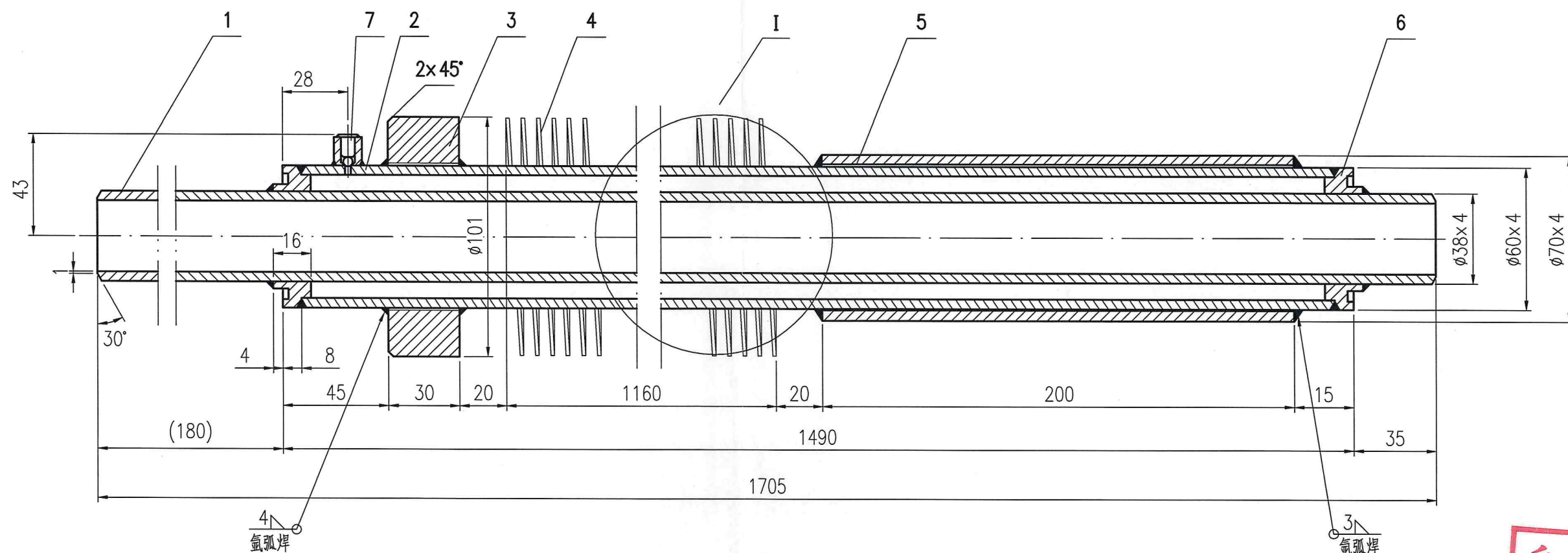




技术要求:

- 翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- φ38x4的钢管要求逐根涡流检测。
- 换热管两端留水压试验余量,按GB/T150《压力容器》进行水压试验,试验压力11.72Mpa,水压试验后切割管子两端,两端坡口,倒角30°,钝边1mm。

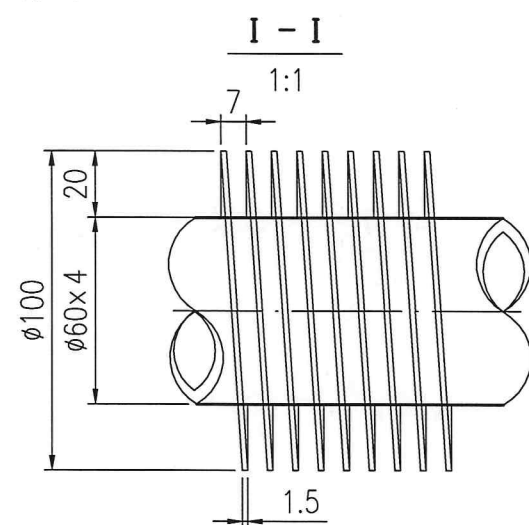
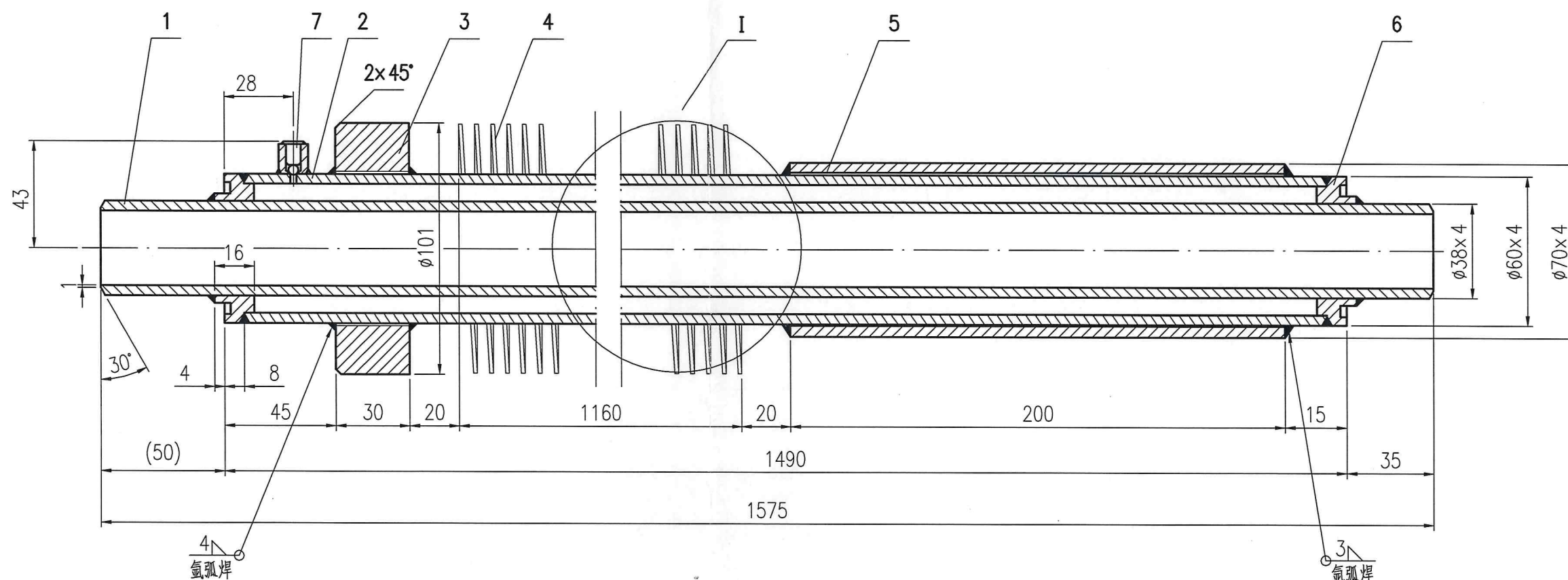
Technical Notes:

- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 Technical Conditions for High Frequency Resistance Welding of Spiral Finned Tubes for Boilers.
- Eddy current should be performed to each base tube.
- Both ends of pipes should remain Water pressure test margin, water pressure test should be according to GB/T150 《Pressure Vessel》, pressure of water pressure test is 11.72MPa, cut ends of the tube groove after water pressure test, chamfer 30°, blunt edge of 1mm.

7	按本图	排气口组件	1	组合件		0.075	
6	按本图	密封端盖	2	20	0.05	0.1	
5	按本图	套管 φ70×4 L=200	1	SA-106 Gr.B		1.3	
4	按本图	翅片 t=1.5 H=21	1	ST12		10.4	
3	按本图	堵头 φ101/φ62 t=30	1	SA-283 Gr.C		1.2	
2	按本图	钢管 φ60×4 L=1474	1	SA-210 Gr.C		8.2	
1	按本图	钢管 φ38×4 L=1705	1	SA-210 Gr.C		5.7	
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 SINGLE 重量(kg)WEIGHT	总 TOTAL 重量(kg)WEIGHT	备注 REMARK

					江苏索普赛瑞装备制造有限公司 Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.			热管Ⅰ φ38×4/φ60×4
					组合件			
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次	15SCG2402-3-2-4-0
DESIGN 设计	许大宇	2024.12.27	SERIAL# 产品编号		27	1:2	0	
APPROVE 批准	赵晓峰	2024.12.27			TOTAL-PAGES 共 张		No.-PAGE 第 张	

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技术要求:

- 1.翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- 2.φ38×4的钢管要求逐根涡流检测。
- 3.换热管两端留水压试验余量,按GB/T150《压力容器》进行水压试验,试验压力11.72Mpa,水压试验后切割管子两端,两端坡口,倒角30°,钝边1mm。

Technical Notes:

1. The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 Technical Conditions for High Frequency Resistance Welding of Spiral Finned Tubes for Boilers.
2. Eddy current should be performed to each base tube.
3. Both ends of pipes should remain Water pressure test margin, water pressure test should be according to GB/T150 《Pressure Vessel》, pressure of water pressure test is 11.72MPa, cut ends of the tube groove after water pressure test, chamfer 30°, blunt edge of 1mm.

受控文件

7	按本图	排气口组件	1	组合件		0.075		
6	按本图	密封端盖	2	20	0.05	0.1		
5	按本图	套管 $\phi 70 \times 4$ L=200	1	SA-106 Gr.B		1.3		
4	按本图	翅片 t=1.5 H=21	1	ST12		10.4		
3	按本图	堵头 $\phi 101/\phi 62$ t=30	1	SA-283 Gr.C		1.2		
2	按本图	钢管 $\phi 60 \times 4$ L=1474	1	SA-210 Gr.C		8.2		
1	按本图	钢管 $\phi 38 \times 4$ L=1575	1	SA-210 Gr.C		5.28		
件号 PART NO.	图号或标准号 DRAWING NO. OR	名 称 DESCRIPTION	数量 QTY.	材 料 MATERIAL	单 SINGLE 重量(kg)	总 TOTAL WEIGHT	备 注 REMARK	
				江苏索普赛瑞装备制造有限公司 Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.				
				组合件			热管II $\phi 38 \times 4/\phi 60 \times 4$ 15SCG2402-3-2-5-0	
MARK 标 记	TOTAL NO. 处 数	FILE NO. 更改文件号	SIGN 签 名	DATE 日 期	WEIGHT(kg) 重 量	SCALE 比 例		REV. 版 次
DESIGN 设计	许大宇 2024.12.27		SERIAL# 产品编号		26.6	1:2		0
APPROVE 批准	赵晓娟 2024.12.27		TOTAL-PAGES 共 张		No.-PAGE 第 张			

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