- The alphanumerical codes of special provisions of construction (TC), equipment (TE) and type approval (TA) of 6.8.4 which are shown in column (13) of Table A of Chapter 3.2 for those substances for the carriage of which the tank has been approved;

- If required, the substances and/or group of substances for the carriage of which the tank has been approved. These shall be shown with their chemical name or the corresponding collective entry (see 2.1.1.2), together with their classification (class, classification code and packing group). With the exception of substances of Class 2 and those listed in 4.3.4.1.3, the listing of approved substances may be dispensed with. In such cases, groups of substances permitted on the basis of the tank code shown in the rationalised approach in 4.3.4.1.2 shall be accepted for carriage taking into account any relevant special provision.

NOTE: *Annex B of EN 12972:2018 + A1:2024 describing the type as well as the list of authorized service equipment for the tank type, or equivalent documents shall be attached to or included in the certificate.*

The substances referred to in the certificate or the groups of substances approved according to the rationalised approach shall, in general, be compatible with the characteristics of the tank. A reservation shall be included in the certificate if it was not possible to investigate this compatibility exhaustively when the type approval was issued.

A copy of the certificate shall be attached to the tank record of each tank, battery-vehicle or MEGC constructed (see 4.3.2.1.7).

When the manufacturer of service equipment had a separate type examination carried out and when the manufacturer requests it, the competent authority shall issue a certificate attesting that the type which has been examined meets the standard listed in the table in 6.8.2.6.1 or 6.8.3.6.

6.8.2.3.3 If the tanks, battery-vehicles or MECGs are manufactured in series without modification this approval shall be valid for the tanks, battery-vehicles or MECGs manufactured in series or according to the prototype.

A type approval may however serve for the approval of tanks with limited variations of the design that either reduce the loads and stresses on the tanks (e.g. reduced pressure, reduced mass, reduced volume) or increase the safety of the structure (e.g. increased shell thickness, more surge-plates, decreased diameter of openings). The limited variations shall be clearly described in the type approval certificate.

6.8.2.3.4 In accordance with 1.8.7.2.2.3, the competent authority shall issue a supplementary approval certificate for the modification in the case of a modification of a tank, battery-vehicle or MEGC with a valid, expired or withdrawn type approval.

6.8.2.4 ***Inspections and tests***

6.8.2.4.1 Shells and their equipment shall either together or separately undergo an initial inspection before being put into service. This inspection shall include:

- A check of conformity to the approved type;

- A check of the design characteristics[11]

- An examination of the internal and external conditions;

- A hydraulic pressure test[12] at the test pressure indicated on the plate prescribed in 6.8.2.5.1; and

- A leakproofness test and a check of satisfactory operation of the equipment.

Except in the case of Class 2, the test pressure for the hydraulic pressure test depends on the calculation pressure and shall be at least equal to the pressure indicated below:

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[11] *The check of the design characteristics shall also include, for shells requiring a test pressure of 1 MPa (10 bar) or higher, the taking of weld test-pieces (work samples) in accordance with 6.8.2.1.23 and the tests prescribed in 6.8.5.*

[12] *In special cases, if agreed by the competent authority, the hydraulic pressure test may be replaced by a pressure test using gas, or if agreed by the inspection body, by using another liquid, where such an operation does not present any danger.*

Calculation pressure (bar)	Test pressure (bar)
G[13]	G[13]
1.5	1.5
2.65	2.65
4	4
10	4
15	4
21	10 (4[14])

The minimum test pressures for Class 2 are given in the table of gases and gas mixtures in 4.3.3.2.5.

The hydraulic pressure test shall be carried out on the shell as a whole and separately on each compartment of compartmented shells.

The test shall be carried out on each compartment at a pressure at least equal to:

– 1.3 times the maximum working pressure; or

– 1.3 times the static pressure of the substance to be carried but not less than 1.3 times the static pressure of water with a minimum of 20 kPa (0.2 bar) for gravity-discharge tanks according to 6.8.2.1.14 (a).

The hydraulic pressure test shall be carried out before the installation of a thermal insulation as may be necessary.

If the shells and their equipment are tested separately, they shall be jointly subjected to a leakproofness test after assembly in accordance with 6.8.2.4.3.

The leakproofness test shall be carried out separately on each compartment of compartmented shells.

6.8.2.4.2 Shells and their equipment shall undergo periodic inspections no later than every

six years. | five years.

These periodic inspections shall include:

- An external and internal examination;
- A leakproofness test in accordance with 6.8.2.4.3 of the shell with its equipment and check of the satisfactory operation of all the equipment;
- As a general rule, a hydraulic pressure test[12] (for the test pressure for the shells and compartments if applicable, see 6.8.2.4.1).

Sheathing for thermal or other insulation shall be removed only to the extent required for reliable appraisal of the characteristics of the shell.

In the case of tanks intended for the carriage of powdery or granular substances, and with the agreement of the inspection body, the periodic hydraulic pressure tests may be omitted and replaced by

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13 *G = minimum calculation pressure according to the general requirements of 6.8.2.1.14 (see 4.3.4.1).*

14 *Minimum test pressure for UN No. 1744 bromine or UN No. 1744 bromine solution.*

12 *In special cases, if agreed by the competent authority, the hydraulic pressure test may be replaced by a pressure test using gas, or if agreed by the inspection body, by using another liquid, where such an operation does not present any danger.*

leakproofness tests in accordance with 6.8.2.4.3, at an effective internal pressure at least equal to the maximum working pressure.

Protective linings shall be visually examined for defects. In case defects appear the condition of the lining shall be evaluated by appropriate test(s).

6.8.2.4.3 Shells and their equipment shall undergo intermediate inspections no later than

three years	two and a half years

after the initial inspection and each periodic inspection.

However, the intermediate inspection may be performed at any time before the specified date.

If an intermediate inspection is performed more than three months before the specified date, another intermediate inspection shall be performed no later than

three years	two and a half years

after this earlier date or alternatively a periodic inspection may be performed in accordance with 6.8.2.4.2.

These intermediate inspections shall include a leakproofness test of the shell with its equipment and check of the satisfactory operation of all the equipment. For this purpose the tank shall be subjected to an effective internal pressure at least equal to the maximum working pressure. For tanks intended for the carriage of liquids or solids in the granular or powdery state, when a gas is used for the leakproofness test it shall be carried out at a pressure at least equal to 25 % of the maximum working pressure. In all cases, it shall not be less than 20 kPa (0.2 bar) (gauge pressure).

For tanks equipped with breather devices and a safety device to prevent the contents spilling out if the tank overturns, the leakproofness test shall be carried out at a pressure at least equal to the static pressure of the densest substance to be carried, the static pressure of water or 20 kPa (0.2 bar) whichever is the highest.

The leakproofness test shall be carried out separately on each compartment of compartmented shells.

Protective linings shall be visually examined for defects. In case defects appear the condition of the lining shall be evaluated by appropriate test(s).

6.8.2.4.4 When the safety of the tank or of its equipment may have been impaired as a result of repairs, alterations or accident, an exceptional inspection shall be carried out. If an exceptional inspection fulfilling the requirements of 6.8.2.4.2 has been performed, then the exceptional inspection may be considered to be a periodic inspection. If an exceptional inspection fulfilling the requirements of 6.8.2.4.3 has been performed then the exceptional inspection may be considered to be an intermediate inspection.

6.8.2.4.5 Certificates shall be issued by the inspection body referred to in 6.8.1.5.4 or 6.8.1.5.6 and shall show the results of the inspections in accordance with 6.8.2.4.1 to 6.8.2.4.4, even in the case of negative results. These certificates shall refer to the list of the substances permitted for carriage in this tank or to the tank code and the alphanumeric codes of special provisions in accordance with 6.8.2.3.2.

A copy of these certificates shall be attached to the tank record of each tank, battery-vehicle or MEGC tested (see 4.3.2.1.7).

6.8.2.5 ***Marking***

6.8.2.5.1 Every tank shall be fitted with a corrosion-resistant metal plate permanently attached to the tank in a place readily accessible for inspection. The following particulars at least shall be marked on the plate by stamping or by any other similar method. These particulars may be engraved directly on the walls of the shell itself, if the walls are so reinforced that the strength of the shell is not impaired[15]:

[15] *Add the units of measurement after the numerical values.*

- Approval number;
- Manufacturer's name or mark;
- Manufacturer's serial number;
- Year of manufacture;
- Test pressure (gauge pressure);
- External design pressure (see 6.8.2.1.7);
- Capacity of the shell – in the case of multiple-compartment shells, the capacity of each compartment –, followed by the symbol "S" when the shells or the compartments of more than 7 500 litres are divided by surge plates into sections of not more than 7 500 litres capacity;
- Design temperature (only if above +50 °C or below -20 °C);
- Date and type of the most recent inspection: "month, year" followed by a "P" when the inspection is the initial inspection or a periodic inspection in accordance with 6.8.2.4.1 and 6.8.2.4.2, or "month, year" followed by an "L" when the inspection is an intermediate inspection in accordance with 6.8.2.4.3;
- Stamp of the inspection body that carried out the inspection;
- Material of the shell and reference to materials standards, if available and, where appropriate, the protective lining;
- Test pressure on the shell as a whole and test pressure by compartment in MPa or bar (gauge pressure) where the pressure by compartment is less than the pressure on the shell.

In addition, the maximum working pressure shall be inscribed on pressure-filled or pressure-discharge tanks (for Class 2, see 6.8.3.5).

6.8.2.5.2

The following particulars shall be inscribed on the tank-vehicle (on the tank itself or on panels)[15]:

- Name of owner or operator;
- Unladen mass of the tank-vehicle; and
- Maximum permissible mass of the tank-vehicle.

The following particulars shall be inscribed on a demountable tank (on the tank itself or on panels)[15]:

- Name of owner or operator;
- "demountable tank";
- Tare of the tank;
- Maximum permissible gross mass of the tank;
- For the substances according to 4.3.4.1.3, the proper shipping name of the substance(s) accepted for carriage;
- Tank code according to 4.3.4.1.1; and
- For substances other than those according to 4.3.4.1.3, the alphanumeric codes of all special provisions TC and TE which are shown in column

The following particulars shall be inscribed on the tank-container (on the tank itself or on panels)[15]:

- Names of owner and of operator;
- Capacity of the shell;
- Tare;
- Maximum permissible gross mass;
- For the substances according to 4.3.4.1.3, the proper shipping name of the substance(s) accepted for carriage;
- Tank code according to 4.3.4.1.1; and
- For substances other than those according to 4.3.4.1.3, the alphanumeric codes of all special provisions TC and TE which are shown in column (13) of Table A of Chapter 3.2 for the substances to be carried in the tank.

15 *Add the units of measurement after the numerical values.*

(13) of Table A of Chapter 3.2 for the substances to be carried in the tank.

6.8.2.6 ***Requirements for tanks which are designed, constructed, inspected and tested according to referenced standards***

NOTE: *Persons or bodies identified in standards as having responsibilities in accordance with ADR shall meet the requirements of ADR.*

6.8.2.6.1 *Design and construction*

Since 1 January 2009 the use of the referenced standards has been mandatory. Exceptions are dealt with in 6.8.2.7 and 6.8.3.7.

Type approval certificates shall be issued in accordance with 1.8.7 and 6.8.2.3. For the issuance of a type approval certificate, one standard applicable according to the indication in column (4) shall be chosen from the table below. If more than one standard may be applied, only one of them shall be chosen.

Column (3) shows the paragraphs of Chapter 6.8 to which the standard conforms.

Column (5) gives the latest date when existing type approvals shall be withdrawn according to 1.8.7.2.2.2; if no date is shown the type approval remains valid until it expires.

Standards shall be applied in accordance with 1.1.5. They shall be applied in full unless otherwise specified in the table below.

The scope of application of each standard is defined in the scope clause of the standard unless otherwise specified in the table below.

Reference	Title of document	Requirements the standard complies with	Applicable for new type approvals or for renewals	Latest date for withdrawal of existing type approvals
(1)	(2)	(3)	(4)	(5)
For design and construction of tanks				
EN 14025:2003 + AC:2005	Tanks for the transport of dangerous goods – Metallic pressure tanks – Design and construction	6.8.2.1	Between 1 January 2005 and 30 June 2009	
EN 14025:2008	Tanks for the transport of dangerous goods – Metallic pressure tanks – Design and construction	6.8.2.1 and 6.8.3.1	Between 1 July 2009 and 31 December 2016	
EN 14025:2013	Tanks for the transport of dangerous goods – Metallic pressure tanks – Design and construction	6.8.2.1 and 6.8.3.1	Between 1 January 2015 and 31 December 2018	
EN 14025:2013+ A1:2016 (except Annex B)	Tanks for the transport of dangerous goods – Metallic pressure tanks – Design and construction	6.8.2.1 and 6.8.3.1	Between 1 January 2017 and 31 December 2021	
EN 14025:2018 + AC:2020	Tanks for the transport of dangerous goods – Metallic pressure tanks – Design and construction ***NOTE:*** *Materials of shells shall at least be attested by a type 3.1 certificate issued in accordance with standard EN 10204.*	6.8.2.1 and 6.8.3.1	Between 1 January 2021 and 31 December 2026	
EN 14025:2023	Tanks for the transport of dangerous goods – Metallic pressure tanks – Design and construction ***NOTE:*** *Materials of shells shall at least be attested by a type 3.1 certificate issued in accordance with standard EN 10204.*	6.8.2.1 and 6.8.3.1	Until further notice	
EN 13094:2004	Tanks for the transport of dangerous goods – Metallic tanks with a working pressure not exceeding 0.5 bar – Design and construction	6.8.2.1	Between 1 January 2005 and 31 December 2009	
EN 13094:2008 + AC:2008	Tanks for the transport of dangerous goods – Metallic tanks with a working pressure not exceeding 0.5 bar – Design and construction	6.8.2.1	Between 1 January 2010 and 31 December 2018	
EN 13094:2015	Tanks for the transport of dangerous goods – Metallic tanks with a working pressure not exceeding 0.5 bar – Design and construction ***NOTE:*** *The guideline on the website of the secretariat of the United Nations Economic Commission for Europe (https://unece.org/guidelines-telematics-application-standards-construction-and-approval-vehicles-calculation-risks) also applies.*	6.8.2.1	Between 1 January 2017 and 31 December 2024	
EN 13094:2020 + A1:2022	Tanks for the transport of dangerous goods – Metallic gravity-discharge Design and construction	6.8.2.1	Until further notice	
EN 12493:2001 (except Annex C)	Welded steel tanks for liquefied petroleum gas (LPG) – Road tankers – Design and manufacture ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.1 (with the exception of 6.8.2.1.17); 6.8.2.4.1 (with the exclusion of the leakproofness test); 6.8.2.5.1, 6.8.3.1 and 6.8.3.5.1	Between 1 January 2005 and 31 December 2010	31 December 2012

Reference	Title of document	Requirements the standard complies with	Applicable for new type approvals or for renewals	Latest date for withdrawal of existing type approvals
(1)	(2)	(3)	(4)	(5)
EN 12493:2008 (except Annex C)	LPG equipment and accessories - Welded steel tanks for liquefied petroleum gas (LPG) – Road tankers – Design and manufacture ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.1 (with the exception of 6.8.2.1.17), 6.8.2.5, 6.8.3.1, 6.8.3.5, 6.8.5.1 to 6.8.5.3	Between 1 January 2010 and 31 December 2013	31 December 2014
EN 12493:2008 + A1:2012 (except Annex C)	LPG equipment and accessories –Welded steel tanks for liquefied petroleum gas (LPG) – Road tankers – Design and manufacture ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.1 (with the exception of 6.8.2.1.17), 6.8.2.5, 6.8.3.1, 6.8.3.5, 6.8.5.1 to 6.8.5.3	Until 31 December 2013	31 December 2015
EN 12493:2013 (except Annex C)	LPG equipment and accessories – Welded steel tanks for liquefied petroleum gas (LPG) – Road tankers – Design and manufacture ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.1, 6.8.2.5, 6.8.3.1, 6.8.3.5, 6.8.5.1 to 6.8.5.3	Between 1 January 2015 and 31 December 2017	31 December 2018
EN 12493:2013 + A1:2014 + AC:2015 (except Annex C)	LPG equipment and accessories – Welded steel tanks for liquefied petroleum gas (LPG) – Road tankers – Design and manufacture ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.1, 6.8.2.5, 6.8.3.1, 6.8.3.5, 6.8.5.1 to 6.8.5.3	Between 1 January 2017 and 31 December 2022	
EN 12493:2013+ A2:2018 (except Annex C)	LPG equipment and accessories - Welded steel pressure vessels for LPG road tankers - Design and manufacture ***NOTE:*** *Road tanker is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.1, 6.8.2.5 6.8.3.1, 6.8.3.5 6.8.5.1 to 6.8.5.3	Between 1 January 2021 and 31 December 2024	
EN 12493:2020 (except Annex C)	LPG equipment and accessories – Welded steel pressure vessels for LPG road tankers – Design and construction ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.1, 6.8.2.5, 6.8.3.1, 6.8.3.5, 6.8.5.1 to 6.8.5.3	Until further notice	
EN 13530-2:2002	Cryogenic vessels – Large transportable vacuum insulated vessels – Part 2: Design, fabrication, inspection and testing	6.8.2.1 (with the exception of 6.8.2.1.17), 6.8.2.4, 6.8.3.1 and 6.8.3.4	Between 1 January 2005 and 30 June 2007	
EN 13530-2:2002 + A1:2004	Cryogenic vessels – Large transportable vacuum insulated vessels – Part 2: Design, fabrication, inspection and testing ***NOTE:*** *Standards EN 1252-1:1998 and EN 1626 referenced in this standard are also applicable to closed cryogenic receptacles for the carriage of UN No. 1972 (METHANE, REFRIGERATED LIQUID or NATURAL GAS, REFRIGERATED LIQUID)..*	6.8.2.1 (with the exception of 6.8.2.1.17), 6.8.2.4, 6.8.3.1 and 6.8.3.4	Until further notice	

Reference	Title of document	Requirements the standard complies with	Applicable for new type approvals or for renewals	Latest date for withdrawal of existing type approvals
(1)	(2)	(3)	(4)	(5)
EN 14398-2:2003 (except Table 1)	Cryogenic vessels - Large transportable non-vacuum insulated vessels - Part 2: Design, fabrication, inspection and testing ***NOTE:*** *This standard shall not be used for those gases which are carried at temperatures below -100 °C.*	6.8.2.1 (with the exception of 6.8.2.1.17, 6.8.2.1.19 and 6.8.2.1.20), 6.8.2.4, 6.8.3.1 and 6.8.3.4	Between 1 January 2005 and 31 December 2016	
EN 14398-2:2003 + A2:2008	Cryogenic vessels – Large transportable non-vacuum insulated vessels – Part 2: Design, fabrication, inspection and testing ***NOTE:*** *This standard shall not be used for those gases which are carried at temperatures below -100 °C.*	6.8.2.1 (with the exception of 6.8.2.1.17, 6.8.2.1.19 and 6.8.2.1.20), 6.8.2.4, 6.8.3.1 and 6.8.3.4	Until further notice	
For equipment				
EN 14432:2006	Tanks for the transport of dangerous goods – Tank equipment for the transport of liquid chemicals – Product discharge and air inlet valves	6.8.2.2.1	Between 1 January 2009 and 31 December 2018	
EN 14432:2014	Tanks for the transport of dangerous goods – Tank equipment for the transport of liquid chemicals and liquefied gases – Product discharge and air inlet valves ***NOTE:*** *This standard may also be used for gravity-discharge tanks.*	6.8.2.2.1, 6.8.2.2.2 and 6.8.2.3.1	Between 1 January 2019 and 31 December 2026	
EN 14432:2023	Tanks for the transport of dangerous goods – Tank equipment for the transport of liquid chemicals and liquefied gases – Product discharge and air inlet valves ***NOTE:*** *This standard may also be used for gravity discharge tanks.*	6.8.2.2.1, 6.8.2.2.2 and 6.8.2.3.1	Until further notice	
EN 14433:2006	Tanks for the transport of dangerous goods – Tank equipment for the transport of liquid chemicals – Foot valves	6.8.2.2.1	Between 1 January 2009 and 31 December 2018	
EN 14433:2014	Tanks for the transport of dangerous goods – Tank equipment for the transport of liquid chemicals and liquefied gases – Foot valves ***NOTE:*** *This standard may also be used for gravity-discharge tanks.*	6.8.2.2.1, 6.8.2.2.2 and 6.8.2.3.1	Between 1 January 2019 and 31 December 2026	
EN 14433:2023	Tanks for the transport of dangerous goods – Tank equipment for the transport of liquid chemicals and liquefied gases – Foot valves ***NOTE:*** *This standard may also be used for gravity discharge tanks.*	6.8.2.2.1, 6.8.2.2.2 and 6.8.2.3.1	Until further notice	
EN 12252:2000	Equipping of LPG road tankers ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.3.2 (with the exception of 6.8.3.2.3)	Between 1 January 2005 and 31 December 2010	31 December 2012
EN 12252:2005 + A1:2008	LPG equipment and accessories – Equipping of LPG road tankers ***NOTE:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.*	6.8.2.2, 6.8.3.2 (with the exception of 6.8.3.2.3) and 6.8.3.4.9	Between 1 January 2011 and 31 December 2018	

Reference	Title of document	Requirements the standard complies with	Applicable for new type approvals or for renewals	Latest date for withdrawal of existing type approvals
(1)	(2)	(3)	(4)	(5)
EN 12252:2014	LPG Equipment and accessories – Equipping of LPG road tankers ***NOTE 1:*** *Road tanker is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.* ***NOTE 2:*** *Safety valves are mandatory from 1 January 2024.*	6.8.2.2, 6.8.3.2 and 6.8.3.4.9	Between 1 January 2017 and 31 December 2024	
EN 12252:2022	LPG equipment and accessories – Equipping of LPG road tankers ***NOTE 1:*** *Road tankers is to be understood in the meaning of "fixed tanks" and "demountable tanks" as per ADR.* ***NOTE 2:*** *Safety valves are mandatory from 1 January 2024.*	6.8.3.2 and 6.8.3.4.9	Until further notice	
EN 14129:2014	LPG Equipment and accessories – Pressure relief valves for LPG pressure vessels	6.8.2.1.1 and 6.8.3.2.9	Until further notice	
EN 1626:2008 (except valve category B)	Cryogenic vessels – Valves for cryogenic service ***NOTE:*** *This standard is also applicable to valves for the carriage of UN No 1972 (METHANE, REFRIGERATED LIQUID or NATURAL GAS, REFRIGERATED LIQUID).*	6.8.2.4 and 6.8.3.4	Until further notice	
EN 13648-1:2008	Cryogenic vessels – Safety devices for protection against excessive pressure – Part 1: Safety valves for cryogenic service	6.8.2.4, 6.8.3.2.12 and 6.8.3.4	Until further notice	
EN 13082:2001	Tanks for transport of dangerous goods – Service equipment for tanks – Vapour transfer valve	6.8.2.2 and 6.8.2.4.1	Between 1 January 2005 and 30 June 2013	31 December 2014
EN 13082:2008 + A1:2012	Tanks for transport of dangerous goods – Service equipment for tanks – Vapour transfer valve	6.8.2.2 and 6.8.2.4.1	Until further notice	
EN 13308:2002	Tanks for transport of dangerous goods – Service equipment for tanks – Non pressure balanced footvalve	6.8.2.2 and 6.8.2.4.1	Until further notice	
EN 13314:2002	Tanks for transport of dangerous goods – Service equipment for tanks – Fill hole cover	6.8.2.2 and 6.8.2.4.1	Until further notice	
EN 13316:2002	Tanks for transport of dangerous goods – Service equipment for tanks –Pressure balanced footvalve	6.8.2.2 and 6.8.2.4.1	Until further notice	
EN 13317:2002 (except for the figure and table B.2 in Annex B) (The material shall meet the requirements of standard EN 13094:2004, Clause 5.2)	Tanks for transport of dangerous goods – Service equipment for tanks – Manhole cover assembly	6.8.2.2 and 6.8.2.4.1	Between 1 January 2005 and 31 December 2010	31 December 2012
EN 13317:2002 + A1:2006	Tanks for transport of dangerous goods – Service equipment for tanks – Manhole cover assembly	6.8.2.2 and 6.8.2.4.1	Between 1 January 2009 and 31 December 2021	
EN 13317:2018	Tanks for transport of dangerous goods - Service equipment for tanks - Manhole cover assembly	6.8.2.2 and 6.8.2.4.1	Until further notice	

Reference	Title of document	Requirements the standard complies with	Applicable for new type approvals or for renewals	Latest date for withdrawal of existing type approvals
(1)	(2)	(3)	(4)	(5)
EN 14595:2005	Tanks for transport of dangerous goods - Service equipment for tanks - Pressure and vacuum breather vent	6.8.2.2 and 6.8.2.4.1	Between 1 January 2007 and 31 December 2020	
EN 14595:2016	Tanks for transport of dangerous goods – Service equipment – Breather device	6.8.2.2 and 6.8.2.4.1	Until further notice	
EN 16257:2012	Tanks for the transport of dangerous goods – Service equipment – Footvalve sizes other than 100 mm dia (nom)	6.8.2.2.1 and 6.8.2.2.2	Until further notice	
EN 13175:2014	LPG Equipment and accessories – Specification and testing for Liquefied Petroleum Gas (LPG) pressure vessel valves and fittings	6.8.2.1.1, 6.8.2.2, 6.8.2.4.1 and 6.8.3.2.3	Between 1 January 2017 and 31 December 2022	
EN 13175:2019 (except clause 6.1.6)	LPG Equipment and accessories – Specification and testing for Liquefied Petroleum Gas (LPG) pressure vessel valves and fittings	6.8.2.1.1, 6.8.2.2, 6.8.2.4.1 and 6.8.3.2.3	Between 1 January 2021 and 31 December 2024	
EN 13175:2019 + A1:2020	LPG Equipment and accessories – Specification and testing for Liquefied Petroleum Gas (LPG) pressure vessel valves and fittings	6.8.2.1.1, 6.8.2.2, 6.8.2.4.1 and 6.8.3.2.3	Until further notice	
EN ISO 23826:2021	Gas cylinders – Ball valves – Specification and testing	6.8.2.1.1 and 6.8.2.2.1	Mandatorily from 1 January 2025	
EN 13799:2022	LPG equipment and accessories – Contents gauges for Liquefied Petroleum Gas (LPG) pressure vessels	6.8.2.2.1 and 6.8.2.2.11	Until further notice	

6.8.2.6.2 *Type examination, inspection and test*

The use of a referenced standard is mandatory.

One standard applicable according to the indication in column (4) shall be chosen from the table below for the type examination and the inspection and test of tanks.

Column (3) shows the paragraphs of Chapter 6.8 to which the standard conforms.

The standards shall be applied in accordance with 1.1.5.

The scope of application of each standard is defined in the scope clause of the standard unless otherwise specified in the Table below.

Reference	Title of document	Requirements the standard complies with	Applicable
(1)	(2)	(3)	(4)
EN 12972:2018	Tanks for transport of dangerous goods – Testing, inspection and marking of metallic tanks	6.8.2.1.23, 6.8.2.3, 6.8.2.4, 6.8.3.4	Until 31 December 2026
EN 12972:2018 + A1:2024	Tanks for transport of dangerous goods – Testing, inspection and marking of metallic tanks	6.8.2.1.23, 6.8.2.3, 6.8.2.4 and 6.8.3.4	Until further notice
EN 14334:2014	LPG equipment and accessories – Inspection and testing of LPG road tankers	6.8.2.4 (except 6.8.2.4.1), 6.8.3.4.2 and 6.8.3.4.9	Until 31 December 2026
EN 14334: 2023	LPG equipment and accessories – Inspection and testing of LPG road tankers ***NOTE:*** *This standard shall not be applied for tanks constructed in accordance with EN 14025.*	6.8.2.4 and 6.8.3.4.9	Until further notice

6.8.2.7 ***Requirements for tanks which are not designed, constructed, inspected and tested according to referenced standards***

To reflect scientific and technical progress or where no standard is referenced in 6.8.2.6 or to deal with specific aspects not addressed in a standard referenced in 6.8.2.6, the competent authority may recognize the use of a technical code providing the same level of safety. Tanks shall, however, comply with the minimum requirements of 6.8.2.

As soon as a standard newly referenced in 6.8.2.6 can be applied, the competent authority shall withdraw its recognition of the relevant technical code. A transitional period ending no later than the date of entry into force of the next edition of ADR may be applied.

The competent authority shall transmit to the secretariat of UNECE a list of the technical codes that it recognises and shall update the list if it changes. The list should include the following details: name and date of the code, purpose of the code and details of where it may be obtained. The secretariat shall make this information publicly available on its website.

A standard which has been adopted for reference in a future edition of the ADR may be approved by the competent authority for use without notifying the UNECE secretariat.

For testing, inspection and marking, the applicable standard referenced in 6.8.2.6 may also be used.

6.8.3 Special requirements applicable to Class 2

6.8.3.1 ***Construction of shells***

6.8.3.1.1 Shells intended for the carriage of compressed or liquefied gases or dissolved gases shall be made of steel. In the case of weldless shells, by derogation from 6.8.2.1.12 a minimum elongation at fracture of 14 % and also a stress σ lower than or equal to limits hereafter given according to the material may be accepted:

(a) When the ratio Re/Rm (of the minimum guaranteed characteristics after heat treatment) is higher than 0.66 without exceeding 0.85:

$$\sigma \leq 0.75 \text{ Re};$$

(b) When the ratio Re/Rm (of the minimum guaranteed characteristics after heat treatment) is higher than 0.85:

$$\sigma \leq 0.5 \text{ Rm}.$$

6.8.3.1.2 The requirements of 6.8.5 apply to the materials and construction of welded shells.

6.8.3.1.3 *(Reserved)*

Construction of battery-vehicles and MEGCs

6.8.3.1.4 Cylinders, tubes, pressure drums and bundles of cylinders, as elements of a battery-vehicle or MEGC, shall be constructed in accordance with Chapter 6.2.

NOTE 1: *Bundles of cylinders which are not elements of a battery-vehicle or of a MEGC shall be subject to the requirements of Chapter 6.2.*

NOTE 2: *Tanks as elements of battery-vehicles and MEGCs shall be constructed in accordance with 6.8.2.1 and 6.8.3.1.*

NOTE 3: *Demountable tanks[16] are not to be considered elements of battery-vehicles or MEGCs.*

6.8.3.1.5 Elements and their fastenings

of battery vehicles | and the frame of MEGCs

[16] *For the definition of "demountable tank" see 1.2.1.*

shall be capable of absorbing under the maximum permissible load the forces defined in 6.8.2.1.2. Under each force the stress at the most severely stressed point of the element and its fastenings shall not exceed the value defined in 6.2.5.3 for cylinders, tubes, pressure drums and bundles of cylinders and for tanks the value of σ defined in 6.8.2.1.16.

6.8.3.2 ***Items of equipment***

6.8.3.2.1 The discharge pipes of tanks shall be capable of being closed by blank flanges or some other equally reliable device. For tanks intended for the carriage of refrigerated liquefied gases, these blank flanges or other equally reliable devices may be fitted with pressure-release openings of a maximum diameter of 1.5 mm.

6.8.3.2.2 Shells intended for the carriage of liquefied gases may be provided with, in addition to the openings prescribed in 6.8.2.2.2 and 6.8.2.2.4, openings for the fitting of gauges, thermometers, manometers and with bleed holes, as required for their operation and safety.

6.8.3.2.3 The internal stop-valve of all filling and all discharge openings of tanks

| with a capacity greater than 1 m³

intended for the carriage of liquefied flammable or toxic gases shall be instant-closing and shall close automatically in the event of an unintended movement of the tank or in the event of fire. It shall also be possible to operate the internal stop-valve by remote control.

However on tanks intended for the carriage of liquefied non-toxic flammable gases, the internal stop-valve with remote control may be replaced by a non-return valve for filling openings into the vapour phase of the tank only. The non-return valve shall be positioned internally in the tank, be spring loaded so that the valve is closed if the pressure in the filling line is equal to or lower than the pressure in the tank and be equipped with appropriate sealing[17].

6.8.3.2.4 All openings, other than those accommodating safety valves and closed bleed holes, of tanks intended for the carriage of liquefied flammable and/or toxic gases shall, if their nominal diameter is more than 1.5 mm, shall be equipped with an internal shut-off device.

6.8.3.2.5 Notwithstanding the requirements of 6.8.2.2.2, 6.8.3.2.3 and 6.8.3.2.4, tanks intended for the carriage of refrigerated liquefied gases may be equipped with external devices in place of internal devices if the external devices afford protection against external damage at least equivalent to that afforded by the wall of the shell.

6.8.3.2.6 If there are thermometers, they shall not project directly into the gas or liquid through the shell.

6.8.3.2.7 Filling and discharge openings situated in the upper part of tanks shall be equipped with, in addition to what is prescribed in 6.8.3.2.3, a second, external, closing device. This device shall be capable of being closed by a blank flange or some other equally reliable device.

6.8.3.2.8 Safety valves shall meet the requirements of 6.8.3.2.9 to 6.8.3.2.12 below:

6.8.3.2.9 Tanks intended for the carriage of flammable liquefied gases shall be fitted with safety valves. Tanks intended for the carriage of compressed gases, non-flammable liquefied gases or dissolved gases, may be fitted with safety valves. Safety valves, where fitted, shall meet the requirements of 6.8.3.2.9.1 to 6.8.3.2.9.5.

6.8.3.2.9.1 Safety valves shall be capable of opening automatically under a pressure between 0.9 and 1.0 times the test pressure of the tank to which they are fitted. They shall be of such a type as to resist dynamic stresses, including liquid surge. The use of dead weight or counterweight valves is prohibited. The

[17] *The use of metal to metal sealing is not permitted.*

required capacity of the safety valves shall be calculated in accordance with the formula contained in 6.7.3.8.1.1 and the safety valve shall conform at least to the requirement of 6.7.3.9.

Safety valves shall be designed to prevent or be protected from the entry of water or other foreign matter which may impair their correct functioning. Any protection shall not impair their performance.

6.8.3.2.9.2 If tanks required to be hermetically closed are equipped with safety valves, these shall be preceded by a bursting disc and the following conditions shall be met:

(a) The minimum burst pressure at 20 °C, tolerances included, shall be greater than or equal to 1.0 times the test pressure;

(b) The maximum burst pressure at 20 °C, tolerances included, shall be equal to 1.1 times the test pressure; and

(c) The bursting disc shall not reduce the required discharge capacity or correct operation of the safety valve.

A pressure gauge or another suitable indicator shall be provided in the space between the bursting disc and the safety valve, to enable detection of any rupture, perforation or leakage of the disc.

6.8.3.2.9.3 Safety valves shall be directly connected to the shell or directly connected to the outlet of the bursting disc.

6.8.3.2.9.4 Each safety valve inlet shall be situated on top of the shell as close as practicable to the top generating line. All safety valve inlets shall, under maximum filling conditions, be situated in the vapour space of the shell and the devices shall be so arranged as to ensure that the escaping vapour is discharged unrestrictedly. For flammable liquefied gases, the escaping vapour shall be directed away from the shell in such a manner that it cannot impinge upon the shell. Protective devices which deflect the flow of vapour are permissible provided the required safety valve capacity is not reduced.

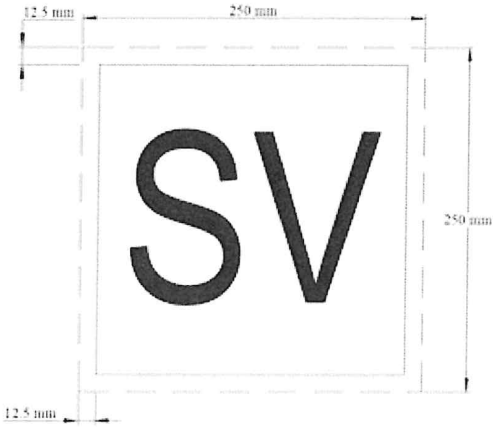
6.8.3.2.9.5 Arrangements shall be made to protect the safety valves from damage caused by the tank overturning or striking overhead obstacles. Where possible, safety valves shall not project outside of the profile of the shell.

6.8.3.2.9.6 Safety valve mark

6.8.3.2.9.6.1 Tanks fitted with safety valves in accordance with 6.8.3.2.9.1 to 6.8.3.2.9.5 shall display the mark as set out in 6.8.3.2.9.6.3 to 6.8.3.2.9.6.6.

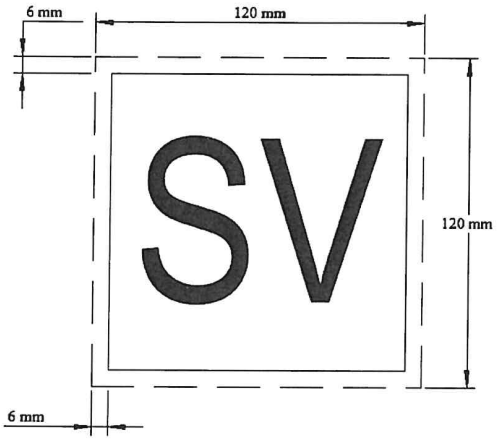
6.8.3.2.9.6.2 Tanks not fitted with safety valves in accordance with 6.8.3.2.9.1 to 6.8.3.2.9.5 shall not display the mark as set out in 6.8.3.2.9.6.3 to 6.8.3.2.9.6.6.

6.8.3.2.9.6.3 The mark shall consist of a white square with minimum dimensions of 250 mm × 250 mm. The line inside the edge shall be black, parallel and approximately 12.5 mm from the outside of that line to the outside edge of the mark. The letters "SV" shall be black, a minimum of 120 mm high and have a minimum stroke thickness of 12 mm.



6.8.3.2.9.6.4 For demountable tanks | For tank-containers

with a capacity of not more than 3 000 litres the mark may be reduced in size to not less than 120 mm × 120 mm. The line inside the edge shall be black, parallel and approximately 6 mm from the outside of that line to the outside edge of the mark. The letters "SV" shall be black, a minimum of 60 mm high and have a minimum stroke thickness of 6 mm.



6.8.3.2.9.6.5 The material used shall be weather-resistant and it shall be ensured that the mark is durable. The mark shall not become detached from its mount in the event of 15 minutes' engulfment in fire. It shall remain affixed irrespective of the orientation of the tank.

6.8.3.2.9.6.6 The letters "SV" shall be indelible and shall remain legible after 15 minutes' engulfment in fire.

6.8.3.2.9.6.7 The marks shall be displayed on both sides and the rear of fixed tanks (tank-vehicles) and on both sides and both ends of demountable tanks. | The marks shall be displayed on both sides and both ends of tank-containers. For tank-containers with a capacity of not more than 3 000 litres the marks may be displayed either on both sides or on both ends.

6.8.3.2.10 Where tanks are intended for carriage by sea, the requirements of 6.8.3.2.9 shall not prohibit the fitting of safety valves conforming to the IMDG Code.

6.8.3.2.11 Tanks intended for the carriage of refrigerated liquefied gases shall be equipped with two or more independent safety valves capable of opening at the maximum working pressure indicated on the tank. Two of these safety valves shall be individually sized to allow the gases formed by evaporation during normal operation to escape from the tank in such a way that the pressure does not at any time exceed by more than 10 % the working pressure indicated on the tank.

One of the safety valves may be replaced by a bursting disc which shall be such as to burst at the test pressure.

In the event of loss of the vacuum in a double-walled tank, or of destruction of 20 % of the insulation of a single-walled tank, the combination of the pressure relief devices shall permit an outflow such that the pressure in the shell cannot exceed the test pressure. The provisions of 6.8.2.1.7 shall not apply to vacuum-insulated tanks.

6.8.3.2.12 These pressure relief devices of tanks intended for the carriage of refrigerated liquefied gases shall be so designed as to function faultlessly even at their lowest working temperature. The reliability of their operation at that temperature shall be established and checked either by testing each device or by testing a specimen device of each design-type.

6.8.3.2.13 The valves of demountable tanks that can be rolled shall be provided with protective caps.

Thermal insulation

6.8.3.2.14 If tanks intended for the carriage of liquefied gases are equipped with thermal insulation, such insulation shall consist of either:

- A sun shield covering not less than the upper third but not more than the upper half of the tank surface and separated from the shell by an air space at least 4 cm across; or
- A complete cladding, of adequate thickness, of insulating materials.

6.8.3.2.15 Tanks intended for the carriage of refrigerated liquefied gases shall be thermally insulated. Thermal insulation shall be ensured by means of a continuous sheathing. If the space between the shell and the sheathing is under vacuum (vacuum insulation), the protective sheathing shall be so designed as to withstand without deformation an external pressure of at least 100 kPa (1 bar) (gauge pressure). By derogation from the definition of "calculation pressure" in 1.2.1, external and internal reinforcing devices may be taken into account in the calculations. If the sheathing is so closed as to be gas-tight, a device shall be provided to prevent any dangerous pressure from developing in the insulating layer in the event of inadequate gas-tightness of the shell or of its items of equipment. The device shall prevent the infiltration of moisture into the heat-insulating sheath.

For type testing of the effectiveness of the insulation system, see 6.8.3.4.11.

6.8.3.2.16 Tanks intended for the carriage of liquefied gases having a boiling point below -182° C at atmospheric pressure shall not include any combustible material either in the thermal insulation or in the means of attachment.

The means of attachment for vacuum insulated tanks may, with the approval of the competent authority, contain plastics substances between the shell and the sheathing.

6.8.3.2.17 By derogation from the requirements of 6.8.2.2.4 shells intended for the carriage of refrigerated liquefied gases need not have an inspection opening.

Items of equipment for battery-vehicles and MEGCs

6.8.3.2.18 Service and structural equipment shall be configured or designed to prevent damage that could result in the release of the pressure receptacle contents during normal conditions of handling and carriage. When the connection between the frame of the battery-vehicle or MEGC and the elements allows relative movement between the sub-assemblies, the equipment shall be so fastened as to permit such movement without damage to working parts. Manifold piping leading to shut-off valves shall be sufficiently flexible to protect the valves and the piping from shearing, or releasing the pressure receptacle contents. The filling and discharge devices (including flanges or threaded plugs) and any protective caps shall be capable of being secured against unintended opening.

6.8.3.2.19 In order to avoid any loss of content in the event of damage, the manifolds, the discharge fittings (pipe sockets, shut-off devices), and the stop-valves shall be protected or arranged from being wrenched off by external forces or designed to withstand them.

6.8.3.2.20 The manifold shall be designed for service in a temperature range of -20° C to +50° C.

The manifold shall be designed, constructed and installed so as to avoid the risk of damage due to thermal expansion and contraction, mechanical shock and vibration. All piping shall be of suitable metallic material. Welded pipe joints shall be used wherever possible.

Joints in copper tubing shall be brazed or have an equally strong metal union. The melting point of brazing materials shall be no lower than 525 °C. The joints shall not decrease the strength of tubing as may happen when cutting threads.

6.8.3.2.21 Except for UN No.1001 acetylene, dissolved, the permissible maximum stress σ of the manifolding arrangement at the test pressure of the receptacles shall not exceed 75 % of the guaranteed yield strength of the material.

The necessary wall thickness of the manifolding arrangement for the carriage of UN No.1001 acetylene, dissolved shall be calculated according to an approved code of practice.

NOTE: *For the yield strength, see 6.8.2.1.11.*

6.8.3.2.22 By derogation from the requirements of 6.8.3.2.3, 6.8.3.2.4 and 6.8.3.2.7, for cylinders, tubes, pressure drums and bundles of cylinders (frames) forming a battery-vehicle or MEGC, the required closing devices may be provided for within the manifolding arrangement.

6.8.3.2.23 If one of the elements is equipped with a safety valve and shut-off devices are provided between the elements, every element shall be so equipped.

6.8.3.2.24 The filling and discharge devices may be affixed to a manifold.

6.8.3.2.25 Each element, including each individual cylinder of a bundle, intended for the carriage of toxic gases, shall be capable of being isolated by a shut-off valve.

6.8.3.2.26 Battery-vehicles or MEGCs intended for the carriage of toxic gases shall not have safety valves, unless the safety valves are preceded by a bursting disc. In the latter case, the arrangement of the bursting disc and safety valve shall be satisfactory to the competent authority.

6.8.3.2.27 When battery-vehicles or MEGCs are intended for carriage by sea, the requirements of 6.8.3.2.26 shall not prohibit the fitting of safety valves conforming to the IMDG Code.

6.8.3.2.28 Receptacles which are elements of a battery-vehicle or MEGC intended for the carriage of flammable gases shall be combined in groups of not more than 5 000 litres which are capable of being isolated by a shut-off valve.

Each element of a battery-vehicle or MEGC intended for the carriage of flammable gases, when consisting of tanks conforming to this Chapter, shall be capable of being isolated by a shut-off valve.

6.8.3.3 ***Type examination and type approval***

No special requirements.

6.8.3.4 ***Inspections and tests***

6.8.3.4.1 The materials of every welded shell with the exception of cylinders, tubes, pressure drums and cylinders as part of bundles of cylinders which are elements of a battery-vehicle or of a MEGC shall be tested according to the method described in 6.8.5.

6.8.3.4.2 The basic requirements for the test pressure are given in 4.3.3.2.1 to 4.3.3.2.4 and the minimum test pressures are given in the table of gases and gas mixtures in 4.3.3.2.5.

6.8.3.4.3 The first hydraulic pressure test shall be carried out before thermal insulation is placed in position. When the shell, its fittings, piping and items of equipment have been tested separately, the tank shall be subjected to a leakproofness test after assembly.

6.8.3.4.4 The capacity of each shell intended for the carriage of compressed gases filled by mass, liquefied gases or dissolved gases shall be determined, under the supervision of an inspection body, by weighing or volumetric measurement of the quantity of water which fills the shell; the measurement of shell capacity shall be accurate to within 1 %. Determination by a calculation based on the dimensions of the shell is not permitted. The maximum filling masses allowed in accordance with packing instruction P200 or P203 in 4.1.4.1 as well as 4.3.3.2.2 and 4.3.3.2.3 shall be prescribed by an inspection body.

6.8.3.4.5 Checking of the welds shall be carried out in accordance with the λ=1 requirements of 6.8.2.1.23.

6.8.3.4.6 For tanks intended for the carriage of refrigerated liquefied gases:

(a) By derogation from the requirements of 6.8.2.4.2, the periodic inspections shall be performed no later than

six years | eight years

after the initial inspection and thereafter no later than every 12 years;

(b) By derogation from the requirements of 6.8.2.4.3, the intermediate inspections shall be performed no later than six years after each periodic inspection.

6.8.3.4.7 In the case of vacuum-insulated tanks, the hydraulic-pressure test and the check of the internal condition may, with the consent of the inspection body, be replaced by a leakproofness test and measurement of the vacuum.

6.8.3.4.8 If, at the time of periodic inspections, openings have been made in shells intended for the carriage of refrigerated liquefied gases, the method by which they are hermetically closed before the shells are returned to service shall be approved by the inspection body and shall ensure the integrity of the shell.

6.8.3.4.9 Leakproofness tests of tanks intended for the carriage of gases shall be performed at a pressure of not less than:

- For compressed gases, liquefied gases and dissolved gases: 20 % of the test pressure;
- For refrigerated liquefied gases: 90 % of the maximum working pressure.

Holding times for tank-containers carrying refrigerated liquefied gases

6.8.3.4.10 The reference holding time for tank-containers carrying refrigerated liquefied gases shall be determined on the basis of the following:

(a) The effectiveness of the insulation system, determined in accordance with 6.8.3.4.11;

(b) The lowest set pressure of the pressure limiting device(s);

(c) The initial filling conditions;

(d) An assumed ambient temperature of 30 °C;

(e) The physical properties of the individual refrigerated liquefied gas intended to be carried.

6.8.3.4.11 The effectiveness of the insulation system (heat influx in watts) shall be determined by type testing the tank-containers. This test shall consist of either:

(a) A constant pressure test (for example at atmospheric pressure) during which the loss of refrigerated liquefied gas is measured over a period of time; or

(b) A closed system test during which the rise in pressure in the shell is measured over a period of time.

When performing the constant pressure test, variations in atmospheric pressure shall be taken into account. When performing either test corrections shall be made for any variation of the ambient temperature from the assumed ambient temperature reference value of 30 °C.

NOTE: *ISO 21014:2006 "Cryogenic vessels — Cryogenic insulation performance" details methods of determining the insulation performance of cryogenic vessels and provides a method of calculating the holding time.*

Inspections and tests for battery-vehicles and MEGCs

6.8.3.4.12 The elements and items of equipment of each battery-vehicle or MEGC shall be inspected and tested either together or separately before being put into service for the first time (initial inspection and test). Thereafter battery-vehicles or MEGCs the elements of which are receptacles shall be inspected at not more than five-year intervals. Battery-vehicles and MEGCs the elements of which are tanks shall be inspected according to 6.8.2.4.2 and 6.8.2.4.3. An exceptional inspection and test shall be performed regardless of the last periodic inspection and test when necessary according to 6.8.3.4.16.

6.8.3.4.13 The initial inspection shall include:

- A check of conformity to the approved type;
- A check of the design characteristics;
- An examination of the internal and external conditions;
- A hydraulic pressure test[12] at the test pressure indicated on the plate prescribed in 6.8.3.5.10;
- A leakproofness test at the maximum working pressure; and
- A check of satisfactory operation of the equipment.

When the elements and their fittings have been pressure-tested separately, they shall be subjected together after assembly to a leakproofness test.

6.8.3.4.14 Cylinders, tubes and pressure drums and cylinders as part of bundles of cylinders shall be tested according to packing instruction P200 or P203 in 4.1.4.1.

The test pressure of the manifold of the battery-vehicle or MEGC shall be the same as that of the elements of the battery-vehicle or MEGC. The pressure test of the manifold may be performed as a hydraulic test or by using another liquid or gas with the agreement of the competent authority. By derogation from this requirement, the test pressure for the manifold of battery-vehicle or MEGC shall not be less than 300 bar for UN No. 1001 acetylene, dissolved.

6.8.3.4.15 The periodic inspection shall include a leakproofness test at the maximum working pressure and an external examination of the structure, the elements and the service equipment without disassembling. The elements and the piping shall be tested at the periodicity defined in packing instruction P200 of 4.1.4.1 and in accordance with the requirements of 6.2.1.6 and 6.2.3.5 respectively. When the elements and equipment have been pressure-tested separately, they shall be subjected together after assembly to a leakproofness test.

6.8.3.4.16 An exceptional inspection and test is necessary when the battery-vehicle or MEGC shows evidence of damaged or corroded areas, or leakage, or any other conditions, that indicate a deficiency that could affect the integrity of the battery-vehicle or MEGC. The extent of the exceptional inspection and test and, if deemed necessary, the disassembling of elements shall depend on the amount of damage or deterioration of the battery-vehicle or MEGC. It shall include at least the examinations required under 6.8.3.4.17.

6.8.3.4.17 The examinations shall ensure that:

(a) The elements are inspected externally for pitting, corrosion, or abrasions, dents, distortions, defects in welds or any other conditions, including leakage, that might render the battery-vehicles or MEGCs unsafe for transport;

(b) The piping, valves, and gaskets are inspected for corroded areas, defects, and other conditions, including leakage, that might render battery-vehicles or MEGCs unsafe for filling, discharge or transport;

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[12] *In special cases, if agreed by the competent authority, the hydraulic pressure test may be replaced by a pressure test using gas, or if agreed by the inspection body, by using another liquid, where such an operation does not present any danger.*

(c) Missing or loose bolts or nuts on any flanged connection or blank flange are replaced or tightened;

(d) All emergency devices and valves are free from corrosion, distortion and any damage or defect that could prevent their normal operation. Remote closure devices and self-closing stop-valves shall be operated to demonstrate proper operation;

(e) Required marks on the battery-vehicles or MEGCs are legible and in accordance with the applicable requirements; and

(f) Any framework, supports and arrangements for lifting the battery-vehicles or MEGCs are in satisfactory condition.

6.8.3.4.18 The tests, inspections and checks in accordance with 6.8.3.4.12 to 6.8.3.4.17 shall be carried out by the inspection body. Certificates shall be issued showing the results of these operations, even in the case of negative results.

These certificates shall refer to the list of the substances permitted for carriage in this battery-vehicle or MEGC in accordance with 6.8.2.3.2.

A copy of these certificates shall be attached to the tank record of each tank, battery-vehicle or MEGC tested (see 4.3.2.1.7).

6.8.3.5 ***Marking***

6.8.3.5.1 The following additional particulars shall be marked by stamping or by any other similar method on the plate prescribed in 6.8.2.5.1, or directly on the walls of the shell itself if the walls are so reinforced that the strength of the tank is not impaired.

6.8.3.5.2 On tanks intended for the carriage of only one substance:

- The proper shipping name of the gas and, in addition for gases classified under an n.o.s. entry, the technical name[18];

This indication shall be supplemented:

- In the case of tanks intended for the carriage of compressed gases filled by volume (pressure), by an indication of the maximum filling pressure at 15 °C permitted for the tank; and

- In the case of tanks intended for the carriage of compressed gases filled by mass, and of liquefied gases, refrigerated liquefied gases or dissolved gases by an indication of the maximum permissible load mass in kg and of the filling temperature if below –20 °C.

6.8.3.5.3 On multipurpose tanks:

- The proper shipping names of the gases and, in addition for gases classified under an n.o.s. entry, the technical name[18] of the gases for whose carriage the tank is approved.

These particulars shall be supplemented by an indication of the maximum permissible load mass in kg for each gas.

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[18] *Instead of the proper shipping name or, if applicable, of the proper shipping name of the n.o.s. entry followed by the technical name, the use of the following names is permitted:*

- *for UN No. 1078 refrigerant gas, n.o.s: mixture F1, mixture F2, mixture F3;*
- *for UN No. 1060 methylacetylene and propadiene mixtures, stabilized: mixture P1, mixture P2;*
- *for UN No. 1965 hydrocarbon gas mixture, liquefied, n.o.s: mixture A, mixture A01, mixture A02, mixture A0, mixture A1, mixture B1, mixture B2, mixture B, mixture C. The names customary in the trade and mentioned in 2.2.2.3, Classification code 2F, UN No. 1965, Note 1 may be used only as a complement;*
- *for UN No. 1010 Butadienes, stabilized: 1,2-Butadiene, stabilized, 1,3-Butadiene, stabilized;*
- *for UN No. 1012 Butylene: 1-butylene, cis-2-butylene, trans-2-butylene, butylenes mixture.*

6.8.3.5.4 On tanks intended for the carriage of refrigerated liquefied gases:

- The maximum working pressure.

- Reference holding time (in days or hours) for each gas[15];
- the associated initial pressures (in bar gauge or kPa gauge)[15]

6.8.3.5.5 On tanks equipped with thermal insulation:

- The inscription "thermally insulated" or "thermally insulated by vacuum".

6.8.3.5.6 In addition to the particulars prescribed in 6.8.2.5.2, the following shall be inscribed on the tank-vehicle (on the tank itself or on panels)[15]:

In addition to the particulars prescribed in 6.8.2.5.2, the following shall be inscribed on the tank-container (on the tank itself or on panels)[15]:

(a)
- The tank code according to the certificate (see 6.8.2.3.2) with the actual test pressure of the tank;
- The inscription: "minimum filling temperature allowed: …";

(b) Where the tank is intended for the carriage of one substance only:
- The proper shipping name of the gas and, in addition for gases classified under an n.o.s. entry, the technical name[18];
- For compressed gases which are filled by mass, and for liquefied gases, refrigerated liquefied gases or dissolved gases, the maximum permissible load mass in kg;

(c) Where the tank is a multipurpose tank:
- The proper shipping name of the gas and, for gases classified under an n.o.s. entry, the technical name[18] of all gases to whose carriage the tank is assigned with an indication of the maximum permissible load mass in kg for each of them;

(d) Where the shell is equipped with thermal insulation:
- The inscription "thermally insulated" (or "thermally insulated by vacuum"), in an official language of the country of registration and also, if that language is not English, French or German, in English, French or German, unless any agreements concluded between the countries concerned in the transport operation provide otherwise.

6.8.3.5.7 *(Reserved)*

6.8.3.5.8 These particulars shall not be required in the case of a vehicle carrying demountable tanks.

6.8.3.5.9 *(Reserved)*

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15 *Add the units of measurement after the numerical values.*

18 *Instead of the proper shipping name or, if applicable, of the proper shipping name of the n.o.s. entry followed by the technical name, the use of the following names is permitted:*

- *for UN No. 1078 refrigerant gas, n.o.s: mixture F1, mixture F2, mixture F3;*
- *for UN No. 1060 methylacetylene and propadiene mixtures, stabilized: mixture P1, mixture P2;*
- *for UN No. 1965 hydrocarbon gas mixture, liquefied, n.o.s: mixture A, mixture A01, mixture A02, mixture A0, mixture A1, mixture B1, mixture B2, mixture B, mixture C. The names customary in the trade and mentioned in 2.2.2.3, Classification code 2F, UN No. 1965, Note 1 may be used only as a complement;*
- *for UN No. 1010 Butadienes, stabilized: 1,2-Butadiene, stabilized, 1,3-Butadiene, stabilized;*
- *for UN No. 1012 Butylene: 1-butylene, cis-2-butylene, trans-2-butylene, butylenes mixture.*

Marking of battery-vehicles and MEGCs

6.8.3.5.10 Every battery-vehicle and every MEGC shall be fitted with a corrosion-resistant metal plate permanently attached in a place readily accessible for inspection. The following particulars at least shall be marked on the plate by stamping or by any other similar method[15]:

- Approval number;
- Manufacturer's name or mark;
- Manufacturer's serial number;
- Year of manufacture;
- Test pressure (gauge pressure)
- Design temperature (only if above +50 °C or below -20 °C);
- Date (month and year) of initial inspection and most recent periodic inspection in accordance with 6.8.3.4.12 and 6.8.3.4.15;
- Stamp of the inspection body that carried out the inspection.

6.8.3.5.11

The following particulars shall be inscribed on the battery-vehicle itself or on a plate[15]:	The following particulars shall be inscribed either on the MEGC itself or on a plate[15]:
- Names of owner or of operator; - Number of elements; - Total capacity of the elements; and for battery-vehicles filled by mass: - Unladen mass; - Maximum permissible mass.	- Names of owner and of operator; - Number of elements; - Total capacity of the elements; - Maximum permissible laden mass; - The tank code according to the certificate of approval (see 6.8.2.3.2) with the actual test pressure of the MEGC; - The proper shipping name of the gases, and in addition, for gases classified under an n.o.s. entry, the technical name[16] of the gases for whose carriage the MEGC is used; and for MEGCs filled by mass: - Tare.

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15 *Add the units of measurement after the numerical values.*

18 *Instead of the proper shipping name or, if applicable, of the proper shipping name of the n.o.s. entry followed by the technical name, the use of the following names is permitted:*

- *For UN No. 1078 refrigerant gas, n.o.s: mixture F1, mixture F2, mixture F3;*
- *For UN No. 1060 methylacetylene and propadiene mixtures, stabilized: mixture P1, mixture P2;*
- *For UN No. 1965 hydrocarbon gas mixture, liquefied, n.o.s: mixture A, mixture A01, mixture A02, mixture A0, mixture A1, mixture B1, mixture B2, mixture B, mixture C. The names customary in the trade and mentioned in 2.2.2.3, Classification code 2F, UN No. 1965, Note 1 may be used only as a complement;*
- *For UN No. 1010 Butadienes, stabilized: 1,2-Butadiene, stabilized, 1,3-Butadiene, stabilized;*
- *For UN No. 1012 Butylene: 1-butylene, cis-2-butylene, trans-2-butylene, butylenes mixture.*

6.8.3.5.12 The frame of a battery-vehicle or MEGC shall bear near the filling point a plate specifying:

- The maximum filling pressure[15] at 15 °C allowed for elements intended for compressed gases;
- The proper shipping name of the gas in accordance with Chapter 3.2 and, in addition for gases classified under an n.o.s. entry, the technical name[18];

and, in addition, in the case of liquefied gases:

- The permissible maximum load per element[15].

6.8.3.5.13 Cylinders, tubes and pressure drums, and cylinders as part of bundles of cylinders, shall be marked according to 6.2.2.7. These receptacles need not be labelled individually with the danger labels as required in Chapter 5.2.

Battery-vehicles and MEGCs shall be placarded and marked according to Chapter 5.3.

6.8.3.6 ***Requirements for battery-vehicles and MEGCs which are designed, constructed, inspected and tested according to referenced standards***

NOTE: *Persons or bodies identified in standards as having responsibilities in accordance with ADR shall meet the requirements of ADR.*

Since 1 January 2009 the use of the referenced standards has been mandatory. Exceptions are dealt with in 6.8.3.7

Type approval certificates shall be issued in accordance with 1.8.7 and 6.8.2.3. For the issuance of a type approval certificate, one standard applicable according to the indication in column (4) shall be chosen from the table below. If more than one standard may be applied, only one of them shall be chosen.

Column (3) shows the paragraphs of Chapter 6.8 to which the standard conforms.

Column (5) gives the latest date when existing type approvals shall be withdrawn according to 1.8.7.2.2.2; if no date is shown the type approval remains valid until it expires.

Standards shall be applied in accordance with 1.1.5. They shall be applied in full unless otherwise specified in the table below.

The scope of application of each standard is defined in the scope clause of the standard unless otherwise specified in the Table below.

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15 *Add the units of measurements after the numerical values.*

18 *Instead of the proper shipping name or, if applicable, of the proper shipping name of the n.o.s. entry followed by the technical name, the use of the following names is permitted:*

- *For UN No. 1078 refrigerant gas, n.o.s: mixture F1, mixture F2, mixture F3;*
- *For UN No. 1060 methylacetylene and propadiene mixtures, stabilized: mixture P1, mixture P2;*
- *For UN No. 1965 hydrocarbon gas mixture, liquefied, n.o.s: mixture A, mixture A01, mixture A02, mixture A0, mixture A1, mixture B1, mixture B2, mixture B, mixture C. The names customary in the trade and mentioned in 2.2.2.3, Classification code 2F, UN No. 1965, Note 1 may be used only as a complement;*
- *For UN No. 1010 Butadienes, stabilized: 1,2-Butadiene, stabilized, 1,3-Butadiene, stabilized;*
- *For UN No. 1012 Butylene: 1-butylene, cis-2-butylene, trans-2-butylene, butylenes mixture.*

Reference	Title of document	Requirements the standard complies with	Applicable for new type approvals or for renewals	Latest date for withdrawal of existing type approvals
(1)	(2)	(3)	(4)	(5)
EN 13807:2003	Transportable gas cylinders – Battery vehicles – Design, manufacture, identification and testing ***NOTE:*** *Where appropriate this standard may also be applied to MEGCs which consist of pressure receptacles.*	6.8.3.1.4 and 6.8.3.1.5, 6.8.3.2.18 to 6.8.3.2.26, 6.8.3.4.12 to 6.8.3.4.14 and 6.8.3.5.10 to 6.8.3.5.13	Between 1 January 2005 and 31 December 2020	
EN 13807:2017	Transportable gas cylinders - Battery vehicles and multiple-element gas containers (MEGCs) - Design, manufacture, identification and testing	6.8.3.1.4, 6.8.3.1.5, 6.8.3.2.18 to 6.8.3.2.28, 6.8.3.4.12 to 6.8.3.4.14 and 6.8.3.5.10 to 6.8.3.5.13	Until further notice	
EN ISO 23826:2021	Gas cylinders – Ball valves – Specification and testing	6.8.2.1.1 and 6.8.2.2.1	Mandatorily from 1 January 2025	

6.8.3.7 ***Requirements for battery-vehicles and MEGCs which are not designed, constructed, inspected and tested according to referenced standards***

To reflect scientific and technical progress or where no standard is referenced in 6.8.3.6 or to deal with specific aspects not addressed in a standard referenced in 6.8.3.6, the competent authority may recognize the use of a technical code providing the same level of safety. Battery-vehicles and MEGCs shall, however, comply with the minimum requirements of 6.8.3.

As soon as a standard newly referenced in 6.8.3.6 can be applied, the competent authority shall withdraw its recognition of the relevant technical code. A transitional period ending no later than the date of entry into force of the next edition of ADR may be applied.

The procedure for periodic inspections shall be specified in the type approval if the standards referenced in 6.2.2, 6.2.4 or 6.8.2.6 are not applicable or shall not be applied.

The competent authority shall transmit to the secretariat of UNECE a list of the technical codes that it recognises and shall update the list if it changes. The list should include the following details: name and date of the code, purpose of the code and details of where it may be obtained. The secretariat shall make this information publicly available on its website.

A standard which has been adopted for reference in a future edition of the ADR may be approved by the competent authority for use without notifying the UNECE secretariat.

6.8.4 **Special provisions**

NOTE 1: *For liquids having a flash-point of not more than 60 °C and for flammable gases, see also 6.8.2.1.26, 6.8.2.1.27 and 6.8.2.2.9.*

NOTE 2: *For requirements for tanks subjected to a pressure test of not less than 1 MPa (10 bar) or for tanks intended for the carriage of refrigerated liquefied gases, see 6.8.5.*

When they are shown under an entry in Column (13) of Table A of Chapter 3.2, the following special provisions apply:

(a) **Construction (TC)**

TC1 The requirements of 6.8.5 are applicable to the materials and construction of these shells.

TC2 Shells, and their items of equipment, shall be made of aluminium not less than 99.5 % pure or of suitable steel not liable to cause hydrogen peroxide to decompose. Where shells are made of aluminium not less than 99.5 % pure, the wall

thickness need not exceed 15 mm, even where calculation in accordance with 6.8.2.1.17 gives a higher value.

TC3 The shells shall be made of austenitic steel.

TC4 Shells shall be provided with an enamel or equivalent protective lining if the material of the shell is attacked by UN No. 3250 chloroacetic acid.

TC5 Shells shall be provided with a lead lining not less than 5 mm thick or an equivalent lining.

TC6 The wall thickness of tanks made of aluminium not less than 99 % pure or aluminium alloy need not exceed 15 mm even where calculation in accordance with 6.8.2.1.17 gives a higher value.

TC7 The effective minimum thickness of the shell shall not be less than 3 mm.

TC8 The shells shall be made of aluminium or aluminium alloy. The shells may be designed for an external design pressure of not less than 5 kPa (0.05 bar).

(b) **Items of equipment (TE)**

TE1 *(Deleted)*

TE2 *(Deleted)*

TE3 Tanks shall in addition meet the following requirements. The heating device shall not penetrate into, but shall be exterior to the shell. However, a pipe used for extracting the phosphorus may be equipped with a heating jacket. The device heating the jacket shall be so regulated as to prevent the temperature of the phosphorus from exceeding the filling temperature of the shell. Other piping shall enter the shell in its upper part; openings shall be situated above the highest permissible level of the phosphorus and be capable of being completely enclosed under lockable caps. The tank shall be equipped with a gauging system for verifying the level of the phosphorus and, if water is used as a protective agent, with a fixed gauge mark showing the highest permissible level of the water.

TE4 Shells shall be equipped with thermal insulation made of materials which are not readily flammable.

TE5 If shells are equipped with thermal insulation, such insulation shall be made of materials which are not readily flammable.

TE6 Tanks may be equipped with a device of a design which precludes its obstruction by the substance carried and which prevents leakage and the build-up of excess overpressure or underpressure inside the shell.

TE7 The shell-discharge system shall be equipped with two mutually independent shut-off devices mounted in series, the first taking the form of a quick-closing internal stop-valve of an approved type and the second that of an external stop-valve, one at each end of the discharge pipe. A blank flange, or another device providing the same measure of security, shall also be fitted at the outlet of each external stop-valve. The internal stop-valve shall be such that if the pipe is wrenched off the stop-valve will remain integral with the shell and in the closed position.

TE8 The connections to the external pipe-sockets of tanks shall be made of materials not liable to cause decomposition of hydrogen peroxide.

TE9 Tanks shall be fitted in their upper part with a shut-off device preventing any build-up of excess pressure inside the shell due to the decomposition of the substances carried, any leakage of liquid, and any entry of foreign matter into the shell.

TE10 The shut-off devices of tanks shall be so designed as to preclude obstruction of the devices by the solidified substance during carriage. Where tanks are sheathed in thermally-insulating material, the material shall be of an inorganic nature and entirely free from combustible matter.

TE11 Shells and their service equipment shall be so designed as to prevent the entry of foreign matter, leakage of liquid or any building up of dangerous excess pressure inside the shell due to the decomposition of the substances carried. A safety valve preventing the entry of foreign matter also fulfils this provision.

TE12 Tanks shall be equipped with thermal insulation complying with the requirements of 6.8.3.2.14. If the SADT of the organic peroxide in the tank is 55 °C or less, or the tank is constructed of aluminium, the shell shall be completely insulated. The sun shield and any part of the tank not covered by it, or the outer sheathing of a complete lagging, shall be painted white or finished in bright metal. The paint shall be cleaned before each transport journey and renewed in case of yellowing or deterioration. The thermal insulation shall be free from combustible matter. Tanks shall be fitted with temperature sensing devices.

Tanks shall be fitted with safety valves and emergency pressure-relief devices. Vacuum-relief devices may also be used. Emergency pressure-relief devices shall operate at pressures determined according to both the properties of the organic peroxide and the construction characteristics of the tank. Fusible elements shall not be permitted in the body of the shell.

Tanks shall be fitted with spring-loaded safety valves to prevent significant pressure build-up within the shell of the decomposition products and vapours released at a temperature of 50 °C. The capacity and start-to-discharge pressure of the safety-valve(s) shall be based on the results of the tests specified in special provision TA2. The start-to-discharge pressure shall however in no case be such that liquid could escape from the valve(s) if the tank were overturned.

The emergency-relief devices may be of the spring-loaded or frangible types designed to vent all the decomposition products and vapours evolved during a period of not less than one hour of complete fire-engulfment as calculated by the following formula:

$$q = 70961 \times F \times A^{0.82}$$

where:

q = heat absorption [W]

A = wetted area [m²]

F = insulation factor

F = 1 for non-insulated tanks, or

$$F = \frac{U\,(923 - T_{P0})}{47032} \text{ for insulated tanks}$$

where:

K = heat conductivity of insulation layer [$W \cdot m^{-1} \cdot K^{-1}$]

L = thickness of insulation layer [m]

U = K/L = heat transfer coefficient of the insulation [$W \cdot m^{-2} \cdot K^{-1}$]

T_{PO} = temperature of peroxide at relieving conditions [K]

The start-to-discharge pressure of the emergency-relief device(s) shall be higher than that above specified and based on the results of the tests referred to in special provision TA2. The emergency-relief devices shall be dimensioned in such a way that the maximum pressure in the tank never exceeds the test pressure of the tank.

NOTE: *An example of a method to determine the size of emergency-relief devices is given in Appendix 5 of the "Manual of Tests and Criteria".*

For tanks equipped with thermal insulation consisting of a complete cladding, the capacity and setting of the emergency-relief device(s) shall be determined assuming a loss of insulation from 1 % of the surface area.

Vacuum-relief devices and spring-loaded safety valves of tanks shall be provided with flame arresters unless the substances to be carried and their decomposition products are non-combustible. Due attention shall be paid to the reduction of the relief capacity caused by the flame arrester.

TE13 Tanks shall be thermally insulated and fitted with a heating device on the outside.

TE14 Tanks shall be equipped with thermal insulation. The thermal insulation directly in contact with the shell and/or components of the heating system shall have an ignition temperature at least 50 °C higher than the maximum temperature for which the tank was designed.

TE15 *(Deleted)*

TE16 *(Reserved)*

TE17 *(Reserved)*

TE18 Tanks intended for the carriage of substances filled at a temperature higher than 190 °C shall be equipped with deflectors placed at right angles to the upper filling openings, so as to avoid a sudden localized increase in wall temperature during filling.

TE19 Fittings and accessories mounted in the upper part of the tank shall be either:

- inserted in a recessed housing; or
- equipped with an internal safety valve; or
- shielded by a cap, or by transverse and/or longitudinal members, or by other equally effective devices, so profiled that in the event of overturning the fittings and accessories will not be damaged.

Fittings and accessories mounted in the lower part of the tank:

Pipe-sockets, lateral shut-off devices, and all discharge devices shall either be recessed by at least 200 mm from the extreme outer edge of the tank or be protected by a rail having a coefficient of inertia of not less than 20 cm^3 transversally to the direction of travel; their ground clearance shall be not less than 300 mm with the tank full.

Fittings and accessories mounted on the rear face of the tank shall be protected by the bumper prescribed in 9.7.6. Their height above the ground shall be such that they are adequately protected by the bumper

TE20 Notwithstanding the other tank-codes which are permitted in the hierarchy of tanks of the rationalized approach in 4.3.4.1.2, tanks shall be equipped with a safety valve.

TE21 The closures shall be protected with lockable caps.

TE22 *(Reserved)*

TE23 Tanks shall be equipped with a device of a design which precludes its obstruction by the substance carried and which prevents leakage and the build-up of excess overpressure or underpressure inside the shell.

TE24 If tanks, intended for the carriage and handling of bitumen, are equipped with a spray bar at the end of the discharge pipe, the closing device, as required by 6.8.2.2.2, may be replaced by a shut-off valve, situated on the discharge pipe and preceding the spray bar.

TE25 *(Reserved)*

TE26 All filling and discharge connections, including those in the vapour phase, of tanks intended for the carriage of flammable refrigerated liquefied gases shall be equipped with an instant closing automatic stop-valve (see 6.8.3.2.3) as close as possible to the tank.

(c) **Type approval (TA)**

TA1 Tanks shall not be approved for the carriage of organic substances.

TA2 This substance may be carried in fixed or demountable tanks or tank-containers under the conditions laid down by the competent authority of the country of origin, if, on the basis of the tests mentioned below, the competent authority is satisfied that such a transport operation can be carried out safely. If the country of origin is not party to ADR, these conditions shall be recognized by the competent authority of the first ADR country reached by the consignment.

For the type approval tests shall be undertaken:

- to prove the compatibility of all materials normally in contact with the substance during carriage;

- to provide data to facilitate the design of the emergency pressure-relief devices and safety valves taking into account the design characteristics of the tank; and

- to establish any special requirements necessary for the safe carriage of the substance.

The test results shall be included in the report for the type approval.

TA3 This substance may be carried only in tanks with the tank code LGAV or SGAV; the hierarchy in 4.3.4.1.2 is not applicable.

TA4 The conformity assessment procedures of section 1.8.7 shall be applied by the competent authority or the inspection body conforming to 1.8.6.3 and accredited according to EN ISO/IEC 17020:2012 (except clause 8.1.3) type A.

TA5 This substance may be carried only in tanks with the tank code S2.65AN(+); the hierarchy in 4.3.4.1.2 is not applicable.

(d) **Tests (TT)**

TT1 Tanks of pure aluminium need to be subjected to the initial and periodic hydraulic pressure tests at a pressure of only 250 kPa (2.5 bar) (gauge pressure).

TT2 The condition of the lining of shells shall be inspected every year by an inspection body, which shall inspect the inside of the shell (see special provision TU43 in 4.3.5).

TT3 By derogation from the requirements of 6.8.2.4.2, periodic inspections shall be performed no later than every eight years and shall include a thickness check using suitable instruments. For such tanks, the leakproofness test and check for which provision is made in 6.8.2.4.3 shall be performed no later than every four years.

TT4 *(Reserved)*

TT5 The hydraulic pressure tests shall be performed no later than every

3 years.	2½ years.

TT6 The periodic inspection shall be performed no later than every 3 years.

TT7 Notwithstanding the requirements of 6.8.2.4.2, the periodic internal inspection may be replaced by a programme approved by the competent authority.

TT8 Tanks on which the proper shipping name required for the entry UN No. 1005 AMMONIA, ANHYDROUS is marked in accordance with 6.8.3.5.1 to 6.8.3.5.3 and constructed of fine-grained steel with a yield strength of more than 400 N/mm² in accordance with the material standard, shall be subjected at each periodic inspection according to 6.8.2.4.2, to magnetic particle inspections to detect surface cracking.

For the lower part of each shell at least 20 % of the length of each circumferential and longitudinal weld shall, together with all nozzle welds and any repair or ground areas, be inspected.

If the mark of the substance on the tank or tank plate is removed, a magnetic particle inspection shall be carried out and these actions recorded in the inspection certificate attached to the tank record.

Such magnetic particle inspections shall be performed in accordance with EN 12972:2018 + A1:2024.

TT9 For inspections and tests (including supervision of the manufacture) the procedures of section 1.8.7 shall be applied by the competent authority or the inspection body conforming to 1.8.6.3 and accredited according to EN ISO/IEC 17020:2012 (except clause 8.1.3) type A.

TT10 The periodic inspections according to 6.8.2.4.2 shall be performed no later than:

every three years.	every two and a half years.

TT11 For fixed tanks (tank-vehicles) and demountable tanks used exclusively for the carriage of LPG, with carbon steel shells and service equipment, the hydraulic pressure test, may, at the time of the periodic inspection and at the request of the applicant, be replaced by the non-destructive testing (NDT) techniques listed below. These techniques may be used either singularly or in combination as deemed suitable by the competent authority or the inspection body (see special provision TT9):

- EN ISO 17640:2018 – Non-destructive testing of welds – Ultrasonic testing – Techniques, testing levels and assessment;

- EN ISO 17638:2016 – Non-destructive testing of welds – Magnetic particle testing, with acceptance of indications in accordance with level 2X of EN ISO 23278:2015 – Non-destructive testing of welds – Magnetic particle testing. Acceptance levels;
- EN ISO 17643:2015 – Non-destructive testing of welds – Eddy current examination of welds by complex plane analysis;
- EN ISO 16809:2019 – Non-destructive testing – Ultrasonic thickness measurement.

Non-destructive checks shall be performed by personnel in accordance with EN 12972:2018 + A1:2024 or EN 14334:2014.

After direct application of heat such as welding or cutting to the pressure containing elements of the tank a hydraulic test shall be carried out in addition to any prescribed NDT.

NDT shall be performed on the areas of the shell and equipment listed in the table below:

<table>
<tr><th>Area of shell and equipment</th><th>NDT</th></tr>
<tr><td>Shell longitudinal butt welds</td><td rowspan="5">100 % NDT, using one or more of the following techniques: ultrasonic, magnetic particle or eddy current testing</td></tr>
<tr><td>Shell circumferential butt welds</td></tr>
<tr><td>Attachments, manway, nozzles and opening welds (internal) direct to the shell</td></tr>
<tr><td>High stress areas of fastening doubling plates (over the end of the saddle horn, plus 400 mm down each side)</td></tr>
<tr><td>Piping and other equipment welds</td></tr>
<tr><td>Shell, areas that cannot be visually inspected from the outside</td><td>Ultrasonic thickness survey, from inside, on a 150 mm (maximum) spaced grid</td></tr>
</table>

Irrespective of the original design and construction standard or technical code used for the tank, the defect acceptance levels shall be in accordance with the requirements of the relevant parts of EN 14025:2023 (Tanks for the transport of dangerous goods – metallic pressure tanks – design and construction), EN 12493:2013 + A2:2020 (LPG equipment and accessories – welded steel pressure vessels for LPG road tankers – design and construction), EN ISO 23278:2015 (Non-destructive testing of welds – magnetic particle testing of welds – acceptance levels) or the acceptance standard referenced in the applicable NDT standard. If an unacceptable defect is found in the tank by NDT methods it shall be repaired and retested. It is not permitted to hydraulic test the tank without undertaking the required repairs. The results of the NDT shall be recorded and retained for the lifetime of the tank.	

(e) **Marking (TM)**

NOTE: *These particulars shall be in an official language of the country of approval, and also, if that language is not English, French or German, in English, French or German, unless any agreements concluded between the countries concerned in the transport operation provide otherwise.*

TM1 Tanks shall bear in addition to the particulars prescribed in 6.8.2.5.2, the words: "**Do not open during carriage. Liable to spontaneous combustion**" (see also the note above).

TM2 Tanks shall bear in addition to the particulars prescribed in 6.8.2.5.2, the words: "**Do not open during carriage. Gives off flammable gases on contact with water**" (see also the note above).

TM3 Tanks shall also bear, on the plate prescribed in 6.8.2.5.1, the proper shipping name and the maximum permissible load mass in kg for this substance.

TM4 For tanks the following additional particulars shall be marked by stamping or by any other similar method on the plate prescribed in 6.8.2.5.2 or directly on the shell itself, if the walls are so reinforced that the strength of the tank is not impaired: the chemical name with the approved concentration of the substance concerned.

TM5 Tanks shall bear, in addition to the particulars referred to in 6.8.2.5.1 the date (month, year) of the most recent inspection of the internal condition of the shell.

TM6 *(Reserved)*

TM7 The trefoil symbol, as described in 5.2.1.7.6, shall be marked by stamping or any other equivalent method on the plate described in 6.8.2.5.1. This trefoil may be engraved directly on the walls of the shell itself, if the walls are so reinforced that the strength of the shell is not impaired.

6.8.5 Requirements concerning the materials and construction of fixed welded tanks, demountable welded tanks, and welded shells of tank-containers for which a test pressure of not less than 1 MPa (10 bar) is required, and of fixed welded tanks, demountable welded tanks and welded shells of tank-containers intended for the carriage of refrigerated liquefied gases of Class 2

6.8.5.1 *Materials and shells*

6.8.5.1.1 (a) Shells intended for the carriage of :

- Compressed, liquefied gases or dissolved gases of Class 2;
- UN Nos. 1380, 2845, 2870, 3194 and 3391 to 3394 of Class 4.2; and
- UN No. 1052 hydrogen fluoride, anhydrous and UN No.1790 hydrofluoric acid with more than 85 % hydrogen fluoride of Class 8

shall be made of steel;

(b) Shells constructed of fine-grained steels for the carriage of:

- Corrosive gases of Class 2 and UN No. 2073 ammonia solution; and
- UN No. 1052 hydrogen fluoride, anhydrous and UN No.1790 hydrofluoric acid with more than 85 % hydrogen fluoride of Class 8

shall be heat-treated for thermal stress relief;

(c) Shells intended for the carriage of refrigerated liquefied gases of Class 2, shall be made of steel, aluminium, aluminium alloy, copper or copper alloy (e.g. brass). However, shells made of copper or copper alloy shall be allowed only for gases containing no acetylene; ethylene, however, may contain not more than 0.005 % acetylene;

(d) Only materials appropriate to the lowest and highest working temperatures of the shells and of their fittings and accessories may be used.

6.8.5.1.2 The following materials shall be allowed for the manufacture of shells:

(a) Steels not subject to brittle fracture at the lowest working temperature (see 6.8.5.2.1):

- Mild steels (except for refrigerated liquefied gases of Class 2);
- Fine-grained steels, down to a temperature of -60 °C;
- Nickel steels (with a nickel content of 0.5 to 9 %), down to a temperature of –196 °C, depending on the nickel content;
- Austenitic chrome-nickel steels, down to a temperature of -270 °C;
- Austenitic-ferritic stainless steels, down to a temperature of -60 °C;

(b) Aluminium not less than 99.5 % pure or aluminium alloys (see 6.8.5.2.2);

(c) Deoxidized copper not less than 99.9 % pure, or copper alloys having a copper content of over 56 % (see 6.8.5.2.3).

6.8.5.1.3 (a) Shells made of steel, aluminium or aluminium alloys shall be either seamless or welded;

(b) Shells made of austenitic steel, copper or copper alloy may be hard-soldered.

6.8.5.1.4 The fittings and accessories may either be screwed to the shells or be secured thereto as follows:

(a) Shells made of steel, aluminium or aluminium alloy: by welding;

(b) Shells made of austenitic steel, of copper or of copper alloy: by welding or hard-soldering.

6.8.5.1.5 The construction of shells and their attachment to the vehicle, to the underframe or in the container frame shall be such as to preclude with certainty any such reduction in the temperature of the load-bearing components as would be likely to render them brittle. The means of attachment of shells shall themselves be so designed that even when the shell is at its lowest working temperature they still possess the necessary mechanical properties.

6.8.5.2 ***Test requirements***

6.8.5.2.1 *Steel shells*

The materials used for the manufacture of shells and the weld beads shall, at their lowest working temperature, but at least at -20 °C, meet at least the following requirements as to impact strength:

- The tests shall be carried out with test-pieces having a V-shaped notch;
- The minimum impact strength (see 6.8.5.3.1 to 6.8.5.3.3) for test-pieces with the longitudinal axis at right angles to the direction of rolling and a V-shaped notch (conforming to ISO R 148) perpendicular to the plate surface, shall be 34 J/cm² for mild steel (which, because of existing ISO standards, may be tested with test-pieces having the longitudinal axis in the direction of rolling); fine-grained steel; ferritic alloy steel Ni < 5 %, ferritic alloy steel 5 % ≤ Ni ≤ 9 %; austenitic Cr - Ni steel; or austenitic-ferritic stainless steel;
- In the case of austenitic steels, only the weld bead need be subjected to an impact-strength test;
- For working temperatures below -196 °C the impact-strength test is not performed at the lowest working temperature, but at -196 °C.

6.8.5.2.2 *Shells made of aluminium or aluminium alloy*

The seams of shells shall meet the requirements laid down by the competent authority.

6.8.5.2.3 *Shells made of copper or copper alloy*

It is not necessary to carry out tests to determine whether the impact strength is adequate.

6.8.5.3 ***Impact-strength tests***

6.8.5.3.1 For sheets less than 10 mm but not less than 5 mm thick, test-pieces having a cross-section of 10 mm × e mm, where "e" represents the thickness of the sheet, shall be used. Machining to 7.5 mm or 5 mm is permitted if it is necessary. The minimum value of 34 J/cm² shall be required in every case.

NOTE: *No impact-strength test shall be carried out on sheets less than 5 mm thick, or on their weld seams.*

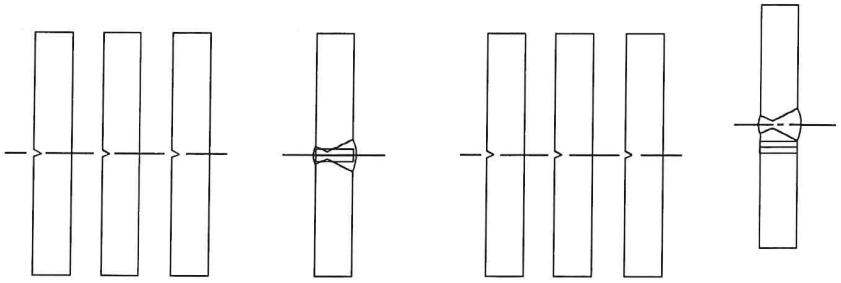
6.8.5.3.2 (a) For the purpose of testing sheets, the impact strength shall be determined on three test-pieces. Test-pieces shall be taken at right angles to the direction of rolling; however, for mild steel they may be taken in the direction of rolling.

(b) For testing weld seams the test-pieces shall be taken as follows:

when e ≤ 10 mm:

three test-pieces with the notch at the centre of the weld;

three test-pieces with the notch in the centre of the heat affected zone (the V-notch to cross the fusion boundary at the centre of the specimen);

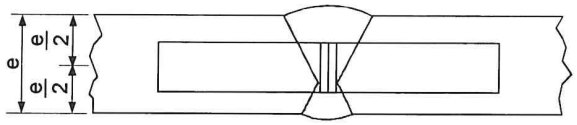


Center of the weld Heat affected zone

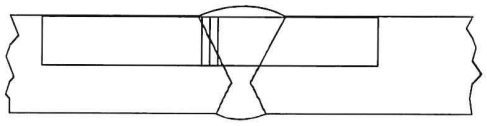
when 10 mm < e ≤ 20 mm:

three test-pieces from the centre of the weld;

three test-pieces from the heat affected zone (the V-notch to cross the fusion boundary at the centre of the specimen);



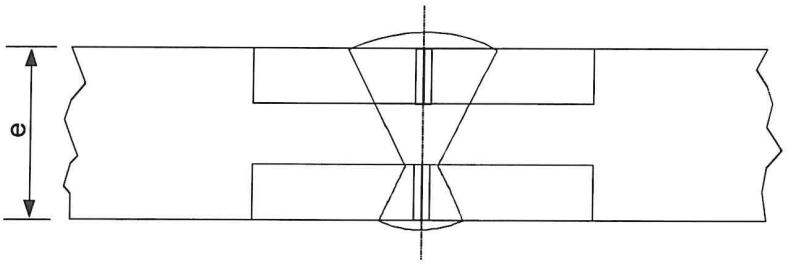
Center of the weld



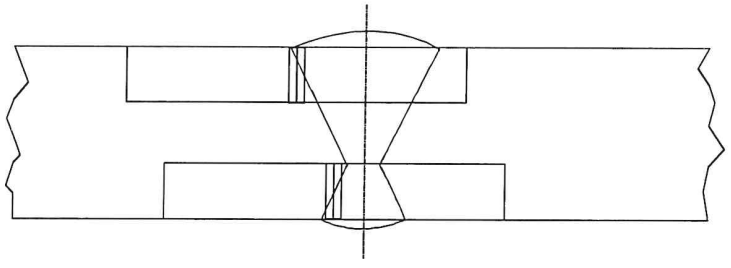
Heat affected zone

when e > 20 mm

two sets of three test-pieces, one set on the upper face, one set on the lower face at each of the points indicated below (the V-notch to cross the fusion boundary at the centre of the specimen for those taken from the heat affected zone)



Center of the weld



Heat affected zone

6.8.5.3.3 (a) For sheets, the average of the three tests shall meet the minimum value of 34 J/cm² indicated in 6.8.5.2.1; not more than one of the individual values may be below the minimum value and then not below 24 J/cm²;

(b) For welds, the average value obtained from the three test-pieces taken at the centre of the weld shall not be below the minimum value of 34 J/cm²; not more than one of the individual values may be below the minimum value and then not below 24 J/cm²;

(c) For the heat affected zone (the V-notch to cross the fusion boundary at the centre of the specimen) the value obtained from not more than one of the three test-pieces may be below the minimum value of 34 J/cm², though not below 24 J/cm².

6.8.5.3.4 If the requirements prescribed in 6.8.5.3.3 are not met, one retest only may be done if:

(a) The average value of the first three tests is below the minimum value of 34 J/cm²; or

(b) More than one of the individual values is less than the minimum value of 34 J/cm² but not below 24 J/cm².

6.8.5.3.5 In a repeated impact test on sheets or welds, none of the individual values may be below 34 J/cm². The average value of all the results of the original test and of the retest should be equal to or more than the minimum of 34 J/cm².

On a repeated impact strength test on the heat-affected zone, none of the individual values may be below 34 J/cm².

6.8.5.4 ***Reference to standards***

The requirements of 6.8.5.2 and 6.8.5.3 shall be deemed to have been complied with if the following relevant standards have been applied:

EN ISO 21028-1:2016 Cryogenic vessels - Toughness requirements for materials at cryogenic temperature - Part 1: Temperatures below -80 °C.

EN ISO 21028-2:2018 Cryogenic vessels – Toughness requirements for materials at cryogenic temperature – Part 2: Temperatures between -80 °C and -20 °C.

CHAPTER 6.9

REQUIREMENTS FOR THE DESIGN, CONSTRUCTION, INSPECTION AND TESTING OF PORTABLE TANKS WITH SHELLS MADE OF FIBRE-REINFORCED PLASTICS (FRP) MATERIALS

6.9.1 Application and general requirements

6.9.1.1 The requirements of section 6.9.2 apply to portable tanks with an FRP shell intended for the carriage of dangerous goods of Classes 1, 3, 5.1, 6.1, 6.2, 8 and 9 by all modes of transport. In addition to the requirements of this Chapter, unless otherwise specified, the applicable requirements of the *International Convention for Safe Containers (CSC)* 1972, as amended, shall be fulfilled by any multimodal portable tank with FRP shell which meets the definition of a "container" within the terms of that Convention.

6.9.1.2 The requirements of this Chapter do not apply to offshore portable tanks.

6.9.1.3 The requirements of Chapter 4.2 and section 6.7.2 apply to FRP portable tank shells except for those concerning the use of metal materials for the construction of a portable tank shell and additional requirements stated in this Chapter.

6.9.1.4 In recognition of scientific and technological advances, the technical requirements of this Chapter may be varied by alternative arrangements. These alternative arrangements shall offer a level of safety not less than that given by the requirements of this Chapter with respect to compatibility with substances carried and the ability of the FRP portable tank to withstand impact, loading and fire conditions. For international carriage, alternative arrangement FRP portable tanks shall be approved by the applicable competent authorities.

6.9.2 Requirements for the design, construction, inspection and testing of FRP portable tanks

6.9.2.1 ***Definitions***

For the purposes of this section, the definitions of 6.7.2.1 apply except for definitions related to metal materials ("Fine grain steel", "Mild steel" and "Reference steel") for the construction of the shell of a portable tank.

Additionally, the following definitions apply to portable tanks with an FRP shell:

External layer means the part of the shell which is directly exposed to the atmosphere;

Fibre-reinforced plastics (FRP), see 1.2.1;

Filament winding means a process for constructing FRP structures in which continuous reinforcements (filament, tape, or other), either previously impregnated with a matrix material or impregnated during winding, are placed over a rotating mandrel. Generally, the shape is a surface of revolution and may include ends (heads);

FRP shell means a closed part of cylindrical shape with an interior volume intended for carriage of chemical substances;

FRP tank means a portable tank constructed with an FRP shell and ends (heads), service equipment, safety relief devices and other installed equipment;

Glass transition temperature (T_g) means a characteristic value of the temperature range over which the glass transition takes place;

Hand layup means a process for moulding reinforced plastics in which reinforcement and resin are placed on a mould;

Liner means a layer on the inner surface of an FRP shell preventing contact with the dangerous goods being carried;

Mat means a fibre reinforcement made of random, chopped or twisted fibres bonded together as sheets of various length and thickness;

Parallel shell-sample means an FRP specimen, which must be representative of the shell, constructed in parallel to the shell construction if it is not possible to use cut-outs from the shell itself. The parallel shell-sample may be flat or curved;

Representative sample means a sample cut out from the shell;

Resin infusion means an FRP construction method by which dry reinforcement is placed into a matched mould, single sided mould with vacuum bag, or otherwise, and liquid resin is supplied to the part through the use of external applied pressure at the inlet and/or application of full or partial vacuum pressure at the vent;

Structural layer means FRP layers of a shell required to sustain the design loads;

Veil means a thin mat with high absorbency used in FRP product plies where polymeric matrix surplus fraction content is required (surface evenness, chemical resistance, leakage-proof, etc.).

6.9.2.2 ***General design and construction requirements***

6.9.2.2.1 The requirements of 6.7.1 and 6.7.2.2 apply to FRP portable tanks. For areas of the shell that are made from FRP, the following requirements of Chapter 6.7 are exempt: 6.7.2.2.1, 6.7.2.2.9.1, 6.7.2.2.13 and 6.7.2.2.14. Shells shall be designed and constructed in accordance with the requirements of a pressure vessel code, applicable to FRP materials, recognized by the competent authority.

In addition, the following requirements apply.

6.9.2.2.2 *Manufacturer's quality system*

6.9.2.2.2.1 The quality system shall contain all the elements, requirements, and provisions adopted by the manufacturer. It shall be documented in a systematic and orderly manner in the form of written policies, procedures, and instructions.

6.9.2.2.2.2 The contents shall in particular include adequate descriptions of:

(a) The organizational structure and responsibilities of personnel with regard to design and product quality;

(b) The design control and design verification techniques, processes, and procedures that will be used when designing the portable tanks;

(c) The relevant manufacturing, quality control, quality assurance and process operation instructions that will be used;

(d) Quality records, such as inspection reports, test data and calibration data;

(e) Management reviews to ensure the effective operation of the quality system arising from the audits in accordance with 6.9.2.2.2.4;

(f) The process describing how customer requirements are met;

(g) The process for control of documents and their revision;

(h) The means for control of non-conforming portable tanks, purchased components, in-process and final materials; and

(i) Training programmes and qualification procedures for relevant personnel.

6.9.2.2.2.3 Under the quality system, the following minimum requirements shall be met for each FRP portable tank manufactured:

(a) Use of an inspection and test plan (ITP);

(b) Visual inspections;

(c) Verification of fibre orientation and mass fraction by means of documented control process;

(d) Verification of fibre and resin quality and characteristics by means of certificates or other documentation;

(e) Verification of liner quality and characteristics by means of certificates or other documentation;

(f) Verification of whichever is applicable of formed thermoplastic resin characteristic or degree of cure of thermoset resin, by direct or indirect means (e.g. Barcol test or differential scanning calorimetry) to be determined in accordance with 6.9.2.7.1.2 (h), or by creep testing of a representative sample or parallel shell-sample in accordance with 6.9.2.7.1.2 (e) for a period of 100 hours;

(g) Documentation of whichever is applicable of thermoplastic resin forming processes or thermoset resin cure and post-cure processes; and

(h) Retention and archiving of shell samples for future inspection and shell verification (e.g. from manhole cut out) for a period of 5 years.

6.9.2.2.2.4 Audit of the quality system

The quality system shall be initially assessed to determine whether it meets the requirements in 6.9.2.2.2.1 to 6.9.2.2.2.3 to the satisfaction of the competent authority.

The manufacturer shall be notified of the results of the audit. The notification shall contain the conclusions of the audit and any corrective actions required.

Periodic audits shall be carried out, to the satisfaction of the competent authority, to ensure that the manufacturer maintains and applies the quality system. Reports of the periodic audits shall be provided to the manufacturer.

6.9.2.2.2.5 Maintenance of the quality system

The manufacturer shall maintain the quality system as approved in order that it remains adequate and efficient.

The manufacturer shall notify the competent authority that approved the quality system of any intended changes. The proposed changes shall be evaluated to determine whether the amended quality system will still satisfy the requirements in 6.9.2.2.2.1 to 6.9.2.2.2.3.

6.9.2.2.3 *FRP Shells*

6.9.2.2.3.1 FRP shells shall have a secure connection with structural elements of the portable tank frame. FRP shell supports and attachments to the frame shall cause no local stress concentrations exceeding the design allowables of the shell structure in accordance with the provisions stated in this Chapter for all operating and test conditions.

6.9.2.2.3.2 Shells shall be made of suitable materials, capable of operating within a minimum design temperature range of -40 °C to +50 °C, unless temperature ranges are specified for specific more severe climatic or operating conditions (e.g. heating elements), by the competent authority of the country where the transport operation is being performed.

6.9.2.2.3.3 If a heating system is installed, it shall comply with 6.7.2.5.12 to 6.7.2.5.15 and with the following requirements:

(a) The maximum operating temperature of the heating elements integrated or connected to the shell shall not exceed the maximum design temperature of the tank;

(b) The heating elements shall be designed, controlled and utilized so that the temperature of the carried substance cannot exceed the maximum design temperature of the tank or a value at which the internal pressure exceeds MAWP; and

(c) Structures of the tank and its heating elements shall allow examination of the shell with respect to possible effects of overheating.

6.9.2.2.3.4 Shells shall consist of the following elements:

- Liner;
- Structural layer;
- External layer.

NOTE: *The elements may be combined if all applicable functional criteria are met.*

6.9.2.2.3.5 The liner is the inner element of the shell designed as the primary barrier to provide for the long-term chemical resistance in relation to the substances to be carried, to prevent any dangerous reaction with the contents or the formation of dangerous compounds and any substantial weakening of the structural layer owing to the diffusion of products through the liner. Chemical compatibility shall be verified in accordance with 6.9.2.7.1.3.

The liner may be an FRP liner or a thermoplastic liner.

6.9.2.2.3.6 FRP liners shall consist of the following two components:

(a) Surface layer ("gel-coat"): adequate resin rich surface layer, reinforced with a veil, compatible with the resin and contents. This layer shall have a maximum fibre mass content of 30 % and have a minimum thickness of 0.25 mm and a maximum thickness of 0.60 mm;

(b) Strengthening layer(s): layer or several layers with a minimum thickness of 2 mm, containing a minimum of 900 g/m² of glass mat or chopped fibres with a mass content in glass of not less than 30 % unless equivalent safety is demonstrated for a lower glass content.

6.9.2.2.3.7 If the liner consists of thermoplastic sheets, they shall be welded together in the required shape, using a qualified welding procedure and personnel. Welded liners shall have a layer of electrically conductive media placed against the non-liquid contact surface of the welds to facilitate spark testing. Durable bonding between liners and the structural layer shall be achieved by the use of an appropriate method.

6.9.2.2.3.8 The structural layer shall be designed to withstand the design loads according to 6.7.2.2.12, 6.9.2.2.3.1, 6.9.2.3.2, 6.9.2.3.4 and 6.9.2.3.6.

6.9.2.2.3.9 The external layer of resin or paint shall provide adequate protection of the structural layers of the tank from environmental and service exposure, including to UV radiation and salt fog, and occasional splash exposure to cargoes.

6.9.2.2.3.10 Resins

The processing of the resin mixture shall be carried out in compliance with the recommendations of the supplier. These resins can be:

- Unsaturated polyester resins;
- Vinyl ester resins;
- Epoxy resins;
- Phenolic resins;
- Thermoplastic resins.

The resin heat distortion temperature (HDT), determined in accordance with 6.9.2.7.1.1 shall be at least 20 °C higher than the maximum design temperature of the shell as defined in 6.9.2.2.3.2, but shall in any case not be lower than 70 °C.

6.9.2.2.3.11 Reinforcement material

The reinforcement material of the structural layers shall be selected such that they meet the requirements of the structural layer.

For the liner glass fibres of at a minimum type C or ECR according to ISO 2078:1993 + Amd 1:2015 shall be used. Thermoplastic veils may only be used for the liner when their compatibility with the intended contents has been demonstrated.

6.9.2.2.3.12 Additives

Additives necessary for the treatment of the resin, such as catalysts, accelerators, hardeners and thixotropic substances as well as materials used to improve the tank, such as fillers, colours, pigments etc. shall not cause weakening of the material, taking into account lifetime and temperature expectancy of the design.

6.9.2.2.3.13 FRP shells, their attachments and their service and structural equipment shall be designed to withstand the loads mentioned in 6.7.2.2.12, 6.9.2.2.3, 6.9.2.3.2, 6.9.2.3.4 and 6.9.2.3.6 without loss of contents (other than quantities of gas escaping through any degassing vents) during the design lifetime.

6.9.2.2.3.14 Special requirements for the carriage of substances with a flash-point of not more than 60 °C

6.9.2.2.3.14.1 FRP tanks used for the carriage of flammable liquids with a flash-point of not more than 60 °C shall be constructed to ensure the elimination of static electricity from the various component parts to avoid the accumulation of dangerous charges.

6.9.2.2.3.14.2 The electrical surface resistance of the inside and outside of the shell as established by measurements shall not be higher than 10^9 Ω. This may be achieved by the use of additives in the resin or interlaminate conducting sheets, such as metal or carbon network.

6.9.2.2.3.14.3 The discharge resistance to earth as established by measurements shall not be higher than 10^7 Ω.

6.9.2.2.3.14.4 All components of the shell shall be electrically connected to each other and to the metal parts of the service and structural equipment of the tank and to the vehicle. The electrical resistance between components and equipment in contact with each other shall not exceed 10 Ω.

6.9.2.2.3.14.5 The electrical surface-resistance and discharge resistance shall be measured initially on each manufactured tank or a specimen of the shell in accordance with the procedure recognized by the competent authority. In the event of damage to the shell, requiring repair, the electrical resistance shall be re-measured.

6.9.2.2.3.15 The tank shall be designed to withstand, without significant leakage, the effects of a full engulfment in fire for 30 minutes as specified by the test requirements in 6.9.2.7.1.5. Testing may be waived with the agreement of the competent authority, where sufficient proof can be provided by tests with comparable tank designs.

6.9.2.2.3.16 Construction process for FRP shells

6.9.2.2.3.16.1 Filament winding, hand layup, resin infusion or other appropriate composite production processes shall be used for construction of FRP shells.

6.9.2.2.3.16.2 The weight of the fibre reinforcement shall conform to that set forth in the procedure specification with a tolerance of +10 % and −0 %. One or more of the fibre types specified in 6.9.2.2.3.11 and in the procedure specification shall be used for reinforcement of shells.

6.9.2.2.3.16.3 The resin system shall be one of the resin systems specified in 6.9.2.2.3.10. No filler, pigment or dye additions shall be used which will interfere with the natural colour of the resin except as permitted by the procedure specification.

6.9.2.3 ***Design criteria***

6.9.2.3.1 FRP shells shall be of a design capable of being stress-analysed mathematically or experimentally by resistance strain gauges or by other methods approved by the competent authority.

6.9.2.3.2 FRP shells shall be designed and constructed to withstand the test pressure. Specific provisions are laid down for certain substances in the applicable portable tank instruction indicated in column (10) of Table A of Chapter 3.2 and described in 4.2.5, or by a portable tank special provision indicated in column (11) of Table A of Chapter 3.2 and described in 4.2.5.3. The minimum wall thickness of the FRP shell shall not be less than that specified in 6.9.2.4.

6.9.2.3.3 At the specified test pressure the maximum tensile relative deformation measured in mm/mm in the shell shall not result in the formation of microcracks, and therefore not be greater than the first measured point of elongation based fracture or damage of the resin, measured during tensile tests prescribed under 6.9.2.7.1.2 (c).

6.9.2.3.4 For internal test pressure, external design pressure specified in 6.7.2.2.10, static loads specified in 6.7.2.2.12 and static gravity loads caused by the contents with the maximum density specified for the design and at maximum filling degree, failure criteria (*FC*) in the longitudinal direction, circumferential direction, and any other in-plane direction of the composite layup shall not exceed the following value:

$$FC \leq \frac{1}{K}$$

where:

$$K = K_0 \times K_1 \times K_2 \times K_3 \times K_4 \times K_5$$

where:

K shall have a minimum value of 4;

K_0 is a strength factor. For the general design the value for K_0 shall be equal to or more than 1.5. The value of K_0 shall be multiplied by a factor of two, unless the shell is provided with protection against damage consisting of a complete metal skeleton including longitudinal and transverse structural members;

K_1 is a factor related to the deterioration in the material properties due to creep and ageing. It shall be determined by the formula:

$$K_1 = \frac{1}{\alpha\beta}$$

where α is the creep factor and β is the ageing factor determined in accordance with 6.9.2.7.1.2 (e) and (f), respectively. When used in calculation, factors α and β shall be between 0 and 1.

Alternatively, a conservative value of $K_1 = 2$ may be applied for the purpose of undertaking the numerical validation exercise in 6.9.2.3.4 (this does not remove the need to perform testing to determine α and β);

K_2 is a factor related to the service temperature and the thermal properties of the resin, determined by the following equation, with a minimum value of 1:

$$K_2 = 1.25 - 0.0125\ (HDT - 70)$$

where *HDT* is the heat distortion temperature of the resin, in °C;

K_3 is a factor related to the fatigue of the material; the value of $K_3 = 1.75$ shall be used unless otherwise agreed with the competent authority. For the dynamic design as outlined in 6.7.2.2.12 the value of $K_3 = 1.1$ shall be used;

K_4 is a factor related to resin curing and has the following values:

1.0 where curing is carried out in accordance with an approved and documented process, and the quality system described under 6.9.2.2.2 includes verification of degree of cure for each FRP portable tank using a direct measurement approach, such as differential scanning calorimetry (DSC) determined via ISO 11357-2:2016, as per 6.9.2.7.1.2 (h);

1.1 where thermoplastic resin forming or thermoset resin curing is carried out in accordance with an approved and documented process, and the quality system described under 6.9.2.2.2 includes verification of whichever is applicable formed thermoplastic resin characteristics or degree of cure of thermoset resin, for each FRP portable tank using an indirect measurement approach as per 6.9.2.7.1.2 (h), such as Barcol testing via ASTM D2583:2013-03 or EN 59:2016, HDT via ISO 75-1:2013, thermo-mechanical analysis (TMA) via ISO 11359-1:2014, or dynamic thermo-mechanical analysis (DMA) via ISO 6721-11:2019;

1.5 in other cases.

K_5 is a factor related to the portable tank instruction in 4.2.5.2.6:

1.0 for T1to T19;

1.33 for T20;

1.67 for T21 to T22.

A design validation exercise using numerical analysis and a suitable composite failure criterion is to be undertaken to verify that the stresses in the plies in the shell are below the allowables. Suitable composite failure criteria include, but are not limited to, Tsai-Wu, Tsai-Hill, Hashin, Yamada-Sun, Strain Invariant Failure Theory, Maximum Strain, or Maximum Stress. Other relations for the strength criteria are allowed upon agreement with the competent authority. The method and results of this design validation exercise are to be submitted to the competent authority.

The allowables are to be determined using experiments to derive parameters required by the chosen failure criteria combined with factor of safety K, the strength values measured as per 6.9.2.7.1.2 (c), and the maximum elongation strain criteria prescribed in 6.9.2.3.5. The analysis of joints is to be undertaken in accordance with the allowables determined in 6.9.2.3.7 and the strength values measured as per 6.9.2.7.1.2 (g). Buckling is to be considered in accordance with 6.9.2.3.6. Design of openings and metallic inclusions is to be considered in accordance with 6.9.2.3.8.

6.9.2.3.5 At any of the stresses as defined in 6.7.2.2.12 and 6.9.2.3.4, the resulting elongation in any direction shall not exceed the value indicated in the following table or one tenth of the elongation at fracture of the resin determined by ISO 527-2:2012, whichever is lower.

Examples of known limits are presented in the table below.

Type of resin	**Maximum strain in tension (%)**
Unsaturated polyester or phenolic	0.2
Vinylester	0.25
Epoxy	0.3
Thermoplastic	See 6.9.2.3.3

6.9.2.3.6 For the external design pressure the minimum safety factor for linear buckling analysis of the shell shall be as defined in the applicable pressure vessel code but not less than three.

6.9.2.3.7 The adhesive bondlines and/or overlay laminates used in the joints, including the end joints, connection between the equipment and shell, the joints of the surge plates and the partitions with the shell shall be capable of withstanding the loads of 6.7.2.2.12, 6.9.2.2.3.1, 6.9.2.3.2, 6.9.2.3.4 and 6.9.2.3.6. In order to avoid concentrations of stresses in the overlay lamination, the applied taper shall not be steeper than 1:6. The shear strength between the overlay laminate and the tank components to which it is bonded shall not be less than:

$$\tau = \gamma \frac{Q}{l} \leq \frac{\tau_R}{K}$$

where:

τ_R is the interlaminar shear strength according to ISO 14130:1997 and Cor 1:2003;

Q is the load per unit width of the interconnection;

K is the safety factor determined as per 6.9.2.3.4;

l is the length of the overlay laminate;

γ is the notch factor relating average joint stress to peak joint stress at failure initiation location.

Other calculation methods for the joints are allowed following approval with the competent authority.

6.9.2.3.8 Metallic flanges and their closures are permitted to be used in FRP shells, under design requirements of 6.7.2. Openings in the FRP shell shall be reinforced to provide at least the same safety factors against

the static and dynamic stresses as specified in 6.7.2.2.12, 6.9.2.3.2, 6.9.2.3.4 and 6.9.2.3.6 as that for the shell itself. The number of openings shall be minimized. The axis ratio of oval-shaped openings shall be not more than 2.

If metallic flanges or componentry are integrated into the FRP shell using bonding, then the characterisation method stated in 6.9.2.3.7 shall apply to the joint between the metal and FRP. If the metallic flanges or componentry are fixed in an alternative fashion, e.g. threaded fastener connections, then the appropriate provisions of the relevant pressure vessel standard shall apply.

6.9.2.3.9 Check calculations of the strength of the shell shall be performed by finite element method simulating the shell layups, joints within FRP shell, joints between the FRP shell and the container frame, and openings. Treatment of singularities shall be undertaken using an appropriate method according to the applicable pressure vessel code.

6.9.2.4 ***Minimum wall thickness of the shell***

6.9.2.4.1 Minimum thickness of the FRP shell shall be confirmed by check calculations of the strength of the shell considering strength requirements given in 6.9.2.3.4.

6.9.2.4.2 Minimum thickness of the FRP shell structural layers shall be determined in accordance with 6.9.2.3.4, however, in any case the minimum thickness of the structural layers shall be at least 3 mm.

6.9.2.5 ***Equipment components for portable tanks with FRP shell***

Service equipment, bottom openings, pressure relief devices, gauging devices, supports, frameworks, lifting and tie-down attachments of portable tanks shall meet the requirements of 6.7.2.5 to 6.7.2.17. If any other metallic features are required to be integrated into the FRP shell, then the provisions of 6.9.2.3.8 shall apply.

6.9.2.6 ***Design approval***

6.9.2.6.1 Design approval of FRP portable tanks shall be as per 6.7.2.18 requirements. The following additional requirements apply to FRP portable tanks.

6.9.2.6.2 The prototype test report for the purpose of the design approval shall additionally include the following:

(a) Results of the material tests used for FRP shell fabrication in accordance with 6.9.2.7.1 requirements;

(b) Results of the ball drop test in accordance with the requirements of 6.9.2.7.1.4.

(c) Results the fire resistance test in accordance with provisions of 6.9.2.7.1.5.

6.9.2.6.3 A service life inspection programme shall be established, which shall be a part of the operation manual, to monitor the condition of the tank at periodic inspections. The inspection programme shall focus on the critical stress locations identified in the design analysis performed under 6.9.2.3.4. The inspection method shall take into account the potential damage mode at the critical stress location (e.g. tensile stress or interlaminate stress). The inspection shall be a combination of visual and non-destructive testing (e.g. acoustic emissions, ultrasonic evaluation, thermographic). For heating elements, the service life inspection programme shall allow an examination of the shell or its representative locations to take into account the effects of overheating.

6.9.2.6.4 A representative prototype tank shall be subjected to tests as specified below. For this purpose, service equipment may be replaced by other items if necessary.

6.9.2.6.4.1 The prototype shall be inspected for compliance with the design type specification. This shall include an internal and external inspection and measurement of the main dimensions.

6.9.2.6.4.2 The prototype, equipped with strain gauges at all locations of high strain, as identified by the design validation exercise in accordance with 6.9.2.3.4, shall be subjected to the following loads and the strain shall be recorded:

(a) Filled with water to the maximum filling degree. The measuring results shall be used to calibrate the design calculations according to 6.9.2.3.4;

(b) Filled with water to the maximum filling degree and subjected to static loads in all three directions mounted by the base corner castings without additional mass applied external to the shell. For comparison with the design calculation according to 6.9.2.3.4 the strains recorded shall be extrapolated in relation to the quotient of the accelerations required in 6.7.2.2.12 and measured;

(c) Filled with water and subjected to the specified test pressure. Under this load, the shell shall exhibit no visual damage or leakage.

The stress corresponding to the measured strain level shall not exceed the minimum factor of safety calculated in 6.9.2.3.4 under any of these loading conditions.

6.9.2.7 ***Additional provisions applicable to FRP portable tanks***

6.9.2.7.1 *Material testing*

6.9.2.7.1.1 Resins

Resin tensile elongation shall be determined in accordance with ISO 527-2:2012. The heat distortion temperature (HDT) of the resin shall be determined in accordance with ISO 75-1:2013.

6.9.2.7.1.2 Shell-samples

Prior to testing, all coatings shall be removed from the samples. If shell samples are not possible then parallel shell-samples may be used. The tests shall cover:

(a) The thickness of the laminates of the central shell wall and the ends;

(b) The mass content and composition of composite reinforcement by ISO 1172:1996 or ISO 14127:2008, as well as orientation and arrangement of reinforcement layers;

(c) The tensile strength, elongation at fracture and modulus of elasticity according to ISO 527-4:1997 or ISO 527-5:2009 for the circumferential and longitudinal directions of the shell. For areas of the FRP shell, tests shall be performed on representative laminates in accordance with ISO 527-4:1997 or ISO 527-5:2009, to permit evaluation of the suitability of safety factor (K). A minimum of six specimens per measure of tensile strength shall be used, and the tensile strength shall be taken as the average minus two standard deviations;

(d) The bending deflection and strength shall be established by the three-point or four-point bending test according to ISO 14125:1998 + Amd 1:2011 using a sample with a minimum width of 50 mm and a support distance of at least 20 times the wall thickness. A minimum of five specimens shall be used.

(e) The creep factor α determined by taking the average result of at least two specimens with the configuration described in (d), subject to creep in three-point or four-point bending, at the maximum design temperature nominated under 6.9.2.2.3.2, for a period of 1 000 hours. The following test is to be undertaken for each specimen:

(i) Place specimen into bending apparatus, unloaded, in oven set to maximum design temperature and allow to acclimatise for a period of not less than 60 minutes;

(ii) Load specimen bending in accordance with ISO 14125:1998 + Amd 1:2011 at flexural stress equal to the strength determined in (d) divided by four. Maintain mechanical load at maximum design temperature without interruption for not less than 1 000 hours;

(iii) Measure the initial deflection six minutes after full load application in (e) (ii). Specimen shall remain loaded in test rig;

(iv) Measure the final deflection 1 000 hours after full load application in (e) (ii); and

(v) Calculate the creep factor α by dividing the initial deflection from (e) (iii) by the final deflection from (e) (iv);

(f) The ageing factor β determined by taking the average result of at least two specimens with the configuration described in (d), subject to loading in static three-point or four-point bending, in

conjunction with immersion in water at the maximum design temperature nominated under 6.9.2.2.3.2 for a period of 1 000 hours. The following test is to be undertaken for each specimen:

(i) Prior to testing or conditioning, specimens shall be dried in an oven at 80 °C for a period of 24 hours;

(ii) The specimen shall be loaded in three-point or four-point bending at ambient temperature, in accordance with ISO 14125:1998 + Amd 1:2011, at the flexural stress level equal to the strength determined in (d) divided by four. Measure the initial deflection six minutes after full load application. Remove specimen from test rig;

(iii) Immerse unloaded specimen in water at the maximum design temperature for a period of not less than 1 000 hours without interruption to the water conditioning period. When conditioning period has lapsed, remove specimens, keep damp at ambient temperature, and complete (f) (iv) within three days;

(iv) The specimen shall be subject to second round of static loading, in a manner identical to (f) (ii). Measure the final deflection six minutes after full load application. Remove specimen from test rig; and

(v) Calculate the ageing factor β by dividing the initial deflection from (f) (ii) by the final deflection from (f) (iv);

(g) The interlaminar shear strength of the joints measured by testing representative samples in accordance with ISO 14130:1997;

(h) The efficiency of whichever is applicable of thermoplastic resin forming characteristics or thermoset resin cure and post-cure processes for laminates determined using one or more of the following methods:

(i) Direct measurement of formed thermoplastic resin characteristics or thermoset resin degree of cure: glass transition temperature (T_g) or melting temperature (T_m) determined using differential scanning calorimetry (DSC) via ISO 11357-2:2016; or

(ii) Indirect measurement of formed thermoplastic resin characteristics or thermoset resin degree of cure:

- HDT via ISO 75-1:2013;
- T_g or T_m using thermo-mechanical analysis (TMA) via ISO 11359-1:2014;
- Dynamic thermo-mechanical analysis (DMA) via ISO 6721-11:2019;
- Barcol testing via ASTM D2583:2013-03 or EN 59:2016.

6.9.2.7.1.3 The chemical compatibility of the liner and chemical contact surfaces of service equipment with the substances to be carried shall be demonstrated by one of the following methods. This demonstration shall account for all aspects of the compatibility of the materials of the shell and its equipment with the substances to be carried, including chemical deterioration of the shell, initiation of critical reactions of the contents and dangerous reactions between both.

(a) In order to establish any deterioration of the shell, representative samples taken from the shell, including any liners with welds, shall be subjected to the chemical compatibility test according to EN 977:1997 for a period of 1 000 hours at 50 °C or the maximum temperature at which a particular substance is approved for carriage. Compared with a virgin sample, the loss of strength and elasticity modulus measured by the bending test according to EN 978:1997 shall not exceed 25 %. Cracks, bubbles, pitting effects as well as separation of layers and liners and roughness shall not be acceptable;

(b) Certified and documented data of positive experiences on the compatibility of filling substances in question with the materials of the shell with which they come into contact at given temperatures, times and other relevant service conditions;

(c) Technical data published in relevant literature, standards or other sources, acceptable to the competent authority;

(d) Upon agreement with the competent authority other methods of chemical compatibility verification may be used.

6.9.2.7.1.4 Ball drop test as per EN 976-1:1997

The prototype shall be subjected to the ball drop test according to EN 976-1:1997, No. 6.6. No visible damage inside or outside the tank shall occur.

6.9.2.7.1.5 Fire resistance test

6.9.2.7.1.5.1 A representative prototype tank with its service and structural equipment in place and filled to 80 % of its maximum capacity with water, shall be exposed to a full engulfment in fire for 30 minutes, caused by an open heating oil pool fire or any other type of fire with the same effect. The fire shall be equivalent to a theoretical fire with a flame temperature of 800 °C, emissivity of 0.9 and to the tank a heat transfer coefficient of 10 W/(m²K) and surface absorptivity of 0.8. A minimum net heat flux of 75 kW/m² shall be calibrated according to ISO 21843:2018. The dimensions of the pool shall exceed those of the tank by at least 50 cm to each side and the distance between fuel level and tank shall be between 50 cm and 80 cm. The rest of the tank below liquid level, including openings and closures, shall remain leakproof except for drips.

6.9.2.8 ***Inspection and testing***

6.9.2.8.1 Inspection and testing of portable FRP tanks shall be carried out as per provisions of 6.7.2.19. In addition, welded thermoplastic liners shall be spark tested under a suitable standard, after pressure tests performed in accordance with the periodic inspections specified in 6.7.2.19.4.

6.9.2.8.2 In addition, the initial and periodic inspections shall follow the service life inspection programme and any associated inspection methods per 6.9.2.6.3.

6.9.2.8.3 The initial inspection and test shall verify that construction of the tank is made in accordance with the quality system required by 6.9.2.2.2.

6.9.2.8.4 Additionally, during inspection of the shell the position of the areas heated by heating elements shall be indicated or marked, be available on design drawings or shall be made visible by a suitable technique (e.g. infrared). Examination of the shell shall take into account the effects of overheating, corrosion, erosion, overpressure and mechanical overloading.

6.9.2.9 ***Retention of samples***

Shell samples (e.g. from manhole cut out) for each tank manufactured shall be maintained for future inspection and shell verification for a period of five years from the date of the initial inspection and test and until successful completion of the required five-year periodic inspection.

6.9.2.10 ***Marking***

6.9.2.10.1 The requirements of 6.7.2.20.1 apply to portable tanks with an FRP shell except those of 6.7.2.20.1 (f) (ii).

6.9.2.10.2 The information required in 6.7.2.20.1 (f) (i) shall be "Shell structural material: Fibre-reinforced plastic" the reinforcement fibre e.g. "Reinforcement: E-glass" and resin e.g. "Resin: Vinyl Ester".

6.9.2.10.3 Requirements of provision 6.7.2.20.2 apply to portable tank with an FRP shell.

CHAPTER 6.10

REQUIREMENTS FOR THE CONSTRUCTION, EQUIPMENT, TYPE APPROVAL, INSPECTION AND MARKING OF VACUUM-OPERATED WASTE TANKS

NOTE 1: For portable tanks and UN multiple-element gas containers (MEGCs) see Chapter 6.7; for fixed tanks (tank-vehicles), demountable tanks and tank containers and tank swap bodies, with shells made of metallic materials, and battery-vehicles and multiple element gas containers (MEGCs) other than UN MEGCs see Chapter 6.8; for fibre-reinforced plastic tanks see Chapter 6.9 or Chapter 6.13, as appropriate.

NOTE 2: This Chapter applies to fixed tanks, demountable tanks, tank-containers and tank swap bodies.

6.10.1 General

6.10.1.1 ***Definition***

NOTE: A tank which fully complies with the requirements of Chapter 6.8 is not considered to be a "vacuum-operated waste tank".

6.10.1.1.1 The term "*protected area*" means the areas located as follows:

(a) The lower part of the tank in a zone which extends over a 60° angle on either side of the lower generating line;

(b) The top part of the tank in a zone which extends over a 30° angle on either side of the top generating line;

(c) On the end front of the tank on motor vehicles;

(d) On the rear end of the tank inside the protection volume formed by the device stipulated in 9.7.6.

6.10.1.2 ***Scope***

6.10.1.2.1 The special requirements of 6.10.2 to 6.10.4 complete or modify Chapter 6.8 and are applied to vacuum-operated waste tanks.

Vacuum-operated waste tanks may be equipped with openable ends, if the requirements of Chapter 4.3 allow bottom discharge of the substances to be carried (indicated by letters "A" or "B" in Part 3 of the tank code given in Column (12) of Table A of Chapter 3.2, in accordance with 4.3.4.1.1).

Vacuum-operated waste tanks shall comply with all requirements of Chapter 6.8, except where overtaken by special requirements in this Chapter. However the requirements of 6.8.2.1.19, 6.8.2.1.20, and 6.8.2.1.21 shall not apply.

6.10.2 Construction

6.10.2.1 Tanks shall be designed for a calculation pressure equal to 1.3 times the filling or discharge pressure but not less than 400 kPa (4 bar) (gauge pressure). For the carriage of substances for which a higher calculation pressure of the tank is specified in Chapter 6.8, this higher pressure shall apply.

6.10.2.2 Tanks shall be designed to withstand a negative internal pressure of 100 kPa (1 bar).

6.10.3 Items of equipment

6.10.3.1 The items of equipment shall be so arranged as to be protected against the risk of being wrenched off or damaged during carriage or handling. This requirement can be fulfilled by placing the items of equipment in a so called "protected area" (see 6.10.1.1.1).

6.10.3.2 The bottom discharge of shells may be constituted by external piping with a stop-valve fitted as close to the shell as practicable and a second closure which may be a blank flange or other equivalent device.

6.10.3.3 The position and closing direction of the stop-valve(s) connected to the shell, or to any compartment in the case of compartmented shells, shall be unambiguous, and be able to be checked from the ground.

6.10.3.4 In order to avoid any loss of contents in the event of damage to the external filling and discharge fittings (pipes, lateral shut-off devices), the internal stop-valve, or the first external stop-valve (where applicable), and its seatings shall be protected against the danger of being wrenched off by external stresses or shall be so designed as to withstand them. The filling and discharge devices (including flanges or threaded plugs) and protective caps (if any) shall be capable of being secured against any unintended opening.

6.10.3.5 The tanks may be equipped with openable ends. Openable ends shall comply with the following conditions:

(a) The ends shall be designed to be secured leaktight when closed;

(b) Unintentional opening shall not be possible;

(c) Where the opening mechanism is power operated the end shall remain securely closed in the event of a power failure;

(d) A safety or breakseal device shall be incorporated to ensure that the openable end cannot be opened when there is still a residual over pressure in the tank. This requirement does not apply to openable ends which are power-operated, where the movement is positively controlled. In this case the controls shall be of the dead-man type and be so positioned that the operator can observe the movement of the openable end at all times and is not endangered during opening and closing of the openable end; and

(e) Provisions shall be made to protect the openable end and prevent it from being forced open during a roll-over of the vehicle, tank-container or tank swap body.

6.10.3.6 Vacuum-operated waste tanks which are fitted with an internal piston to assist in the cleaning of the tank or discharging shall be provided with stop-devices to prevent the piston in every operational position being ejected from the tank when a force equivalent to the maximum working pressure of the tank is applied to the piston. The maximum working pressure for tanks or compartments with pneumatic operated piston shall not exceed 100 kPa (1.0 bar). The internal piston shall be constructed in a manner and of materials which will not cause an ignition source when the piston is moved.

The internal piston may be used as a compartment provided it is secured in position. Where any of the means by which the internal piston is secured is external to the tank, it shall be placed in a position not liable to accidental damage.

6.10.3.7 The tanks may be equipped with suction booms if:

(a) The boom is fitted with an internal or external stop-valve fixed directly to the shell, or directly to a bend that is welded to the shell; a rotation crown wheel can be fitted between the shell or the bend and the external stop valve, if this rotation crown wheel is located in the protected area and the stop-valve control device is protected with a housing or cover against the danger of being wrenched off by external loads;

(b) The stop-valve mentioned in (a) is so arranged that carriage with the valve in an open position is prevented; and

(c) The boom is constructed in such a way that the tank will not leak as a result of accidental impact on the boom.

6.10.3.8 The tanks shall be fitted with the following additional service equipment:

(a) The outlet of a pump/exhauster unit shall be so arranged as to ensure that any flammable or toxic vapours are diverted to a place where they will not cause a danger;

NOTE: *This requirement may, for example, be complied with by the use of a vertical pipe discharging at the top, or a low-level outlet with a connection which allows attachment of a hose.*

(b) A device to prevent immediate passage of flame shall be fitted to all openings of a vacuum pump/exhauster unit which may provide a source of ignition and which is fitted on a tank used for the carriage of flammable wastes, or the tank shall be explosion pressure shock resistant, which means being capable of withstanding without leakage, but allowing deformation, an explosion resulting from the passage of the flame;

(c) Pumps which can deliver a positive pressure shall have a safety device fitted in the pipework which can be pressurised. The safety device shall be set to discharge at a pressure not exceeding the maximum working pressure of the tank;

(d) A stop-valve shall be fitted between the shell, or the outlet of the overfill prevention device fitted to the shell, and the pipework connecting the shell to the pump/exhauster unit;

(e) The tank shall be fitted with a suitable pressure/vacuum manometer which shall be mounted in a position where it can be easily read by the person operating the pump/exhauster unit. A distinguishing line shall be marked on the scale to indicate the maximum working pressure of the tank;

(f) The tank, or in case of compartmented tanks, every compartment, shall be equipped with a level indicating device. Glass level-gauges and level-gauges of other suitable transparent material may be used as level indicating devices provided:

(i) they form a part of the tank wall and have a resistance to the pressure comparable to that of the tank; or they are fitted external to the tank;

(ii) the top and bottom connections to the tank are equipped with shut-off valves fixed directly to the shell and so arranged that carriage with the valves in an open position is prevented;

(iii) are suitable for operation at the maximum working pressure of the tank; and

(iv) are placed in a position where they will not be liable to accidental damage.

6.10.3.9 The shells of vacuum-operated waste tanks shall be fitted with a safety valve preceded by a bursting disc.

The valve shall be capable of opening automatically at a pressure between 0.9 and 1.0 times the test pressure of the tank to which it is fitted. The use of dead weight or counterweight valves is prohibited.

The bursting disc shall burst at the earliest when the initial opening pressure of the valve is reached and at the latest when this pressure reaches the test pressure of the tank to which it is fitted.

Safety devices shall be of such a type as to resist dynamic stresses, including liquid surge.

The space between the bursting disc and the safety valve shall be provided with a pressure gauge or suitable tell-tale indicator for the detection of disc rupture, pinholing or leakage wich could cause a malfunction of the safety valve.

6.10.4 Inspection

Vacuum-operated waste tanks shall be subject no later than every three years for fixed tanks or demountable tanks and no later than every two and a half years for tank-containers and tank swap bodies to an examination of the internal condition, in addition to the inspection according to 6.8.2.4.3.