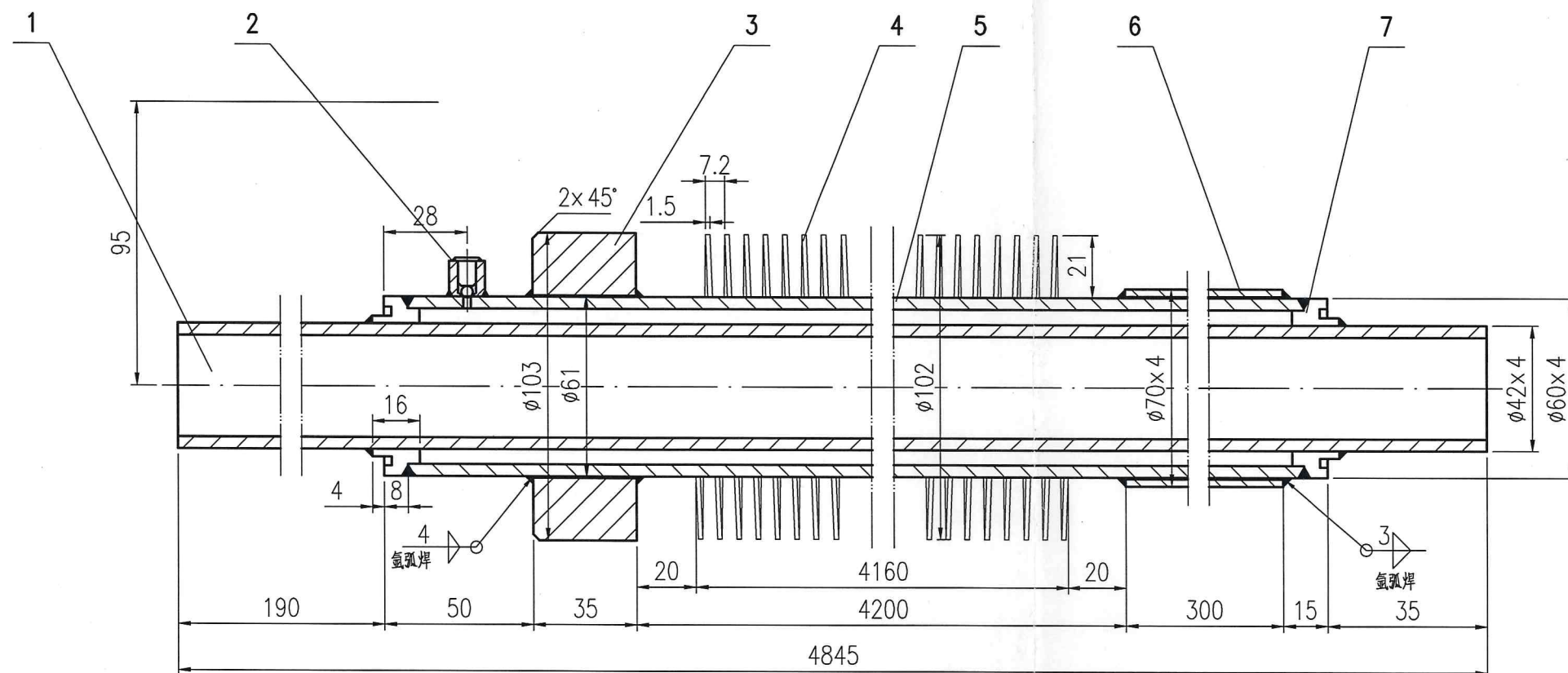
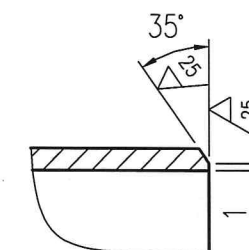




件1和件5两端坡口详图
DETAIL OF END OF PART 1 AND 5

1:1



受控文件

技术要求:

- 翅片管的制造和检验按NB/T47030-2022《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- φ42×4和φ60×4的钢管要求逐根涡流检测。
- 内管和外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10.56Mpa,水压试验后切割管子两端,两端坡口,倒角35°,钝边1mm。

Technical Notes:

- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2022 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 10.56MPa, cut ends of the tube groove after water pressure test, chamfer 35°, blunt edge of 1mm.

7	按本图 SEE THIS DWG	密封端盖 SEAL END CAPS	2	20	0.15	0.3	
6	按本图 SEE THIS DWG	套管φ70×4 L=300 SLEEVE	1	20		2.0	
5	按本图 SEE THIS DWG	钢管 φ60×4 L=4584 TUBE	1	SA-210 Gr.C		25.3	
4	按本图 SEE THIS DWG	翅片 t=1.5 H=21+1 DESCRIPTION	1	ST12		39.6	
3	按本图 SEE THIS DWG	堵头 φ103/φ61 t=35 END CAP	1	SA-283 Gr.C		1.4	
2	按本图 SEE THIS DWG	排气口组件 EXHAUST PORT ASSEMBLY	1	组合件		0.1	
1	按本图 SEE THIS DWG	钢管φ42×4 L=4825 TUBE	1	SA-210 Gr.C		19.1	

件号 PART NO.	图号或标准号 DRAWING OR STD. NO.	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 SINGLE 重量(kg)WEIGHT	总 TOTAL 重量(kg)WEIGHT	备注 REMARK
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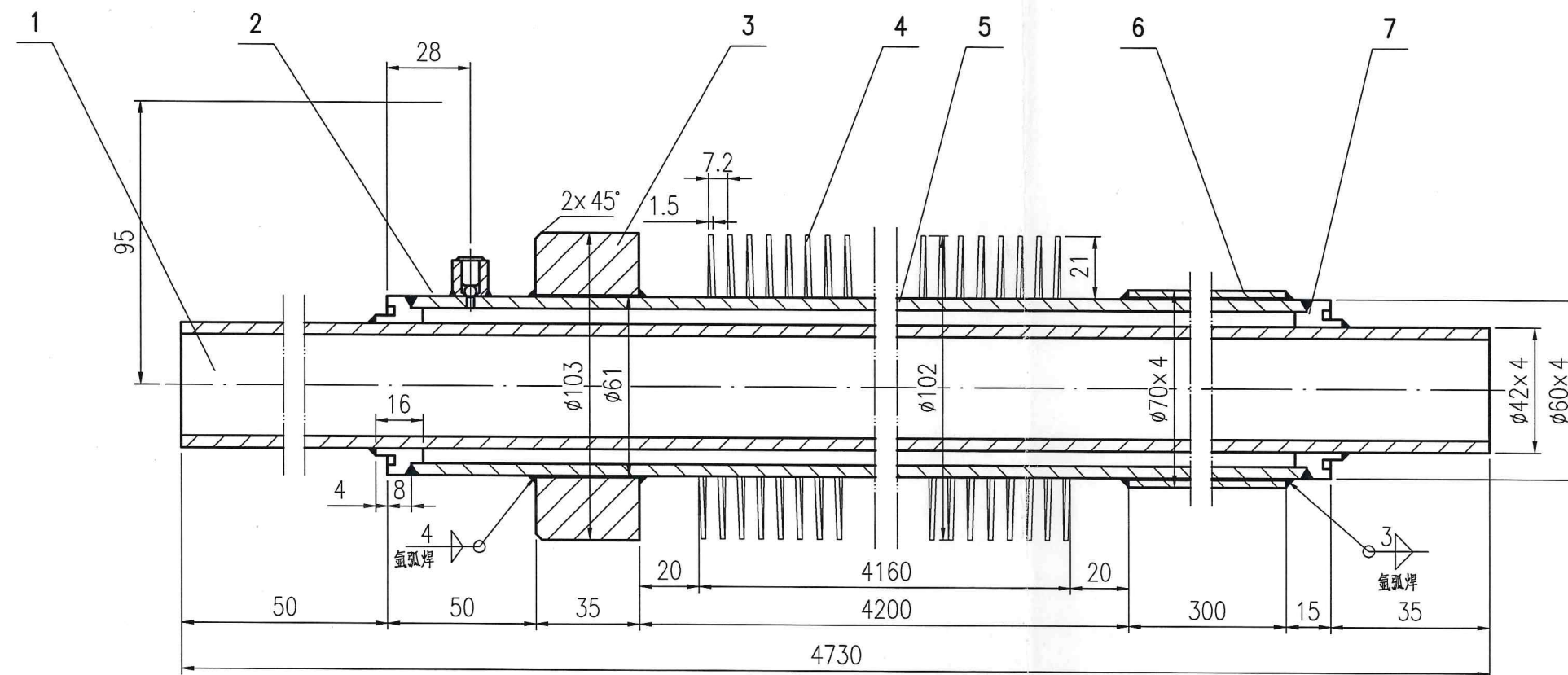
江苏索普赛瑞装备制造有限公司
Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.

ASSEMBLY

热管
热管φ42×4/φ60×4

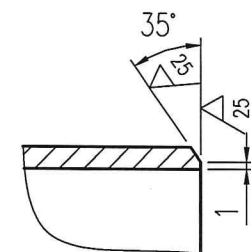
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次	15SCG2408-1-2-4-0
DESIGN 设计	许大宇	2025.2.28	SERIAL# 产品编号		87.8	1:2	0	
APPROVE 批准	赵晓娟	2025.2.28	24-1009EK1L		TOTAL-PAGES 共 张	No.-PAGE 第 张		

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件1和件5两端坡口详图
DETAIL OF END OF PART 1 AND 5

1:1



受控文件

技术要求:

- 1.翅片管的制造和检验按NB/T47030—2022《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- 2.φ42×4和φ60×4的钢管要求逐根涡流检测。
- 3.内管和外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10.56Mpa,水压试验后切割管子两端,两端坡口,倒角35°,钝边1mm。

Technical Notes:

1. The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2022 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 10.56MPa, cut ends of the tube groove after water pressure test, chamfer 35°, blunt edge of 1mm.

7	按本图 SEE THIS DWG	密封端盖 SEAL END CAPS	2	20	0.15	0.3	
6	按本图 SEE THIS DWG	套管φ70×4 L=300 SLEEVE	1	20		2.0	
5	按本图 SEE THIS DWG	钢管 φ60×4 L=4584 TUBE	1	SA-210 Gr.C		25.3	
4	按本图 SEE THIS DWG	翅片 t=1.5 H=21+1 DESCRIPTION	1	ST12		39.6	
3	按本图 SEE THIS DWG	堵头 φ103/φ61 t=35 END CAP	1	SA-283 Gr.C		1.4	
2	按本图 SEE THIS DWG	排气口组件 EXHAUST PORT ASSEMBLY	1	组合件		0.1	
1	按本图 SEE THIS DWG	钢管φ42×4 L=4685 TUBE	1	SA-210 Gr.C		18.6	
件号 PART NO.	图号或标准号 DRAWING OR STD. NO.	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.			
				ASSEMBLY		热管Ⅱ φ42×4/φ60×4	
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	2025.2.28	SERIAL# 产品编号	87.3	1:2	0	15SCG2408-1-2-5-0
APPROVE 批准	赵晓峰	2025.2.28	24-1009EK1L	TOTAL-PAGES 共 张	No.-PAGE 第 张		

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