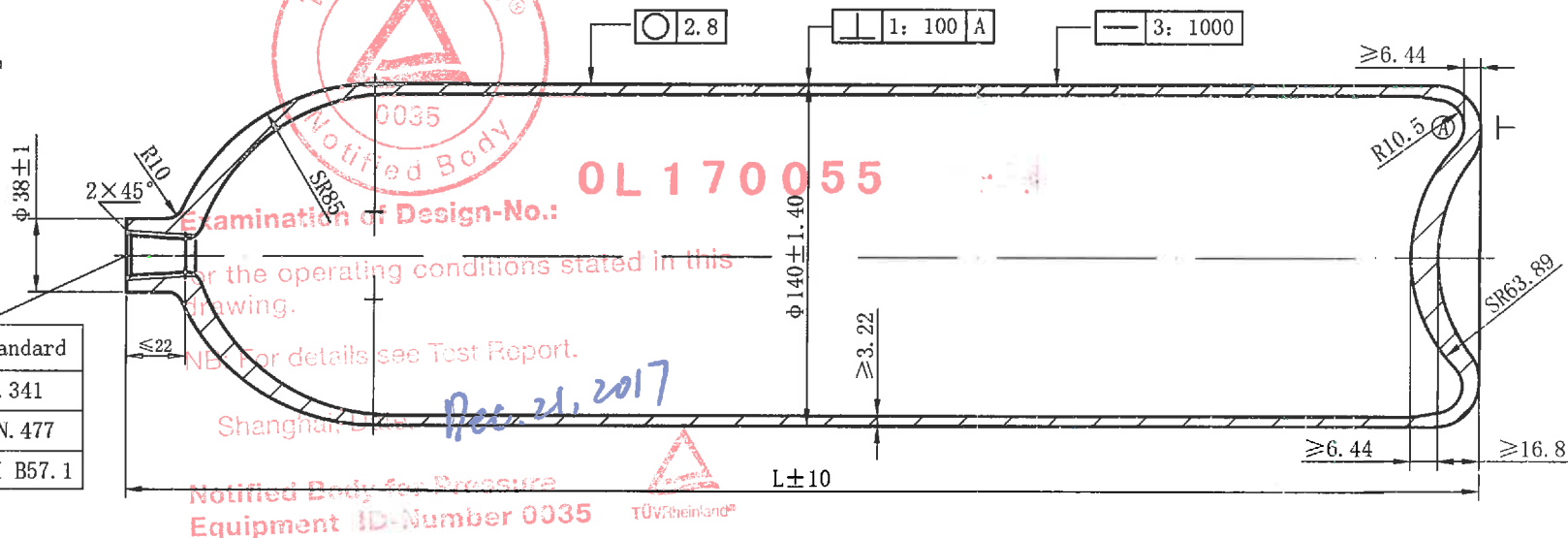




thread specification	standard
1"-14	BS. 341
W28.8	DIN. 477
3/4"NGT	ANSI B57. 1



- 1.The material is steel alloy ,the chemical composition is as follows:(in weight percent) (%)

	C	Mn	Si	S	P	S+P	Cr	Mo	Ni	V+Nb+Ti+B+Zr
34CrMo4	0.30~0.37	0.50~0.80	0.15~0.35	max0.010	max0.020	max0.025	0.90~1.20	0.15~0.25	max0.40	max0.15

2. All cylinders must be subjected to heat treatment (T) the mechanical property is as follows:

	$R_e(N/mm)^2$	$R_g(N/mm)^2$	A (%)	Hardness values (HB)	$a_{KV}(-50^\circ C)(J/cm^2)(\text{Longitudinal})$
34CrMo4	≥ 770	≥ 905	≥ 14	246~302	Minimum ≥ 48 Average ≥ 60

3. Sureface powder coating customer or standard request.
4. Design standards: ADR/RID 2017 & EN ISO9809-1:2010. The test pressure 300 bar. Max. working pressure 200bar.
5. Thread: 25E (EN629-1) W28.8 (DIN477).
6. Heat treatment: quenched and tempered ($q: 880 \pm 20^{\circ}\text{C}$, $t: 590 \pm 20^{\circ}\text{C}$).
7. In hydraulic burst test, the measured burst pressure shall be : $P_b \geq 480\text{bar}$ and the observed yield pressure shall be : $P_y \geq 392.7\text{bar}$.

Arrangements of stampmarkings

25E CN SINOMA XXXXXXXX UT
PW200 PH300BAR X. XXKG X. XXL 3. 22MM
ISO 9809-1 D  2017/5 Tr 0035

a	Serial number	
b	Flaw Detection	
c	Weight	
d	Volume	
e	Standard: ISO 9809-1	
f	the inspection stamp markings	 — IS  — XA

	min	Type approved	max
Water Volume(L) ($^{+5}_{-0}$)	4.0	10.0	15.0
Hight (H, mm) ($^{+10}_{-10}$)	380	820	1210
Weight (W, kg) ($\pm 5\%$)	7.0	14.0	20.0

DRAWN	王杰	DESCRIPTION	φ 140 GAS CYLINDER	SCALE	
CHECKED	陈新章	MATERIAL	34CrMo4	DATE	2017. 12. 05
APPROVED	王杰	DWG NO.	SZM1408/01 (原图号 SZB52-A-01)	ISSUE	