

per day, shall be pressure tested to destruction and must not burst below 270 psig gauge pressure. The container tested shall be complete with end assembled.

(b) Each such 25,000 containers or less, successively produced per day, shall constitute a lot and if the test container shall fail, the lot shall be rejected or ten additional containers may be selected at random and subjected to the test under which failure occurred. These containers shall be complete with ends assembled. Should any of the ten containers thus tested fail, the entire lot must be rejected. All containers constituting a lot shall be of like material, size, design, construction, finish and quality.

[Order 71, 31 FR 9074, July 1, 1966. Redesignated at 32 FR 5606, Apr. 5, 1967, as amended by 66 FR 45387, Aug. 28, 2001]

§ 178.33a-9 Marking.

(a) By means of printing, lithographing, embossing, or stamping, each container must be marked to show:

(1) DOT-2Q.

(2) Name or symbol of person making the mark specified in paragraph (a)(1) of this section. Symbol, if used, must be registered with the Associate Administrator.

(b) [Reserved]

[Amdt. 178-40, 41 FR 38181, Sept. 9, 1976, as amended by Amdt. 178-97, 56 FR 66287, Dec. 20, 1991; 66 FR 45386, Aug. 28, 2001]

Subpart C—Specifications for Cylinders

SOURCE: Amdt. 178-114, 61 FR 25942, May 23, 1996, unless otherwise noted.

§ 178.35 General requirements for specification cylinders.

(a) *Compliance.* Compliance with the requirements of this subpart is required in all details.

(b) *Inspections and analyses.* Chemical analyses and tests required by this subchapter must be made within the United States, unless otherwise approved in writing by the Associate Administrator, in accordance with subpart I of part 107 of this chapter. In-

spections and verification must be performed by—

(1) An independent inspection agency approved in writing by the Associate Administrator, in accordance with subpart I of part 107 of this chapter; or

(2) For DOT Specifications 3B, 3BN, 3E, 4B, 4BA, 4D (water capacity less than 1,100 cubic inches), 4B240ET, 4AA480, 4L, 8, 8AL, 4BW, 39 (marked service pressure 900 p.s.i.g. or lower) and 4E manufactured in the United States, a competent inspector of the manufacturer.

(c) *Duties of inspector.* The inspector shall determine that each cylinder made is in conformance with the applicable specification. Except as otherwise specified in the applicable specification, the inspector shall perform the following:

(1) Inspect all material and reject any not meeting applicable requirements. For cylinders made by the billet-piercing process, billets must be inspected and shown to be free from pipe, cracks, excessive segregation and other injurious defects after parting or, when applicable, after nick and cold break.

(2) Verify the material of construction meets the requirements of the applicable specification by—

(i) Making a chemical analysis of each heat of material;

(ii) Obtaining a certified chemical analysis from the material manufacturer for each heat of material (a ladle analysis is acceptable); or

(iii) If an analysis is not provided for each heat of material by the material manufacturer, by making a check analysis of a sample from each coil, sheet, or tube.

(3) Verify compliance of cylinders with the applicable specification by—

(i) Verifying identification of material is proper;

(ii) Inspecting the inside of the cylinder before closing in ends;

(iii) Verifying that the heat treatment is proper;

(iv) Obtaining samples for all tests and check chemical analyses (NOTE: Recommended locations for test specimens taken from welded cylinders are depicted in Figures 1 through 5 in Appendix C to this subpart for the specific construction design.);

(v) Witnessing all tests;