents (e.g. see ISO 7225) shall be identified. First, the marking shall be checked to ensure that the cylinder in question is within its design life. When composite cylinders have been designed and manufactured for a limited design life, this is indicated on the cylinder marking.

The cylinder shall be depressurized and emptied in a safe, controlled manner before proceeding. For Type 4 and Type 5 cylinders, take necessary precautions and/or consult the cylinder manufacturer for depressurization procedures to avoid damaging the cylinder.

WARNING — The uncontrolled opening and/or removal of valves from cylinders can lead to injury, death and/or property damage.

Prior to valve removal, the user shall follow procedures described in ISO 25760. A check shall be made to ensure that the cylinder is empty of gas. Provided the requirements as stated in ISO 25760 have been complied with, the cylinder shall be depressurized safely and the valve removed.

Cylinders with unknown gas contents shall be emptied as if the gas is dangerous (i.e. toxic, flammable or oxidizing) as described in ISO 25760.

When the valve is non-functional, cylinders shall be emptied safely as described in ISO 25760.

Access shall be provided to the entire external surface of the cylinder for visual inspection and measurement.

7 External visual inspection

7.1 Preparation

7.1.1 General

The composite material including any exterior coating applied for protection shall not be removed for the visual inspection.

Composite cylinders differ from their metal counterparts in that a competent person may repair them when only limited damage has taken place (see 7.4). These limits are defined in Table 1; following this repair, cylinders shall be subjected to a pressure test before being returned to service.

If the cylinder identification label is illegible, the manufacturer shall be contacted or the cylinder shall be rejected in accordance with Clause 13.

The manufacturer may provide a supplementary identification label to the cylinder if, as a minimum, the original label's serial number is still clearly legible.