CHAPTER 6.2

REQUIREMENTS FOR THE CONSTRUCTION AND TESTING OF RECEPTACLES FOR GASES, AEROSOL DISPENSERS AND SMALL RECEPTACLES CONTAINING GAS (GAS CARTRIDGES)

6.2.1 General requirements for receptacles for gases

NOTE: *For aerosol dispensers and small receptacles containing gas (gas cartridges) see 6.2.4.*

6.2.1.1 *Design and construction*

6.2.1.1.1 Receptacles and their closures shall be designed, calculated, manufactured, tested and equipped in such a way as to withstand all conditions to which they will be subjected during their normal use and during normal conditions of carriage.

In the design of pressure receptacles, all relevant factors shall be taken into account such as:

- internal pressure;
- ambient and operational temperatures, including during carriage;
- dynamic loads.

Normally the wall thickness shall be determined by calculation, accompanied, if needed, by experimental stress analysis. The wall thickness may be determined by experimental means.

Appropriate design calculations for the pressure envelope and supporting components shall be used to ensure the safety of the receptacles concerned.

The minimum wall thickness to withstand pressure shall be calculated in particular with regard to:

- the calculation pressures, which shall not be less than the test pressure;
- the calculation temperatures allowing for appropriate safety margins;
- the maximum stresses and peak stress concentrations where necessary;
- factors inherent to the properties of the material.

The test pressure of receptacles is prescribed in packing instruction P200 in 4.1.4.1 for cylinders, tubes, pressure drums and bundles of cylinders. The test pressure for cryogenic receptacles, closed, shall not be less than 1.3 times the maximum working pressure increased by 1 bar for vacuum insulated receptacles.

Material characteristics to be considered are, when applicable:

- yield stress;

- tensile strength;

- time-dependent strength;

- fatigue data;

- Young's modulus (modulus of elasticity);

- appropriate amount of plastic strain;

- impact strength;

- fracture resistance.

6.2.1.1.2 Receptacles for UN No.1001, acetylene, dissolved, shall be filled entirely with a porous material, uniformly distributed, of a type approved by the competent authority and which:

(a) does not attack the receptacles or form harmful or dangerous compounds either with the acetylene or with the solvent;

(b) is capable of preventing the spread of decomposition of the acetylene in the mass.

The solvent shall not attack the receptacles.

6.2.1.2 ***Materials of receptacles***

The materials of which the receptacles and their closures are made as well as all substances that might come into contact with the contents shall not be liable to attack the contents or form harmful or dangerous compounds therewith.

The following materials may be used:

(a) carbon steel for compressed, liquefied, refrigerated liquefied gases and gases dissolved under pressure;

(b) alloy steel (special steels), nickel, nickel alloy (such as monel) for compressed, liquefied, refrigerated liquefied gases and gases dissolved under pressure;

(c) copper for:

(i) gases of classification codes 1A, 1O, 1F and 1TF, whose filling pressure referred to a temperature of 15 °C does not exceed 2 MPa (20 bar);

(ii) gases of classification code 2A and also UN No. 1033 dimethyl ether; UN No.1037 ethyl chloride; UN No.1063 methyl chloride; UN

No.1079 sulphur dioxide; UN No.1085 vinyl bromide; UN No. 1086 vinyl chloride; and UN No.3300 ethylene oxide and carbon dioxide mixture with more than 87% ethylene oxide;

(iii) gases of classification codes 3A, 3O and 3F;

(d) aluminium alloy: see special requirement "a" of packing instruction P200 (12) in 4.1.4.1;

(e) composite material for compressed, liquefied, refrigerated liquefied gases and gases dissolved under pressure;

(f) synthetic materials for refrigerated liquefied gases; and

(g) glass for the refrigerated liquefied gases of classification code 3A other than UN No.2187 carbon dioxide, refrigerated, liquid or mixtures thereof, and gases of classification code 3O.

6.2.1.3 ***Service equipment***

6.2.1.3.1 *Openings*

Apart from a manhole which, if provided, shall be closed by an effective closure and apart from the necessary orifice for the removal of deposits, pressure drums shall not be equipped with more than two openings one for the filling and one for the discharge.

Cylinders and pressure drums, intended for the carriage of gases of classification code 2F may be provided with other openings intended in particular for verifying the level of the liquid and the gauge pressure.

6.2.1.3.2 *Fittings*

(a) If cylinders are fitted with a device to prevent rolling, this device shall not be integral with the valve cap;

(b) Pressure drums which are capable of being rolled shall be equipped with rolling hoops or be otherwise protected against damage due to rolling (e.g. by corrosion resistant metal sprayed on to the receptacle surface);

(c) Pressure drums and cryogenic receptacles, which are not capable of being rolled, shall be fitted with devices (skids, rings, straps,) ensuring that they can be safely handled by mechanical means and so arranged as not to impair the strength of, nor cause undue stresses in, the wall of the receptacle;

(d) Bundles of cylinders shall be fitted with appropriate devices ensuring that they can be handled and carried safely. The manifold shall have at least the same test pressure as the cylinders. The manifold and the master cock shall be situated so as to be protected against any damage.

6.2.1.3.3 *Safety valves*

Cryogenic receptacles, closed, shall be fitted with one or more pressure relief devices to protect the vessel against excess pressure. Excess pressure means a pressure in excess of 110% of the maximum working pressure due to normal heat leak or in excess of the test pressure due to the loss of vacuum for vacuum insulated receptacles or due to the failure in the open position of a pressure build up system.

6.2.1.4 ***Approval of receptacles***

6.2.1.4.1 The conformity of receptacles, having a test pressure capacity product of more than 150 MPa.litre (1 500 bar.litre) with the provisions of Class 2, shall be assessed by one of the following methods:

(a) Single receptacles shall be examined, tested and approved by a testing and certifying body approved by the competent authority of the country of approval [1], on the basis of the technical documentation and declaration of the manufacturer on compliance with the relevant provisions of Class 2.

The technical documentation shall include full specifications on design and construction, and full documentation on the manufacturing and testing; or

(b) The construction of the receptacles shall be tested and approved by a testing and certifying body approved by the competent authority of the country of approval [1] on the basis of the technical documentation with regard to their compliance with the relevant provisions of Class 2.

Receptacles shall furthermore be designed, manufactured and tested according to a comprehensive quality assurance programme for design, manufacture, final inspection and testing. The quality assurance programme shall guarantee the conformity of the receptacles with the relevant provisions of Class 2 and shall be approved and supervised by a testing and certifying body approved by the competent authority of the country of approval [1]; or

(c) The design type of the receptacles shall be approved by a testing and certifying body approved by the competent authority of the country of approval [1]. Any receptacle of this design shall be manufactured and tested according to a quality assurance programme for production, final inspection and testing, which shall be approved and supervised by a testing and certifying body approved by the competent authority of the country of approval [1]; or

(d) The design type of the receptacles shall be approved by a testing and certifying body approved by the competent authority of the country of approval [1]. Any receptacle of this design shall be tested under the supervision of a testing and certifying body approved by the competent authority of the country of approval [1] on the basis of a declaration of the manufacturer on compliance with the approved design and the relevant provisions of Class 2.

[1] *If the country of approval is not a contracting party to ADR, the competent authority of a contracting party to ADR.*

6.2.1.4.2 The conformity of receptacles having a test pressure capacity product of more than 30 MPa.litre (300 bar.litre) and not more than 150 MPa.litre (1 500 bar.litre) with the provisions of Class 2 shall be assessed by one of the methods described in 6.2.1.4.1 or by one of the following methods:

(a) The receptacles shall be designed, manufactured and tested according to a comprehensive quality assurance programme for their design, manufacture, final inspection and testing, approved and supervised by a testing and certifying body approved by the competent authority of the country of approval [1]; or

(b) The design type of the receptacle shall be approved by a testing and certifying body approved by the competent authority of the country of approval [1]. The compliance of any receptacle with the approved design shall be declared in writing by the manufacturer on the basis of his quality assurance programme for final inspection and testing of receptacles, approved and supervised by a testing and certifying body approved by the competent authority of the country of approval [1]; or

(c) The design type of the receptacle shall be approved by a testing and certifying body approved by the competent authority of the country of approval [1]. The compliance of any receptacle with the approved design shall be declared in writing by the manufacturer and all receptacles of this type shall be tested under the supervision of a testing and certifying body approved by the competent authority of the country of approval[1];

6.2.1.4.3 The conformity of receptacles, having a test pressure capacity product of not more than 30 MPa.litre (300 bar.litre) with the provisions for Class 2 shall be assessed by one of the methods described in 6.2.1.4.1 or 6.2.1.4.2 or by one of the following methods:

(a) The compliance of any receptacle with a design, fully specified in technical documentation, shall be declared in writing by the manufacturer and receptacles of this design shall be tested under the supervision of a testing and certifying body approved by the competent authority of the country of approval [1]; or

(b) The design type of the receptacles shall be approved by a testing and certifying body approved by the competent authority of the country of approval [1]. The compliance of all receptacles with the approved design shall be declared in writing by the manufacturer and all receptacles of this type shall be tested individually.

6.2.1.4.4 The requirements of 6.2.1.4.1 to 6.2.1.4.3 shall be deemed to be complied with:

(a) as regards the quality assurance systems mentioned in 6.2.1.4.1 and 6.2.1.4.2, if they conform to the relevant European Standard of the EN ISO 9000 series;

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[1] *If the country of approval is not a contracting party to ADR, the competent authority of a contracting party to ADR.*

(b) in their entirety, if the relevant conformity assessment procedures of Council Directive 99/36/EC [2] have been complied with as follows:

(i) for the receptacles listed under 6.2.1.4.1, the modules G, or H1, or B in combination with D, or B in combination with F;

(ii) for the receptacles listed under 6.2.1.4.2, the modules H, or B in combination with E, or B in combination C1, or B1 in combination with F, or B1 in combination with D;

(iii) for the receptacles listed under 6.2.1.4.3, the modules A1, or D1, or E1.

6.2.1.4.5 *Requirements for manufacturers*

The manufacturer shall be technically competent and shall possess all suitable means required for the satisfactory manufacture of receptacles; this relates in particular to qualified personnel:

(a) to supervise the entire manufacturing process;

(b) to carry out joining of materials;

(c) to carry out the relevant tests.

The proficiency test of a manufacturer shall in all instances be carried out by a testing and certifying body approved by the competent authority of the country of approval [1]. The particular certification process the manufacturer intends to apply shall be taken into consideration.

6.2.1.4.6 *Requirements for testing and certifying bodies*

Testing and certifying bodies shall be independent from manufacturing enterprises and technologically competent to the degree required. These requirements shall be deemed to be met if the bodies have been approved on the basis of an accreditation procedure in accordance with the relevant European standards of series EN 45 000.

6.2.1.5 *Initial inspection*

6.2.1.5.1 Receptacles shall be subjected to initial inspection in accordance with the following specifications:

On an adequate sample of receptacles:

(a) Testing of the material of construction in respect at least of yield stress, tensile strength, and permanent elongation at fracture;

(b) Measurement of wall thickness at the thinnest point, and calculation of the stress;

[2] *Council Directive 99/36/EC concerning transportable pressure equipment (Official Journal of the European Communities, No. L 138 of 1.06.1999).*

(c) Checking the homogeneity of the material for each manufacturing batch, and examination of the external and internal condition of the receptacles;

For all receptacles:

(d) A hydraulic pressure test. Receptacles shall withstand the test pressure without undergoing permanent deformation or exhibiting cracks;

NOTE: *With the agreement of the testing and certifying body approved by the competent authority of the country of approval [1], the hydraulic pressure test may be replaced by a test using a gas, where such operation does not entail any danger.*

(e) An examination of the markings on the receptacles, see 6.2.1.7;

(f) In addition, receptacles intended for the carriage of UN No. 1001 acetylene, dissolved, shall have an inspection of the nature of the porous material and the quantity of solvent.

6.2.1.5.2 *Specific provisions applying to aluminium alloy receptacles*

(a) In addition to the initial inspection required by 6.2.1.5.1, it is necessary to test for possible intercrystalline corrosion of the inside wall of the receptacles where use is made of an aluminium alloy containing copper, or where use is made of an aluminium alloy containing magnesium and manganese and the manganese content is greater than 3.5% or the manganese content lower than 0.5%.

(b) In the case of an aluminium/copper alloy the test shall be carried out by the manufacturer at the time of approval of a new alloy by the competent authority; it shall thereafter be repeated in the course of production, for each pour of the alloy.

(c) In the case of an aluminium/magnesium alloy the test shall be carried out by the manufacturer at the time of approval of a new alloy and of the manufacturing process by the competent authority. The test shall be repeated whenever a change is made in the composition of the alloy or in the manufacturing process.

6.2.1.6 ***Periodic inspection***

6.2.1.6.1 Refillable receptacles shall be subjected to periodic inspections under the supervision of a testing and certifying body approved by the competent authority of the country of approval [1], in accordance with the periodicities defined in the relevant packing instruction P200 or P203 in 4.1.4.1 and in accordance with the following specifications:

(a) External examination of the receptacle, equipment and markings;

[1] *If the country of approval is not a contracting party to ADR, the competent authority of a contracting party to ADR.*

[1] *If the country of approval is not a contracting party to ADR, the competent authority of a contracting party to ADR.*

(b) Internal examination of the receptacle (e.g. by weighing, examination of the internal condition, checks of wall thickness);

(c) The hydraulic pressure test and, if necessary, inspection of the characteristics of the material by suitable tests;

***NOTE 1**: With the agreement of the testing and certifying body approved by the competent authority of the country of approval [1], the hydraulic pressure test may be replaced by a test using a gas, where such operation does not entail any danger, or by an equivalent method based on ultrasound.*

***NOTE 2**: With the agreement of the testing and certifying body approved by the competent authority of the country of approval [1], the hydraulic pressure test of cylinders and tubes may be replaced by an equivalent method based on acoustic emission.*

***NOTE 3**: With the agreement of the testing and certifying body approved by the competent authority of the country of approval [1], the hydraulic pressure test of each welded steel cylinder intended for the carriage of gases of UN No.1965, hydrocarbon gas mixture liquefied, n.o.s., with a capacity below 6,5 l may be replaced by another test ensuring an equivalent level of safety.*

6.2.1.6.2 For receptacles intended for the carriage of UN No.1001 acetylene, dissolved, only the external condition (corrosion, deformation) and the condition of the porous mass (loosening, settlement) shall be examined.

6.2.1.6.3 By derogation from 6.2.1.6.1 (c) closed cryogenic receptacles shall be subjected to external inspection and to a leakproofness test. The leakproofness test shall be carried out with the gas contained in the receptacle or with an inert gas. Checking shall be performed by means of a pressure gauge or by vacuum measurement. The thermal insulation need not be removed.

6.2.1.7 ***Marking of receptacles***

6.2.1.7.1 Refillable receptacles shall bear the following particulars in clearly legible and durable characters:

(a) The manufacturer's name or mark;

(b) The approval number (if the design type of the receptacle is approved according to 6.2.1.4);

(c) The manufacturer's serial number;

(d) The tare of the receptacle without fittings and accessories, when the check of wall thickness required during the periodic inspection is performed by weighing;

(e) The test pressure (gauge pressure);

(f) The date (month and year) of the initial inspection and the most recent periodic inspection;

***NOTE**: The month need not be indicated for gases for which the interval between periodic inspection is 10 years or more (see 4.1.4.1 packing instructions P200 (9) and P203 (8)).*

(g) The stamp of the expert who carried out the tests and inspections;

(h) In the case of UN No.1001 acetylene, dissolved: the permitted filling pressure (see 4.1.4.1, packing instruction P200 (6)) and the total of the mass of: the empty receptacle, the fittings and accessories, the porous mass and the solvent;

(i) The water capacity in litres;

(j) For compressed gases filled by pressure, the maximum filling pressure at 15 °C allowed for the receptacle.

These marks shall be immovably affixed, e.g. engraved, either on a reinforced part of the receptacle, on a ring, or on immovably affixed attachments.

They can also be engraved on the receptacle directly, provided it can be demonstrated that the strength of the receptacle is not impaired by the marking.

***NOTE**: See also 5.2.1.6*

6.2.1.7.2 Non-refillable receptacles shall bear the following particulars in clearly legible and durable characters:

(a) The manufacturer's name or mark;

(b) The approval number (if the design type of the receptacle is approved according to 6.2.1.4);

(c) The manufacturer's serial or batch number;

(d) The test pressure (gauge pressure);

(e) The date (month and year) of manufacture;

(f) The stamp of the expert who carried out the initial inspection;

(g) The UN number and the proper shipping name as determined in accordance with Chapter 3.1;

In the case of gases classified under an N.O.S. entry, only the UN number and the technical name [3] of the gas have to be indicated;

[3] *Instead of the technical name the use of one 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;*

In the case of mixtures, not more than the two constituents which most predominantly contribute to the hazards have to be indicated;

(h) The words '**DO NOT REFILL**"; this marking shall be a minimum of 6 mm in height.

The marks mentioned in this paragraph, other than (g), shall be immovably affixed, e.g. engraved, either on a reinforced part of the receptacle, on a ring, or on immovably affixed attachments. They can also be engraved on the receptacle directly, provided it can be demonstrated that the strength of the receptacle is not impaired by the marking.

6.2.2 Receptacles designed, constructed and tested according to standards

The requirements of 6.2.1 are considered to have been complied with if the following standards, as relevant, are applied:

Reference	Title of document	Applicable sub-sections and paragraphs
for materials		
EN 1797-1:1998	Cryogenic vessels -Gas/material compatibility - Part 1: Oxygen compatibility.	6.2.1.2
EN ISO 11114-1:1997	Transportable gas cylinders - Compatibility of cylinder and valve materials with gas contents -Part 1: Metallic materials.	6.2.1.2
EN ISO 11114-2:2000	Transportable gas cylinders - Compatibility of cylinder and valve materials with gas contents -Part 2: Non-metallic materials.	6.2.1.2
EN 1252-1: 1998	Cryogenic vessels – Materials - Part 1: Toughness requirements for temperature below -80 °C.	6.2.1.2
for cylinders		
Annex I, Parts 1 to 3 to 84/525/EEC	Council directive on the approximation of the laws of the Member States relating to seamless steel gas cylinders.	6.2.1.1 and 6.2.1.5
Annex I, Parts 1 to 3 to 84/526/EEC	Council directive on the approximation of the laws of the Member States relating to seamless, unalloyed aluminium and aluminium alloy gas cylinders.	6.2.1.1 and 6.2.1.5
Annex I, Parts 1 to 3 to 84/527/EEC	Council directive on the approximation of the laws of the Member States relating to welded unalloyed steel gas cylinders.	6.2.1.1 and 6.2.1.5
EN 1442:1998	Transportable refillable welded steel cylinders for liquefied petroleum gas (LPG) - Design and construction.	6.2.1.1, 6.2.1.5 and 6.2.1.7
EN 1800:1998/AC: 1999	Transportable gas cylinders - Acetylene cylinders - Basic requirements and definitions.	6.2.1.1.2
EN 1964-1:1999	Transportable gas cylinders – Specifications for the design and construction of refillable transportable seamless steel gas cylinders of capacity from 0.5 litres up to 150 litres – Part 1: Cylinders made of seamless steel with a Rm value of less than	6.2.1.1 and 6.2.1.5

- *For UN No. 1965 hydrocarbon gas mixture, liquefied, n.o.s.: mixture A or butane, mixture A01 or butane, mixture A02 or butane, mixture A0 or butane, mixture A1, mixture B1, mixture B2, mixture B, mixture C or propane.*

Reference	Title of document	Applicable sub-sections and paragraphs
	1 100 MPa.	
EN 1975:1999 (except Annex G)	Transportable gas cylinders – Specifications for the design and construction of refillable transportable seamless aluminium and aluminium alloy gas cylinders of capacity from 0.5 litres up to 150 litres.	6.2.1.1 and 6.2.1.5
EN ISO 11120:1999	Gas cylinders – Refillable seamless steel tubes for compressed gas transport of water capacity between 150 litres and 3 000 litres – Design, construction and testing.	6.2.1.1 and 6.2.1.5
EN 1964-3: 2000	Transportable gas cylinders-Specifications for the design and construction of refillable transportable seamless steel gas cylinders of capacity from 0.5 litre up to 150 litres - Part 3: Cylinders made of stainless steel.	6.2.1.1 and 6.2.1.5
EN 12862: 2000	Transportable gas cylinders- Specifications for the design and construction of refillable transportable welded aluminium alloy gas cylinders.	6.2.1.1 and 6.2.1.5
EN 1251-1: 2000	Cryogenic vessels- Transportable, vacuum insulated, of not more than 1 000 litres volume- Part 1: Fundamental requirements	6.2.1.7.1
EN 1251-2: 2000	Cryogenic vessels- Transportable, vacuum insulated, of not more than 1000 litres volume- Part 2: Design, fabrication, inspection and testing	6.2.1.1 and 6.2.1.5
EN 1251-3: 2000	Cryogenic vessels- Transportable, vacuum insulated, of not more than 1 000 litres volume- Part 3: Operational requirements	6.2.1.6
for closures		
EN 849:1996 (except Annex A)	Transportable gas cylinders - Cylinder valves: Specification and type testing	6.2.1.1
for markings		
EN 1089-1: 1996	Transportable gas cylinders - Gas cylinder identification (excluding LPG) - Part 1: Stampmarking	6.2.1.7.1 except (b) and 6.2.1.7.2 except (b)

6.2.3 Requirements for receptacles not designed, constructed and tested according to standards

Receptacles not designed, constructed and tested according to standards listed in the table of 6.2.2 shall be designed, constructed and tested in accordance with the provisions of a technical code providing the same level of safety and recognised by the competent authority. The requirements of 6.2.1 and the following requirements however shall be met:

6.2.3.1 *Metal cylinders, tubes, pressure drums and bundles of cylinders*

At the test pressure, the stress in the metal at the most severely stressed point of the receptacle shall not exceed 77% of the guaranteed minimum yield stress (Re).

"Yield stress" means the stress at which a permanent elongation of 2 per thousand (i.e. 0.2%) or, for austenitic steels, 1% of the gauge length on the test-piece, has been produced.

NOTE: *In the case of sheet-metal the axis of the tensile test-piece shall be at right angles to the direction of rolling. The permanent elongation at fracture, shall be measured on a test-piece of circular cross-section in which the gauge length "l" is equal to five times the diameter "d" (l=5d); if test pieces of rectangular cross-section are used, the gauge length "l" shall be calculated by the formula:*

$$l = 5.65\sqrt{Fo}$$

where Fo indicates the initial cross-sectional area of the test-piece.

Receptacles and their closures shall be made of suitable materials which shall be resistant to brittle fracture and to stress corrosion cracking between -20 °C and +50 °C.

For welded receptacles only materials of faultless weldability whose adequate impact strength at an ambient temperature of -20 °C can be guaranteed, particularly in the weld seams and the zones adjacent thereto, shall be used.

Welds shall be skilfully made and shall afford the fullest safety.

Any additional thickness to allow for corrosion shall not be taken into consideration in calculating the thickness of the walls.

6.2.3.2 ***Additional provisions relating to aluminium-alloy receptacles for compressed gases, liquefied gases, gases dissolved under pressure and non pressurized gases subject to special requirements (gas samples) as well as articles containing gas under pressure other than aerosol dispensers and small receptacles containing gas (gas cartridges)***

6.2.3.2.1 *The materials of aluminium-alloy receptacles which are to be accepted shall satisfy the following requirements:*

	A	**B**	**C**	**D**
Tensile strength, Rm, in MPa (=N/mm^2)	49 to 186	196 to 372	196 to 372	343 to 490
Yield stress, Re, in MPa (=N/mm^2) (permanent set λg = 0.2%)	10 to 167	59 to 314	137 to 334	206 to 412
Permanent elongation at fracture (l = 5d) in per cent	12 to 40	12 to 30	12 to 30	11 to 16
Bend test (diameter of former d = n H e, where e is the thickness of the test piece)	n=5(Rm ≤ 98) n=6(Rm>98)	n=6(Rm ≤ 325) n=7(Rm >325)	n=6(Rm ≤ 325) n=7(Rm>325)	n=7(Rm ≤ 392) n=8(Rm>392)
Aluminium Association Series Number [a]	1 000	5 000	6 000	2 000

[a] *See "Aluminium Standards and Data", Fifth edition, January 1976, published by the Aluminium Association, 750 Third Avenue, New York.*

The actual properties will depend on the composition of the alloy concerned and on the final treatment of the receptacle, but whatever alloy is used the thickness of the receptacle shall be calculated by one of the following formulae:

$$e = \frac{P_{MPa}\ D}{\frac{2Re}{1.3} + P_{MPa}} \quad or \quad e = \frac{P_{bar}\ D}{\frac{20Re}{1.3} + P_{bar}}$$

where e = minimum thickness of receptacle wall, in mm;
P_{MPa} = test pressure, in MPa
P_{bar} = test pressure, in bar
D = nominal external diameter of the receptacle, in mm; and
Re = guaranteed minimum proof stress with 0.2 % proof stress, in MPa ($=N/mm^2$)

In addition, the value of the minimum guaranteed proof stress (Re) introduced into the formula is in no case to be greater than 0.85 times the guaranteed minimum tensile strength (Rm), whatever the type of alloy used.

NOTE 1: *The above characteristics are based on previous experience with the following materials used for receptacles:*

Column A: Aluminium, unalloyed, 99.5 g pure;

Column B: Alloys of aluminium and magnesium;

Column C: Alloys of aluminium, silicon and magnesium, such as ISO/R209-Al-Si-Mg (Aluminium Association 6351);

Column D: Alloys of aluminium, copper and magnesium;

NOTE 2: *The permanent elongation at fracture is measured by means of test-pieces of circular cross-section in which the gauge length "l" is equal to five times the diameter "d" (l= 5d); if test-pieces of rectangular section are used the gauge length shall be calculated by the formula:*

$$l = 5.65\sqrt{Fo}$$

where Fo is the initial cross-section area of the test-piece.

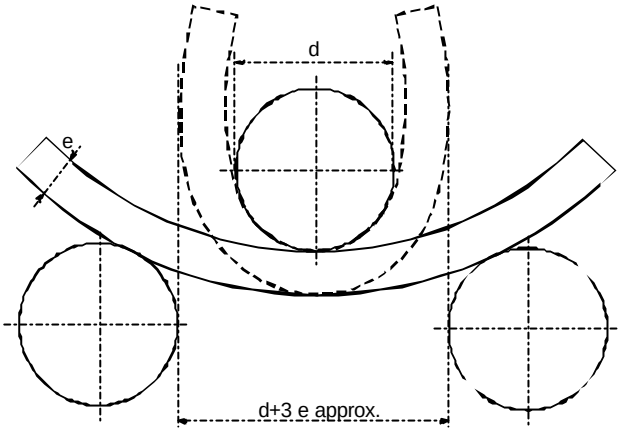
NOTE 3: *(a) The bend test (see diagram) shall be carried out on specimens obtained by cutting into two equal parts of width 3e, but in no case less than 25 mm, an annular section of a cylinder. The specimens shall not be machined elsewhere than on the edges.*

(b) The bend test shall be carried out between a mandrel of diameter (d) and two circular supports separated by a distance of (d + 3e). During the test the inner faces shall be separated by a distance not greater than the diameter of the mandrel.

(c) The specimen shall not exhibit cracks when it has been bent inwards around the mandrel until the inner faces are separated by a distance not greater than the diameter of the mandrel.

(d) The ratio (n) between the diameter of the mandrel and the thickness of the specimen shall conform to the values given in the table.

Diagram of bend test



6.2.3.2.2 A lower minimum elongation value is acceptable on condition that an additional test approved by the competent authority of the country in which the receptacles are made proves that safety of carriage is ensured to the same extent as in the case of receptacles constructed to comply with the characteristics given in the table in 6.2.3.2.1 (see also annex G of EN 1975: 1999).

6.2.3.2.3 The wall thickness of the receptacles at the thinnest point shall be the following:

- where the diameter of the receptacle is less than 50 mm: not less than 1.5 mm;
- where the diameter of the receptacle is from 50 to 150 mm: not less than 2 mm; and
- where the diameter of the receptacle is more than 150 mm: not less than 3 mm.

6.2.3.2.4 The ends of the receptacles shall have a semicircular, elliptical or "basket-handle" section; they shall afford the same degree of safety as the body of the receptacle.

6.2.3.3 ***Receptacles in composite materials***

For composite cylinders, tubes, pressure drums and bundles of cylinders which make use of composite materials i.e. comprising a liner hoop wrapped or fully wrapped with reinforcement material, the construction shall be such that a minimum burst ratio (burst pressure divided by test pressure) is:

- 1.67 for hoop wrapped receptacles;
- 2.00 for fully wrapped receptacles.

6.2.3.4 ***Closed cryogenic receptacles***

The following requirements apply to the construction of closed cryogenic receptacles for refrigerated liquefied gases:

6.2.3.4.1 All the mechanical and technological characteristics of the metal used shall be established for each receptacle at the initial inspection; with regard to the impact strength, see 6.8.5.3;

6.2.3.4.2 If other materials are used, they shall resist brittle fracture at the lowest working temperature of the receptacle and its fittings;

6.2.3.4.3 Receptacles shall be fitted with a safety valve which shall be capable of opening at the working pressure shown on the receptacle. The valves shall be so constructed as to work perfectly even at their lowest working temperature. Their reliability of functioning at that temperature shall be established and checked by testing each valve or a sample of valves of the same type of construction;

6.2.3.4.4 The vents and safety valves of receptacles shall be so designed as to prevent the liquid from splashing out;

6.2.3.4.5 Receptacles whose filling is measured by volume shall be provided by a level indicator;

6.2.3.4.6 The receptacles shall be thermally insulated. The thermal insulation shall be protected against impact by means of continuous sheathing. If the space between the receptacle and the sheathing is airless (vacuum-insulation), the protective sheathing shall be designed to withstand without deformation an external pressure of at least 100 kPa (1 bar). If the sheathing is so closed as to be gas-tight (e.g. in the case of vacuum-insulation), 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 receptacle or its fittings. The device shall prevent moisture from penetrating into the insulation.

6.2.4 General requirements for aerosol dispensers and small receptacles containing gas (gas cartridges)

6.2.4.1 *Design and construction*

6.2.4.1.1 Aerosol dispensers (UN No.1950 aerosols) containing only a gas or a mixture of gases, and small receptacles containing gas (gas cartridges) (UN No.2037), shall be made of metal. This requirement shall not apply to aerosols and small receptacles containing gas (gas cartridges) with a maximum capacity of 100 ml for UN No. 1011 butane. Other aerosol dispensers (UN No.1950 aerosols) shall be made of metal, synthetic material or glass. Receptacles made of metal and having an outside diameter of not less than 40 mm shall have a concave bottom.

6.2.4.1.2 The capacity of receptacles made of metal shall not exceed 1 000 ml; that of receptacles made of synthetic material or of glass shall not exceed 500 ml.

6.2.4.1.3 Each model of receptacles (aerosol dispensers or cartridges) shall, before being put into service, satisfy a hydraulic pressure test carried out in conformity with 6.2.4.2.

6.2.4.1.4 The release valves and dispersal devices of aerosol dispensers (UN No.1950 aerosols) and the valves of UN No.2037 small receptacles containing gas (gas cartridges) shall ensure that the receptacles are so closed as to be leakproof and shall

be protected against accidental opening. Valves and dispersal devices which close only by the action of the internal pressure are not to be accepted.

6.2.4.2 ***Initial testing***

6.2.4.2.1 The internal pressure to be applied (test pressure) shall be 1.5 times the internal pressure at 50 °C, with a minimum pressure of 1 MPa (10 bar).

6.2.4.2.2 The hydraulic pressure tests shall be carried out on at least five empty receptacles of each model:

(a) until the prescribed test pressure is reached, by which time no leakage or visible permanent deformation shall have occurred; and

(b) until leakage or bursting occurs; the dished end, if any, shall yield first and the receptacle shall not leak or burst until a pressure 1.2 times the test pressure has been reached or passed.

6.2.4.3 ***Reference to standards***

The requirements of this section are deemed to be met if the following standards are complied with:

- for aerosol dispensers (UN No. 1950 aerosols): Annex to Council Directive 75/324/EEC [4] as amended by Commission Directive 94/1/EC [5];

- for UN No.2037, small recipients containing gas (gas cartridges) containing UN No. 1965, hydrocarbon gas mixture n.o.s, liquefied: EN 417:1992 Non-refillable metallic gas cartridges for liquefied petroleum gases, with or without a valve, for use with portable appliances - Construction, inspection, testing and marking.

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[4] *Council Directive 75/324/EEC of 20 May 1975 on the approximation of the laws of the Member States relating to aerosol dispensers, published in the Official Journal of the European Communities No. L 147 of 9.06.1975.*

[5] *Commission Directive 94/1/EC of January 1994, adapting some technicalities of Council Directive 75/324/EEC on the approximation of the laws of the relating Member States to aerosol dispensers published in the Official Journal of the European Communities No. L 23 of 28.01.1994.*

CHAPTER 6.3

REQUIREMENTS FOR THE CONSTRUCTION AND TESTING OF PACKAGINGS FOR CLASS 6.2 SUBSTANCES

NOTE: *The requirements of this Chapter don't apply to packagings used for the carriage of Class 6.2 substances according to packing instruction P621 of 4.1.4.1.*

6.3.1 General

6.3.1.1 A packaging that meets the requirements of this section and of 6.3.2 may, after decision by the competent authority, be marked with:

(a) the United Nations packaging symbol;

(b) the code designating the type of packaging according to the requirements of 6.1.2;

(c) the text "CLASS 6.2";

(d) the last two digits of the year of manufacture of the packaging;

(e) the state authorizing the allocation of the mark, indicated by the distinguishing sign for motor vehicles in international traffic [1];

(f) the name of the manufacturer or other identification of the packaging specified by the competent authority;

(g) for packagings meeting the requirements of 6.3.2.9, the letter "U", inserted immediately following the marking required in (b) above.

6.3.1.2 ***Example of marking***

4G/CLASS 6.2/92 as in 6.3.1.1 (a), (b), (c) and (d)
S/SP-9989-ERIKSSON as in 6.3.1.1 (e), (f)

6.3.2 Test requirements for packagings

6.3.2.1 Other than for packagings for live animals and organisms, samples of each packaging shall be prepared for testing as described in 6.3.2.2 and then subjected to the tests in 6.3.2.4 to 6.3.2.6. If the nature of the packaging makes it necessary, equivalent preparation and tests are permitted, provided that these may be demonstrated to be at least as effective.

6.3.2.2 Samples of each packaging shall be prepared as for carriage, except that the substance to be carried shall be replaced by water or, where conditioning at -18 °C is

[1] *Distinguishing sign for motor vehicles in international traffic prescribed in Vienna Convention on Road Traffic (1968).*

specified, by water/antifreeze. Each primary receptacle shall be filled to 98% capacity.

6.3.2.3 ***Tests required***

Material of					**Tests required**				
outer packaging			**inner packaging**		**Refer to 6.3.2.5**				**Refer to 6.3.2.6**
Fibre-board	**Plastics**	**Other**	**Plastics**	**Other**	**(a)**	**(b)**	**(c)**	**(d)**	
x			x			x	x	when dry	x
x				x		x		ice is used	x
	x		x				x		x
	x			x			x		x
		x	x				x		x
		x		x	x				x

6.3.2.4 Packagings prepared as for carriage shall be subjected to the tests in 6.3.2.3, which - for test purposes - categorizes packagings according to their material characteristics. For outer packagings, the headings in the table relate to fibreboard or similar materials whose performance may be rapidly affected by moisture; plastics which may embrittle at low temperature; and other materials such as metal whose performance is not affected by moisture or temperature. If a primary receptacle and a secondary packaging are made of different materials, the material of the primary receptacle determines the appropriate test. In instances where a primary receptacle is made of two materials, the material most liable to damage shall determine the appropriate tests.

6.3.2.5 (a) Samples shall be subjected to free-fall drops on to a rigid, non-resilient, flat, horizontal surface from a height of 9 m. Where the samples are in the shape of a box, five shall be dropped in sequence:

(i) one flat on to the base,

(ii) one flat on to the top,

(iii) one flat on to the long side,

(iv) one flat on to the short side,

(v) one on to a corner.

Where the samples are in the shape of a drum, three shall be dropped in sequence:

(vi) one diagonally on to the top chime, with the centre of gravity directly above the point of impact,

(vii) one diagonally on to the base chime,

(viii) one flat on to the side.

Following the appropriate drop sequence, there shall be no leakage from the primary receptacle(s) which shall remain protected by absorbent material in the secondary packaging.

NOTE: *While the sample shall be released in the required orientation, it is accepted that for aerodynamic reasons the impact may not take place in that orientation.*

(b) The samples shall be subjected to a water spray that simulates exposure to rainfall of approximately 5 cm per hour for at least one hour. It shall then be subjected to the test described in (a).

(c) The samples shall be conditioned in an atmosphere of -18 °C or less for a period of at least 24 hours and within 15 minutes of removal from that atmosphere be subjected to the test described in (a). Where the samples contain dry ice, the conditioning period may be reduced to 4 hours.

(d) Where the packaging is intended to contain dry ice, a test additional to that specified in (a) or (b) or (c) shall be carried out. One sample shall be stored so that all the dry ice dissipates and then be subjected to the test described in (a).

6.3.2.6 Packagings with a gross mass of 7 kg or less shall be subjected to the tests described in (a) below and packagings with a gross mass exceeding 7 kg to the tests in (b) below.

(a) Samples shall be placed on a level hard surface. A cylindrical steel rod with a mass of at least 7 kg, a diameter not exceeding 38 mm and whose impact end edges have a radius not exceeding 6 mm, shall be dropped in a vertical free fall from a height of 1 m, measured from the impact end to the impact surface of the sample. One sample shall be placed on its base. A second sample shall be placed in an orientation perpendicular to that used for the first. In each instance the steel rod shall be aimed to impact the primary receptacle. Following each impact, penetration of the secondary packaging is acceptable, provided that there is no leakage from the primary receptacle(s).

(b) Samples shall be dropped on to the end of a cylindrical steel rod. The rod shall be set vertically in a level hard surface. It shall have a diameter of 38 mm and the edges of the upper end a radius not exceeding 6 mm. The rod shall protrude from the surface a distance at least equal to that between the primary receptacle(s) and the outer surface of the outer packaging with a minimum of 200 mm. One sample shall be dropped in a vertical free fall from a height of 1 m, measured from the top of the steel rod. A second sample shall be dropped from the same height in an orientation perpendicular to that used for the first. In each instance, the packaging shall be so orientated that the steel rod could penetrate the primary receptacle(s). Following each impact, there shall be no leakage from the primary receptacle(s).

6.3.2.7 The competent authority may permit the selective testing of packagings that differ only in minor respects from a tested type, e.g. smaller sizes of inner packagings or inner packagings of lower net mass; and packagings such as drums, bags and boxes which are produced with small reductions in external dimension(s).

6.3.2.8 Provided an equivalent level of performance is maintained, the following variations in the primary receptacles placed within a secondary packaging are allowed without the need for further testing of the completed packaging:

(a) Primary receptacles of equivalent or smaller size as compared to the tested primary receptacles may be used provided:

(i) the primary receptacles are of similar design to the primary receptacle tested (e.g. shape: round, rectangular, etc.);

(ii) the material of construction of the primary receptacles (e.g. glass, plastics, metal) offers resistance to impact and stacking forces equivalent to or better than that of the primary receptacles originally tested;

(iii) the primary receptacles have the same or smaller openings and the closure is of equivalent design (e.g. screw cap, friction lid, etc.);

(iv) sufficient additional cushioning material is used to take up empty spaces and to prevent significant movement of the primary receptacles; and

(v) primary receptacles are oriented within the secondary packagings in the same manner as in the tested package.

(b) A lesser number of the tested primary receptacles, or of the alternative types of primary receptacles identified in (a) above, may be used provided sufficient cushioning is added to fill the void space(s) and to prevent significant movement of the primary receptacles.

6.3.2.9 Inner receptacles of any type may be assembled within an intermediate (secondary) packaging and carried without testing in the outer packaging under the following conditions:

(a) The intermediate/outer packaging combination shall have been successfully tested in accordance with 6.3.2.6 with fragile (e.g. glass) inner receptacles;

(b) The total combined gross mass of inner receptacles shall not exceed one half the gross mass of inner receptacles used for the drop test in (a) above;

(c) The thickness of cushioning between inner receptacles and between inner receptacles and the outside of the intermediate packaging shall not be reduced below the corresponding thicknesses in the originally tested packaging; and if a single inner receptacle was used in the original test, the thickness of cushioning between inner receptacles shall not be less than the thickness of cushioning between the outside of the intermediate packaging and the inner receptacle in the original test. When either fewer or smaller inner receptacles are used (as compared to the inner receptacles used in the drop test), sufficient additional cushioning material shall be used to take up the void;

(d) The outer packaging shall have successfully passed the stacking test in 6.1.5.6 while empty. The total mass of identical packages shall be based on the combined mass of inner receptacles used in the drop test in (a) above;

(e) For inner receptacles containing liquids, an adequate quantity of absorbent material to absorb the entire liquid content of the inner receptacles shall be present;

(f) If the outer packaging is intended to contain inner receptacles for liquids and is not leakproof, or is intended to contain inner receptacles for solids and is not siftproof, a means of containing any liquid or solid contents in the event of leakage shall be provided in the form of a leakproof liner, plastics bag or other equally effective means of containment;

(g) In addition to the markings prescribed in 6.3.1.1(a) to (f), packagings shall be marked in accordance with 6.3.1.1 (g).

CHAPTER 6.4

REQUIREMENTS FOR THE CONSTRUCTION, TESTING AND APPROVAL OF PACKAGES AND MATERIAL OF CLASS 7

6.4.1 *(Reserved)*

6.4.2 General requirements

6.4.2.1 The package shall be so designed in relation to its mass, volume and shape that it can be easily and safely carried. In addition, the package shall be so designed that it can be properly secured in or on the vehicle during carriage.

6.4.2.2 The design shall be such that any lifting attachments on the package will not fail when used in the intended manner and that, if failure of the attachments should occur, the ability of the package to meet other requirements of this Annex would not be impaired. The design shall take account of appropriate safety factors to cover snatch lifting.

6.4.2.3 Attachments and any other features on the outer surface of the package which could be used to lift it shall be designed either to support its mass in accordance with the requirements of 6.4.2.2 or shall be removable or otherwise rendered incapable of being used during carriage.

6.4.2.4 As far as practicable, the packaging shall be so designed and finished that the external surfaces are free from protruding features and can be easily decontaminated.

6.4.2.5 As far as practicable, the outer layer of the package shall be so designed as to prevent the collection and the retention of water.

6.4.2.6 Any features added to the package at the time of carriage which are not part of the package shall not reduce its safety.

6.4.2.7 The package shall be capable of withstanding the effects of any acceleration, vibration or vibration resonance which may arise under routine conditions of carriage without any deterioration in the effectiveness of the closing devices on the various receptacles or in the integrity of the package as a whole. In particular, nuts, bolts and other securing devices shall be so designed as to prevent them from becoming loose or being released unintentionally, even after repeated use.

6.4.2.8 The materials of the packaging and any components or structures shall be physically and chemically compatible with each other and with the radioactive contents. Account shall be taken of their behaviour under irradiation.

6.4.2.9 All valves through which the radioactive contents could otherwise escape shall be protected against unauthorized operation.

6.4.2.10 The design of the package shall take into account ambient temperatures and pressures that are likely to be encountered in routine conditions of carriage.

6.4.2.11 For radioactive material having other dangerous properties the package design shall take into account those properties; see 2.1.3.5.3 and 4.1.9.1.5.

6.4.3 *(Reserved)*

6.4.4 Requirements for excepted packages

An excepted package shall be designed to meet the requirements specified in 6.4.2.

6.4.5 Requirements for Industrial packages

6.4.5.1 Industrial packages Types 1, 2, and 3 (Types IP-1, IP-2, and IP-3) shall meet the requirements specified in 6.4.2 and 6.4.7.2.

6.4.5.2 An Industrial package Type 2 (Type IP-2) shall, if it were subjected to the tests specified in 6.4.15.4 and 6.4.15.5, prevent:

(a) Loss or dispersal of the radioactive contents; and

(b) Loss of shielding integrity which would result in more than a 20% increase in the radiation level at any external surface of the package.

6.4.5.3 An Industrial package Type 3 (Type IP-3) shall meet all the requirements specified in 6.4.7.2 to 6.4.7.15.

6.4.5.4 ***Alternative requirements for Industrial packages Types 2 and 3 (Types IP-2 and IP-3)***

6.4.5.4.1 Packages may be used as Industrial package Type 2 (Type IP-2) provided that:

(a) They satisfy the requirements of 6.4.5.1;

(b) They are designed to conform to the standards prescribed in Chapter 6.1 or other requirements at least equivalent to those standards; and

(c) When subjected to the tests required for packing groups I or II in Chapter 6.1, they would prevent:

(i) loss or dispersal of the radioactive contents; and

(ii) loss of shielding integrity which would result in more than a 20% increase in the radiation level at any external surface of the package.

6.4.5.4.2 Tank-containers and portable tanks may also be used as Industrial package Types 2 or 3 (Types IP-2 or IP-3), provided that:

(a) They satisfy the requirements of 6.4.5.1;

(b) They are designed to conform to the standards prescribed in Chapter 6.7 or Chapter 6.8, or other requirements at least equivalent to those standards, and are capable of withstanding a test pressure of 265 kPa; and

(c) They are designed so that any additional shielding which is provided shall be capable of withstanding the static and dynamic stresses resulting from handling and routine conditions of carriage and of preventing a loss of shielding integrity which would result in more than a 20% increase in the radiation level at any external surface of the portable tanks or tank-containers.

6.4.5.4.3 Tanks, other than portable tanks and tank-containers, may also be used as Industrial package Types 2 or 3 (Types IP-2 or IP-3) for carrying LSA-I and LSA-II liquids and gases as prescribed in Table 4.1.9.2.4, provided that they conform to standards at least equivalent to those prescribed in 6.4.5.4.2.

6.4.5.4.4 Containers may also be used as Industrial package Types 2 or 3 (Types IP-2 or IP-3), provided that:

(a) The radioactive contents are restricted to solid materials;

(b) They satisfy the requirements of 6.4.5.1; and

(c) They are designed to conform to ISO 1496-1:1990: "Series 1 Containers - Specifications and Testing - Part 1: General Cargo Containers" excluding dimensions and ratings. They shall be designed such that if subjected to the tests prescribed in that document and the accelerations occurring during routine conditions of carriage they would prevent:

(i) loss or dispersal of the radioactive contents; and

(ii) loss of shielding integrity which would result in more than a 20% increase in the radiation level at any external surface of the containers.

6.4.5.4.5 Metal intermediate bulk containers may also be used as Industrial package Type 2 or 3 (Type IP-2 or IP-3) provided that:

(a) They satisfy the requirements of 6.4.5.1; and

(b) They are designed to conform to the standards and tests prescribed in Chapter 6.5 for packing groups I or II, but with the drop test conducted in the most damaging orientation, they would prevent:

(i) loss or dispersal of the radioactive contents; and

(ii) loss of shielding integrity which would result in more than a 20% increase in the radiation level at any external surface of the intermediate bulk container.

6.4.6 Requirements for packages containing uranium hexafluoride

6.4.6.1 Except as allowed in 6.4.6.4, uranium hexafluoride shall be packaged and carried in accordance with the provisions of ISO 7195:1993 "Packaging of uranium hexafluoride (UF_6) for transport", and the requirements of 6.4.6.2 and 6.4.6.3. The package shall also meet the requirements prescribed elsewhere in ADR which pertain to the radioactive and fissile properties of the material.

6.4.6.2 Each package designed to contain 0.1 kg or more of uranium hexafluoride shall be designed so that it would meet the following requirements:

(a) Withstand without leakage and without unacceptable stress, as specified in ISO 7195:1993, the structural test as specified in 6.4.21.5;

(b) Withstand without loss or dispersal of the uranium hexafluoride the test specified in 6.4.15.4; and

(c) Withstand without rupture of the containment system the test specified in 6.4.17.3.

6.4.6.3 Packages designed to contain 0.1 kg or more of uranium hexafluoride shall not be provided with pressure relief devices.

6.4.6.4 Subject to the approval of the competent authority, packages designed to contain 0.1 kg or more of uranium hexafluoride may be carried if:

(a) The packages are designed to requirements other than those given in ISO 7195:1993 and 6.4.6.2 and 6.4.6.3 but, notwithstanding, the requirements of 6.4.6.2 and 6.4.6.3 are met as far as practicable;

(b) The packages are designed to withstand without leakage and without unacceptable stress a test pressure less than 2.76 MPa as specified in 6.4.21.5; or

(c) For packages designed to contain 9 000 kg or more of uranium hexafluoride, the packages do not meet the requirement of 6.4.6.2 (c).

6.4.7 Requirements for Type A packages

6.4.7.1 Type A packages shall be designed to meet the general requirements of 6.4.2 and of 6.4.7.2 to 6.4.7.17.

6.4.7.2 The smallest overall external dimension of the package shall not be less than 10 cm.

6.4.7.3 The outside of the package shall incorporate a feature such as a seal, which is not readily breakable and which, while intact, will be evidence that it has not been opened.

6.4.7.4 Any tie-down attachments on the package shall be so designed that, under normal and accident conditions of carriage, the forces in those attachments shall not impair the ability of the package to meet the requirements of ADR.

6.4.7.5 The design of the package shall take into account temperatures ranging from -40°C to +70°C for the components of the packaging. Attention shall be given to freezing temperatures for liquids and to the potential degradation of packaging materials within the given temperature range.

6.4.7.6 The design and manufacturing techniques shall be in accordance with national or international standards, or other requirements, acceptable to the competent authority.

6.4.7.7 The design shall include a containment system securely closed by a positive fastening device which cannot be opened unintentionally or by a pressure which may arise within the package.

6.4.7.8 Special form radioactive material may be considered as a component of the containment system.

6.4.7.9 If the containment system forms a separate unit of the package, it shall be capable of being securely closed by a positive fastening device which is independent of any other part of the packaging.

6.4.7.10 The design of any component of the containment system shall take into account, where applicable, the radiolytic decomposition of liquids and other vulnerable materials and the generation of gas by chemical reaction and radiolysis.

6.4.7.11 The containment system shall retain its radioactive contents under a reduction of ambient pressure to 60 kPa.

6.4.7.12 All valves, other than pressure relief valves, shall be provided with an enclosure to retain any leakage from the valve.

6.4.7.13 A radiation shield which encloses a component of the package specified as a part of the containment system shall be so designed as to prevent the unintentional release of that component from the shield. Where the radiation shield and such component within it form a separate unit, the radiation shield shall be capable of being securely closed by a positive fastening device which is independent of any other packaging structure.

6.4.7.14 A package shall be so designed that **if** it were subjected to the tests specified in 6.4.15, it would prevent:

(a) Loss or dispersal of the radioactive contents; and

(b) Loss of shielding integrity which would result in more than a 20% increase in the radiation level at any external surface of the package.

6.4.7.15 The design of a package intended for liquid radioactive material shall make provision for ullage to accommodate variations in the temperature of the contents, dynamic effects and filling dynamics.

Type A packages to contain liquids

6.4.7.16 A Type A package designed to contain liquids shall, in addition:

(a) Be adequate to meet the conditions specified in 6.4.7.14 above if the package is subjected to the tests specified in 6.4.16; and

(b) Either

(i) be provided with sufficient absorbent material to absorb twice the volume of the liquid contents. Such absorbent material shall be suitably positioned so as to contact the liquid in the event of leakage; or

(ii) be provided with a containment system composed of primary inner and secondary outer containment components designed to ensure retention of the liquid contents, within the secondary outer containment components, even if the primary inner components leak.

Type A packages to contain gas

6.4.7.17 A package designed for gases shall prevent loss or dispersal of the radioactive contents if the package were subjected to the tests specified in 6.4.16. A Type A package designed for tritium gas or for noble gases shall be excepted from this requirement.

6.4.8 Requirements for Type B(U) packages

6.4.8.1 Type B(U) packages shall be designed to meet the requirements specified in 6.4.2, and of 6.4.7.2 to 6.4.7.15, except as specified in 6.4.7.14 (a), and, in addition, the requirements specified in 6.4.8.2 to 6.4.8.15.

6.4.8.2 A package shall be so designed that, under the ambient conditions specified in 6.4.8.4 and 6.4.8.5 heat generated within the package by the radioactive contents shall not, under normal conditions of carriage, as demonstrated by the tests in 6.4.15, adversely affect the package in such a way that it would fail to meet the applicable requirements for containment and shielding if left unattended for a period of one week. Particular attention shall be paid to the effects of heat, which may:

(a) Alter the arrangement, the geometrical form or the physical state of the radioactive contents or, if the radioactive material is enclosed in a can or receptacle (for example, clad fuel elements), cause the can, receptacle or radioactive material to deform or melt; or

(b) Lessen the efficiency of the packaging through differential thermal expansion or cracking or melting of the radiation shielding material; or

(c) In combination with moisture, accelerate corrosion.

6.4.8.3 A package shall be so designed that, under the ambient condition specified in 6.4.8.4, the temperature of the accessible surfaces of a package shall not exceed 50 °C, unless the package is carried under exclusive use.

6.4.8.4 The ambient temperature shall be assumed to be 38 °C.

6.4.8.5 The solar insolation conditions shall be assumed to be as specified in Table 6.4.8.5.

Table 6.4.8.5: Insolation data

Form and location of surface	**Insolation for 12 hours per day (W/m^2)**
Flat surfaces carried horizontally:	
- base	none
- other surfaces	800
Flat surfaces not carried horizontally:	
- each surface	200 [a]
Curved surfaces	400 [a]

[a] *Alternatively, a sine function may be used, with an absorption coefficient adopted and the effects of possible reflection from neighbouring objects neglected.*

6.4.8.6 A package which includes thermal protection for the purpose of satisfying the requirements of the thermal test specified in 6.4.17.3 shall be so designed that such protection will remain effective if the package is subjected to the tests specified in 6.4.15 and 6.4.17.2 (a) and (b) or 6.4.17.2 (b) and (c), as appropriate. Any such protection on the exterior of the package shall not be rendered ineffective by ripping, cutting, skidding, abrasion or rough handling.

6.4.8.7 A package shall be so designed that, if it were subjected to:

(a) The tests specified in 6.4.15, it would restrict the loss of radioactive contents to not more than 10^{-6} A_2 per hour; and

(b) The tests specified in 6.4.17.1, 6.4.17.2 (b), 6.4.17.3, and 6.4.17.4 and the tests in

(i) 6.4.17.2 (c), when the package has a mass not greater than 500 kg, an overall density not greater than 1 000 kg/m^3 based on the external dimensions, and radioactive contents greater than 1 000 A_2 not as special form radioactive material, or

(ii) 6.4.17.2 (a), for all other packages, it would meet the following requirements:

- retain sufficient shielding to ensure that the radiation level at 1 m from the surface of the package would not exceed 10 mSv/h with the maximum radioactive contents which the package is designed to contain; and

- restrict the accumulated loss of radioactive contents in a period of one week to not more than 10 A_2 for krypton-85 and not more than A_2 for all other radionuclides.

Where mixtures of different radionuclides are present, the provisions of 2.2.7.7.2.4 to 2.2.7.7.2.6 shall apply except that for krypton-85 an effective A_2(i) value equal to 10 A_2 may be used. For case (a) above, the assessment shall take into account the external contamination limits of 4.1.9.1.2.

6.4.8.8 A package for radioactive contents with activity greater than 10^5 A_2 shall be so designed that if it were subjected to the enhanced water immersion test specified in 6.4.18, there would be no rupture of the containment system.

6.4.8.9 Compliance with the permitted activity release limits shall depend neither upon filters nor upon a mechanical cooling system.

6.4.8.10 A package shall not include a pressure relief system from the containment system which would allow the release of radioactive material to the environment under the conditions of the tests specified in 6.4.15 and 6.4.17.

6.4.8.11 A package shall be so designed that if it were at the maximum normal operating pressure and it were subjected to the tests specified in 6.4.15 and 6.4.17, the level of strains in the containment system would not attain values which would adversely affect the package in such a way that it would fail to meet the applicable requirements.

6.4.8.12 A package shall not have a maximum normal operating pressure in excess of a gauge pressure of 700 kPa.

6.4.8.13 The maximum temperature of any surface readily accessible during carriage of a package shall not exceed 85 °C in the absence of insolation under the ambient conditions specified in 6.4.8.4. The package shall be carried under exclusive use, as specified in 6.4.8.3, if this maximum temperature exceeds 50 °C. Account may be taken of barriers or screens intended to give protection to persons without the need for the barriers or screens being subject to any test.

6.4.8.14 *(Reserved)*

6.4.8.15 A package shall be designed for an ambient temperature range from -40 °C to +38 °C.

6.4.9 Requirements for Type B(M) packages

6.4.9.1 Type B(M) packages shall meet the requirements for Type B(U) packages specified in 6.4.8.1, except that for packages to be carried solely within a specified country or solely between specified countries, conditions other than those given in 6.4.7.5, 6.4.8.4, 6.4.8.5, and 6.4.8.8 to 6.4.8.15 above may be assumed with the approval of the competent authorities of these countries. Notwithstanding, the requirements for Type B(U) packages specified in 6.4.8.8 to 6.4.8.15 shall be met as far as practicable.

6.4.9.2 Intermittent venting of Type B(M) packages may be permitted during carriage, provided that the operational controls for venting are acceptable to the relevant competent authorities.

6.4.10 *(Reserved)*

6.4.11 Requirements for packages containing fissile material

6.4.11.1 Fissile material shall be carried so as to:

(a) Maintain sub-criticality during normal and accident conditions of carriage; in particular, the following contingencies shall be considered:

(i) water leaking into or out of packages;

(ii) the loss of efficiency of built-in neutron absorbers or moderators;

(iii) rearrangement of the contents either within the package or as a result of loss from the package;

(iv) reduction of spaces within or between packages;

(v) packages becoming immersed in water or buried in snow; and

(vi) temperature changes; and

(b) Meet the requirements:

(i) of 6.4.7.2 for fissile material contained in packages;

(ii) prescribed elsewhere in ADR which pertain to the radioactive properties of the material; and

(iii) specified in 6.4.11.3 to 6.4.11.12, unless excepted by 6.4.11.2.

6.4.11.2 Fissile material meeting one of the provisions (a) to (d) of this paragraph is excepted from the requirement to be carried in packages that comply with 6.4.11.3 to 6.4.11.12 as well as the other requirements of ADR that apply to fissile material. Only one type of exception is allowed per consignment.

(a) A mass limit per consignment such that:

$$\frac{\textit{mass of uranium - 235 (g)}}{X} + \frac{\textit{mass of other fissile material (g)}}{Y} < 1$$

where X and Y are the mass limits defined in Table 6.4.11.2, provided that either:

(i) each individual package contains not more than 15 g of fissile material; for unpackaged material, this quantity limitation shall apply to the consignment being carried in or on the vehicle; or

(ii) the fissile material is a homogeneous hydrogenous solution or mixture where the ratio of fissile nuclides to hydrogen is less than 5% by mass; or

(iii) there is not more than 5 g of fissile material in any 10 litre volume of material.

Neither beryllium nor deuterium shall be present in quantities exceeding 0.1% of the fissile material mass;

(b) Uranium enriched in uranium-235 to a maximum of 1% by mass, and with a total plutonium and uranium-233 content not exceeding 1% of the mass of uranium-235, provided that the fissile material is distributed essentially homogeneously throughout the material. In addition, if uranium-235 is present in metallic, oxide or carbide forms, it shall not form a lattice arrangement;

(c) Liquid solutions of uranyl nitrate enriched in uranium-235 to a maximum of 2% by mass, with a total plutonium and uranium-233 content not exceeding 0.002% of the mass of uranium, and with a minimum nitrogen to uranium atomic ratio (N/U) of 2;

(d) Packages containing, individually, a total plutonium mass not more than 1 kg, of which not more than 20% by mass may consist of plutonium-239, plutonium-241 or any combination of those radionuclides.

Table 6.4.11.2: Consignment mass limits for exceptions from the requirements for packages containing fissile material

Fissile material	Fissile material mass (g) mixed with substances having an average hydrogen density less than or equal to water	Fissile material mass (g) mixed with substances having an average hydrogen density greater than water
Uranium -235(X)	400	290
Other fissile material (Y)	250	180

6.4.11.3 Where the chemical or physical form, isotopic composition, mass or concentration, moderation ratio or density, or geometric configuration is not known, the assessments of 6.4.11.7 to 6.4.11.12 shall be performed assuming that each parameter that is not known has the value which gives the maximum neutron multiplication consistent with the known conditions and parameters in these assessments.

6.4.11.4 For irradiated nuclear fuel the assessments of 6.4.11.7 to 6.4.11.12 shall be based on an isotopic composition demonstrated to provide:

(a) The maximum neutron multiplication during the irradiation history; or

(b) A conservative estimate of the neutron multiplication for the package assessments. After irradiation but prior to shipment, a measurement shall be performed to confirm the conservatism of the isotopic composition.

6.4.11.5 The packaging, after being subjected to the tests specified in 6.4.15, must prevent the entry of a 10 cm cube.

6.4.11.6 The package shall be designed for an ambient temperature range of -40°C to + 38°C unless the competent authority specifies otherwise in the certificate of approval for the package design.

6.4.11.7 For a package in isolation, it shall be assumed that water can leak into or out of all void spaces of the package, including those within the containment system. However, if the design incorporates special features to prevent such leakage of water into or out of certain void spaces, even as a result of error, absence of leakage may be assumed in respect of those void spaces. Special features shall include the following:

(a) Multiple high standard water barriers, each of which would remain watertight if the package were subject to the tests prescribed in 6.4.11.12 (b), a high degree of quality control in the manufacture, maintenance and repair of packagings and tests to demonstrate the closure of each package before each shipment; or

(b) For packages containing uranium hexafluoride only:

(i) packages where, following the tests prescribed in 6.4.11.12 (b), there is no physical contact between the valve and any other component of the packaging other than at its original point of attachment and where, in addition, following the test prescribed in 6.4.17.3 the valves remain leaktight; and

(ii) a high degree of quality control in the manufacture, maintenance and repair of packagings coupled with tests to demonstrate closure of each package before each shipment.

6.4.11.8 It shall be assumed that the confinement system shall be closely reflected by at least 20 cm of water or such greater reflection as may additionally be provided by the surrounding material of the packaging. However, when it can be demonstrated that the confinement system remains within the packaging following the tests prescribed in 6.4.11.12 (b), close reflection of the package by at least 20 cm of water may be assumed in 6.4.11.9 (c).

6.4.11.9 The package shall be subcritical under the conditions of 6.4.11.7 and 6.4.11.8 with the package conditions that result in the maximum neutron multiplication consistent with:

(a) Routine conditions of carriage (incident free);

(b) The tests specified in 6.4.11.11 (b);

(c) The tests specified in 6.4.11.12 (b).

6.4.11.10 *(Reserved)*

6.4.11.11 For normal conditions of carriage a number "N" shall be derived, such that five times "N" shall be sub-critical for the arrangement and package conditions that provide the maximum neutron multiplication consistent with the following:

(a) There shall not be anything between the packages, and the package arrangement shall be reflected on all sides by at least 20 cm of water; and

(b) The state of the packages shall be their assessed or demonstrated condition if they had been subjected to the tests specified in 6.4.15.

6.4.11.12 For accident conditions of carriage a number "N" shall be derived, such that two times "N" shall be sub-critical for the arrangement and package conditions that provide the maximum neutron multiplication consistent with the following:

(a) Hydrogenous moderation between packages, and the package arrangement reflected on all sides by at least 20 cm of water; and

(b) The tests specified in 6.4.15 followed by whichever of the following is the more limiting:

(i) the tests specified in 6.4.17.2 (b) and, either 6.4.17.2 (c) for packages having a mass not greater than 500 kg and an overall density not greater than 1 000 kg/m^3 based on the external dimensions, or 6.4.17.2 (a) for all other packages; followed by the test specified in 6.4.17.3 and completed by the tests specified in 6.4.19.1 to 6.4.19.3; or

(ii) the test specified in 6.4.17.4; and

(c) Where any part of the fissile material escapes from the containment system following the tests specified in 6.4.11.12 (b), it shall be assumed that fissile material escapes from each package in the array and all of the fissile material shall be arranged in the configuration and moderation that results in the maximum neutron multiplication with close reflection by at least 20 cm of water.

6.4.12 Test procedures and demonstration of compliance

6.4.12.1 Demonstration of compliance with the performance standards required in 2.2.7.3.3, 2.2.7.3.4, 2.2.7.4.1, 2.2.7.4.2, and 6.4.2 to 6.4.11 must be accomplished by any of the methods listed below or by a combination thereof:

(a) Performance of tests with specimens representing LSA-III material, or special form radioactive material, or with prototypes or samples of the packaging, where the contents of the specimen or the packaging for the tests shall simulate as closely as practicable the expected range of radioactive contents and the specimen or packaging to be tested shall be prepared as presented for carriage;

(b) Reference to previous satisfactory demonstrations of a sufficiently similar nature;

(c) Performance of tests with models of appropriate scale incorporating those features which are significant with respect to the item under investigation when

engineering experience has shown results of such tests to be suitable for design purposes. When a scale model is used, the need for adjusting certain test parameters, such as penetrator diameter or compressive load, shall be taken into account;

(d) Calculation, or reasoned argument, when the calculation procedures and parameters are generally agreed to be reliable or conservative.

6.4.12.2 After the specimen, prototype or sample has been subjected to the tests, appropriate methods of assessment shall be used to assure that the requirements for the test procedures have been fulfilled in compliance with the performance and acceptance standards prescribed in 2.2.7.3.3, 2.2.7.3.4, 2.2.7.4.1, 2.2.7.4.2, and 6.4.2 to 6.4.11.

6.4.12.3 All specimens shall be inspected before testing in order to identify and record faults or damage including the following:

(a) Divergence from the design;

(b) Defects in manufacture;

(c) Corrosion or other deterioration; and

(d) Distortion of features.

The containment system of the package shall be clearly specified. The external features of the specimen shall be clearly identified so that reference may be made simply and clearly to any part of such specimen.

6.4.13 Testing the integrity of the containment system and shielding and evaluating criticality safety

After each of the applicable tests specified in 6.4.15 to 6.4.21:

(a) Faults and damage shall be identified and recorded;

(b) It shall be determined whether the integrity of the containment system and shielding has been retained to the extent required in 6.4.2 to 6.4.11 for the package under test; and

(c) For packages containing fissile material, it shall be determined whether the assumptions and conditions used in the assessments required by 6.4.11.1 to 6.4.11.12 for one or more packages are valid.

6.4.14 Target for drop tests

The target for the drop tests specified in 2.2.7.4.5 (a), 6.4.15.4, 6.4.16 (a), 6.4.17.2 shall be a flat, horizontal surface of such a character that any increase in its resistance to displacement or deformation upon impact by the specimen would not significantly increase the damage to the specimen.

6.4.15 Tests for demonstrating ability to withstand normal conditions of carriage

6.4.15.1 The tests are: the water spray test, the free drop test, the stacking test and the penetration test. Specimens of the package shall be subjected to the free drop test, the stacking test and the penetration test, preceded in each case by the water spray test. One specimen may be used for all the tests, provided that the requirements of 6.4.15.2 are fulfilled.

6.4.15.2 The time interval between the conclusion of the water spray test and the succeeding test shall be such that the water has soaked in to the maximum extent, without appreciable drying of the exterior of the specimen. In the absence of any evidence to the contrary, this interval shall be taken to be two hours if the water spray is applied from four directions simultaneously. No time interval shall elapse, however, if the water spray is applied from each of the four directions consecutively.

6.4.15.3 Water spray test: The specimen shall be subjected to a water spray test that simulates exposure to rainfall of approximately 5 cm per hour for at least one hour.

6.4.15.4 Free drop test: The specimen shall drop onto the target so as to suffer maximum damage in respect of the safety features to be tested.

(a) The height of drop measured from the lowest point of the specimen to the upper surface of the target shall be not less than the distance specified in Table 6.4.15.4 for the applicable mass. The target shall be as defined in 6.4.14;

(b) For rectangular fibreboard or wood packages not exceeding a mass of 50 kg, a separate specimen shall be subjected to a free drop onto each corner from a height of 0.3 m;

(c) For cylindrical fibreboard packages not exceeding a mass of 100 kg, a separate specimen shall be subjected to a free drop onto each of the quarters of each rim from a height of 0.3 m.

Table 6.4.15.4: Free drop distance for testing packages to normal conditions of carriage

Package mass (kg)	Free drop distance (m)
Package mass < 5 000	1.2
5 000 ≤ Package mass < 10 000	0.9
10 000 ≤ Package mass < 15 000	0.6
15 000 ≤ Package mass	0.3

6.4.15.5 Stacking test: Unless the shape of the packaging effectively prevents stacking, the specimen shall be subjected, for a period of 24 h, to a compressive load equal to the greater of the following:

(a) The equivalent of 5 times the mass of the actual package; and

(b) The equivalent of 13 kPa multiplied by the vertically projected area of the package.

The load shall be applied uniformly to two opposite sides of the specimen, one of which shall be the base on which the package would typically rest.

6.4.15.6 Penetration test: The specimen shall be placed on a rigid, flat, horizontal surface which will not move significantly while the test is being carried out.

(a) A bar of 3.2 cm in diameter with a hemispherical end and a mass of 6 kg shall be dropped and directed to fall, with its longitudinal axis vertical, onto the centre of the weakest part of the specimen, so that, if it penetrates sufficiently far, it will hit the containment system. The bar shall not be significantly deformed by the test performance;

(b) The height of drop of the bar measured from its lower end to the intended point of impact on the upper surface of the specimen shall be 1 m.

6.4.16 Additional tests for Type A packages designed for liquids and gases

A specimen or separate specimens shall be subjected to each of the following tests unless it can be demonstrated that one test is more severe for the specimen in question than the other, in which case one specimen shall be subjected to the more severe test.

(a) Free drop test: The specimen shall drop onto the target so as to suffer the maximum damage in respect of containment. The height of the drop measured from the lowest part of the specimen to the upper surface of the target shall be 9 m. The target shall be as defined in 6.4.14;

(b) Penetration test: The specimen shall be subjected to the test specified in 6.4.15.6 except that the height of drop shall be increased to 1.7 m from the 1 m specified in 6.4.15.6 (b).

6.4.17 Tests for demonstrating ability to withstand accident conditions in carriage

6.4.17.1 The specimen shall be subjected to the cumulative effects of the tests specified in 6.4.17.2 and 6.4.17.3, in that order. Following these tests, either this specimen or a separate specimen shall be subjected to the effect(s) of the water immersion test(s) as specified in 6.4.17.4 and, if applicable, 6.4.18.

6.4.17.2 Mechanical test: The mechanical test consists of three different drop tests. Each specimen shall be subjected to the applicable drops as specified in 6.4.8.7 or 6.4.11.12. The order in which the specimen is subjected to the drops shall be such that, on completion of the mechanical test, the specimen shall have suffered such damage as will lead to the maximum damage in the thermal test which follows.

(a) For drop I, the specimen shall drop onto the target so as to suffer the maximum damage, and the height of the drop measured from the lowest point of the specimen to the upper surface of the target shall be 9 m. The target shall be as defined in 6.4.14;

(b) For drop II, the specimen shall drop so as to suffer the maximum damage onto a bar rigidly mounted perpendicularly on the target. The height of the drop measured from the intended point of impact of the specimen to the upper surface of the bar shall be 1 m. The bar shall be of solid mild steel of circular section, (15.0 cm ± 0.5 cm) in diameter and 20 cm long unless a longer bar would cause greater damage, in which case a bar of sufficient length to cause maximum damage shall be used. The upper end of the bar shall be flat and horizontal with its edges rounded off to a radius of not more than 6 mm. The target on which the bar is mounted shall be as described in 6.4.14;

(c) For drop III, the specimen shall be subjected to a dynamic crush test by positioning the specimen on the target so as to suffer maximum damage by the drop of a 500 kg mass from 9 m onto the specimen. The mass shall consist of a solid mild steel plate 1 m by 1 m and shall fall in a horizontal attitude. The height of the drop shall be measured from the underside of the plate to the highest point of the specimen. The target on which the specimen rests shall be as defined in 6.4.14.

6.4.17.3 Thermal test: The specimen shall be in thermal equilibrium under conditions of an ambient temperature of 38 °C, subject to the solar insolation conditions specified in Table 6.4.8.5 and subject to the design maximum rate of internal heat generation within the package from the radioactive contents. Alternatively, any of these parameters are allowed to have different values prior to and during the test, providing due account is taken of them in the subsequent assessment of package response.

The thermal test shall then consist of:

(a) Exposure of a specimen for a period of 30 minutes to a thermal environment which provides a heat flux at least equivalent to that of a hydrocarbon fuel/air fire in sufficiently quiescent ambient conditions to give a minimum average flame emissivity coefficient of 0.9 and an average temperature of at least 800 °C, fully engulfing the specimen, with a surface absorptivity coefficient of 0.8 or that value which the package may be demonstrated to possess if exposed to the fire specified, followed by,

(b) Exposure of the specimen to an ambient temperature of 38 °C, subject to the solar insolation conditions specified in Table 6.4.8.5 and subject to the design maximum rate of internal heat generation within the package by the radioactive contents for a sufficient period to ensure that temperatures in the specimen are everywhere decreasing and/or are approaching initial steady state conditions. Alternatively, any of these parameters are allowed to have different values following cessation of heating, providing due account is taken of them in the subsequent assessment of package response.

During and following the test the specimen shall not be artificially cooled and any combustion of materials of the specimen shall be permitted to proceed naturally.

6.4.17.4 Water immersion test: The specimen shall be immersed under a head of water of at least 15 m for a period of not less than eight hours in the attitude which will lead to maximum damage. For demonstration purposes, an external gauge pressure of at least 150 kPa shall be considered to meet these conditions.

6.4.18 Enhanced water immersion test for Type B(U) and Type B(M) packages containing more than 10^5 A_2

Enhanced water immersion test: The specimen shall be immersed under a head of water of at least 200 m for a period of not less than one hour. For demonstration purposes, an external gauge pressure of at least 2 MPa shall be considered to meet these conditions.

6.4.19 Water leakage test for package containing fissile material

6.4.19.1 Packages for which water in-leakage or out-leakage to the extent which results in greatest reactivity has been assumed for purposes of assessment under 6.4.11.7 to 6.4.11.12 shall be excepted from the test.

6.4.19.2 Before the specimen is subjected to the water leakage test specified below, it shall be subjected to the tests in 6.4.17.2 (b), and either 6.4.17.2 (a) or (c) as required by 6.4.11.12, and the test specified in 6.4.17.3.

6.4.19.3 The specimen shall be immersed under a head of water of at least 0.9 m for a period of not less than 8 hours and in the attitude for which maximum leakage is expected.

6.4.20 *(Reserved)*

6.4.21 Inspections for packagings designed to contain 0.1 kg or more of uranium hexafluoride

6.4.21.1 Every manufactured packaging and its service and structural equipment shall, either jointly or separately, undergo an inspection initially before being put into service and periodically thereafter. These inspections shall be performed and certified by agreement with the competent authority.

6.4.21.2 The initial inspection shall consist of a check of the design characteristics, a structural test, a leakproofness test, a water capacity test and a check of satisfactory operation of the service equipment.

6.4.21.3 The periodic inspections shall consist of a visual examination, a structural test, a leakproofness test and a check of satisfactory operation of the service equipment. The maximum intervals for periodic inspections shall be five years. Packagings which have not been inspected within this five-year period shall be examined before carriage in accordance with a programme approved by the competent authority . They shall not be refilled before completion of the full programme for periodic inspections.

6.4.21.4 The check of design characteristics shall demonstrate compliance with the design type specifications and the manufacturing programme.

6.4.21.5 For the initial structural test, packagings designed to contain 0.1 kg or more of uranium hexaflouride shall be tested hydraulically at an internal pressure of at least 1.38 MPa but, when the test pressure is less than 2.76 MPa, the design shall require multilateral approval. For retesting packagings, any other equivalent non-destructive testing may be applied subject to multilateral approval.

6.4.21.6 The leakproofness test shall be performed in accordance with a procedure which is capable of indicating leakages in the containment system with a sensitivity of 0.1 Pa.l/s (10^{-6} bar.l/s).

6.4.21.7 The water capacity of the packagings shall be established with an accuracy of ± 0.25% at a reference temperature of 15 °C. The volume shall be stated on the plate described in 6.4.21.8.

6.4.21.8 A plate made of non-corroding metal shall be durably attached to every packaging in a readily accessible place. The method of attaching the plate must not impair the strength of the packaging. The following particulars, at least, shall be marked on the plate by stamping or by any other equivalent method:

- Approval number;
- Manufacturer's serial number;
- Maximum working pressure (gauge pressure);
- Test pressure (gauge pressure);
- Contents: uranium hexafluoride;
- Capacity in litres;
- Maximum permissible filling mass of uranium hexafluoride;
- Tare mass;
- Date (month, year) of the initial test and the most recent periodic test;
- Stamp of the expert who performed the tests.

6.4.22 Approvals of package designs and materials

6.4.22.1 The approval of designs for packages containing 0.1 kg or more of uranium hexafluoride requires that:

(a) Each design that meets the requirements of 6.4.6.4 shall require multilateral approval;

(b) After 31 December 2003, each design that meets the requirements of 6.4.6.1 to 6.4.6.3 shall require unilateral approval by the competent authority of the country of origin of the design.

6.4.22.2 Each Type B(U) and Type C package design shall require unilateral approval, except that:

(a) A package design for fissile material, which is also subject to 6.4.22.4, 6.4.23.7, and 5.1.5.3.1 shall require multilateral approval; and

(b) A Type B(U) package design for low dispersible radioactive material shall require multilateral approval.

6.4.22.3 Each Type B(M) package design, including those for fissile material which are also subject to the requirements of 6.4.22.4, 6.4.23.7, and 5.1.5.3.1 and those for low dispersible radioactive material, shall require multilateral approval.

6.4.22.4 Each package design for fissile material which is not excepted according to 6.4.11.2 from the requirements that apply specifically to packages containing fissile material shall require multilateral approval.

6.4.22.5 The design for special form radioactive material shall require unilateral approval. The design for low dispersible radioactive material shall require multilateral approval (see also 6.4.23.8).

6.4.22.6 Any design that requires unilateral approval originating in a country Contracting Party to ADR shall be approved by the competent authority of this country; if the country where the package has been designed is not a Contracting Party to ADR, carriage is possible on condition that:

(a) a certificate has been supplied by this country, proving that the package satisfies the technical requirements of ADR, and that this certificate is countersigned by the competent authority of the first country Contracting Party to ADR reached by the consignment;

(b) if no certificate and no existing package design approval by a country Contracting Party to ADR has been supplied, the package design is approved by the competent authority of the first country Contracting Party to ADR reached by the consignment.

6.4.22.7 For designs approved under the transitional measures see 1.6.5.

6.4.23 Applications and approvals for radioactive material carriage

6.4.23.1 *(Reserved)*

6.4.23.2 An application for shipment approval shall include:

(a) The period of time, related to the shipment, for which the approval is sought;

(b) The actual radioactive contents, the expected modes of carriage, the type of vehicle, and the probable or proposed route; and

(c) The details of how the precautions and administrative or operational controls, referred to in the package design approval certificates issued under 5.1.5.3.1, are to be put into effect.

6.4.23.3 An application for approval of shipments under special arrangement shall include all the information necessary to satisfy the competent authority that the overall level of safety in carriage is at least equivalent to that which would be provided if all the applicable requirements of ADR had been met.

The application shall also include:

(a) A statement of the respects in which, and of the reasons why, the consignment cannot be made in full accordance with the applicable requirements of ADR; and

(b) A statement of any special precautions or special administrative or operational controls which are to be employed during carriage to compensate for the failure to meet the applicable requirements of ADR.

6.4.23.4 An application for approval of Type B(U) or Type C package design shall include:

(a) A detailed description of the proposed radioactive contents with reference to their physical and chemical states and the nature of the radiation emitted;

(b) A detailed statement of the design, including complete engineering drawings and schedules of materials and methods of manufacture;

(c) A statement of the tests which have been done and their results, or evidence based on calculative methods or other evidence that the design is adequate to meet the applicable requirements;

(d) The proposed operating and maintenance instructions for the use of the packaging;

(e) If the package is designed to have a maximum normal operating pressure in excess of 100 kPa gauge, a specification of the materials of manufacture of the containment system, the samples to be taken, and the tests to be made;

(f) Where the proposed radioactive contents are irradiated fuel, a statement and a justification of any assumption in the safety analysis relating to the characteristics of the fuel and a description of any pre-shipment measurement as required by 6.4.11.4 (b);

(g) Any special stowage provisions necessary to ensure the safe dissipation of heat from the package considering the various modes of carriage to be used and type of vehicle or container;

(h) A reproducible illustration, not larger than 21 cm by 30 cm, showing the make-up of the package; and

(i) A specification of the applicable quality assurance programme as required by 1.7.3.

6.4.23.5 An application for approval of a Type B(M) package design shall include, in addition to the general information required for package approval in 6.4.23.4 for Type B(U) packages:

(a) A list of the requirements specified in 6.4.7.5, 6.4.8.4, 6.4.8.5 and 6.4.8.8 to 6.4.8.15 with which the package does not conform;

(b) Any proposed supplementary operational controls to be applied during carriage not regularly provided for in this Annex, but which are necessary to ensure the safety of the package or to compensate for the deficiencies listed in (a) above;

(c) A statement relative to any restrictions on the mode of carriage and to any special loading, carriage, unloading or handling procedures; and

(d) The range of ambient conditions (temperature, solar radiation) which are expected to be encountered during carriage and which have been taken into account in the design.

6.4.23.6 The application for approval of designs for packages containing 0.1 kg or more of uranium hexafluoride shall include all information necessary to satisfy the competent authority that the design meets the applicable requirements of 6.4.6.1, and a description of the applicable quality assurance programme as required in 1.7.3.

6.4.23.7 An application for a fissile package approval shall include all information necessary to satisfy the competent authority that the design meets the applicable requirements of 6.4.11.1, and a specification of the applicable quality assurance programme as required by 1.7.3.

6.4.23.8 An application for approval of design for special form radioactive material and design for low dispersible radioactive material shall include:

(a) A detailed description of the radioactive material or, if a capsule, the contents; particular reference shall be made to both physical and chemical states;

(b) A detailed statement of the design of any capsule to be used;

(c) A statement of the tests which have been done and their results, or evidence based on calculative methods to show that the radioactive material is capable of meeting the performance standards, or other evidence that the special form radioactive material or low dispersible radioactive material meets the applicable requirements of ADR;

(d) A specification of the applicable quality assurance programme as required in 1.7.3; and

(e) Any proposed pre-shipment actions for use in the consignment of special form radioactive material or low dispersible radioactive material.

6.4.23.9 Each approval certificate issued by a competent authority shall be assigned an identification mark. The identification mark shall be of the following generalized type:

VRI/Number/Type Code

(a) Except as provided in 6.4.23.10 (b), VRI represents the international vehicle registration identification code of the country issuing the certificate [2];

(b) The number shall be assigned by the competent authority, and shall be unique and specific with regard to the particular design or shipment. The shipment approval identification mark shall be clearly related to the design approval identification mark;

(c) The following type codes shall be used in the order listed to indicate the types of approval certificates issued:

AF	Type A package design for fissile material
B(U)	Type B(U) package design [B(U) F if for fissile material]
B(M)	Type B(M) package design [B(M) F if for fissile material]
C	Type C package design (CF if for fissile material)
IF	Industrial package design for fissile material
S	Special form radioactive material
LD	Low dispersible radioactive material
T	Shipment
X	Special arrangement

In the case of package designs for non-fissile or fissile excepted uranium hexafluoride, where none of the above codes apply, then the following type codes shall be used:

H(U)	Unilateral approval
H(M)	Multilateral approval;

(d) For package design and special form radioactive material approval certificates, other than those issued under transitional packaging the provisions of 1.6.5.2 to 1.6.5.4, and for low dispersible radioactive material approval certificates, the symbols "-96" shall be added to the type code.

6.4.23.10 These type codes shall be applied as follows:

(a) Each certificate and each package shall bear the appropriate identification mark, comprising the symbols prescribed in 6.4.23.9 (a), (b), (c) and (d) above, except that, for packages, only the applicable design type codes including, if applicable, the symbols "-96", shall appear following the second stroke, that is, the "T" or "X" shall not appear in the identification marking on the package. Where the design approval and shipment approval are combined, the applicable type codes do not need to be repeated. For example:

[2] *See Vienna Convention on Road Traffic (1968).*

A/132/B(M)F-96: A Type B(M) package design approved for fissile material, requiring multilateral approval, for which the competent authority of Austria has assigned the design number 132 (to be marked on both the package and on the package design approval certificate);

A/132/B(M)F-96T: The shipment approval issued for a package bearing the identification mark elaborated above (to be marked on the certificate only);

A/137/X: A special arrangement approval issued by the competent authority of Austria, to which the number 137 has been assigned (to be marked on the certificate only);

A/139/IF-96: An industrial package design for fissile materia l approved by the competent authority of Austria, to which package design number 139 has been assigned (to be marked on both the package and on the package design approval certificate); and

A/145/H(U)-96: A package design for fissile excepted uranium hexafluoride approved by the competent authority of Austria, to which package design number 145 has been assigned (to be marked on both the package and on the package design approval certificate);

(b) Where multilateral approval is effected by validation according to 6.4.23.16, only the identification mark issued by the country of origin of the design or shipment shall be used. Where multilateral approval is effected by issue of certificates by successive countries, each certificate shall bear the appropriate identification mark and the package whose design was so approved shall bear all appropriate identification marks.

For example:

A/132/B(M)F-96
CH/28/B(M)F-96

would be the identification mark of a package which was originally approved by Austria and was subsequently approved, by separate certificate, by Switzerland. Additional identification marks would be tabulated in a similar manner on the package;

(c) The revision of a certificate shall be indicated by a parenthetical expression following the identification mark on the certificate. For example, A/132/B(M)F-96 (Rev.2) would indicate revision 2 of the Austrian package design approval certificate; or A/132/B(M)F-96 (Rev.0) would indicate the original issuance of the Austrian package design approval certificate. For original issuances, the parenthetical entry is optional and other words such as "original issuance" may also be used in place of "Rev.0". Certificate revision numbers may only be issued by the country issuing the original approval certificate;

(d) Additional symbols (as may be necessitated by national regulations) may be added in brackets to the end of the identification mark; for example, A/132/B(M)F-96(SP503);

(e) It is not necessary to alter the identification mark on the packaging each time that a revision to the design certificate is made. Such re-marking shall be required only in those cases where the revision to the package design certificate involves a change in the letter type codes for the package design following the second stroke.

6.4.23.11 Each approval certificate issued by a competent authority for special form radioactive material or low dispersible radioactive material shall include the following information:

(a) Type of certificate;

(b) The competent authority identification mark;

(c) The issue date and an expiry date;

(d) List of applicable national and international regulations, including the edition of the IAEA Regulations for the Safe Transport of Radioactive Material under which the special form radioactive material or low dispersible radioactive material is approved;

(e) The identification of the special form radioactive material or low dispersible radioactive material;

(f) A description of the special form radioactive material or low dispersible radioactive material;

(g) Design specifications for the special form radioactive material or low dispersible radioactive material which may include references to drawings;

(h) A specification of the radioactive contents which includes the activities involved and which may include the physical and chemical form;

(i) A specification of the applicable quality assurance programme as required in 1.7.3;

(j) Reference to information provided by the applicant relating to specific actions to be taken prior to shipment;

(k) If deemed appropriate by the competent authority, reference to the identity of the applicant;

(l) Signature and identification of the certifying official.

6.4.23.12 Each approval certificate issued by a competent authority for a special arrangement shall include the following information:

(a) Type of certificate;

(b) The competent authority identification mark;

(c) The issue date and an expiry date;

(d) Mode(s) of carriage;

(e) Any restrictions on the modes of carriage, type of vehicle, container, and any necessary routing instructions;

(f) List of applicable national and international regulations, including the edition of the IAEA Regulations for the Safe Transport of Radioactive Material under which the special arrangement is approved;

(g) The following statement:

"This certificate does not relieve the consignor from compliance with any requirement of the government of any country through or into which the package will be carried.";

(h) References to certificates for alternative radioactive contents, other competent authority validation, or additional technical data or information, as deemed appropriate by the competent authority;

(i) Description of the packaging by a reference to the drawings or a specification of the design. If deemed appropriate by the competent authority, a reproducible illustration, not larger than 21 cm by 30 cm, showing the make-up of the package shall also be provided, accompanied by a brief description of the packaging, including materials of manufacture, gross mass, general outside dimensions and appearance;

(j) A specification of the authorized radioactive contents, including any restrictions on the radioactive contents which might not be obvious from the nature of the packaging. This shall include the physical and chemical forms, the activities involved (including those of the various isotopes, if appropriate), amounts in grams (for fissile material), and whether special form radioactive material or low dispersible radioactive material, if applicable;

(k) Additionally, for packages containing fissile material:

(i) a detailed description of the authorized radioactive contents;

(ii) the value of the criticality safety index;

(iii) reference to the documentation that demonstrates the criticality safety of the contents;

(iv) any special features, on the basis of which the absence of water from certain void spaces has been assumed in the criticality assessment;

(v) any allowance (based on 6.4.11.4 (b)) for a change in neutron multiplication assumed in the criticality assessment as a result of actual irradiation experience; and

(vi) the ambient temperature range for which the special arrangement has been approved;

(l) A detailed listing of any supplementary operational controls required for preparation, loading, carriage, unloading and handling of the consignment, including any special stowage provisions for the safe dissipation of heat;

(m) If deemed appropriate by the competent authority, reasons for the special arrangement;

(n) Description of the compensatory measures to be applied as a result of the shipment being under special arrangement;

(o) Reference to information provided by the applicant relating to the use of the packaging or specific actions to be taken prior to the shipment;

(p) A statement regarding the ambient conditions assumed for purposes of design if these are not in accordance with those specified in 6.4.8.4, 6.4.8.5, and 6.4.8.15, as applicable;

(q) Any emergency arrangements deemed necessary by the competent authority;

(r) A specification of the applicable quality assurance programme as required in 1.7.3;

(s) If deemed appropriate by the competent authority, reference to the identity of the applicant and to the identity of the carrier;

(t) Signature and identification of the certifying official.

6.4.23.13 Each approval certificate for a shipment issued by a competent authority shall include the following information:

(a) Type of certificate;

(b) The competent authority identification mark(s);

(c) The issue date and an expiry date;

(d) List of applicable national and international regulations, including the edition of the IAEA Regulations for the Safe Transport of Radioactive Material under which the shipment is approved;

(e) Any restrictions on the modes of carriage, type of vehicle, container, and any necessary routeing instructions;

(f) The following statement:

"This certificate does not relieve the consignor from compliance with any requirement of the government of any country through or into which the package will be carried.";

(g) A detailed listing of any supplementary operational controls required for preparation, loading, carriage, unloading and handling of the consignment, including any special stowage provisions for the safe dissipation of heat or maintenance of criticality safety;

(h) Reference to information provided by the applicant relating to specific actions to be taken prior to shipment;

(i) Reference to the applicable design approval certificate(s);

(j) A specification of the actual radioactive contents, including any restrictions on the radioactive contents which might not be obvious from the nature of the packaging. This shall include the physical and chemical forms, the total activities involved (including those of the various isotopes, if appropriate), amounts in grams (for fissile material), and whether special form radioactive material or low dispersible radioactive material, if applicable;

(k) Any emergency arrangements deemed necessary by the competent authority;

(l) A specification of the applicable quality assurance programme as required in 1.7.3;

(m) If deemed appropriate by the competent authority, reference to the identity of the applicant;

(n) Signature and identification of the certifying official.

6.4.23.14 Each approval certificate of the design of a package issued by a competent authority shall include the following information:

(a) Type of certificate;

(b) The competent authority identification mark;

(c) The issue date and an expiry date;

(d) Any restriction on the modes of carriage, if appropriate;

(e) List of applicable national and international regulations, including the edition of the IAEA Regulations for the Safe Transport of Radioactive Material under which the design is approved;

(f) The following statement;

"This certificate does not relieve the consignor from compliance with any requirement of the government of any country through or into which the package will be carried.";

(g) References to certificates for alternative radioactive contents, other competent authority validation, or additional technical data or information, as deemed appropriate by the competent authority;

(h) A statement authorizing shipment where shipment approval is required under 5.1.5.2.2, if deemed appropriate;

(i) Identification of the packaging;

(j) Description of the packaging by a reference to the drawings or specification of the design. If deemed appropriate by the competent authority, a reproducible illustration, not larger than 21 cm by 30 cm, showing the make-up of the package should also be provided, accompanied by a brief description of the packaging, including materials of manufacture, gross mass, general outside dimensions and appearance;

(k) Specification of the design by reference to the drawings;

(l) A specification of the authorized radioactive content, including any restrictions on the radioactive contents which might not be obvious from the nature of the packaging. This shall include the physical and chemical forms, the activities involved (including those of the various isotopes, if appropriate), amounts in grams (for fissile material), and whether special form radioactive material or low dispersible radioactive material, if applicable;

(m) Additionally, for packages containing fissile material:

(i) a detailed description of the authorized radioactive contents;

(ii) the value of the criticality safety index;

(iii) reference to the documentation that demonstrates the criticality safety of the contents;

(iv) any special features, on the basis of which the absence of water from certain void spaces has been assumed in the criticality assessment;

(v) any allowance (based on 6.4.11.4 (b)) for a change in neutron multiplication assumed in the criticality assessment as a result of actual irradiation experience; and

(vi) the ambient temperature range for which the package design has been approved;

(n) For Type B(M) packages, a statement specifying those requirements of 6.4.7.5, 6.4.8.4, 6.4.8.5 and 6.4.8.8 to 6.4.8.15 with which the package does not conform and any amplifying information which may be useful to other competent authorities;

(o) A detailed listing of any supplementary operational controls required for preparation, loading, carriage, unloading and handling of the consignment, including any special stowage provisions for the safe dissipation of heat;

(p) Reference to information provided by the applicant relating to the use of the packaging or specific actions to be taken prior to shipment;

(q) A statement regarding the ambient conditions assumed for purposes of design if these are not in accordance with those specified in 6.4.8.4, 6.4.8.5 and 6.4.8.15, as applicable;

(r) A specification of the applicable quality assurance programme as required in 1.7.3;

(s) Any emergency arrangements deemed necessary by the competent authority;

(t) If deemed appropriate by the competent authority, reference to the identity of the applicant;

(u) Signature and identification of the certifying official.

6.4.23.15 The competent authority shall be informed of the serial number of each packaging manufactured to a design approved by them. The competent authority shall maintain a register of such serial numbers.

6.4.23.16 Multilateral approval may be by validation of the original certificate issued by the competent authority of the country of origin of the design or shipment. Such validation may take the form of an endorsement on the original certificate or the issuance of a separate endorsement, annex, supplement, etc., by the competent authority of the country through or into which the shipment is made.