

# SEAMLESS STEEL CYLINDERS Ø 273

up to 90 Lt.

working pressure 200 bar



Seamless Steel Refillable Cylinders for compressed, mixed and liquefied gases COMPLYING WITH 99/36/CE DIRECTIVE (T-PED)						
REFERENCE TECHNICAL STANDARD:			EN 1964-1:1999			
Water capacity [l.] (-0) (+5%)	40	50	67.5	80	90	
Nominal weight [kg.]	47	55	70	81	90	
Length l [mm.] (±20)	900	1095	1430	1670	1860	
<b>Material:</b>	SEAMLESS STEEL TUBE		34CrMo4	(EN 10083-1)		
<b>MANUFACTURING DETAILS</b>						
MANUFACTURING PROCESS: HOT SPINNING OF SEAMLESS STEEL TUBE						
HEAT TREATMENT: QUENCHING AND TEMPERING						
MECHANICAL PROPERTIES (min.)						
R <sub>m</sub> [Mpa]	R <sub>e</sub> [Mpa]	A <sub>5</sub> [%]	KV IMPACT TEST AT -50 °C [J/cm <sup>2</sup> ]			
900	800	14	average on 3 specimens		single value	
HRC= 27 ÷ 34			40		32	
<b>DESIGN DATA</b>						
NECK THREAD (Alternative thread to customer's requirement)	Inl. thread	Ext. thread	Ø <sub>e</sub>	Ø <sub>i</sub>	h	
	25E EN 629-1	-	40	-	≈ 25	
	1" / 11.5 NGT	-	46	-	≈ 35	
	-	2,5" / 12UN-2A	-	48.8	≈ 60	
MINIMUM EFFECTIVE THICKNESS for the cylindrical wall, net of tolerance:					<b>6.3 mm</b>	
Working pressure: up to 200 bar		Test pressure = up to 300 bar		Burst pressure: ≥ 480 bar		
Working temperature: min. -50 °C; max +50 °C						
Filling ratio for liquefied gases: depending from type of gas Hydrogen, Carbon Monoxide and gases incompatible and/or corroding cylinder steel are excluded						

