



Institut luxembourgeois de la normalisation  
de l'accréditation, de la sécurité et qualité  
des produits et services

## ILNAS-EN 12807:2019

### **LPG equipment and accessories - Transportable refillable brazed steel cylinders for liquefied petroleum gas (LPG) - Design and construction**

Équipement et accessoires pour GPL -  
Bouteilles transportables et  
rechargeables en acier brasé pour gaz de  
pétrole liquéfié (GPL) - Conception et

Flüssiggas-Geräte und Ausrüstungsteile -  
Ortsbewegliche, wiederbefüllbare,  
hartgelötete Flaschen aus Stahl für  
Flüssiggas (LPG) - Auslegung und

07/2019



## National Foreword

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EUROPEAN STANDARD <sup>ILNAS-EN 12807:2019</sup> **EN 12807**  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

July 2019

ICS 23.020.35

Supersedes EN 12807:2009

English Version

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brazed steel cylinders for liquefied petroleum gas (LPG) -  
Design and construction**

Équipement et accessoires pour GPL - Bouteilles  
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Flüssiggas-Geräte und Ausrüstungsteile -  
Ortsbewegliche, wiederbefüllbare, hartgelötete  
Flaschen aus Stahl für Flüssiggas (LPG) - Auslegung  
und Herstellung

This European Standard was approved by CEN on 15 March 2019.

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EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels**

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## European foreword

This document (EN 12807:2019) has been prepared by Technical Committee CEN/TC 286 “Liquefied petroleum gas equipment and accessories”, the secretariat of which is held by NSAI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2020, and conflicting national standards shall be withdrawn at the latest by January 2020.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 12807:2009.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association.

The main technical changes include the updating of:

- the normative references;
- the environmental considerations; and
- definitions.

This document has been submitted for reference into the RID [6] and/or in the ADR [5].

All stages of the manufacture, distribution and disposal of these cylinders may have an effect on the environment; CEN/TS 16765 sets out environmental considerations for this document.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, North Macedonia, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

## Introduction

This document calls for the use of substances and procedures that may be injurious to health if adequate precautions are not taken. It refers only to technical suitability and does not absolve the user from legal obligations relating to health and safety at any stage.

It has been assumed in the drafting of this document that the execution of its provisions is entrusted to appropriately qualified and experienced people.

All pressures are gauge unless otherwise stated.

NOTE This document requires measurement of material properties, dimensions and pressures. All such measurements are subject to a degree of uncertainty due to tolerances in measuring equipment, etc. It may be beneficial to refer to the leaflet “measurement uncertainty leaflet (SP INFO 2000 27 uncertainty pdf)” [7].

## 1 Scope

This document specifies the minimum requirements for the design, construction and testing during manufacture of transportable refillable brazed steel Liquefied Petroleum Gas (LPG) cylinders, of water capacity from 0,5 l up to and including 15 l, exposed to ambient temperatures.

This document applies only to cylinders having a circular cross-section without any longitudinal joint.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 1044<sup>1</sup>, *Brazing — Filler metals*

EN 10002-1<sup>2</sup>, *Metallic materials - Tensile testing — Part 1: Method of test at ambient temperature*

EN 10204, *Metallic products — Types of inspection documents*

EN 12797, *Brazing — Destructive tests of brazed joints*

EN 12799:2000, *Brazing — Non-destructive examination of brazed joints*

EN 13134, *Brazing — Procedure approval*

EN 14894, *LPG equipment and accessories — Cylinder and drum marking*

CEN/TS 16765, *LPG equipment and accessories — Environmental considerations for CEN/TC 286 standards*

EN ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature (ISO 6892-1)*

EN ISO 11117:2008, *Gas cylinders — Valve protection caps and valve guards — Design, construction and tests (ISO 11117:2008)*

EN ISO 11363-1, *Gas cylinders - 17E and 25E taper threads for connection of valves to gas cylinders – Part 1: Specifications (ISO 11363-1)*

EN ISO 13585, *Brazing — Qualification test of brazers and brazing operators (ISO 13585)*

EN ISO 17672, *Brazing — Filler metals (ISO 17672)*

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<sup>1</sup> This standard has been withdrawn and was replaced by EN ISO 17672.

<sup>2</sup> This standard has been withdrawn and was replaced by EN ISO 6892-1.