
**Nuclear energy — Packagings for the
transport of uranium hexafluoride
(UF₆)**

*Energie nucléaire — Emballages pour le transport de l'hexafluorure
d'uranium (UF₆)*

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Contents

	Page
Foreword	vii
Introduction	ix
1 Scope	1
2 Normative references	1
3 Terms and definitions	3
4 Management system	5
5 General requirements for cylinders and valve protection	5
5.1 Design of cylinders and valve protection	5
5.2 Fabrication of new cylinders	6
5.2.1 General	6
5.2.2 Radiography and other non-destructive examinations (NDEs)	7
5.2.3 Testing	7
5.2.4 Cylinder marking	8
5.2.5 Reports, certification, and records	8
5.2.6 Outer surface	9
5.2.7 Cleanliness	9
5.2.8 Standard cylinders	10
5.3 In-service cylinders and valve protection	10
5.3.1 Cleanliness	10
5.3.2 Testing	10
5.3.3 Routine inspections	11
5.3.4 Periodic inspections and tests	12
5.3.5 Cylinder maintenance/repair/alteration	14
5.3.6 Maintenance of valves specified in 8.2 and 8.3	14
6 Specific requirements for cylinders and valve protection	15
6.1 1S Cylinder	15
6.1.1 Design conditions	15
6.1.2 Materials	15
6.1.3 Fabrication	15
6.1.4 Radiography	15
6.1.5 Valve	15
6.1.6 Plug	15
6.1.7 Valve installation	15
6.1.8 Testing	16
6.1.9 Cylinder marking	16
6.1.10 Cleaning	16
6.1.11 Certification	16
6.1.12 External surface treatment	16
6.2 2S Cylinder	16
6.2.1 Design conditions	16
6.2.2 Materials	16
6.2.3 Fabrication	16
6.2.4 Radiography	16
6.2.5 Valve	17
6.2.6 Plug	17
6.2.7 Valve installation	17
6.2.8 Testing	17
6.2.9 Cylinder marking	17
6.2.10 Cleaning	17
6.2.11 Certification	17
6.2.12 External surface treatment	17
6.3 5B Cylinder	17

6.3.1	Design conditions	17
6.3.2	Materials	17
6.3.3	Fabrication	18
6.3.4	Radiography	18
6.3.5	Valve	18
6.3.6	Plug	18
6.3.7	Valve installation	18
6.3.8	Testing	18
6.3.9	Cylinder marking	18
6.3.10	Cleaning	18
6.3.11	Certification	18
6.3.12	External surface treatment	18
6.4	8A Cylinder	19
6.4.1	Design conditions	19
6.4.2	Materials	19
6.4.3	Fabrication	19
6.4.4	Radiography	19
6.4.5	Valve	19
6.4.6	Plug	19
6.4.7	Valve installation	19
6.4.8	Testing	19
6.4.9	Cylinder marking	19
6.4.10	Cleaning	20
6.4.11	Certification	20
6.4.12	External surface treatment	20
6.5	12B Cylinder	20
6.5.1	Design conditions	20
6.5.2	Materials	20
6.5.3	Fabrication	20
6.5.4	Radiography	20
6.5.5	Valve	20
6.5.6	Plug	20
6.5.7	Valve installation	21
6.5.8	Testing	21
6.5.9	Cylinder marking	21
6.5.10	Cleaning	21
6.5.11	Certification	21
6.5.12	External surface treatment	21
6.6	30B Cylinder	21
6.6.1	Design conditions	21
6.6.2	Materials	21
6.6.3	Fabrication	22
6.6.4	Radiography	22
6.6.5	Valve	22
6.6.6	Plug	22
6.6.7	Valve and plug installation	22
6.6.8	Testing	22
6.6.9	Cylinder marking	22
6.6.10	Cleaning	22
6.6.11	Certification	22
6.6.12	External surface treatment	22
6.7	30C Cylinder	22
6.7.1	Design conditions	22
6.7.2	Materials	22
6.7.3	Fabrication	23
6.7.4	Radiography and non-destructive examination (NDE)	23
6.7.5	Valve	23
6.7.6	Plug	23

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ISO 7195:2020

<https://standards.iteh.ai/catalog/standards/sist/edcc3527-b790-447a-8d95->

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6.7.7	Valve and plug installation	23
6.7.8	Testing	23
6.7.9	Cylinder marking	23
6.7.10	Cleaning	24
6.7.11	Certification	24
6.7.12	External surface treatment	24
6.8	48Y or 48X cylinder	24
6.8.1	Design conditions	24
6.8.2	Materials	24
6.8.3	Fabrication	25
6.8.4	Radiography	25
6.8.5	Valve	25
6.8.6	Plug	25
6.8.7	Valve and plug installation	25
6.8.8	Testing	25
6.8.9	Cylinder marking	25
6.8.10	Cleaning	26
6.8.11	Certification	26
6.8.12	External surface treatment	26
7	General requirements for cylinder valves and plugs	26
7.1	Manufacturing process for valves and plugs	26
7.1.1	Process	26
7.1.2	Materials	26
7.1.3	Material test report	26
7.1.4	Manufacturing	27
7.1.5	Material stress-relief specifications	27
7.1.6	Cleaning	27
7.1.7	Tinning of valves and plugs	27
7.1.8	Assembly of valves	28
7.1.9	Testing of valves	29
7.1.10	Packaging of valves and plugs	30
7.1.11	Certification	30
7.2	Installation of valves and plugs specified in 8.3 and 8.4	30
8	Specific requirements for cylinder valves and plugs	31
8.1	Valves for 1S and 2S cylinders	31
8.1.1	General	31
8.1.2	Design conditions	31
8.1.3	Materials	31
8.1.4	Marking	32
8.2	Cylinder valve 50 (3/4 in)	32
8.2.1	Design conditions	32
8.2.2	Materials	32
8.2.3	Material test report	32
8.2.4	Manufacturing	32
8.2.5	Cleaning	32
8.2.6	Tinning	33
8.2.7	Assembly	33
8.2.8	Testing	33
8.3	Cylinder valve 51 (1 in)	33
8.3.1	Design conditions	33
8.3.2	Materials	33
8.3.3	Material test report	34
8.3.4	Manufacturing	34
8.3.5	Cleaning	34
8.3.6	Tinning	34
8.3.7	Assembly	34
8.3.8	Testing	34

8.4	Plug	34
8.4.1	Design conditions	34
8.4.2	Materials	35
8.4.3	Machining	35
8.4.4	Cleaning	35
8.4.5	Tinning	35
8.4.6	Certification	35
9	Shipping	35
9.1	Tamper indication	35
9.2	New cylinders	36
9.3	Clean and washed out cylinders	36
9.4	Other cylinders	36
9.5	Outer protection	36
	Bibliography	91

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[ISO 7195:2020](https://standards.iteh.ai/catalog/standards/sist/cdcc3527-b790-447a-8d95-c2047f860714/iso-7195-2020)

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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 (standards.iteh.ai)

This document was prepared by Technical Committee ISO/TC 85, *Nuclear energy, nuclear technologies, and radiological protection*, Subcommittee SC 5, *Nuclear installations, processes and fuel technologies, WG4, Transport of radioactive material*.
ISO 7195:2020
<https://standards.iteh.ai/catalog/standards/sist/cdccc3527-b790-447a-8d95-c2047f860714/iso-7195-2020>

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.

This third edition cancels and replaces the second edition (ISO 7195:2005), which has been technically revised. The main changes compared to the previous edition are:

- The title of the document has been slightly changed to better reflect its scope;
- The general structure of the document has been partly reorganized to enhance clarity and to ease comparison with ANSI N14.1;
- The cylinder model 48G has been removed and the cylinder model 30C added;
- The socket head plugs for 30 in and 48 in cylinders have been added (alternative to hex head plugs);
- The list of references and the list of terms and definitions used have been updated;
- “Quality assurance programme” has been replaced by “management system”;
- Clauses related to manufacture, periodic inspection and recertification have been redrafted for better clarity;
- The possibility for 30B, 48X and 48Y cylinders to use non-destructive examinations as an alternative to hydrostatic testing during their periodic inspections, with the condition that additional examinations are carried out at the time of their manufacturing, has been introduced;
- The use of leak test methods other than the specified one is now permitted;

- The existing tie down requirements have been replaced by a reference to the new Appendix IV of IAEA SSG-26;
- The reuse of valves and plugs removed from cylinders is no longer permitted;
- All the figures have been revised to correct errors, increase clarity and add missing information.

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Introduction

The transport of uranium hexafluoride (UF_6) is an essential operation in the nuclear industry. The packaging and transport of UF_6 is subject to the relevant transport regulations for dangerous goods of each of the countries through or into which the material is transported. This document does not take precedence over applicable regulations, nor does it relieve the consignor and other parties from compliance with these regulations. For more detailed information, the user of this document is encouraged to consult the appropriate regulatory document.

According to IAEA Regulations for the Safe Transport of Radioactive Material (SSR-6), and all regulations based on, except as allowed in its para. 634, uranium hexafluoride in quantities of 0,1 kg or more is required to be packaged and transported in accordance with the provisions of this document.

ANSI N14.1 has been used internationally as an industry reference and the standard cylinders included in ANSI N14.1 have been used widely for international transport of UF_6 . However, in some cases minor adaptations of the American standard were required to meet local conditions in a particular country. For example, equivalent materials may have been used instead of the materials specified. Moreover, the certification of cylinders as pressure vessels can have required equivalent authorization procedures appropriate in the countries concerned, rather than the US procedure specified.

This document presents primarily information on UF_6 packagings (including cylinders and valve protection). It is intended to provide for compatibility of UF_6 cylinders among different users within the nuclear industry. It has been developed from ANSI N14.1, but with incorporation of, and allowance for, other equivalent materials and national certification procedures.

Throughout this document and in conformity with standard ISO practice, SI metric units are used in preference to imperial units (which are given in parenthesis for information). However, generic cylinder designations are based on the diameter expressed in imperial units (48" for instance).

If a common, commercially available component uses features that are defined in an appropriate non-SI metric-based Standard document, only the relevant base units are quoted.

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Nuclear energy — Packagings for the transport of uranium hexafluoride (UF₆)

1 Scope

This document provides the following:

- specifications for cylinders for the transport of uranium hexafluoride (UF₆) to provide compatibility among different users,
- description of cylinder designs, but is not intended to develop new designs,
- fabrication requirements for the procurement of new cylinders designed for the transport of 0,1 kg or more of uranium hexafluoride,
- fabrication requirements for the procurement of new valve protections, valves and plugs, and
- requirements for cylinders and valve protections in service.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitute 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 263, *ISO inch screw threads — General plan and selection for screws, bolts and nuts — Diameter range 0,06 to 6 in*

ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method*

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

ISO 12807, *Safe transport of radioactive materials — Leakage testing on packages*

ANSI/ASME B1.1, *Unified Inch Screw Threads (UN and UNR Thread Form)*

ANSI/ASME B1.5, *Acme Screw Threads*

ANSI/ASME B1.20.1, *Pipe Threads, General Purpose (Inch)*

ANSI/ASME B16.11, *Forged Steel Fittings, Socket-Welding and Threaded*

ANSI/AWS A5.8M/A5.8, *Specification for Filler Metals for Brazing and Braze Welding*

ANSI/AWS A5.14/A5.14M, *Specification for Nickel and Nickel-Alloy Bare Welding Electrodes and Rods*

ANSI/AWS D1.1/D1.1M, *Structural Welding Code — Steel*

ANSI/CGA V-1, *Standard for Compressed Gas Cylinder Valve Outlet and Inlet Connections*

ASTM A20/A20M, *Standard Specification for General Requirements for Steel Plates for Pressure Vessels*

ASTM A36/A36M, *Standard Specification for Carbon Structural Steel*

ASTM A53/A53M, *Standard Specification for Pipe, Black and Hot-Dipped, Zinc-Coated, Welded and Seamless*

ASTM A105/A105M, *Standard Specification for Carbon Steel Forgings for Piping Applications*

ISO 7195:2020(E)

ASTM A106/A106M, *Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service*

ASTM A108, *Standard Specification for Steel Bar, Carbon and Alloy, Cold-Finished*

ASTM A131/A131M, *Standard Specification for Structural Steel for Ships*

ASTM A193/A193M, *Standard Specification for Alloy-Steel and Stainless Steel Bolting Materials for High Temperature or High Pressure Service and Other Special Purpose Applications*

ASTM A234/A234M, *Standard Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperature Service*

ASTM A240/A240M, *Standard Specification for Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels and for General Applications*

ASTM A285/A285M, *Standard Specification for Pressure Vessel Plates, Carbon Steel, Low and Intermediate-Tensile Strength*

ASTM A354, *Standard Specification for Quenched and Tempered Alloy Steel Bolts, Studs, and Other Externally Threaded Fasteners*

ASTM A516/A516M, *Standard Specification for Pressure Vessel Plates, Carbon Steel for Moderate- and Lower-Temperature Service*

ASTM A574, *Standard Specification for Alloy Steel Socket-Head Cap Screws*

ASTM A575, *Standard Specification for Steel Bars, Carbon, Merchant Quality, M-Grades*

ASTM B16/B16M, *Standard Specification for Free-Cutting Brass Rod, Bar and Shapes for Use in Screw Machines*

ASTM B32, *Standard Specification for Solder Metal*

ASTM B127, *Standard Specification for Nickel-Copper Alloy (UNS N04400) Plate, Sheet, and Strip*

ASTM B150/B150M, *Standard Specification for Aluminum Bronze Rod, Bar, and Shapes*

ASTM B160, *Standard Specification for Nickel Rod and Bar*

ASTM B161, *Standard Specification for Nickel Seamless Pipe and Tube*

ASTM B162, *Standard Specification for Nickel Plate, Sheet, and Strip*

ASTM B164, *Standard Specification for Nickel-Copper Alloy Rod, Bar, and Wire*

ASTM B165, *Standard Specification for Nickel-Copper Alloy (UNS N04400) Seamless Pipe and Tube*

ASTM B209, *Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate*

ASTM B211, *Standard Specification for Aluminum and Aluminum-Alloy Bar, Rod, and Wire*

ASTM B249/B249M, *Standard Specification for General Requirements for Wrought Copper and Copper-Alloy Rod, Bar, Shapes and Forgings*

ASTM B366/B366M, *Standard Specification for Factory-Made Wrought Nickel and Nickel Alloy Fittings*

ASTM E2375, *Standard Practice for Ultrasonic Examination of Wrought Products*

IAEA SSR-6, *Regulations for the Safe Transport of Radioactive Material*

SAE J512, *Automotive Tube Fittings*

SAE J513, *Refrigeration Tube Fittings — General Specifications*

NUREG/CR-6407, *Classification of Transportation Packaging and Dry Spent Fuel Storage System Components According to Importance to Safety*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in the IAEA SSR-6 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>
- IEC Electropedia: available at <http://www.electropedia.org/>

NOTE 1 Units are those of the International System, with other units shown in brackets for information.

NOTE 2 Throughout this document, the words *suggested* and *typical* denote an example for weld constructions, dimensions and/or layout, and means that other solutions may be used provided they comply with the requirements in the code and this document, as appropriate.

NOTE 3 Throughout this document, the words *nominal* and *Schedule* qualify a thickness of a material from stock (plate, bar, pipe, etc.), for which the tolerance is according to the standard specification for the relevant material.

3.1

authorized inspector

individual who is qualified by the jurisdictional authority/inspection authority as requested by the code

3.2

clean and washed out cylinder

cylinder that has been previously used and has been cleaned to remove residual quantities of uranium and other contaminants

3.3

code

pressure vessel code that is acceptable to the transport competent authority

EXAMPLE Section VIII of ANSI/ASME Boiler and Pressure Vessel Code is an example.

3.4

competent authority

national or international regulatory body or authority designated or otherwise recognized as such for any purpose in connection with the relevant transport regulations for dangerous goods

3.5

competent inspector

individual who is qualified according to the owner's requirements regarding inspection activities as detailed in its quality assurance program

3.6

cylinder

pressure vessel, equipped with its valves and plugs, as applicable

3.7

fabricator

manufacturer, repairer, or modifier of cylinders and valve protection

3.8

heel

residual amount of UF₆ and/or non-volatile reaction products of uranium

3.9

heeled cylinder

cylinder containing a heel in quantities equal to or less than those specified

Note 1 to entry: See [Table 8](#).

3.10

jurisdictional authority/inspection authority

entity with the power, right, or authority to interpret and enforce laws, rules, or ordinances pertaining to the code

3.11

maximum allowable working pressure

MAWP

maximum allowable working pressure as defined by the code

3.12

minimum design metal temperature

MDMT

minimum design metal temperature as defined by the code

3.13

new cylinder

cylinder that has been cleaned to remove fabrication debris and contaminants that would react with UF₆ and that has never been filled with UF₆

3.14

owner

individual, agency, contractor, company, or corporation that carries or will carry title to the cylinder during its use

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3.15

outer protection

mechanical and/or thermal protection during transport for cylinders containing UF₆

3.16

package

packaging containing UF₆ or heel prepared for transport in compliance with the relevant transport regulations for dangerous goods

3.17

packaging

cylinder equipped with all its outer protection necessary to ensure the containment and the other safety functions of the package in compliance with the relevant transport regulations for dangerous goods

3.18

pressure vessel

container designed, fabricated, examined, inspected, tested and certified in accordance with the code

3.19

service life

period of time from initial stamping at the end of manufacturing until the pressure vessel is no longer suitable for transport of UF₆ and is not repaired and returned to service and/or scrapped to prevent further use

3.20

tare

cylinder mass with valve(s), including cap(s), and plug(s) without valve protection with an internal air or nitrogen total absolute pressure corrected to 34,5 kPa (5 lbf/in²)

3.21

water capacity

water mass in kilogram, corrected to a temperature of 15,6 °C (60 °F)

4 Management system

In alignment with the IAEA SSR-6, a management system based on international, national or other standards acceptable to the transport competent authority shall be established and implemented for all activities (including the manufacture, maintenance and repair of cylinder and outer protection) within the scope of this document, to ensure compliance with its relevant provisions. Certification that the design specification has been fully implemented shall be available to the transport competent authority. The manufacturer or owner shall be prepared:

- a) To provide facilities for inspection during manufacture and use;
- b) To demonstrate compliance with this document to the transport competent authority.

For guidance, see the IAEA SSG-26.

5 General requirements for cylinders and valve protection

5.1 Design of cylinders and valve protection

NOTE 1 Codes and standards listed in [Clause 2](#) with corresponding versions using metric units can be used interchangeably.

NOTE 2 With respect to this document, American Society of Mechanical Engineers (ASME) material and filler metal specifications, identified by the prefix “S,” are interchangeable with corresponding ASTM International (ASTM) and American Welding Society (AWS) specifications referenced herein and listed in [Clause 2](#).

Cylinders shall

- be as shown in [Figures 3](#) to [11](#) and in accordance with the requirements specified in [6.1](#) to [6.8](#), and
- comply with the code.

In order to minimize points of leakage, only one valve and one plug (where applicable) should be installed. However, if the purchaser deems additional valves or plugs necessary, they shall be installed in accordance with the requirements specified in [6.3](#) to [6.8](#).

Additional holes in skirts are permitted and shall be designed such that the fitness for purpose of the package is not impaired.

Details of pressure vessel (including skirts, stiffening rings, lifting lugs), valve, and plug are given in [Figures 1](#) to [16](#).

Valve protection for specific cylinders shall be as shown in [Figures 5](#) to [12](#).

Threads identified in this document shall conform to ISO 263 or ANSI/ASME B1.20.1, unless otherwise specified.

Metric units shown in this document may have been converted from Imperial units. Rounding of values is acceptable when not in conflict with the functional specification.

Annotations to dimensions used in figures: “typical” means “example” and “REF” means “indicative” only.

The parameters given in [Table 1](#), along with the values for the minimum volume shown in [Table 3](#), shall be the basis by which the pressure vessel parts of the various cylinders are designed.