



CGA C-20—2021
REQUALIFICATION STANDARD
FOR METALLIC,
DOT AND TC 3-SERIES
GAS CYLINDERS AND TUBES
USING ULTRASONIC TESTING

THIRD EDITION

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Work Item 17-033
Cylinder Specifications Committee

NOTE—Technical changes from the previous edition are underlined.

NOTE—Appendices A and D (Informative) are for information only.

NOTE—Appendices B and C (Normative) are requirements.

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Contents	Page
1 Introduction.....	5
2 Scope	5
3 Definitions.....	5
4 Personnel qualification and responsibilities.....	8
5 Ultrasonic testing equipment.....	9
5.1 Power supply.....	12
5.2 Analog-to-digital converter.....	12
5.3 Pulser/receiver.....	12
5.4 Rate generator.....	12
5.5 Transducer	13
5.6 Software (automated systems).....	13
5.7 Display.....	13
5.8 Instrument controls.....	15
5.9 Motion controls	15
5.10 Data storage.....	15
5.11 Ultrasonic testing equipment maintenance	15
6 System calibration	16
6.1 Calibration cylinder standard requirements.....	22
6.2 Required simulated defects in calibration standards	22
6.3 Ultrasonic testing system calibration procedure.....	25
6.4 Care and maintenance of calibration standard.....	26
6.5 Verification of equipment calibration.....	26
7 Examination procedures.....	26
7.1 Preliminary steps.....	27
7.2 Cylinder inspection	27
7.3 Ultrasonic testing of the cylinder.....	28
7.4 Requirements for ultrasonic testing.....	28
7.5 Monitoring of acoustic coupling	28
7.6 Procedure	29
7.7 Cylinder disposition	29
8 Ultrasonic testing acceptance/rejection criteria	29
9 Secondary ultrasonic testing evaluation and disposition.....	30
10 Reporting and documentation	30
11 Cylinder marking	31
12 References	31
13 Additional references.....	32
 Figures	
Figure 1—Example of a pulse-echo unit, block diagram.....	10
Figure 2—Example of ultrasonic testing equipment (cylinders).....	11
Figure 3—Example of ultrasonic testing equipment (tubes)	11
Figure 4—Example of ultrasonic testing equipment (cylinders).....	12
Figure 5a—Example of an analog A-scan display	13
Figure 5b—Example of a digital A-scan display.....	14
Figure 6—Example of a B-scan display	14
Figure 7—Example of a C-scan display.....	15

Figure 8a—Example of a calibration standard (cylinder)	23
Figure 8b—Example of a calibration standard (tube).....	24
Figure 9—Sidewall-to-base transition notch diagram	25
Figure 10—Example of typical sound path	26

Tables

Table 1a—Minimum required simulated defect criteria for calibration standards (U.S. units)	16
Table 1b—Minimum required simulated defect criteria for calibration standards (SI units).....	19
Table 2—Common cylinder diameter ranges allowed to test with referenced calibration standard diameter....	22

Appendices

Appendix A—Examples of common types of defects found in cylinders or tubes (Informative)	33
Appendix B—Manual ultrasonic testing technique selection (Normative).....	36
Appendix C—Ultrasonic testing secondary evaluation acceptance/rejection criteria (Normative).....	42
Appendix D—Relevant and nonrelevant indications (Informative).....	47

Appendices Figures

Figure A-1—Cracks in the transition area base—cylindrical part (Photo courtesy of Swiss TS)	33
Figure A-2—Detailed view of crack(s) in the transition area base (Photo courtesy of Swiss TS).....	33
Figure A-3—Detailed view of pitting corrosion in the transition area base cylindrical part— concave base (Photo courtesy of Swiss TS)	34
Figure A-4—Detailed view of crack in cylinder.....	34
Figure A-5—Detailed view of pitting corrosion in a cylinder.....	35
Figure C-1—Flaw envelope (l x a) required by acceptance/rejection criteria.....	42
Figure C-2—Requirements for treating multiple flaws as a single large flaw	42

Appendix Table

Table C-1a—Ultrasonic examination secondary evaluation acceptance/rejection criteria (U.S. units).....	43
Table C-1b—Ultrasonic examination secondary evaluation acceptance/rejection criteria (SI Units).....	45

1 Introduction

This standard is used for the requalification of metallic seamless cylinders and tubes using ultrasonic testing (UT).

UT of cylinders and tubes provides for measurement of wall thickness and detection of both internal and external pits, cracks, and other flaws that cannot be easily discerned by visual inspection or hydrostatic test methods. UT can be performed without removal of the valve and contents.

A cylinder or tube that has been rejected by UT shall not be subsequently requalified for continued service by the use of the hydrostatic test method.

WARNING: *Cylinder requalification can subject the personnel performing examinations to certain hazards such as exposure to containers under pressure and flammable or toxic gases, which can result in death or serious injury.*

2 Scope

This standard identifies and describes the various acceptable UT methods (also known as ultrasonic examination [UE] methods) that may be used in place of internal visual inspection and hydrostatic requalification methods used to examine certain metallic, U.S. Department of Transportation (DOT)/Transport Canada (TC) 3-series gas cylinders and tubes as mandated by Title 49 of the U.S. *Code of Federal Regulations* (49 CFR) and TC's *Transportation of Dangerous Goods Regulations*, and cylinders manufactured under certain DOT special permits or TC equivalency certificates [1, 2].¹ This standard also specifies the allowable flaw acceptance/rejection criteria to be used. This standard may also be applied to other seamless steel and aluminum alloy cylinders and tubes when authorized by the regulatory authority.

Aluminum alloy cylinders susceptible to sustained load cracking such as those manufactured from 6351 aluminum alloy shall also have the shoulder and neck area internally visually inspected and an eddy current examination of neck threads completed in accordance with established regulatory requirements.

This standard does not address any safety, health, or environmental considerations associated with UT or regulations and codes. Operating procedures and processes regarding worker safety precautions and requirements shall be met. See additional references in Section 13.

3 Definitions

For the purpose of this publication, the following definitions apply.

3.1 Publication terminology

3.1.1 Shall

Indicates that the procedure is mandatory. It is used wherever the criterion for conformance to specific recommendations allows no deviation.

3.1.2 Should

Indicates that a procedure is recommended.

3.1.3 May

Indicate that the procedure is optional.

3.1.4 Will

Is used only to indicate the future, not a degree of requirement.

3.1.5 Can

Indicates a possibility or ability.

¹ References are shown by bracketed numbers and are listed in order of appearance in the reference section.