TECHNICAL REPORT

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Gas cylinders — Refillable seamless steel — Performance tests —

Part 3:
Fracture performance tests — Cyclical burst tests

Bouteilles à gaz — Rechargeables en acier sans soudure — Essais de performance —

Partie 3: Essais de mode de rupture — Essais de rupture cyclique

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

In exceptional circumstances, when a technical committee has collected data of a different kind from that which is normally published as an International Standard ("state of the art", for example), it may decide by a simple majority vote of its participating members to publish a Technical Report. A Technical Report is entirely informative in nature and does not have to be reviewed until the data it provides are considered to be no longer valid or useful.

Attention is drawn to the possibility that some of the elements of this part of ISO/TR 12391 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO/TR 12391-3 was prepared by Technical Committee ISO/TC 58, *Gas cylinders*, Subcommittee SC 3, *Cylinder design*.

ISO/TR 12391 consists of the following parts, under the general title *Gas cylinders — Refillable seamless steel — Performance tests*:

— *Part 1: Philosophy, background and conclusions*

— *Part 2: Fracture performance tests — Monotonic burst tests*

— *Part 3: Fracture performance tests — Cyclical burst tests*

— *Part 4: Flawed-cylinder cycle test*

Introduction

Gas cylinders as specified in ISO 9809-1 have been constructed of steel with a maximum tensile strength of less than 1 100 MPa. With the technical changes in steel-making using a two-stage process, referred to as ladle metallurgy or secondary refining, significant improvement in mechanical properties have been achieved. These improved mechanical properties provide the opportunity of producing gas cylinders with higher tensile strength and which achieve a lower ratio of steel to gas weight. The major concern in using steels of higher tensile strength with correspondingly higher design wall stress is safety throughout the life of the gas cylinder.

When ISO/TC 58/SC 3 began drafting ISO 9809-2, Working Group 14 was formed to study the need for additional controls for the manufacture of steel gas cylinders having a tensile strength greater than 1 100 MPa.

This part of ISO/TR 12391 presents all of the specific test results of the monotonic, flawed-cylinder burst tests that were conducted in order to evaluate the fracture performance of cylinders ranging in tensile strength from less 750 MPa to greater than 1 210 MPa.

Gas cylinders — Refillable seamless steel — Performance tests —

Part 3:
Fracture performance tests — Cyclical burst tests

1 Scope

This part of ISO/TR 12391 applies to seamless refillable cylinders of all sizes from 0,5 l up to and including 150 l water capacity produced of steel with tensile strength (R_m) greater than 1 100 MPa.

It can also be applied to cylinders produced from steels used at lower tensile strengths. In particular, it provides the technical rationale and background to guide future alterations of existing ISO standards or for developing advanced design standards.

This part of ISO/TR 12391 is a summary and compilation of the test results obtained during the development of the "flawed-cylinder cyclical burst test". The test is an alternate test method to the flawed-cylinder burst test with monotonic pressurization and is used to evaluate the fracture performance of steel cylinders which are used to transport high-pressure compressed gases.

The concept and development of the flawed-cylinder cyclical burst test is described in ISO/TR 12391-1. The details of the test method and the criteria for acceptable fracture performance of steel cylinders are given in 9.2.5.3.2 of ISO 9809-2:2000. In this part of ISO/TR 12391, test results are reported for more than one hundred flawed-cylinder cyclical burst tests that were conducted on seamless steel cylinders that ranged in tensile strength from 750 MPa to 1 210 MPa. The test method is intended to be used both for the selection of materials and to establish design parameters in the development of new cylinders as well as for an efficient quality control test to be used during the production of cylinders.

2 References

ISO 148:1983, *Steel — Charpy impact test (V-notch)*

ISO 6892:1998, *Metallic materials — Tensile testing at ambient temperature*

ISO 9809-1:1999, *Gas cylinders — Refillable seamless steel gas cylinders — Design, construction and testing — Part 1: Quenched and tempered steel cylinders with tensile strength less than 1 100 MPa*

ISO 9809-2:2000, *Gas cylinders — Refillable seamless steel gas cylinders — Design, construction and testing – Part 2: Quenched and tempered steel cylinders with tensile strength greater than or equal to 1 100 MPa*

ISO/TR 12391-1, *Gas cylinders — Refillable seamless steel — Performance tests — Part 1: Philosophy, background and conclusions*

ISO/TR 12391-2, *Gas cylinders — Refillable seamless steel — Performance tests — Part 2: Fracture performance tests — Monotonic burst tests*

3 Symbols

A is the elongation, expressed as a percentage (= d/t_d);

d is the flaw depth, expressed in millimetres (= $A \times t_d$);

D is the outside diameter of the cylinder, expressed in millimetres;

l_o is the flaw length, expressed in millimetres (= $n \times t_d$);

n represents multiples of t_d (= l_o/t_d);

P_f is the failure pressure measured in the flawed-cylinder burst test expressed in bar.

P_h is the calculated design test pressure for the cylinder, expressed in bar;

P_s is the calculated design service pressure for the cylinder, expressed in bar;

R_e is the guaranteed minimum yield strength;

R_{ea} is the actual measured value of yield strength, expressed in megapascals;

$R_{g,\,max}$ is the maximum value of tensile strength guaranteed by the manufacturer, expressed in megapascals;

$R_{g,\,min}$ is the minimum value of tensile strength guaranteed by the manufacturer, expressed in megapascals;

R_m is the actual measured value of tensile strength, expressed in megapascals;

t_a is the actual measured wall thickness at the location of the flaw, expressed in millimetres;

t_d is the calculated minimum design wall thickness, expressed in millimetres.

4 Background information

High-pressure industrial gases (such as oxygen, nitrogen, argon, hydrogen, helium, etc.) are stored and transported in portable steel cylinders. These cylinders are designed, manufactured, and maintained in accordance with ISO 9809-1 and ISO 9809-2. The cylinders are constructed from specified alloy steels that are generally modified versions of steel alloys such as AISI 4130 or 34 Cr Mo 4 and AISI 4140 [1] or equivalent steels made to other national specifications. The cylinders are of seamless construction and are manufactured by either a forging process, a tube-drawing process, or by a plate-drawing process. The required mechanical properties are obtained by using an austenitizing, quenching and tempering heat treatment. Typical sizes of these cylinders are 100 mm to 250 mm in diameter, 500 mm to 2 000 mm in length, and 3 mm to 20 mm in wall thickness. Typical working pressure ranges from 100 bar to 400 bar.

Until recently, the tensile strength of the steels used in the construction of such cylinders has been limited to a maximum of about 1 100 MPa. This limitation for the maximum tensile strength occurs because the fracture toughness of the steels decreases with increase in the tensile strength and above a tensile strength of about 1 100 MPa the fracture toughness was not adequate to prevent fracture of the cylinders. Recently developed new alloy steels, which are modifications of the AISI 4130 and AISI 4140 steels, which have both high tensile strength and high fracture toughness make it possible to construct lighter cylinders with higher tensile strength steels. This permits the use of cylinder designs in which the stress in the cylinder wall is increased for a constant wall thickness. The use of higher strength steels will therefore achieve a lower ratio of steel weight to gas weight that reduces shipping and handling costs.

A major concern in using higher strength steels for cylinder construction and correspondingly higher design wall stress is the ability to maintain the same level of safety throughout the life of the cylinder. In particular, increasing the tensile strength of the steels and increasing the stress in the wall of the cylinders could make the cylinders less fracture resistant than cylinders made out of steels with the traditionally used lower tensile strength levels. In order to use steels with strength levels higher than 1 100 MPa, it was determined that new requirements were needed to assure adequate fracture resistance of the cylinders.

To develop these requirements, a working group on cylinder fracture (WG 14) was formed under ISO/TC 58/SC 3. WG 14 was assigned the task of: “developing a suitable test method and specifications to assure adequate fracture resistance for gas cylinders made from steels with tensile strengths greater than 1 100 MPa". WG 14 decided that the test method and specifications that were developed should demonstrate that the overall “fracture resistance” of cylinders made out of higher strength steels was equivalent to that of cylinders made from lower strength steels. Fracture resistance of the cylinder is defined as the adequate fracture initiation strength in the presence of a crack-like flaw to assure leak rather than fracture performance of the cylinder at a specified failure pressure (usually the marked service pressure of the cylinder).

The test methods and procedures that have previously been used to evaluate the fracture performance of high pressure cylinders have been based either on fracture mechanics tests and analysis or have been based on empirical correlations with the Charpy-V-notch (CVN) test impact energy [4]. The objectives of these test methods and procedures are to predict the fracture initiation stress (or pressure) and fracture mode (leak or unstable fracture).

The fracture mechanics tests and analysis showed that to provide adequate fracture resistance, the cylinder wall should be in the plane-stress fracture state and that the fracture should occur under elastic-plastic conditions. To reliably evaluate the fracture performance of cylinders in the plane-stress fracture state requires that an elastic-plastic fracture mechanics analysis (i.e. J_{Ic}, J_R) be conducted. Using the fracture mechanics analysis approach to evaluate fracture performance may require that a complex and expensive finite-element analysis be done for each specific type of flaw on each specific cylinder design to establish the J_{Ic} or J_R requirements for adequate fracture resistance. Also, the J_{Ic} materials property test required to evaluate the cylinder material is expensive and time consuming. Such costly and time-consuming tests have not proven to be practical for use with the high volume cylinder production.

Empirical correlations have been used to predict the fracture performance of cylinders. These empirical correlations relate the fracture initiation stress level for specific flaw types to the Charpy-V-notch (CVN) test impact energy. Although the Charpy-V-notch (CVN) test is useful for evaluating the quality of cylinders during production, the Charpy-V-notch (CVN) test alone may not be a reliable means to evaluate the fracture resistance of new designs of steel cylinders or to evaluate new steel alloys for cylinder construction.

As a result of these limitations with fracture mechanics analysis and with empirical correlations based on CVN tests, it was concluded that an alternate approach was required to evaluate the fracture resistance of high strength steel cylinders. It was decided that the test method that was developed should measure the total fracture resistance of the cylinder and not just the fracture toughness. Therefore, WG 14 decided to use a direct approach to evaluate the fracture resistance of cylinders and this led to the development of the “Flawed-cylinder burst test” and the “Flawed-cylinder cyclical burst test”.

In these test methods, the fracture test is performed on an actual, full size, cylinder rather than by measuring the fracture properties of the material alone by taking small scale test specimens from the cylinder, such as for J_{Ic} tests. The proposed test methods consist of testing cylinders in which flaws of specified sizes are machined into the external surface of the cylinders, the cylinders are pressurized until failure, and the failure pressure and failure mode (leak or fracture) is determined. This approach is only possible because the cylinders are required by the existing safety regulations to be produced in large, controlled groups of uniform cylinders and therefore a single sample cylinder from the group will adequately represent the behaviour of all cylinders in the production group.

The concept of the flawed-cylinder burst test and flawed-cylinder cyclical burst test and the development conducted under WG 14 are described in ISO/TR 12391-1. The results of the flawed-cylinder burst test conducted with monotonic pressurization are described in ISO/TR 12391-2.

In the development of the test method and acceptance criteria for the flawed-cylinder burst test and the flawed-cylinder cyclical burst test, it was decided that the fracture performance of newer, higher-strength steel cylinders should be essentially the same as that of the lower strength, existing cylinders because the existing cylinders have provided fracture-safe performance during their many years of service. Therefore, flawed-cylinder burst tests and flawed-cylinder cyclical burst tests were conducted on cylinders with strength levels covering the full range of strength levels currently being produced in the world. Flawed-cylinder burst tests were conducted on cylinders made from steels ranging in tensile strength from 620 MPa to 1 400 MPa and flawed-cylinder cyclical burst tests were conducted on cylinders made from steels ranging in tensile strength from 750 MPa to 1 210 MPa. Ten different companies in seven different countries (Austria, France, Germany, Japan, Sweden, the United Kingdom and the United States) conducted flawed-cylinder burst tests and flawed-cylinder cyclical burst tests.

This part of ISO/TR 12391 is limited to a summary and compilation of the results of the flawed-cylinder cyclical burst tests that were conducted by WG 14 during the development of the test method for the flawed-cylinder cyclical burst tests. This part of ISO/TR 12391 is in the form of a database of the test results that is to be used for further analysis of the fracture performance of steel cylinders.

5 Experimental test programme

5.1 Types of cylinder tested

Flawed-cylinder cyclical burst tests were conducted on cylinders that represented all of the currently used and proposed new types of seamless steel cylinders. A brief description of all the cylinders that were tested is shown in Tables 1 to 3. For this study, the cylinders were classified into material groups (designated groups B to D) based on the actual measured tensile strength, R_m, of the cylinders that were tested. The actual measured tensile strength for each group of cylinders that was tested is shown in Tables 4 to 6. The general description of the cylinders in each material group is shown below. Cylinders made from materials in groups B to D are currently being produced and used throughout the world.

NOTE Material groups designated A and E were only used for cylinders tested using the flawed-cylinder burst test with monotonic pressurization and the results are reported in ISO/TR 12391-2.

Material group	Description of cylinder	Tensile strength R_m
B	Cylinders made from alloy steel (Cr-Mo steels) heat treated by quenching and tempering; these cylinders may generally be used for all gases	750 MPa < $R_m \leqslant$ 950 MPa
C	Cylinders made from alloy steel (Cr-Mo steels) heat treated by quenching and tempering; these cylinders are restricted to use with non-corrosive gasesand are made in accordance with ISO 9809-1	950 MPa $\leqslant R_m \leqslant$ 1 080 MPa
D	Cylinders made from alloy steel (Cr-Mo steels) heat treated by quenching and tempering; high strength and high toughness steel cylinders restricted to use with non-corrosive gasesand and made in accordance with ISO 9809-2	1 080 MPa $\leqslant R_m \leqslant$ 1 210 MPa

Within each main material group (B to D) material subgroups are designated, e.g., material subgroups B-1 and B-10. All the cylinders within a given subgroup were made to the same specification, of the same size (diameter, thickness and volume), the same material, the same specified tensile strength range, the same designated service pressure and test pressure, and were made by the same manufacturing process. The cylinders in a specific material subgroup (e.g. subgroup B-10) may be of a different alloy, size, design specification or manufacturing process than cylinders in a different materials subgroup (e.g. B-1) in the same main material group (e.g. group B). However, the actual measured tensile strength for all cylinders in a material group will be in the same range (e.g. 750 MPa to 950 MPa for all cylinders in group B).

In Tables 1 to 3, it should be noted that the code numbers for some material subgroups (e.g. B-2, C-3 and C-4) are missing. The cylinders in these missing material subgroups were tested using the flawed-cylinder cyclical burst test, with monotonic pressurization and were not tested using the flawed-cylinder cyclical burst test procedures. The results of the tests on cylinders made from missing material subgroups using the flawed-cylinder cyclical burst test, with monotonic pressurization are reported in ISO/TR 12391-2.

In Tables 1 to 3, each flawed-cylinder cyclical burst test is assigned a number in sequence, as shown in the first column, for purposes of tracking each test. The same number is then used to identify the cylinders in the tables for the results of the mechanical property tests (Tables 4 to 6) and in the tables for the results of the flawed-cylinder cyclical burst test (Tables 7 to 9). In addition, each individual cylinder tested is assigned a code, such as CB-B-1-1 as shown in the second column of the tables; e.g. this code shows that the test is a cyclical burst test (CB), for material subgroup B-1, and is cylinder number 1 in this material subgroup.

The specified tensile strength range shown in Tables 1 to 3 is the range of “guaranteed” minimum, $R_{g,\,min}$, and maximum, $R_{g,\,max}$, tensile strength designated by the cylinder manufacturer or the cylinder specification used for the design of the cylinder. These values are used to calculate the cylinder wall thickness when designing the cylinder. These are specified values rather than actual measured values of the tensile strength, R_m. In a few cases, the manufacturer did not provide a specified minimum or maximum tensile strength values.

The information required to calculate the wall thickness of the cylinder, the test pressure of the cylinder and the service pressure of the cylinder are shown in Tables 1 to 3. This information includes the outside diameter or the cylinder, D, and the particular national or international design specification (when provided by the manufacturer) used by the manufacturer to design the cylinder. These specifications are used to calculate the stress in the cylinder wall, the minimum design wall thickness of the cylinder, t_d, the maximum design test pressure, P_h and the maximum design service pressure, P_s. Each of the national or international cylinder specifications may have a different formula for calculating the stress in the wall of the cylinder and therefore the design wall thickness for a specified cylinder diameter and service pressure. In some cases the cylinders tested were not designed to an existing design specification so these cylinders are designated as experimental cylinders.

The other items shown in Tables 1 to 3, for information purposes only, are:

— the type of manufacturing process used to make the cylinder;

— the cylinder volume (in litres);

— the specific material used (when provided by the manufacturer).

This information is only shown in order to better identify the cylinders that were tested and is not used for any analysis of the test results.

It should be noted that in a few cases, the actual measured tensile strength, R_m, for one or more cylinders in a particular material subgroup is slightly outside the designated range for the tensile strength of the particular material subgroup in which the cylinder is included. However, the measured tensile strength of the rest of the cylinders from the same material subgroup that were tested is within the appropriate tensile strength range for that material subgroup.

5.2 Material properties tests

Conventional mechanical properties tests, such as tensile tests conducted in accordance with ISO 6892 and Charpy-V-notch tests conducted in accordance with ISO 148, were carried out on each set of cylinders on which flawed-cylinder cyclical burst tests were performed. The results of these tests are shown in Tables 4 to 6 for each group of materials.

The tensile test results shown in Tables 4 to 6 are the actual measured yield strength, R_{ea}, the actual measured tensile strength, R_m, and the total elongation, A. These material properties are required to be measured by all of the existing national or international cylinder design specifications. The actual measured tensile strength value is used to determine that the cylinder meets the specification to which it is manufactured and is used in this test programme to classify the cylinder in the appropriate material group tested. The actual measured yield strength is used to determine that the cylinder meets the requirement for the yield strength to tensile strength ratio when this ratio is a part of the specification. The actual measured tensile strength value may also be used for additional analysis of the cylinder design parameters permitted in some of the specifications. The total elongation is used to determine that the requirement for minimum elongation is met when that is part of the specification to which the cylinder is manufactured. The elongation value is not used for any calculations in the design of cylinder.

For cylinders manufactured in the United States (such as those designated as DOT type 3A or 3AA) the tensile tests used to measure the properties of the cylinders were of the type specified by the CFR Title 49 Part 178 [2]. These test specimens have a fixed gauge length of 50 mm, a fixed width of 38 mm and a thickness equal to the actual wall thickness of the finished cylinder from which the specimens were taken. For other cylinders, the tensile tests of the type specified by ISO 6892 were used. The ISO test specimens have a gauge length of 5,65 × the square root of the cross section of the specimen, a width of 4 × the specimen thickness and a thickness equal to the actual wall thickness of the finished cylinder from which the specimens were taken. The ultimate tensile strength and the yield strength values should be essentially the same when measured with either the DOT or the ISO type of specimen. The measured elongation values will be different depending on the specific type of tensile specimen used.

The Charpy-V-notch tests were conducted in accordance with test method ASTM E23-02 [3] for cylinders manufactured in the United States. For other cylinders, the Charpy-V-notch tests were conducted in accordance with the test method described in ISO 148. The Charpy-V-notch impact test energy values should be essentially the same when measured with either the ASTM or the ISO test method. The Charpy-V-notch test specimens had cross sectional dimensions of either 10 mm deep by 5 mm thick or 10 mm deep by 4 mm thick depending on the available wall thickness of the cylinder and the orientation of the Charpy-V-notch test specimen. The exact dimensions of each Charpy-V-notch test specimen used are shown in Tables 4 to 6. The Charpy-V-notch tests were conducted either at ambient temperature (20 °C) or at low temperature (– 50 °C), as shown in Tables 4 to 6.

The Charpy-V-notch test specimens were either oriented with the longitudinal axis of the specimen parallel to the longitudinal axis of the cylinder (designated longitudinal specimens) or with the longitudinal axis of the specimen perpendicular to the longitudinal axis of the cylinder (designated transverse specimens). As shown in Tables 4 to 6, not all combinations of test temperatures and specimen orientation were used on each cylinder that was tested. The total energy absorbed in breaking the Charpy-V-notch test specimens was measured in Joules (J). All Charpy-V-notch test results are reported in J/cm^2, where the total energy absorbed is divided by the area of the specimen ligament below the specimen notch.

In the specifications for certain cylinder designs, particularly for material groups C and D cylinders, minimum Charpy-V-notch energy levels are required. The Charpy-V-notch tests were conducted on all cylinders to determine that these requirements were met. The Charpy-V-notch energy test results are not used to evaluate the results of the flawed-cylinder cyclical burst test. However, the Charpy-V-notch energy test results are reported here because these results may be used to evaluate the fracture performance of the cylinders using alternate analysis procedures to the flawed-cylinder cyclical burst test.

For certain material subgroups on which flawed-cylinder cyclical burst tests were conducted, mechanical properties test specimens were taken from each cylinder in the material subgroup after the burst test was completed. In this case, the test results are shown in the tables of results for each of the individual cylinders.

For some material subgroups on which flawed-cylinder cyclical burst tests were conducted, mechanical properties test specimens were taken only from selected cylinders in that particular material subgroup after the burst test was completed. In these cases, results are shown in the tables of results for the cylinders for which mechanical property tests were conducted and blank spaces are shown for the other cylinders on which flawed-cylinder cyclical burst tests were conducted but mechanical properties tests were not conducted. Because the cylinders in a particular material subgroup are all of the same type and from the same production batch, the mechanical properties test results for the cylinders that were tested are considered to adequately represent the properties of all cylinders in that material subgroup.

5.3 Description of the flawed-cylinder cyclical burst test

The flawed-cylinder cyclical burst test is used to evaluate the overall fracture performance of the entire cylinder and not just the “fracture toughness” of the material as determined with conventional fracture toughness test specimens. The flawed-cylinder cyclical burst test is intended to be both a “design qualification approval test" and a "production lot test". The full details of the test and the criteria for acceptable fracture performance of steel cylinders are given in 9.2.5 of ISO 9809-2:2000.

In the flawed-cylinder cyclical burst test, the fracture performance of the cylinder is evaluated by cyclically pressurizing a cylinder with a designated type (shape and sharpness) and size (length and depth) of surface flaw until failure occurs. Failure occurs either by leaking or by fracturing.

The cylinder to be tested has a flaw machined into the exterior surface of the cylinder wall. The flaw is machined in the location of probable maximum stress under pressurized loading, i.e. a longitudinal surface flaw at mid-length and at the thinnest place in the cylinder wall. To make the tests adequately uniform and reproducible, a surface flaw with a deep enough standard geometry is required. The geometry of the standard flaw is shown in Figure 1. A standard Charpy-V-notch milling cutter is used to machine the flaw to the designated length and depth. The milling cutter is required to meet the following specification:

— thickness of the cutter = 12,5 mm ± 0,2 mm;

— angle of the cutter = 45° ± 1°;

— tip radius $\leqslant$ 0,2 mm;

— for cylinders $\leqslant$ 140 mm in diameter, cutter diameter = 50,0 mm ± 0,5 mm;

— for cylinders $>$ 140 mm in diameter, cutter diameter = 60 mm to 80 mm.

This machined flaw is a surface flaw of the type shown in Figure 1. The flaw size is specified as:

— flaw length, $l_o = 1{,}6\,(D \times t_d)^{0{,}5}$

NOTE For the size of cylinders tested here, this flaw length is approximately $l_o = 10 \times t_d$.

— flaw depth, $d > 0{,}60 \times t_d$

Pressurization is carried out hydrostatically. During the test, each cylinder is filled with water at room temperature and the pressure is cycled until the cylinder fails. The maximum cycling pressure is the "adjusted design service pressure" = $P_s \times (t_a/t_d)$. This pressure is also the designated failure pressure, P_f, of the cylinder in the test. The minimum cycling pressure is 10 % of the maximum pressure, but not more than 30 bar. The maximum cycling frequency is 15 cycles/min.

The test is continued until failure occurs. The number of cycles to failure is recorded and the failure mode (either leak or fracture) is recorded. For this test the definition of fracture is "an extension of at least 10 % in the length of the machined flaw in the longitudinal direction". The failure pressure and failure mode, either leak or fracture, are reported as the test results. The failure pressure is the maximum cyclical pressure, $P_f = P_s \times (t_a/t_d)$. During the flawed-cylinder cyclical burst test, a single test cylinder may be sufficient if the failure occurs by leaking, and shows that the cylinder has adequate fracture resistance.

The overall fracture performance of the cylinder is determined with the flawed-cylinder cyclical burst test by empirically determining the "leak-fracture boundary" for the specified maximum cycling pressure. This requires that a series of cylinders with different flaw lengths be tested. The "leak-fracture boundary" for a specified maximum cycling pressure is defined as the average of the longest flaw length at which a leak occurs and the shortest flaw length at which a fracture occurs.

During the development of the flawed-cylinder cyclical burst test, some tests were conducted on series of cylinders with a range of flaw lengths to define the "leak-fracture boundary" for each particular type of cylinder and material. This was done to evaluate the overall fracture performance of the cylinder type. An example of such test results is shown in Figure 2. It is expected that this procedure to determine the full "leak-fracture boundary" over a range of flaw lengths will be used only for the "design qualification" evaluation of new cylinders (i.e. for new materials and production processes) to demonstrate that the cylinder type has adequate fracture resistance.

Once the full fracture performance is determined for a particular cylinder type from the flawed-cylinder cyclical burst tests conducted during the “design qualification” procedure, the testing procedure used to evaluate cylinders during large scale production can be simplified and made much more efficient. For production testing, a single cylinder with the specified flaw length is tested at the designated maximum cycling pressure and if the failure mode is a ”leak”, the cylinder satisfies the criteria for adequate fracture resistance given in ISO 9809-2.

During the development of the flawed-cylinder cyclical burst test, it was decided that the acceptable level of fracture resistance for cylinders of any strength level should be equivalent to the fracture resistance of existing cylinders that have been used for extended periods of time. Therefore, flawed-cylinder cyclical burst tests were conducted on cylinders with tensile strength levels ranging from about 750 MPa to 1 210 MPa. The existing cylinders (with tensile strengths levels less than 950 MPa) have provided fracture-safe performance during many years of service. From these results, it was determined that to have fracture resistance equivalent to the fracture resistance of existing cylinders, new higher strength steel cylinders should have a leak-fracture boundary of P_f/P_s greater than 1,0 when the designated flaw length was, $l_o = 1,6\,(D \times t_d)^{0,5}$.

6 Flawed-cylinder cyclical burst test results

6.1 Flawed-cylinder burst test procedure

The results of all of the flawed-cylinder cyclical burst tests that were conducted are shown in Tables 7 to 9. For each cylinder tested, the crack length, l_o, in terms of a multiple of the design minimum cylinder wall thickness, t_d, is given as $l_o = n \times t_d$ (e.g. $l_o = 10\ t_d$). This term is used as a common reference to compare cylinders with different wall thicknesses. The flaw depth, d, at the start of the cycling testing is given as a percentage of the design minimum cylinder wall thickness t_d (e.g. $100 \times d/t_d = 80\ \%$).

For a specified flaw length and cycling pressure, the number of cycles at which the cylinder fails depends on the initial depth of the flaw and the thickness of the remaining ligament of metal below the flaw. Failure of the cylinder occurs when the original flaw depth is increased by fatigue due to the pressure cycling so that the ligament of metal below the flaw breaks. Once the ligament of metal below the flaw fails, the cylinder will either leak or fracture depending on whether the combination of stress and flaw length is below or above the critical level for fracture to occur.

The actual cylinder wall thickness, t_a, at the location of the machined flaw is measured after the test. The actual cylinder wall thickness at any location in the cylinder should be greater than the design minimum cylinder wall thickness, t_d. The actual measured cylinder wall thickness is included in the data in order to permit additional analysis of the results using this cylinder wall thickness instead of the nominal cylinder wall thickness that is given by the design minimum cylinder wall thickness. The pressure at the time that the cylinder fails, either by leaking or by fracturing, is given as P_f measured in bar. The failure mode, either leak or fracture, is reported.

The ratio of the failure pressure, P_f, to the marked service pressure of the cylinder, P_s, is given as P_f/P_s. The marked service pressure (bar) is the maximum pressure to which the cylinder may be filled when in service and is specified by the cylinder manufacturer. It should be noted that the marked service pressure for the cylinders of the same size and tensile strength would be slightly different depending on the design specification used by the manufacturer. The cylinders were designed and the marked service pressure was specified according to the design specification used in the country of manufacture. The use of the parameter P_f/P_s permits the leak-fracture boundary to be defined in terms of the marked service pressure of the cylinder. This allows a comparison of cylinders of different sizes (diameters and wall thickness) to be made on a common basis.

ISO 9809-2 requires that the measured ratio of the failure pressure to the service pressure, P_f/P_s, be adjusted to account for the local thickness of the cylinder wall at the location of the flaw. This adjustment was made to the measured values of the P_f/P_s ratio for all of the flawed-cylinder cyclical burst tests conducted in this study. The adjusted ratio of the failure pressure to the service pressure, $P_{f,\ adjusted}/P_s$, is shown as the last column in Tables 7 to 9.

For completeness of the database, the results of all tests that were conducted are shown in Tables 7 to 9. It should be noted that a range of test parameters (such as flaw length, flaw depth and maximum cycling pressure) were used in the tests conducted here as part of the development of the flawed-cylinder cyclical burst procedure. Therefore, many of the tests were not conducted using the exact flaw length, flaw depth, and maximum cycling pressure specified in ISO 9809-2 and shown above.

For some of the material subgroups, cylinders with a range of flaw lengths were tested to define the full leak-fracture boundary over a range of flaw lengths. The results of flawed-cylinder cyclical burst tests for these material subgroups are shown in Tables 7 to 9 and are plotted in the Figures 3 to 7. To define the leak-fracture boundary, the shortest flaw length for which a failure occurred by fracture and the longest flaw length for which failure occurred by leaking are plotted. An estimate of the leak-fracture boundary is shown in Figures 3 to 7 for each material subgroup. Data for failures over a range of flaw lengths is available for material subgroups B-1, C-5, D-1, D-7 and D-12.

For some of the other material subgroups, all the flawed-cylinder cyclical burst tests were conducted at a single defined flaw length and both leak results and fracture results were obtained. For these tests the leak-fracture boundary can be defined only for the single specified flaw length. These results are not plotted but the test results are summarized and the estimated leak-fracture boundary for these material subgroups is shown in Table 10. Flawed-cylinder cyclical burst tests for material subgroups C-10 and C-11 were conducted at only a single value of flaw length.

For some of the material subgroups, all the flawed-cylinder cyclical burst tests were conducted at a single defined flaw length and only leak results or fracture results were obtained. These test results are summarized in Table 11. An estimate of the leak-fracture boundary is reported as the minimum flaw length at specified pressure at which failure by fracture occurs or the maximum flaw length at a specific pressure at which failure by leaking occurs. These results may be of value if there are similar cylinders in other material subgroups with which they may be combined to estimate the leak-fracture boundary more accurately.

Flawed-cylinder cyclical burst tests for material subgroups B-10, B-11, C-2, C-12, C-13, C-14, D-2 and D-13 were conducted at only a single value of flaw length and each test series resulted in failure only by leaking or by fracture. Because there were failures that did not occur by both leaking and failure, the leak-fracture boundary could not be determined. It could only be estimated that the leak-fracture boundary was greater than the longest flaw at which failure occurred by leaking or less than the shortest flaw where failure occurred by fracture.

6.2 Flawed-cylinder cyclical burst test results for group B materials

The cylinders made from group B materials were cylinders made from chromium-molybdenum alloy steel. These cylinders are representative of the largest number of cylinders that have been in worldwide use for about 60 years. Cylinders of this type normally have a service pressure rating of 150 bar to 200 bar.

Eleven cylinders from material subgroup B-1 were tested. The results of these tests are shown in Table 7. The cylinders in material subgroup B-1 were all tested at a maximum cyclical pressure of 1,5 × the design service pressure, i.e. $P_f/P_s = 1,5$. This is the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length ranged from $l_o = 8,6 \times t_d$ to $l_o = 11,2 \times t_d$. The initial flaw depth ranged from 31,3 % to 78,8 % of the design wall thickness, t_d, of the cylinders. Four of the test cylinders failed by leaking and seven of the cylinders failed by fracturing. As shown in Figure 3, the leak-fracture boundary for material subgroup B-1 cylinders is at a flaw length of $l_o = 8,8 \times t_d$ at a failure pressure of 1,5 × the service pressure, P_s. Therefore, these cylinders should have an adequate level of fracture resistance according to the requirements of ISO 9809-2.

Only one cylinder from material subgroup B-10 was tested by cyclical pressurization. This cylinder was tested at a maximum cyclical pressure of 1,72 × the design service pressure, i.e. $P_f/P_s = 1,72$. This is above the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length was $l_o = 9,9 \times t_d$. The initial flaw depth was 9,8 % of the design wall thickness of the cylinders. The cylinder failed by fracturing. A single cylinder from the B-10 material subgroup was also tested using the flawed-burst testing procedure with monotonic pressurization. This cylinder had an initial flaw depth of 83,3 % of the design wall thickness and failed at a maximum pressure of 0,93 × the design service pressure, i.e. $P_f/P_s = 0,93$. This cylinder failed by leaking. However, because the cylinder that was tested using cyclical pressurization and the cylinder that was tested using monotonic pressurization had significantly different failure pressures and different initial flaw depths, no specific conclusions can be drawn from these tests.

Two cylinders from material subgroup B-11 were tested by cyclical pressurization. These cylinders were tested at a maximum cyclical pressure of 1,5 × the design service pressure, i.e. P_f/P_s = 1,5. This is the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length was l_o = 10,0 t_d to l_o = 10,6 t_d. The initial flaw depth ranged from 9,5 % to 10,6 % of the design wall thickness of the cylinders. Both of the cylinders failed by leaking. This represents an adequate level of fracture resistance for all cylinders in this group. Two cylinders from the B-11 material subgroup were also tested using the flawed-burst testing procedure with monotonic pressurization. These cylinders had initial flaw depths ranging from of 83,7 % to 85,9 % of the design wall thickness and failed at a maximum pressure of 1,13 × to 1,29 × the design service pressure, i.e. P_f/P_s = 1,13 to 1,29. These cylinders failed by leaking. However, because the cylinder that was tested using cyclical pressurization and the cylinder that was tested using monotonic pressurization had significantly different failure pressures and different initial flaw depths, no specific conclusions can be drawn from these tests

6.3 Flawed-cylinder cyclical burst test results for group C materials

The cylinders made from group C materials are higher strength steel cylinders that have been used worldwide for about 10 years. These cylinders are generally made from chromium-molybdenum alloy steel that is produced to higher levels of cleanliness to improve its fracture toughness. This permits the cylinders to be designed for a service pressure of about 300 bar.

Four cylinders from material subgroup C-1 were tested. The results of these tests are shown in Table 8. The cylinders in material subgroup C-1 were all tested at a maximum cyclical pressure of 1 × the design service pressure, i.e. P_f/P_s = 1,0. This is the normal service pressure used for these cylinders. The initial flaw length ranged from l_o = 5,9 × t_d to l_o = 7,3 × t_d. The initial flaw depth ranged from 51,3 % to 75,9 % of the design wall thickness, t_d, of the cylinders. All four of the test cylinders failed by leaking. These tests were conducted using the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2. The initial flaw length was just slightly less than that required by ISO 9809-2. Therefore, it is expected that these cylinders have an adequate level of fracture resistance to meet the requirements of ISO 9809-2.

Five cylinders from material subgroup C-2 were tested. The results of these tests are shown in Table 8. The cylinders in material subgroup C-2 were all tested at a maximum cyclical pressure of 1,5 × the design service pressure, i.e. P_f/P_s = 1,5. This is the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length ranged from l_o = 9,4 × t_d to l_o = 10,0 × t_d. The initial flaw depth ranged from 26,5 % to 67,0 % of the design wall thickness of the cylinders. All five of the test cylinders failed by leaking. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2, except that the maximum test pressure was considerably higher than that specified in ISO 9809-2. Therefore, these cylinders should have an adequate level of fracture resistance to meet the requirements of ISO 9809-2.

Seven cylinders from material subgroup C-5 were tested. The results of these tests are shown in Table 8. The cylinders in material subgroup C-5 were all tested at a maximum cyclical pressure of 1,5 × the design service pressure, i.e. P_f/P_s = 1,5. This is the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length ranged from l_o = 5,7 × t_d to l_o = 20,0 × t_d. The initial flaw depth ranged from 6,0 % to 23,0 % of the design wall thickness of the cylinders. Four of the test cylinders failed by leaking and three of the cylinders failed by fracturing. As shown in Figure 4, the leak-fracture boundary for material subgroup C-5 cylinders is at a flaw length estimated to be l_o = 15,0 × t_d at a failure pressure of 1,5 × the service pressure, P_s. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2, except that the flaw depth was less than specified and the maximum test pressure was higher than that specified in ISO 9809-2. Therefore, these cylinders exceed the level of fracture resistance required by ISO 9809-2.

Four cylinders from material subgroup C-10 were tested. The results of these tests are shown in Table 8. The cylinders in material subgroup C-10 were tested at a maximum cyclical pressure of 1,0 × or 1,5 × the design service pressure, i.e. P_f/P_s = 1,0 or 1,5. This is either the service pressure or the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length for all tests was l_o = 10,0 × t_d. The initial flaw depth ranged from 15,0 % to 30,0 % of the design wall thickness, t_d, of the cylinders. The cylinder that was tested with a maximum test pressure equal to the service pressure, P_f/P_s = 1,0, failed by leaking. The other cylinders that were tested with a maximum test pressure equal to the service pressure, P_f/P_s = 1,5, failed by fracturing. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2, except that the maximum test pressure was considerably higher than that specified in ISO 9809-2. Therefore, these cylinders should have an adequate level of fracture resistance to meet the requirements of ISO 9809-2.

Seven cylinders from material subgroup C-11 were tested. The results of these tests are shown in Table 8. The cylinders in material subgroup C-11 were tested at a maximum cyclical pressure of 1,25 × the design service pressure, i.e. P_f/P_s = 1,25. This is halfway between the service pressure and the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length for all tests was $l_o = 10{,}0 \times t_d$. The initial flaw depth was 53,0 % of the design wall thickness of the cylinders. Three of the cylinders failed by fracturing and four of the cylinders failed by leaking. These tests were conducted using the conditions that generally exceeded the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2. Therefore, these cylinders should have an adequate level of fracture resistance to meet the requirements of ISO 9809-2.

Two cylinders from material subgroup C-12 were tested by cyclical pressurization. These cylinders were tested at a maximum cyclical pressure of about 1,5 × the design service pressure, i.e. P_f/P_s = 1,5. This is the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length ranged from $l_o = 10{,}0 \times t_d$. The initial flaw depth was about 42 % of the design wall thickness, t_d, of the cylinders. Both of the cylinders failed by fracturing. Two cylinders from the C-12 material subgroup were also tested using the flawed-cylinder burst testing procedure with monotonic pressurization. These cylinders had initial flaw depths of 85,0 % of the design wall thickness and failed at a maximum pressure of 1,05 × to 1,13 × the design service pressure, i.e. P_f/P_s = 1,05 to 1,13. These cylinders failed by leaking. However, because the cylinder that was tested using cyclical pressurization and the cylinder that was tested using monotonic pressurization had significantly different failure pressures and different initial flaw depths, no specific conclusions can be drawn from these tests.

Only one cylinder from material subgroup C-13 was tested by cyclical pressurization. This cylinder was tested at a maximum cyclical pressure of 1,62 × the design service pressure, i.e. P_f/P_s = 1,62. This is above the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length was $l_o = 9{,}9 \times t_d$. The initial flaw depth was 10,9 % of the design wall thickness of the cylinders. The cylinder failed by leaking. A single cylinder from the C-13 material subgroup was also tested using the flawed-burst testing procedure with monotonic pressurization. This cylinder had an initial flaw depth of 86,0 % of the design wall thickness and failed at a maximum pressure of 1,31 × the design service pressure, i.e. P_f/P_s = 1,31. This cylinder failed by leaking. However, because the cylinder that was tested using cyclical pressurization and the cylinder that was tested using monotonic pressurization had significantly different failure pressures and different initial flaw depths, no specific conclusions can be drawn from these tests.

Three cylinders from material subgroup C-14 were tested by cyclical pressurization. These cylinders were tested at a maximum cyclical pressure of 1,5 × the design service pressure, i.e. P_f/P_s = 1,5. This is the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length was $l_o = 10{,}0 \times t_d$. The initial flaw depth ranged from 10,3 % to 12,8 % of the design wall thickness of the cylinders. All these failed by leaking. Three cylinders from the C-14 material subgroup were also tested using the flawed-cylinder burst testing procedure with monotonic pressurization. These cylinders had an initial flaw depths of 83,0 % to 86,0 % of the design wall thickness and failed at a maximum pressure of 1,05 × to 1,26 × the design service pressure, i.e. P_f/P_s = 1,05 to 1,26. These cylinders failed by leaking. However, because the cylinder that was tested using cyclical pressurization and the cylinder that was tested using monotonic pressurization had significantly different failure pressures and different initial flaw depths, no specific conclusions can be drawn from these tests.

6.4 Flawed-cylinder cyclical burst test results for group D materials

The cylinders made from group D materials are the highest strength steel cylinders now permitted for use in any country in the world. They are restricted to use for shipping non-corrosive (non-hydrogen bearing) gases. These cylinders are generally made from modified chromium-molybdenum alloy steels that have a good combination of tensile strength and fracture toughness. These cylinders are intended to have service pressures at or above 300 bar.

Fourteen cylinders from material subgroup D-1 were tested. The results of these tests are shown in Table 9. The cylinders in material subgroup D-1 were all tested at a maximum cyclical pressure of 1,0 × or 1,5 × the design service pressure, i.e. P_f/P_s = 1,0 or 1,5. This is either the normal service pressure or the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length ranged from $l_o = 6{,}0 \times t_d$ to $l_o = 10{,}1 \times t_d$. The initial flaw depth ranged from 9,8 % to 91,8 % of the design wall thickness, t_d, of the cylinders. Thirteen of the test cylinders failed by leaking when tested at a maximum cyclical pressure of 1,0 × or 1,5 × the service pressure, P_s, and one of the cylinders failed by fracturing when tested at a maximum cyclical pressure of 1,5 × the service pressure. As shown in Figure 5, the leak-fracture boundary for material subgroup D-1 cylinders is at a flaw length estimated to be $l_o = 10{,}0 \times t_d$ at a failure pressure of 1,5 × the service pressure. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2, except that the flaw depth was less than specified and the maximum test pressure was higher than that specified in ISO 9809-2. Therefore, these cylinders exceed the level of fracture resistance to meet the requirements of ISO 9809-2.

Three cylinders from material subgroup D-2 were tested by cyclical pressurization. These cylinders were tested at a maximum cyclical pressure of 1,5 × the design service pressure, i.e. P_f/P_s = 1,5. This is the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length was $l_o = 10{,}0\, t_d$. The initial flaw depth ranged from 62,7 % to 65,3 % of the design wall thickness, t_d, of the cylinders. All three failed by leaking. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2, except that the maximum test pressure was higher than that specified in ISO 9809-2. Therefore, these cylinders exceed the level of fracture resistance required by ISO 9809-2. In addition, fifteen cylinders from the D-2 material subgroup were also tested using the flawed-cylinder burst testing procedure with monotonic pressurization. These cylinders had an initial flaw length of approximately $l_o = 10{,}0\, t_d$. These cylinders had an initial flaw depths of 67,6 % to 93,8 % of the design wall thickness and failed at a maximum pressure of 1,08 × to 1,41 × the design service pressure, i.e. P_f/P_s = 0,86 to 1,41. These cylinders failed by both fracturing and leaking.

Seven cylinders from material subgroup D-7 were tested by cyclical pressurization. These cylinders were tested at a maximum cyclical pressure of about 1,0 × the design service pressure, i.e. P_f/P_s = 1,0. This is the normal service pressure used for these cylinders. The initial flaw length ranged from $l_o = 3{,}5 \times t_d$ to $l_o = 6{,}7 \times t_d$. The initial flaw depth was about 40 % of the design wall thickness, t_d, of the cylinders. As shown in Figure 6, the leak-fracture boundary for material subgroup D-7 cylinders is at a flaw length estimated to be $l_o = 4{,}0 \times t_d$ at a failure pressure of 1,0 × the service pressure, P_s. Three of the cylinders failed by fracturing and four of the cylinders failed by leaking. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2 except that the initial flaw length was shorter than that required by the ISO standard. Because the initial flaw length was considerably shorter than that required by ISO 9809-2 and some of the cylinders failed by fracturing, these cylinders would not meet the level of fracture resistance required by ISO 9809-2.

Eight cylinders from material subgroup D-8 were tested by cyclical pressurization. These cylinders were tested at a maximum cyclical pressure ranging from 0,88 × to 1,45 × the design service pressure, i.e. P_f/P_s = 0,86 to 1,45. The initial flaw length ranged from $l_o = 10{,}0 \times t_d$ to $l_o = 20{,}0 \times t_d$. The initial flaw depth ranged from 15 % to 75 % of the design wall thickness, t_d, of the cylinders. Three of the cylinders failed by leaking and five of the cylinders failed by fracturing. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2. Because the lowest failure pressure at which failure by fracturing occurred was greater than the service pressure, these cylinders exceed the level of fracture resistance required by ISO 9809-2.

Fourteen cylinders from material subgroup D-12 were tested by cyclical pressurization. These cylinders were tested at a maximum cyclical pressure ranging from 1,0 × to 1,5 × the design service pressure, i.e. P_f/P_s = 1,0 to 1,5. The initial flaw length ranged from $l_o = 7{,}8 \times t_d$ to $l_o = 18{,}6 \times t_d$. The initial flaw depth ranged from 27 % to 47 % of the design wall thickness, t_d, of the cylinders. Nine of the cylinders failed by leaking and five of the cylinders failed by fracturing. As shown in Figure 7 the leak-fracture boundary for material subgroup D-12 cylinders is at a flaw length estimated to be $l_o = 10{,}5 \times t_d$ at a failure pressure of 1,25 × the service pressure, P_s. These tests were conducted using the conditions that generally satisfied the conditions for conducting the flawed-cylinder cyclical burst test specified in ISO 9809-2. Because the lowest failure pressure at which failure by fracturing occurred was greater than the service pressure, these cylinders exceed the level of fracture resistance required by ISO 9809-2.

Only one cylinder from material subgroup D-13 was tested by cyclical pressurization. This cylinder was tested at a maximum cyclical pressure of 1,8 × the design service pressure, i.e. P_f/P_s = 1,8. This is above the normal pressure used for hydrostatically retesting these cylinders. The initial flaw length was $l_o = 9{,}7 \times t_d$. The initial flaw depth was 10,6 % of the design wall thickness, t_d, of the cylinders. The cylinder failed by fracturing. A single cylinder from the D-13 material subgroup was also tested using the flawed-burst testing procedure with monotonic pressurization. This cylinder had an initial flaw depth of 84,0 % of the design wall thickness and failed at a maximum pressure of 1,3 × the design service pressure, i.e. P_f/P_s = 1,3. This cylinder failed by leaking. However, because the cylinder that was tested using cyclical pressurization and the cylinder that was tested using monotonic pressurization had significantly different failure pressures and different initial flaw depths, no specific conclusions can be drawn from these tests.

7 Discussion

7.1 Background

The objective of this part of ISO/TR 12391 was to compile the results of the flawed-cylinder cyclical burst tests that were conducted during the development of the flawed-cylinder cyclical burst test method. The test results obtained in this programme can be used to evaluate the effectiveness of the flawed-cylinder cyclical burst test, as a test method to measure the fracture performance of seamless steel cylinders, and to derive suitable criteria for using the test to evaluate new designs of cylinders and cylinders during production. No extensive discussion or analysis of the test data will be presented in this part of ISO/TR 12391.

The objective of the flawed-cylinder cyclical burst test is to evaluate new designs of cylinders by determining the leak-fracture boundary for a range of flaw lengths. The leak-fracture boundary is defined in terms of the ratio, P_f/P_s, of the failure pressure, P_f, to the marked service pressure, P_s, of the cylinder. As required by ISO 9809-2, a flaw of the specified size and shape in the wall of the cylinder shall fail by leaking at a pressure above the service pressure of the cylinder.

The tests results reported here were obtained by the members of WG 14. These test results were used to demonstrate that the flawed-cylinder cyclical burst test adequately evaluates the fracture resistance of seamless steel cylinders of all strength levels currently used for cylinder construction. The results of these tests were used to establish the procedure for conducting the flawed-cylinder cyclical burst test and for defining the acceptance criteria for passing the test. The flawed-cylinder cyclical burst test procedure and acceptance criteria developed by WG 14 are included in 9.2.5 of ISO 9809-2:2000.

7.2 ISO 9809-2 flawed-cylinder cyclical burst test procedures and acceptance criteria

Based on the test results reported here, WG 14 developed specific test procedures and acceptance criteria for using the flawed-cylinder cyclical burst test to evaluate new cylinder designs and new cylinder materials and to evaluate samples of production cylinders. The specific test procedures finally adopted by WG 14 and published in 9.2.5 of ISO 9809-2:2000, differ slightly from the procedures used to carry out most of the tests described in this part of ISO/TR 12391.

In ISO 9809-2, the flaw shape used in the flawed-cylinder cyclical burst is the same as the flaw shape used in the tests conducted in this study and described in 5.3 and Figure 1. The final procedure adopted by WG 14 and published in ISO 9809-2 specifies that cylinders with only a single defined flaw length are required to be tested to evaluate the fracture performance of the cylinders. This is in contrast to the test results reported here in which cylinders with a range of flaw lengths were tested for many of the material groups to evaluate the total fracture performance of the cylinders. In tests conducted during the development of the flawed-cylinder cyclical burst test and reported here, the flaw length was defined in terms of the design minimum thickness, t_d, of the cylinder alone. In these tests, a common flaw length was $l_o = 10 \times t_d$. However, the single flaw length used in the tests conducted in accordance with ISO 9809-2 is defined differently than the way the flaw length is defined in the tests results reported here. In ISO 9809-2, the flaw length is defined in terms of both the cylinder design minimum wall thickness, t_d, and the cylinder diameter, D.

For tests conducted in accordance with ISO 9809-2, the single flaw length is defined as $l_o = 1{,}6(D \times t_d)^{0{,}5}$. This has the effect of normalizing the flaw length in terms of both the cylinder diameter and the cylinder wall thickness and therefore makes the test equivalent for cylinders of all sizes and wall thickness. The basis for this choice of flaw length is that the fracture strength of a flawed cylinder is a known function of the cylinder diameter, D, the cylinder wall thickness, t_d, and the flaw length, l_o. Because many of the tests results reported here used cylinders of approximately 230 mm in diameter and approximately 6 mm thick, the flaw length calculated using ISO 9809-2 is about the same (i.e. 10 × t_d) as that used in any of the tests.

In the tests conducted in accordance with ISO 9809-2, the cylinder is cycled to a maximum pressure equal to the service pressure, P_s, of the cylinder. This maximum cycle pressure is then designated as the failure pressure, P_f. The results of the test that are recorded are the failure pressure and the failure mode (leak or fracture). These results are recorded in the same way as for all of the tests reported here. However, in ISO 9809-2, the failure pressure is then adjusted to account for local variations in the cylinder wall thickness. This is done because the actual thickness in the vicinity of the flaw, t_a, is generally significantly different from the design minimum wall thickness of the cylinder, t_d. The adjusted failure pressure ($P_{f,\ adjusted}$) is calculated as $P_{f,\ adjusted} = (P_f \times t_d/t_a)$. This adjustment to the failure pressure is based on the assumption that the failure pressure of a cylinder without a flaw is directly proportional to the actual thickness of the cylinder wall, t_a.

ISO 9809-2 requires that an acceptable result of the flawed-cylinder cyclical burst test is that the failure is by leaking (any extension of the flaw is less than 10 %) when the failure pressure (maximum cyclical pressure) is at the adjusted service pressure $P_{s,\ adjusted} = (P_s \times t_d/t_a)$.

It should be noted that the procedure specified in ISO 9809-2 only requires that the flawed-cylinder cyclical burst test, results in leakage at a specified value of the adjusted service pressure $P_{s,\ adjusted}$ and does not require that the leak-fracture boundary be determined by having cylinders fail by both leaking and fracturing in the test.

The flawed-cylinder cyclical burst test may be conducted in accordance with ISO 9809-2 for either “prototype” cylinders or for sample cylinders from a production “batch”. “Prototype” cylinders shall be produced and tested whenever there are changes in:

— the manufacturing process;

— the factory in which the cylinders are manufactured;

— the composition of the steel;

— the heat treatment;

— the guaranteed minimum yield strength, R_e, or the guaranteed minimum tensile strength, $R_{g\ min}$;

— the nominal diameter or design minimum wall thickness of the cylinder;

— the length of the cylinder (an increase of more than 50 %).

A production “batch” of cylinders is defined as a group of cylinders (less than 1 000) that are produced from the same heat of steel and produced under identical conditions. Sample cylinders are taken from each production batch and tested to destruction.

When used to evaluate the fracture performance of “prototype” cylinders, at least two cylinders from an initial production run of 50 cylinders shall be tested and shall successfully meet the performance criteria described above. Although it is not required by ISO 9809-2, when a substantial change in made, such as when a new or higher strength alloy steel is used, it is recommended that the fracture performance of the “prototype” cylinders be evaluated by conducting flawed-cylinder cyclical burst tests with a wide range of flaw lengths and to establish the entire leak-fracture boundary over this range. It should be noted the procedure specified in ISO 9809-2 only requires that the flawed-cylinder cyclical burst test results in leaking at a specified value of the P_f/P_s ratio and does not require that the leak-fracture boundary be determined.

7.3 Comparison of the flawed-cylinder cyclical burst test with the flawed-cylinder burst test with monotonic pressurization to evaluate fracture performance

ISO 9809-2 permits the fracture performance of seamless steel cylinders to be evaluated by use of either the flawed-cylinder cyclical burst test or the flawed-cylinder burst test with monotonic pressurization. In principle, both the flawed-cylinder cyclical burst test and the flawed-cylinder burst test with monotonic pressurization can be used to evaluate the fracture performance of seamless steel cylinders and should produce equivalent results. The flawed-cylinder burst test with monotonic pressurization is described in detail in ISO/TR 12391-2.

In both types of test, a specifically defined size, depth and shape of flaw is machined into the cylinder wall and the cylinder is pressurized until failure occurs and the failure mode (either leak or fracture) is determined. The only significant technical difference in the two tests is that, in the flawed-cylinder burst test with monotonic pressurization, the pressure is increased continuously until the remaining ligament of metal below the original flaw fails by over stressing and then the cylinder either leaks or fractures whereas in the flawed-cylinder cyclical burst test, the remaining ligament of metal below the original flaw fails by fatigue and then the cylinder either leaks or fractures. In either case, whether the cylinder ultimately fails by leaking or by fracturing is controlled by the length of the final flaw created by fatiguing or by over stressing, the stress in the cylinder wall at the time of the final failure, and the fracture resistance (fracture toughness) of the cylinder material. These tests should produce equivalent results.

To determine if the two test methods were equivalent, the results of fracture performance tests carried out using the flawed-cylinder cyclical burst test were compared with the results of fracture performance tests carried out using the flawed-cylinder burst test with monotonic pressurization on similar cylinders. The test results that were carried out using the flawed-cylinder burst test with monotonic pressurization on similar cylinders that were used in this comparison are reported in detail in ISO/TR 12391-2. Test results on only a few selected cylinder tests that were tested by both methods were used in this comparison. At least one example of cylinders from each material group that was tested was used for this comparison to determine if the testing procedures were valid for all cylinders manufactured in accordance with ISO 9809-2.

The results of the comparison of the cylinder fracture performance for tests conducted using the flawed-cylinder cyclical burst test and the cylinder fracture performance for tests conducted using the flawed-cylinder burst test with monotonic pressurization are shown in Figures 8 to 12.

For each of the material groups tested, tests conducted using the flawed-cylinder cyclical burst test gave equivalent results to tests conducted using the flawed-cylinder burst test with monotonic pressurization. This is shown in Figures 8 to 12 where tests that failed by either leaking or fracturing were always on the same side of the leak-fracture boundary regardless of which test method was used. In addition, for a given flaw length, the failure pressure was approximately the same for tests conducted using either test method and the failure mode (leak or fracture) was the same.

8 Summary and conclusions

Extensive test results of flawed-cylinder cyclical burst tests and mechanical property tests that were conducted on seamless steel cylinders are compiled. The results of these tests were used to demonstrate the capability of the flawed-cylinder cyclical burst to reliably evaluate the fracture performance of steel cylinders.

The results of these tests were used by ISO/TC 58/SC 3 to define the testing procedures and acceptance criteria for the flawed-cylinder cyclical burst test. The flawed-cylinder cyclical burst test or the flawed-cylinder burst test with monotonic pressurization is required to be conducted on steel cylinders using ISO 9809-2 for high strength steel cylinders.

Both the flawed-cylinder cyclical burst test and the flawed-cylinder burst test with monotonic pressurization give equivalent results when used for evaluating the fracture performance of seamless steel cylinders.

Table 1 — Cylinder description for group B materials

Test No	Cylinder No.	Type of cylinder mfg.	Specified tensile strength $R_{g\ min}$ MPa	Specified tensile strength $R_{g\ max}$ MPa	Cylinder specification	Material (steel alloy and special notes)	Vol. l	Dia. D mm	Design test pressure P_h bar	Design service pressure P_s bar	Design thickness t_d mm
Material group B-1											
15	CB-B-1-1	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
16	CB-B-1-2	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
17	CB-B-1-3	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
18	CB-B-1-4	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
19	CB-B-1-5	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
20	CB-B-1-6	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
21	CB-B-1-7	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
22	CB-B-1-8	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
23	CB-B-1-9	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
24	CB-B-1-10	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
25	CB-B-1-11	Billet	845	950	ISO 4705	Cr-Mo	50	230	300	200	5,8
Material group B-10											
394	CB-B-10-1	Billet	800	950	ISO 9809	Cr-Mo	50	232	300	200	6,0
395	CB-B-10-2	Billet	800	950	ISO 9809	Cr-Mo	50	232	300	200	6,0
Material group B-11											
407	CB-B-11-1	Tube	750	880	ISO 9809	C-Mn	47	232	255	170	5,4
408	CB-B-11-2	Tube	750	880	ISO 9809	C-Mn	47	232	255	170	5,4
409	CB-B-11-3	Tube	815	930	ISO 9809	Cr-Mo	49	232	300	200	5,9
410	CB-B-11-4	Tube	815	930	ISO 9809	Cr-Mo	49	232	300	200	5,9

Table 2 — Cylinder description for group C materials

Test No	Cylinder No.	Type of cylinder mfg.	Specified tensile strength		Cylinder specification	Material (steel alloy and special notes)	Vol.	Dia.	Design test pressure	Design service pressure	Design thickness
			$R_{g\,min}$	$R_{g\,max}$				D	P_h	P_s	t_d
			MPa	MPa			l	mm	bar	bar	mm
Material group C-1											
11	CB-C-1-1	Billet	1 016	1 090	ISO 4705	Cr-Mo	50	230	450	300	7,7
12	CB-C-1-2	Billet	1 016	1 090	ISO 4705	Cr-Mo	50	230	450	300	7,7
13	CB-C-1-3	Billet	1 016	1 090	ISO 4705	Cr-Mo	50	230	450	300	7,7
14	CB-C-1-4	Billet	1 016	1 090	ISO 4705	Cr-Mo	50	230	450	300	7,7
Material group C-2											
26	CB-C-2-1	Billet	934	—	ISO 4705	Cr-Mo	50	230	300	200	5,2
27	CB-C-2-2	Billet	934	—	ISO 4705	Cr-Mo	50	230	300	200	5,2
28	CB-C-2-3	Billet	934	—	ISO 4705	Cr-Mo	50	230	300	200	5,2
29	CB-C-2-4	Billet	934	—	ISO 4705	Cr-Mo	50	230	300	200	5,2
30	CB-C-2-5	Billet	934	—	ISO 4705	Cr-Mo	50	230	300	200	5,2
Material group C-5											
183	CB-C-5-1	Tube	880	1 030		Cr-Mo	50	229	300	200	6,0
184	CB-C-5-2	Tube	880	1 030		Cr-Mo	50	229	300	200	6,0
185	CB-C-5-3	Tube	880	1 030		Cr-Mo	50	229	300	200	6,0
186	CB-C-5-4	Tube	880	1 030		Cr-Mo	50	229	300	200	6,0
187	CB-C-5-5	Tube	880	1 030		Cr-Mo	50	229	300	200	6,0
188	CB-C-5-6	Tube	880	1 030		Cr-Mo	50	229	300	200	6,0
201	CB-C-5-7	Tube	880	1 030		Cr-Mo	50	229	300	200	5,6
Material group C-10											
323	CB-C-10-1	Billet	930	1 063	E-9370	Cr-Mo	50	235	345	230	5,6
324	CB-C-10-2	Billet	930	1 063	E-9370	Cr-Mo	50	235	345	230	5,6
325	CB-C-10-3	Billet	930	1 063	E-9370	Cr-Mo	50	235	345	230	5,6
326	CB-C-10-4	Billet	930	1 063	E-9370	Cr-Mo	50	235	345	230	5,6

Table 2 (*continued*)

Test No	Cylinder No.	Type of cylinder mfg.	Specified tensile strength		Cylinder specification	Material (steel alloy and special notes)	Vol.	Dia.	Design test pressure	Design service pressure	Design thickness
			$R_{g\ min}$	$R_{g\ max}$				D	P_h	P_s	t_d
			MPa	MPa			l	mm	bar	bar	mm
Material group C-11											
368	CB-C-11-1	PLATE	930	1 138	E-9791	Cr-Mo	10	184	362	241	4,6
369	CB-C-11-2	PLATE	930	1 138	E-9791	Cr-Mo	10	184	362	241	4,6
370	CB-C-11-3	PLATE	930	1 138	E-9791	Cr-Mo	10	184	362	241	4,6
371	CB-C-11-4	PLATE	930	1 138	E-9791	Cr-Mo	10	184	362	241	4,6
372	CB-C-11-5	PLATE	930	1 138	E-9791	Cr-Mo	10	184	362	241	4,6
373	CB-C-11-6	PLATE	930	1 138	E-9791	Cr-Mo	10	184	362	241	4,6
374	CB-C-11-7	PLATE	930	1 138	E-9791	Cr-Mo	10	184	362	241	4,6
Material group C-12											
390	CB-C-12-2	Tube	950	1 100	ISO 9809	Cr-Mo	14	191	476	317	6,6
391	CB-C-12-3	Tube	950	1 100	ISO 9809	Cr-Mo	14	191	476	317	6,6
392	CB-C-12-4	Tube	950	1 100	ISO 9809	Cr-Mo	14	191	476	317	6,6
393	CB-C-12-5	Tube	950	1 100	ISO 9809	Cr-Mo	14	191	476	317	6,6
Material group C-13											
396	CB-C-13-1	Billet	1 000	1 150	ISO 9809	Alloy steel	47	232		190	4,6
397	CB-C-13-2	Billet	1 000	1 150	ISO 9809	Alloy steel	47	232		190	4,6
Material group C-14											
400	CB-C-14-1	Billet	900	1 100	JIS SPEC.	Alloy steel	47	232		163	4,3
410	CB-C-14-2	Billet	900	1 100	JIS SPEC.	Alloy steel	47	232		163	4,3
402	CB-C-14-3	Billet	900	1 100	JIS SPEC.	Alloy steel	47	232		163	4,3
403	CB-C-14-4	Billet	900	1 100	JIS SPEC.	Alloy steel	47	232		163	4,3
405	CB-C-14-5	Billet	900	1 100	JIS SPEC.	Alloy steel	47	232		163	4,3
406	CB-C-14-6	Billet	900	1 100	JIS SPEC.	Alloy steel	47	232		163	4,3

Table 3 — Cylinder description for group D materials

Test No	Cylinder No.	Type of cylinder mfg.	Specified tensile strength		Cylinder specification	Material (steel alloy and special notes)	Vol.	Dia.	Design test pressure	Design service pressure	Design thickness
			$R_{g\,min}$ MPa	$R_{g\,max}$ MPa			l	D mm	P_h bar	P_s bar	t_d mm
Material group D-1											
1	CB-D-1-1	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
2	CB-D-1-2	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
3	CB-D-1-3	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
4	CB-D-1-4	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
5	CB-D-1-5	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
6	CB-D-1-6	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
7	CB-D-1-7	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
8	CB-D-1-8	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
9	CB-D-1-9	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
10	CB-D-1-10	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	300	200	4,5
11	CB-D-1-11	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	450	300	7,7
12	CB-D-1-12	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	450	300	7,7
13	CB-D-1-13	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	450	300	7,7
14	CB-D-1-14	Billet	1 100	1 160	ISO 4705	Cr-Mo	50	230	450	300	7,7
Material group D-2											
31	CB-D-2-1	Billet	1 130	1 190		Alloy Steel	50	230	300	200	4,5
32	CB-D-2-2	Billet	1 130	1 190		Alloy Steel	50	230	300	200	4,5
33	CB-D-2-3	Billet	1 130	1 190		Alloy Steel	50	230	300	200	4,5
40	CB-D-2-4	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
41	CB-D-2-5	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
42	CB-D-2-6	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5

Table 3 (*continued*)

Test No	Cylinder No.	Type of cylinder mfg.	Specified tensile strength		Cylinder specification	Material (steel alloy and special notes)	Vol.	Dia.	Design test pressure	Design service pressure	Design thickness
			$R_{g\ min}$ MPa	$R_{g\ max}$ MPa			l	D mm	P_h bar	P_s bar	t_d mm
43	CB-D-2-7	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
44	CB-D-2-8	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
45	CB-D-2-9	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
46	CB-D-2-10	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
47	CB-D-2-11	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
48	CB-D-2-12	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
49	CB-D-2-13	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
50	CB-D-2-14	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
51	CB-D-2-15	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
52	CB-D-2-16	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
53	CB-D-2-17	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
54	CB-D-2-18	Billet	1 100	1 160		Cr-Mo	50	230	300	200	4,5
Material group D-7											
142	CB-D-7-1	Billet	1 068,7	1 206,6		Cr-Mo	50	236	465	310.2	6,6
143	CB-D-7-2	Billet	1 068,7	1 206,6		Cr-Mo	50	236	465	310.2	6,6
144	CB-D-7-3	Billet	1 068,7	1 206,6		Cr-Mo	50	236	465	310.2	6,6
145	CB-D-7-4	Billet	1 068,7	1 206,6		Cr-Mo	50	236	465	310.2	6,6
146	CB-D-7-5	Billet	1 068,7	1 206,6		Cr-Mo	50	236	465	310.2	6,6
147	CB-D-7-6	Billet	1 068,7	1 206,6		Cr-Mo	50	236	465	310.2	6,6
149	CB-D-7-7	Billet	1 068,7	1 206,6		Cr-Mo	50	236	465	310.2	6,6

Table 3 *(continued)*

Test No	Cylinder No.	Type of cylinder mfg.	Specified tensile strength $R_{g\,min}$ MPa	Specified tensile strength $R_{g\,max}$ MPa	Cylinder specification	Material (steel alloy and special notes)	Vol. l	Dia. D mm	Design test pressure P_h bar	Design service pressure P_s bar	Design thickness t_d mm
Material group D-8											
202	CB-D-8-1	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
203	CB-D-8-2	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
204	CB-D-8-3	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
230	CB-D-8-4	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
231	CB-D-8-5	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
232	CB-D-8-6	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
233	CB-D-8-7	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
234	CB-D-8-8	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
235	CB-D-8-9	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
236	CB-D-8-10	Tube	1 100	—		Cr-Mo	50	229	375	250	6,0
Material group D-12											
376	CB-D-12-1	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
377	CB-D-12-2	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
378	CB-D-12-3	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
379	CB-D-12-4	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
380	CB-D-12-5	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
381	CB-D-12-6	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
382	CB-D-12-7	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
383	CB-D-12-8	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
384	CB-D-12-9	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
385	CB-D-12-10	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6

Table 3 *(continued)*

Test No	Cylinder No.	Type of cylinder mfg.	Specified tensile strength $R_{g\ min}$ MPa	Specified tensile strength $R_{g\ max}$ MPa	Cylinder specification	Material (steel alloy and special notes)	Vol. l	Dia. D mm	Design test pressure P_h bar	Design service pressure P_s bar	Design thickness t_d mm
386	CB-D-12-11	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
387	CB-D-12-12	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
388	CB-D-12-13	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
389	CB-D-12-14	Plate	930	1 138		Cr-Mo	10	184	362	241	4,6
Material group D-13											
398	CB-D-13-1	Billet	1 050	1 200	ISO 9809	Alloy Steel	47	232	300	200	4,6
399	CB-D-13-2	Billet	1 050	1 200	ISO 9809	Alloy Steel	47	232	300	200	4,6

Table 4 — Mechanical properties of group B materials

Test No.	Cylinder No.	Tensile test results			Charpy- V- Notch test results					
		Yield strength R_{ea} MPa	Tensile strength R_m MPa	Elong. A %	Transverse orientation			Longitudinal orientation		
					Size mm	at + 20 °C J/cm²	at – 50 °C J/cm²	Size mm	at + 20 °C J/cm²	at – 50 °C J/cm²
Material group B-1										
15	CB-B-1-1	819	916	18,4	10 × 5	38	33	10 × 5	141	128
16	CB-B-1-2	800	897	17,3	10 × 5	39	33	10 × 5	144	135
17	CB-B-1-3	756	877	17,4	10 × 5	40	36	10 × 5	142	129
18	CB-B-1-4	850	947	17,3	10 × 5	35	29	10 × 5	143	124
19	CB-B-1-5	787	887	17,9	10 × 5	40	36	10 × 5	149	132
20	CB-B-1-6	831	937	16,6	10 × 5	44	40	10 × 5	148	—
21	CB-B-1-7	842	928	17,2	10 × 5	44	41	10 × 5	151	—
22	CB-B-1-8	829	931	16,8	10 × 5	44	36	10 × 5	150	128
23	CB-B-1-9	842	932	15,5	10 × 5	47	40	10 × 5	154	—
24	CB-B-1-10	800	894	18,4	10 × 5	56	—	10 × 5	168	—
25	CB-B-1-11	822	921	17,0	10 × 5	51	48	10 × 5	154	—
Material group B-10										
394	CB-B-10-1	748	875	14,1	10 × 4	40	34	10 × 4	99	85
395	CB-B-10-2	748	875	14,1	10 × 4	40	34	10 × 4	99	85
Material group B-11										
407	CB-B-11-1	713	824	17,0	10 × 4	39	37	10 × 4	101	82
408	CB-B-11-2	713	824	17,0	10 × 4	39	37	10 × 4	101	82
409	CB-B-11-3	763	872	17,5	10 × 4	64	58	10 × 4	145	135
410	CB-B-11-4	763	872	17,5	10 × 4	64	58	10 × 4	145	135

Table 5 — Mechanical properties of group C materials

Test No.	Cylinder No.	Tensile test results: Yield strength R_{ea} MPa	Tensile test results: Tensile strength R_m MPa	Tensile test results: Elong. A %	Charpy- V- Notch test results: Transverse orientation: Size mm	Transverse orientation: at + 20 °C J/cm²	Transverse orientation: at – 50 °C J/cm²	Longitudinal orientation: Size mm	Longitudinal orientation: at + 20 °C J/cm²	Longitudinal orientation: at – 50 °C J/cm²
Material group C-1										
11	CB-C-1-1	987	1 057	15,2	10 × 8,3	28	21	10 × 8,3	110	—
12	CB-C-1-2	999	1 069	15,4	10 × 8,3	28	20	10 × 8,3	106	—
13	CB-C-1-3	991	1 057	15,1	10 × 8,3	27	22	10 × 8,3	110	—
14	CB-C-1-4	965	1 036	16,0	10 × 8,3	28	23	10 × 8,3	108	—
Material group C-2										
26	CB-C-2-1	1 013	1 074	14,4	10 × 5	53	48	10 × 5	111	99
27	CB-C-2-2	939	1 018	14,4	10 × 5	59	40	10 × 5	96	—
28	CB-C-2-3	973	1 048	15,9	10 × 5	67	56	10 × 5	126	107
29	CB-C-2-4	1 015	1 096	15,0	10 × 5	68	38	10 × 5	118	66
30	CB-C-2-5	963	1 035	14,8	10 × 5	86	77	10 × 5	130	118
Material group C-5										
183	CB-C-5-1	878	994	20,3	10 × 5	123	55	10 × 5	—	106
184	CB-C-5-2	878	994	20,3	10 × 5	123	55	10 × 5	—	106
185	CB-C-5-3	855	961	17,2	10 × 5	123	55	10 × 5	—	106
186	CB-C-5-4	855	961	17,2	10 × 5	123	55	10 × 5	—	106
187	CB-C-5-5	855	961	17,2	10 × 5	123	55	10 × 5	—	106
188	CB-C-5-6	855	961	17,2	10 × 5	123	55	10 × 5	—	106
201	CB-C-5-7	852	964	18,8	10 × 5	128	57	10 × 5	—	124
Material group C-10										
323	CB-C-10-1	854	985	20,0	—	—	—	—	—	> 100

Table 5 (*continued*)

Test No.	Cylinder No.	Tensile test results: Yield strength R_{ea} MPa	Tensile strength R_m MPa	Elong. A %	Charpy- V- Notch test results: Transverse orientation: Size mm	at + 20 °C J/cm²	at – 50 °C J/cm²	Longitudinal orientation: Size mm	at + 20 °C J/cm²	at – 50 °C J/cm²
324	CB-C-10-2	854	985	20,0	—	—	—	—	—	> 100
325	CB-C-10-3	854	985	20,0	—	—	—	—	—	> 100
326	CB-C-10-4	854	985	20,0	—	—	—	—	—	> 100
Material group C-11										
368	CB-C-11-1	1 032	953	17,5	10 × 4	—	—	—	—	68
369	CB-C-11-2	1 082	995	17,0	10 × 4	—	—	—	—	75
370	CB-C-11-3	1 054	985	18,3	10 × 4	—	—	—	—	86
371	CB-C-11-4	1 035	962	18,3	10 × 4	—	—	—	—	56
372	CB-C-11-5	1 030	947	17,8	10 × 4	—	—	—	—	76
373	CB-C-11-6	992	921	18,0	10 × 4	—	—	—	—	72
374	CB-C-11-7									
Material group C-12										
390	CB-C-12-2	842	962	13,7	10 × 4	77	75	10 × 4	132	123
391	CB-C-12-3	842	962	13,7	10 × 4	77	75	10 × 4	132	123
392	CB-C-12-4	969	1 067	12,7	10 × 4	56	53	10 × 4	100	92
393	CB-C-12-5	969	1 067	12,7	10 × 4	56	53	10 × 4	100	92
Material group C-13										
396	CB-C-13-1	999	1 072	14,4	10 × 4	98	89	10 × 4	141	128
397	CB-C-13-2	999	1 072	14,4	10 × 4	98	89	10 × 4	141	128
Material group C-14										
400	CB-C-14-1	921	985	16,2	10 × 4	52	43	10 × 4	134	130
410	CB-C-14-2	921	985	16,2	10 × 4	52	43	10 × 4	134	130

Table 5 *(continued)*

Test No.	Cylinder No.	Tensile test results			Charpy- V- Notch test results					
		Yield strength	Tensile strength	Elong.	Transverse orientation			Longitudinal orientation		
		R_{ea}	R_m	A	Size	at + 20 °C	at – 50 °C	Size	at + 20 °C	at – 50 °C
		MPa	MPa	%	mm	J/cm^2	J/cm^2	mm	J/cm^2	J/cm^2
402	CB-C-14-3	921	985	16,2	10 × 4	52	43	10 × 4	134	130
403	CB-C-14-4	921	985	16,2	10 × 4	52	43	10 × 4	134	130
405	CB-C-14-5	921	985	16,2	10 × 4	52	43	10 × 4	134	130
406	CB-C-14-6	921	985	16,2	10 × 4	52	43	10 × 4	134	130

Table 6 — Mechanical properties of group D materials

Test No.	Cylinder No.	Tensile test results			Charpy- V- Notch test results					
		Yield strength	Tensile strength	Elong.	Transverse orientation			Longitudinal orientation		
		R_{ea}	R_m	A	Size	at + 20 °C	at – 50 °C	Size	at + 20 °C	at – 50 °C
		MPa	MPa	%	mm	J/cm^2	J/cm^2	mm	J/cm^2	J/cm^2
Material group D-1										
1	CB-D-1-1	1 058	1 129	15,3	10 × 5	58	42	10 × 5	99	—
2	CB-D-1-2	1 059	1 130	14,8	10 × 5	64	36	10 × 5	100	—
3	CB-D-1-3	1 039	1 103	14,6	10 × 5	66	42	10 × 5	108	—
4	CB-D-1-4	1 032	1 103	14,9	10 × 5	57	47	10 × 5	104	—
5	CB-D-1-5	939	1 145	14,7	10 × 5	60	39	10 × 5	99	—
6	CB-D-1-6	1 055	1 018	14,4	10 × 5	59	40	10 × 5	96	—
7	CB-D-1-7	1 072	1 120	15,3	10 × 5	62	39	10 × 5	103	—
8	CB-D-1-8	1 079	1 132	14,2	10 × 5	54	42	10 × 5	102	—
9	CB-D-1-9	1 053	1 142	14,8	10 × 5	63	41	10 × 5	96	—
10	CB-D-1-10	1 053	1 116	15,0	10 × 5	56	39	10 × 5	102	—
11	CB-D-1-11	987	1 057	15,2	10 × 5	28	21	10 × 5	110	—
12	CB-D-1-12	999	1 069	15,4	10 × 5	28	20	10 × 5	106	—
13	CB-D-1-13	991	1 057	15,1	10 × 5	27	22	10 × 5	110	—
14	CB-D-1-14	965	1 036	16,0	10 × 5	28	23	10 × 5	108	—
Material group D-2										
31	CB-D-2-1	1 079	1 173	14,4	10 × 5	83	30	10 × 5	119	—
32	CB-D-2-2	1 039	1 143	14,5	10 × 5	77	—	10 × 5	117	—
33	CB-D-2-3	1 069	1 149	15,4	10 × 5	82	41	10 × 5	104	—
40	CB-D-2-4	1 087	1 154	14,3	10 × 5	46	26	10 × 5	91	—
41	CB-D-2-5	1 054	1 122	15,3	10 × 5	68	42	10 × 5	103	—

Table 6 (*continued*)

Test No.	Cylinder No.	Tensile test results			Charpy- V- Notch test results					
		Yield strength	Tensile strength	Elong.	Transverse orientation			Longitudinal orientation		
		R_{ea}	R_m	A	Size	at + 20 °C	at – 50 °C	Size	at + 20 °C	at – 50 °C
		MPa	MPa	%	mm	J/cm²	J/cm²	mm	J/cm²	J/cm²
42	CB-D-2-6	1 072	1 135	15,2	10 × 5	53	39	10 × 5	96	—
43	CB-D-2-7	1 060	1 128	14,4	10 × 5	55	38	10 × 5	97	—
44	CB-D-2-8	1 070	1 135	14,0	10 × 5	53	38	10 × 5	95	—
45	CB-D-2-9	1 042	1 112	15,6	10 × 5	56	46	10 × 5	105	—
46	CB-D-2-10	1 063	1 136	14,0	10 × 5	56	36	10 × 5	93	—
47	CB-D-2-11	1 052	1 117	15,3	10 × 5	57	38	10 × 5	99	—
48	CB-D-2-12	1 060	1 124	14,4	10 × 5	61	43	10 × 5	102	—
49	CB-D-2-13	1 059	1 127	14,0	10 × 5	59	—	10 × 5	103	—
50	CB-D-2-14	1 069	1 143	15,0	10 × 5	58	43	10 × 5	100	—
51	CB-D-2-15	1 056	1 126	14,1	10 × 5	36	28	10 × 5	109	—
52	CB-D-2-16	1 067	1 135	14,0	10 × 5	85	52	10 × 5	108	—
53	CB-D-2-17	1 041	1 117	15,1	10 × 5	94	58	10 × 5	117	—
54	CB-D-2-18	1 017	1 104	15,2	10 × 5	60	41	10 × 5	111	—
Material group D-7										
142	CB-D-7-1	1 070	1 104	—	10 × 5	24	17	10 × 5	68	—
143	CB-D-7-2	1 145	1 150	—	10 × 5	24	17	10 × 5	68	—
144	CB-D-7-3	1 111	1 139	—	10 × 5	24	17	10 × 5	68	—
145	CB-D-7-4	1 139	1 166	—	10 × 5	24	17	10 × 5	68	—
146	CB-D-7-5	1 125	1 152	—	10 × 5	24	17	10 × 5	68	—
147	CB-D-7-6	1 097	1 118	—	10 × 5	24	17	10 × 5	68	—
149	CB-D-7-7	1 139	1 166	—	10 × 5	24	17	10 × 5	68	—

Table 6 (*continued*)

Test No.	Cylinder No.	Tensile test results			Charpy- V- Notch test results					
		Yield strength	Tensile strength	Elong.	Transverse orientation			Longitudinal orientation		
		R_{ea}	R_m	A	Size	at + 20 °C	at – 50 °C	Size	at + 20 °C	at – 50 °C
		MPa	MPa	%	mm	J/cm²	J/cm²	mm	J/cm²	J/cm²
Material group D-8										
202	CB-D-8-1	1 157	1 197	15,3	10 × 5	—	—	—	73	—
203	CB-D-8-2	1 147	1 202	16,5	10 × 5	—	—	—	73	—
204	CB-D-8-3	1 047	1 203	14,5	10 × 5	—	—	—	73	—
230	CB-D-8-4	—	1 120	16,9	10 × 5	—	—	—	—	—
231	CB-D-8-5	—	1 130	16,1	10 × 5	—	—	—	55	—
232	CB-D-8-6	—	1 130	16,1	10 × 5	—	—	—	55	—
233	CB-D-8-7	—	1 130	16,1	10 × 5	—	—	—	55	—
234	CB-D-8-8	—	1 130	16,1	10 × 5	—	—	—	55	—
235	CB-D-8-9	—	1 130	16,1	10 × 5	—	—	—	55	—
236	CB-D-8-10	—	1 130	16,1	10 × 5	—	—	—	55	—
Material group D-12										
376	CB-D-12-1	1 039	1 103	8,2	—	—	—	—	—	—
377	CB-D-12-2	1 037	1 101	7,6	—	—	—	—	—	—
378	CB-D-12-3	1 077	1 144	7,3	—	—	—	—	—	—
379	CB-D-12-4	1 031	1 104	8,0	—	—	—	—	—	—
380	CB-D-12-5	1 008	1 062	4,0	—	—	—	—	—	—
381	CB-D-12-6	1 029	1 095	6,0	—	—	—	—	—	—
382	CB-D-12-7	1 045	1 110	8,9	—	—	—	—	—	—
383	CB-D-12-8	1 019	1 081	8,4	—	—	—	—	—	—
384	CB-D-12-9	1 041	1 099	7,8	—	—	—	—	—	—
385	CB-D-12-10	1 028	1 094	8,2	—	—	—	—	—	—

Table 6 (*continued*)

Test No.	Cylinder No.	Tensile test results			Charpy- V- Notch test results					
		Yield strength	Tensile strength	Elong.	Transverse orientation			Longitudinal orientation		
		R_{ea}	R_m	A	Size	at + 20 °C	at – 50 °C	Size	at + 20 °C	at – 50 °C
		MPa	MPa	%	mm	J/cm^2	J/cm^2	mm	J/cm^2	J/cm^2
386	CB-D-12-11	1 001	1 074	9,1	—	—	—	—	—	—
387	CB-D-12-12	1 020	1 086	8,4	—	—	—	—	—	—
388	CB-D-12-13	—	1 070	—	—	—	—	—	—	—
389	CB-D-12-14	—	1 070	—	—	—	—	—	—	—
Material group D-13										
398	CB-D-13-1	1 072	1 124	15,0	10 × 4	88	79	10 × 4	131	120
399	CB-D-13-2	1 072	1 124	15,0	10 × 4	88	79	10 × 4	131	120

Table 7 — Flawed-cylinder cyclical burst test results for group B materials

Burst test No.	Cylinder No.	Design test pressure bar	Design service pressure bar	Flaw length $n = l_o/t_d$	Flaw depth % of t_d	Thickness at flaw t_a mm	Number of cycles	Failure pressure P_f bar	Failure mode	Measured ratio P_f/P_s	Adjusted ratio $(P_f/P_s)(t_d/t_a)$
Material group B-1											
15	CB-B-1-1	300	200	11,2	31,3	6,4	610	300	Fracture	1,50	1,36
16	CB-B-1-2	300	200	10,8	30,8	6,5	490	300	Fracture	1,50	1,34
17	CB-B-1-3	300	200	10,0	55,4	6,5	67	300	Fracture	1,50	1,34
18	CB-B-1-4	300	200	9,6	55,4	6,5	57	300	Fracture	1,50	1,34
19	CB-B-1-5	300	200	8,7	66,2	6,5	12	300	Fracture	1,50	1,34
20	CB-B-1-6	300	200	8,9	74,6	6,3	25	300	Leak	1,50	1,38
21	CB-B-1-7	300	200	8,7	69,0	6,5	14	300	Fracture	1,50	1,34
22	CB-B-1-8	300	200	8,6	78,8	6,6	7	300	Fracture	1,50	1,32
23	CB-B-1-9	300	200	8,7	75,4	6,5	12	300	Leak	1,50	1,34
24	CB-B-1-10	300	200	8,7	75,8	6,6	43	300	Leak	1,50	1,32
25	CB-B-1-11	300	200	8,7	76,9	6,5	70	300	Leak	1,50	1,34
Material group B-10											
394	CB-B-10-1	300	200	9,9	83,3	6,6	Monotonic	186	Leak	0,93	0,85
395	CB-B-10-2	300	200	9,8	10,6	6,2	4993	344	Fracture	1,72	1,65
Material group B-11											
407	CB-B-11-1	255	170	10,6	10,3	6,2	18 158	255	Leak	1,50	1,31
408	CB-B-11-2	255	170	10,0	83,7	6,2	Monotonic	220	Leak	1,29	1,13
409	CB-B-11-3	300	200	10,0	9,5	6,5	12 379	300	Leak	1,50	1,36
410	CB-B-11-4	300	200	10,3	85,9	6,4	Monotonic	225	Leak	1,13	1,04

Table 8 — Flawed-cylinder cyclical burst test results for group C materials

Burst test No.	Cylinder No.	Design test pressure bar	Design service pressure bar	Flaw length $n = l_o/t_d$	Flaw depth % of t_d	Thickness at flaw t_a mm	Number of cycles	Failure pressure P_f bar	Failure mode	Measured ratio P_f/P_s	Adjusted ratio $(P_f/P_s)(t_d/t_a)$
Material group C-1											
11	CB-C-1-1	450	300	6,7	75,9	7,9	361	300	Leak	1,00	0,97
12	CB-C-1-2	450	300	5,9	75,9	7,9	404	300	Leak	1,00	0,97
13	CB-C-1-3	450	300	7,3	64,1	7,8	446	300	Leak	1,00	0,99
14	CB-C-1-4	450	300	6,0	51,3	7,8	1 528	300	Leak	1,00	0,99
Material group C-2											
26	CB-C-2-1	300	200	9,6	51,7	6,0	197	300	Leak	1,50	1,30
27	CB-C-2-2	300	200	9,4	26,5	4,9	1 720	300	Leak	1,50	1,59
28	CB-C-2-3	300	200	9,8	67,0	6,0	51	300	Leak	1,50	1,30
29	CB-C-2-4	300	200	9,8	67,0	6,0	95	300	Leak	1,50	1,30
30	CB-C-2-5	300	200	10,0	33,0	6,0	357	300	Leak	1,50	1,30
Material group C-5											
183	CB-C-5-1	300	200	20,0	16,0	6,0	2 747	300	Fracture	1,50	1,49
184	CB-C-5-2	300	200	20,0	16,0	6,0	2 747	300	Fracture	1,50	1,49
185	CB-C-5-3	300	200	20,0	16,0	6,9	4 192	300	Fracture	1,50	1,30
186	CB-C-5-4	300	200	5,7	23,0	6,8	5 401	300	Leak	1,50	1,32
187	CB-C-5-5	300	200	5,7	6,0	7,5	8 788	300	Leak	1,50	1,19
188	CB-C-5-6	300	200	10,0	23,0	6,7	3 275	300	Leak	1,50	1,34
201	CB-C-5-7	300	200	10,0	23,0	6,7	3 342	300	Leak	1,50	1,34

Table 8 (*continued*)

Burst test No.	Cylinder No.	Design test pressure bar	Design service pressure bar	Flaw length $n = l_o/t_d$	Flaw depth % of t_d	Thickness at flaw t_a mm	Number of cycles	Failure pressure P_f bar	Failure mode	Measured ratio P_f/P_s	Adjusted ratio $(P_f/P_s)(t_d/t_a)$
Material group C-10											
323	CB-C-10-1	345	230	10,0	15,0	6,5	7 046	345	Fracture	1,50	1,29
324	CB-C-10-2	345	230	10,0	20,0	6,5	4 500	345	Fracture	1,50	1,29
325	CB-C-10-3	345	230	10,0	30,0	6,5	8 78	345	Fracture	1,50	1,29
326	CB-C-10-4	345	230	10,0	30,0	6,5	1 599	230	Leak	1,00	0,86
Material group C-11											
368	CB-C-11-1	362	241	10,0	53,0	4,8	1308	302	Leak	1,25	1,19
369	CB-C-11-2	362	241	10,0	53,0	4,9	973	302	Fracture	1,25	1,16
370	CB-C-11-3	362	241	10,0	53,0	4,8	1 322	302	Fracture	1,25	1,19
371	CB-C-11-4	362	241	10,0	53,0	4,9	2 637	302	Leak	1,25	1,16
372	CB-C-11-5	362	241	10,0	53,0	4,9	4 388	302	Leak	1,25	1,16
373	CB-C-11-6	362	241	10,0	53,0	4,7	1 967	302	Fracture	1,25	1,21
374	CB-C-11-7	362	241	10,0	53,0	4,9	1 025	302	Leak	1,25	1,16
Material group C-12											
390	CB-C-12-2	476	317	10,0	85,0	6,5	Monotonic	333	Leak	1,05	1,07
391	CB-C-12-3	476	317	10,0	—	6,4	4 707	476	Fracture	1,50	1,55
392	CB-C-12-4	490	317	10,0	86,0	6,3	Monotonic	353	Leak	1,11	1,17
393	CB-C-12-5	490	317	10,0	42,0	6,2	27	490	Fracture	1,54	1,64
Material group C-13											
396	CB-C-13-1	285	190	9,9	86,0	4,7	Monotonic	255	Leak	1,34	1,31
397	CB-C-13-2	285	190	9,9	10,9	4,9	5 505	326	Leak	1,72	1,62

Table 8 (*continued*)

Burst test No.	Cylinder No.	Design test pressure bar	Design service pressure bar	Flaw length $n = l_o/t_d$	Flaw depth % of t_d	Thickness at flaw t_a mm	Number of cycles	Failure pressure P_f bar	Failure mode	Measured ratio P_f/P_s	Adjusted ratio $(P_f/P_s)(t_d/t_a)$
Material group C-14											
400	CB-C-14-1	245	163	10,0	10,3	4,8	12 000	245	—	1,50	1,36
410	CB-C-14-2	245	163	10,0	11,9	4,8	12 000	245	—	1,50	1,34
402	CB-C-14-3	245	163	10,0	12,6	4,8	10 582	245	Leak	1,50	1,35
403	CB-C-14-4	245	163	10,0	83,0	4,8	Monotonic	227	Leak	1,39	1,26
405	CB-C-14-5	245	163	10,0	86,0	4,9	Monotonic	196	Leak	1,20	1,05
406	CB-C-14-6	245	163	10,0	85,0	4,7	Monotonic	191	Leak	1,17	1,07

Table 9 — Flawed-cylinder cyclical burst test results for group D materials

Burst test No.	Cylinder No.	Design test pressure bar	Design service pressure bar	Flaw length $n = l_o/t_d$	Flaw depth % of t_d	Thickness at flaw t_a mm	Number of cycles	Failure pressure P_f bar	Failure mode	Measured ratio P_f/P_s	Adjusted ratio $(P_f/P_s)(t_d/t_a)$
Material group D-1											
1	CB-D-1-1	300	200	7,5	91,8	4,9	2	300	Leak	1,50	1,38
2	CB-D-1-2	300	200	8,2	76,9	5,4	32	300	Leak	1,50	1,25
3	CB-D-1-3	300	200	8,5	58,8	5,1	30	300	Leak	1,50	1,32
4	CB-D-1-4	300	200	8,5	76,9	5,2	75	300	Leak	1,50	1,30
5	CB-D-1-5	300	200	9,0	76,9	5,2	54	300	Leak	1,50	1,30
6	CB-D-1-6	300	200	9,4	26,5	4,9	1720	300	Leak	1,50	1,38
7	CB-D-1-7	300	200	9,8	8,0	5,0	9457	300	Leak	1,50	1,35
8	CB-D-1-8	300	200	10,0	65,6	4,9	17	300	Fracture	1,50	1,38
9	CB-D-1-9	300	200	10,0	59,0	4,9	171	300	Leak	1,50	1,38
10	CB-D-1-10	300	200	10,1	9,8	5,1	15 920	300	Leak	1,50	1,32
11	CB-D-1-11	450	300	6,7	75,9	7,9	361	300	Leak	1,00	0,97
12	CB-D-1-12	450	300	5,9	75,9	7,9	404	300	Leak	1,00	0,97
13	CB-D-1-13	450	300	7,3	64,1	7,8	446	300	Leak	1,00	0,99
14	CB-D-1-14	450	300	6,0	51,3	7,8	1 528	300	Leak	1,00	0,99
Material group D-2											
31	CB-D-2-1	300	200	10,0	65,3	4,9	56	300	Leak	1,50	1,38
32	CB-D-2-2	300	200	10,0	62,7	5,1	182	300	Leak	1,50	1,32
33	CB-D-2-3	300	200	10,3	63,0	5,4	51	300	Leak	1,50	1,25
40	CB-D-2-4	300	200	8,3	83,3	4,8	Monotonic	300	Leak	1,50	1,41
41	CB-D-2-5	300	200	7,0	93,8	4,8	Monotonic	300	Leak	1,50	1,41
42	CB-D-2-6	300	200	10,0	90	5,0	Monotonic	300	Leak	1,50	1,35

Table 9 (*continued*)

Burst test No.	Cylinder No.	Design test pressure bar	Design service pressure bar	Flaw length $n = l_o/t_d$	Flaw depth % of t_d	Thickness at flaw t_a mm	Number of cycles	Failure pressure P_f bar	Failure mode	Measured ratio P_f/P_s	Adjusted ratio $(P_f/P_s)(t_d/t_a)$
43	CB-D-2-7	300	200	10,0	85	5,0	Monotonic	300	Leak	1,50	1,35
44	CB-D-2-8	300	200	10,0	80	5,0	Monotonic	300	Leak	1,50	1,35
45	CB-D-2-9	300	200	10,0	75	5,0	Monotonic	300	Fracture	1,50	1,35
46	CB-D-2-10	300	200	10,0	70,6	5,1	Monotonic	300	Fracture	1,50	1,32
47	CB-D-2-11	300	200	10,0	76,9	5,2	Monotonic	300	Fracture	1,50	1,30
48	CB-D-2-12	300	200	10,0	71,6	5,1	Monotonic	300	Fracture	1,50	1,32
49	CB-D-2-13	300	200	10,0	67,6	5,1	Monotonic	300	Fracture	1,50	1,32
50	CB-D-2-14	300	200	9,5	76,9	5,2	Monotonic	285	Leak	1,43	1,23
51	CB-D-2-15	300	200	10,0	85,5	5,5	Monotonic	215	Leak	1,08	0,88
52	CB-D-2-16	300	200	10,0	76,3	5,9	Monotonic	290	Leak	1,45	1,11
53	CB-D-2-17	300	200	10,0	75	6,0	Monotonic	310	Leak	1,55	1,16
54	CB-D-2-18	300	200	10,0	78,3	6,0	Monotonic	282	Leak	1,41	1,06
Material group D-7											
142	CB-D-7-1	465.4	310	3,5	40,0	7,3	—	317	Fracture	1,02	0,92
143	CB-D-7-2	465	310	4,2	40,0	7,3	—	317	Leak	1,02	0,92
144	CB-D-7-3	465	310	4,3	40,0	7,2	—	310	Leak	1,00	0,92
145	CB-D-7-4	465	310	4,6	40,0	7,7	—	310	Leak	1,00	0,86
146	CB-D-7-5	465	310	4,9	40,0	7,3	—	310	Leak	1,00	0,90
147	CB-D-7-6	465	310	6,7	38,0	7,6	—	284	Fracture	0,92	0,80
149	CB-D-7-7	465.4	310	6,6	38,0	7,7	—	284	Fracture	0,92	0,78
Material group D-8											
202	CB-D-8-1	390	260	10,0	70,0	6,8	—	300	Fracture	1,15	1,01
203	CB-D-8-2	390	260	10,0	75,0	6,8	—	230	Leak	0,88	0,78

Table 9 (*continued*)

Burst test No.	Cylinder No.	Design test pressure bar	Design service pressure bar	Flaw length $n = l_o/t_d$	Flaw depth % of t_d	Thickness at flaw t_a mm	Number of cycles	Failure pressure P_f bar	Failure mode	Measured ratio P_f/P_s	Adjusted ratio $(P_f/P_s)(t_d/t_a)$
204	CB-D-8-3	300	200	10,0	15,0	6,8	—	290	Fracture	1,45	1,27
230	CB-D-8-4	375	250	10,0	75,0	6,7	—	300	Leak	1,20	1,07
231	CB-D-8-5	375	250	10,0	70,0	6,6	—	330	Leak	1,32	1,19
232	CB-D-8-6	375	250	10,0	65,0	6,6	—	350	Fracture	1,40	1,27
233	CB-D-8-7	375	250	10,0	70,0	6,6	Monotonic	390	Fracture	1,56	1,41
234	CB-D-8-8	375	250	10,0	65,0	6,4	Monotonic	300	Fracture	1,20	1,12
235	CB-D-8-9	375	250	20,0	15,0	6,7	4614	300	Fracture	1,20	1,07
236	CB-D-8-10	375	250	20,0	15,0	6,8	1 888	300	Fracture	1,20	1,05
Material group D-12											
376	CB-D-12-1	362	241	13,9	47,0	4,8	81	362	Fracture	1,50	1,42
377	CB-D-12-2	362	241	8,5	47,0	4,8	394	362	Leak	1,50	1,42
378	CB-D-12-3	362	241	18,6	27,0	4,8	1 150	302	Fracture	1,25	1,19
379	CB-D-12-4	362	241	13,2	27,0	4,8	1 349	302	Fracture	1,25	1,19
380	CB-D-12-5	362	241	7,8	27,0	4,8	2 583	302	Leak	1,25	1,19
381	CB-D-12-6	362	241	11,8	27,0	4,8	2 424	302	Fracture	1,25	1,19
382	CB-D-12-7	362	241	10,5	27,0	4,8	3 026	302	Leak	1,25	1,19
383	CB-D-12-8	362	241	9,1	27,0	4,8	2 495	302	Leak	1,25	1,19
384	CB-D-12-9	362	241	10,5	27,0	4,8	3 504	302	Fracture	1,25	1,19
385	CB-D-12-10	362	241	8,4	27,0	4,8	4 249	302	Leak	1,25	1,19
386	CB-D-12-11	362	241	9,1	27,0	4,8	8 265	302	Leak	1,25	1,19
387	CB-D-12-12	362	241	9,1	27,0	4,8	2 8411	302	Leak	1,25	1,19
388	CB-D-12-13	362	241	13,2	27,0	4,8	—	241	Leak	1,00	0,95
389	CB-D-12-14	362	241	13,2	27,0	4,8	—	241	Leak	1,00	0,95