



BSI Standards Publication

Gas cylinders — Cylinder valves — Manufacturing tests and examinations

National foreword

This British Standard is the UK implementation of EN ISO 14246:2022+A1:2025. It is identical to ISO 14246:2022, incorporating amendment 1:2025. It supersedes BS EN ISO 14246:2022, which is withdrawn.

The start and finish of text introduced or altered by amendment is indicated in the text by tags. Tags indicating changes to ISO text carry the number of the ISO amendment. For example, text altered by ISO amendment 1 is indicated by A1 A1.

The UK participation in its preparation was entrusted to Technical Committee PVE/3/1, Gas containers - Valve fittings for gas containers.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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Date	Text affected
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English Version

Gas cylinders - Cylinder valves - Manufacturing tests and examinations (ISO 14246:2022)

Bouteilles à gaz - Robinets de bouteilles à gaz - Essais
de fabrication et contrôles (ISO 14246:2022)

Gasflaschen - Flaschenventile - Herstellungsprüfungen
und untersuchungen (ISO 14246:2022)

This European Standard was approved by CEN on 13 February 2022.

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

European foreword

This document (EN ISO 14246:2022) has been prepared by Technical Committee ISO/TC 58 "Gas cylinders" in collaboration with Technical Committee CEN/TC 23 "Transportable gas cylinders" the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by August 2022, and conflicting national standards shall be withdrawn at the latest by August 2022.

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

This document supersedes EN ISO 14246:2014.

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Endorsement notice

The text of ISO 14246:2022 has been approved by CEN as EN ISO 14246:2022 without any modification.

European foreword to Amendment 1

This document (EN ISO 14246:2022/A1:2025) has been prepared by Technical Committee ISO/TC 58 "Gas cylinders" in collaboration with Technical Committee CEN/TC 23 "Transportable gas cylinders" the secretariat of which is held by BSI.

This Amendment to the European Standard EN ISO 14246:2022 shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by March 2026, and conflicting national standards shall be withdrawn at the latest by March 2026.

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This document has been prepared under a standardization request addressed to CEN by the European Commission. The Standing Committee of the EFTA States subsequently approves these requests for its Member States.

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Endorsement notice

The text of ISO 14246:2022/Amd 1:2025 has been approved by CEN as EN ISO 14246:2022/A1:2025 without any modification.

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Foreword

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

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 58, *Gas cylinders*, Subcommittee SC 2, *Cylinder fittings*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 23, *Transportable gas cylinders*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 14246:2014), which has been technically revised. It also incorporates Amendment ISO 14246:2014/Amd 1:2017. The main changes are as follows:

- in [Clause 4](#), a maximum level of hydrocarbon contamination of 220 mg/m² and a maximum particle size of 200 µm has been introduced for valves for oxygen and other oxidizing gases for general purpose applications, and the mandatory reference to ISO 15001 has been changed to an example for medical applications;
- in [5.2](#), indent c), the value of the test pressure for specific acetylene valves has been reduced from 37 bar to 35 bar;
- in [5.4](#), the requirements concerning the verification of the assembly with regard to the use of correct components and assembly torques have been clarified.

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