

Australian Standard™

**Steel cylinders for compressed gases—
Welded two-piece construction—0.1 kg
to 150 kg**

This Australian Standard was prepared by Committee ME-002, Gas Cylinders. It was approved on behalf of the Council of Standards Australia on 8 December 2004. This Standard was published on 4 January 2005.

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Air Conditioning and Refrigeration Wholesalers Association
Australasian Institute of Engineer Surveyors
Australian Chamber of Commerce and Industry
The Australian Gas Association
Australian Liquefied Petroleum Gas Association
Certification Bodies (Australia)
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STANDARDS AUSTRALIA

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OF

AS 2469—2005

Steel cylinders for compressed gases—Welded two-piece construction—0.1 kg to
150 kg

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NOTES

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PREFACE

This Standard was prepared by the Australian members of the Joint Standards Australia/Standards New Zealand Committee ME-002, Gas Cylinders to supersede AS 2469—1998, *Steel cylinders for compressed gases—Welded two-piece construction—0.1 kg to 35 kg*. After consultation with stakeholders in both countries, Standards Australia and Standards New Zealand decided to develop this Standard as an Australian, rather than an Australian/New Zealand Standard.

This Standard is one of a suite of three Standards for welded and brazed cylinders for compressed gases, the other Standards being as follows:

AS

- 2470 Steel cylinders for compressed gases—Welded three-piece construction with longitudinal joint—11 kg to 150 kg
- 3577 Steel cylinders for compressed gases—Welded—150 kg to 500 kg

This Standard provides for gas cylinders produced in large quantities. Users of this Standard should note that a competent person or body will require other quality control procedures to be employed at the point of manufacture in Australia, or, for cylinders manufactured overseas, sampling and testing at the point of entry into Australia. It should also be noted that before a gas cylinder can be first filled in Australia it must be stamped with a Certificated Gas Cylinder Test Station registered mark in accordance with the relevant Standard in the AS 2030 series.

The construction requirements now allow two piece welded cylinders to be made with capacities up to 150 kg water capacity. This brings this Standard into alignment with ISO 4706, *Refillable welded steel gas cylinders*.

The terms ‘normative’ and ‘informative’ have been used in this Standard to define the application of the appendix to which they apply. A ‘normative’ appendix is an integral part of a Standard, whereas an ‘informative’ appendix is only for information and guidance.

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STANDARDS AUSTRALIA

Australian Standard

Steel cylinders for compressed gases—Welded two-piece construction—0.1 kg to 150 kg**1 SCOPE**

This Standard specifies requirements for welded carbon and stainless steel cylinders with no longitudinal joint and one circumferential joint, of water capacity not less than 0.1 kg nor more than 150 kg, which have test pressures from 1750 kPa to 7000 kPa and are intended for the storage and transport of compressed gases in accordance with AS 2030.1. Requirements for pneumatic testing are given in Appendix A.

NOTES:

- 1 A gas cylinder manufactured by welding but which includes any brazing on or on, the pressure-retaining portions is for the purpose of this Standard considered to be a brazed gas cylinder.
- 2 Other Australian Standards for brazed and welded gas cylinders are AS 2468, AS 2470, and AS 3577.
- 3 Appendix B lists the suggested minimum information that should be supplied by the purchaser when ordering gas cylinders to this Standard.

2 REFERENCED DOCUMENTS

A list of documents referred to in this Standard is given in Appendix C.

3 DEFINITIONS

For the purpose of this Standard, the definitions given in AS 2030.1 and those below apply.

3.1 Attachment

Any fitting attached to the pressure-retaining sections of the cylinder by welding, including bosses, pads, valve protection rings, and footrings.

3.2 Inspection Body

A body responsible for inspection, which may cover any one or more of the following:

- (a) Design verification.
- (b) Fabrication inspection.
- (c) In-service inspection.

3.3 Inspector

A person, acceptable to the competent person or body, who ensures and certifies that all the inspections specified herein have been carried out and that the cylinders comply with all the requirements of this Standard.

4 MATERIAL**4.1 Steelmaking process**

The steel shall be made by the open hearth, basic oxygen, or an electric process, and shall be continuously cast. Production by the use of ingots is acceptable provided the steel is fully killed. Rimmed steels shall not be used for arc welded components.