

N/A Oliver Zhu
Inspector

thread specification	standard
1"-14	BS341
W28.8-1/14	DIN. 477
3/4"-14-NGT	CGA V-1
25E	EN629
W27.8	GOST 9909-81

Examination of Design No. **OL 200012**

for the operating conditions stated in this drawing.

NB: For details see Test Report.

Shanghai, Date: **Apr. 15, 2020**

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

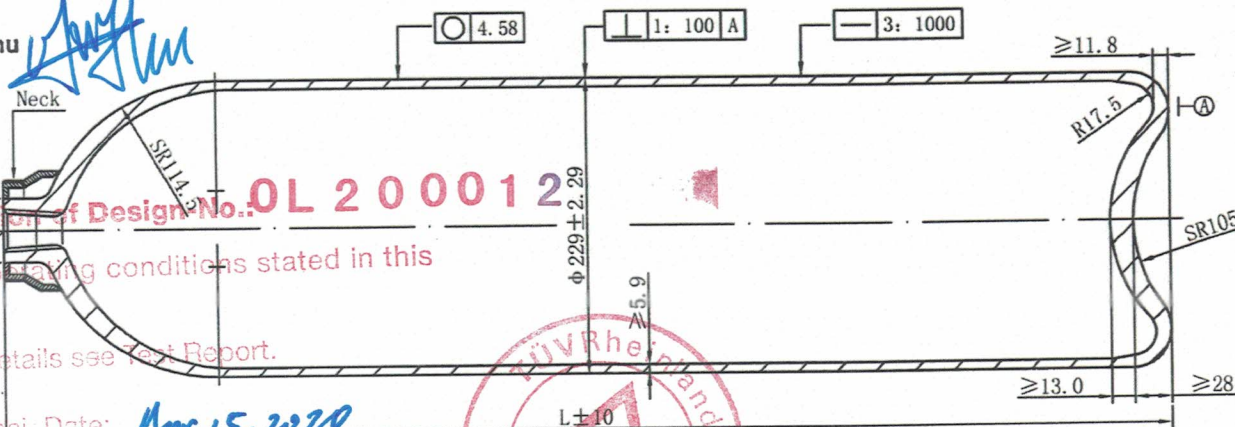
	C	Mn	Si	S	P	S+P	Cr	Mo	Ni	V+Nb+Ti+B+Zr
34CrMo4	0.30~0.37	0.50~0.80	0.15~0.35	max0.010	max0.020	max0.025	0.90~1.20	0.15~0.25	max0.40	max0.15

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

	R _m (N/mm ²)	R _{eH} (N/mm ²)	A(%)	Hardness values (HB)	a _{KV} (-50°C) (J/cm ²) (Transverse)
34CrMo4	≥680	≥800	≥14	238~280	Minimum ≥28 Average ≥35

Note: When the cylinder used to contain hydrogen, the maximum tensile strength shall be not more than 950MPa, and the measured yield ratio is not greater than 0.9.

3. Surface powder coating customer or standard request.
4. Design standards: ADR/RID 2019 & EN ISO9809-1:2010. The test pressure 300 bar. Max. working pressure 200bar.
5. Thread: 25E (EN629-1) W28.8 (DIN477) and more.
6. Neck: According to customer choice, The axial load of the neck is greater than 10 times the weight of the empty cylinder and not less than 1000N, and the torque for turning the neck is greater than 100N.m
7. Heat treatment: quenched and tempered (q: 870±20°C, t: 630±20°C).
8. 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 stamp markings

25E CN SINOMA	XXXXXXX	UT
PW200	PH300BAR	X. XXKG X. XXL 5.9MM
ISO 9809-1 D	2020/04	TT0035

(a)	Manufacturer's mark (SINOMA or SZ)
(b)	Serial number
(c)	Flaw Detection
(d)	Weight
(e)	Volume
(f)	Standard: ISO 9809-1
(g)	the inspection stamp markings
(1)	IS body
(2)	Xa body (0035)

	min	Type approved	max
Water Volume (L) (+5%/-0)	20.0	50.0	60.0
Hight (H, mm) (+10/-10)	655	1480	1755
Weight (W, kg) (±5KG)	28.5	59.0	69.0

DRAWN		DESCRIPTION	φ 229 GAS CYLINDER	SCALE	
CHECKED		MATERIAL	34CrMo4	DATE	2020.04.01
APPROVED		DWG NO.	SZM2205/01	ISSUE	