

NOTES

- Cylinder for compressed and permanent and liquefied gases. Not for hydrogen or other embrittling gases (see EN ISO 11114-1).

Pos.	"D"	ØD _{1min}	L _{1min}
1	25E PN EN ISO 11363-1	38	22
2	W28,8x1/14keg-DIN477	41	22
3	W31,3x1/14keg-DIN477	36	18
4	1-11/2NGT -CGA V-1	41	22

OR THREAD ACC. TO CUSTOMER'S REQUEST

MECHANICAL PROPERTIES OF MANUFACTURED CYLINDER BODY AFTER QUENCHING AND TEMPERING

R _e N/mm ² min	R _m N/mm ²	A ₅ %	Impact strength values (transverse -50°C), J/cm ² Minimum wall thickness, mm 3 to 5
850	940-1099	14	≥ A - 30 ≥ B - 40

CHEMICAL COMPOSITION OF MATERIALS %

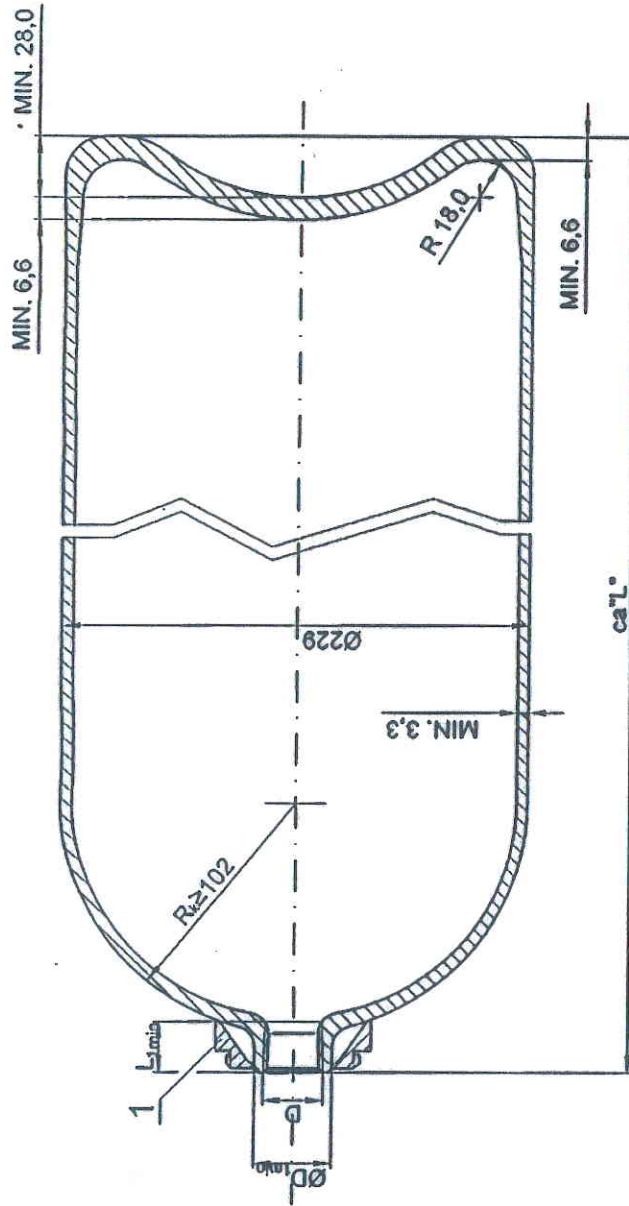
C=0,33-0,37%; Si=0,15-0,35%; Mn=0,70-0,90%;
 P<0,015%; S<0,010%; P+S<0,025%
 Cr=0,90-1,20%; Mo=0,17-0,30%; Ni<0,3%
 Σ V, Nb, Ti, B, Zr <0,15%
 Quench: °C 850±30°C - AQUA-QUENCH MK
 Temper: °C 590±30°C

	FAMILY RANGE	
Capacity [L]	20	50
Weight ca [kg]	25,5	43,0
Length ca [mm]	665	1460

DIMENSIONS AND WEIGHT

Length "L" ca mm	TECHNICAL DATA OF TYPICAL FAMILY CYLINDERS	
	40 L	50 L
1195	1460	1460
40,0	43,0	43,0

Weight without neck ring - ca kg



MANUFACTURING AND ACCEPTANCE

- Design and calculation of cylinder wall thickness made in accordance with EN 1964-1:1999, ISO 9809-1:1999 and EN ISO 9809-1:2010, Directive 2010/35/EU and ADR/RID 2013
- Test pressure: 200 bar
Working pressure up to: 133 bar

EXAMINED
 This document has been examined and given the status of a Design Appraisal Document numbered COV1412843
 Date: 24 Oct. 2014 Initial: RH
 Coventry Office
 Lloyd's Register EMEA
 CONSENT

TOLERANCES

capacity +5 %
 wall thickness -0 %
 weight +30 %
 outside diameter, +10 %
 -5 %
 ±1%

1	Neck ring (minimum weight ca 0,7 kg)	Neck ring W60 DIN 4664, EN ISO 11117 or W-952 or neck ring acc. to customer's request
Note		
Pos.	Name of parts	Changes
Designed by	P. Wojewódka	07.14
Drawn by	P. Wojewódka	07.14
Checked by	H. Pławski	07.14
Approved by	P. Kotłowiec	07.14
Signature	Date	
Surname	VITKOVICE MILMET S.A.	
Material	SOSNOWIEC	
Weight [kg]		34CrMo4 EN 10083
Name		Seamless steel cylinder Ø229
Drawing No.		LA4-0959
Scale		Revision