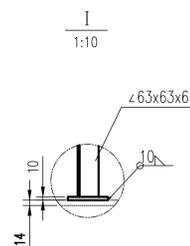
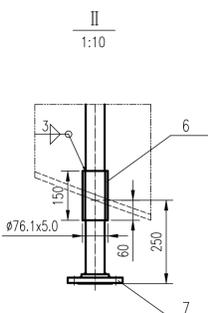
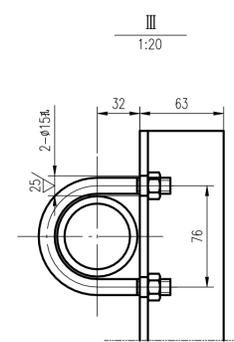
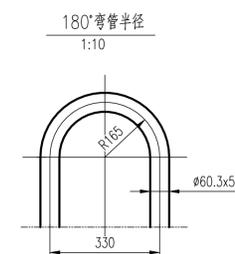
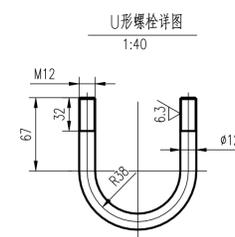
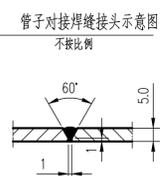
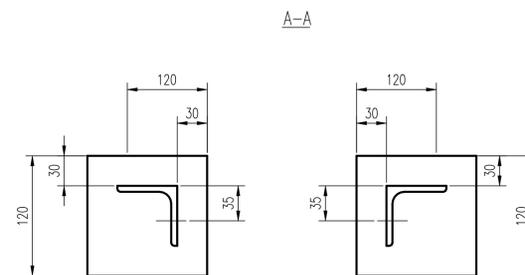


件号	D	Dx(C-1)	G1	G2	G3	L	每组传热面积 m ²
1	1600	1600x(14-1)=20800	990	845	815	22780	96.3
2	1600	1600x(14-1)=20800	560	893	803	21920	92.7
3	1600	1600x(12-1)=17600	1250	968	807	20100	85.1
4	1600	1600x(10-1)=14400	1320	968	807	17040	72.3
5	1600	1600x(6-1)=8000	920	按图	按图	9840	42.3

注: C为支架组数, G2尺寸为参考尺寸,实际尺寸现场测量



技术要求

- Technical requirement
- 管子对接接头形式及尺寸按本图所示。
 - The type and size of pipe butt joint are shown in this drawing.
 - 蒸汽盘管的对接必须满足以下要求:
 - The docking of steam coils must meet the following requirements:
 - 最短管长不得小于300mm,且弯管不得有折皱;
 - a. The shortest pipe length shall not be less than 300mm, and flat-fall seam is not allowed in the bend;
 - 对口错边量不得超过管子壁厚15%,且不大于0.5mm;
 - b. The offset of butt joint shall not exceed 15% of the pipe wall thickness, and shall not be greater than 0.5 mm;
 - 对接接头必须进行100%RT检测,并且符合NB/T47013.2《承压设备无损检测 第2部分:射线检测》中B级合格。
 - c. Butt joints shall be subjected to 100%RT inspection, and conform to Grade II in NB/T47013.2 Non-destructive Testing of Pressure Equipment Part 2: Radiographic Testing, with technical grade AB.
 - 盘管组装完毕后要进行水压试验,试验压力为1.01MPa,合格后方可使用。
 3. After the coil is assembled, conduct a water pressure test, the test pressure is 1.01MPa, and it can be used only after it is qualified.
 - 盘管组装时要用固定螺栓固定,注意不要固定太紧,以免膨胀损坏。
 4. Spot weld after the coil assembly is positioned with the fixing bolts. Be careful not to fix it too tightly to avoid expansion damage.

图号	名称	数量	材料	单位	数量	重量
12	垫板 120x120x10	224	Q235B	1.13	253.1	
11	螺母 M12	4928	8级	0.0159	78.4	
10	U形螺栓 12	2464	Q235A	0.223	549.5	
9	角钢 L6.3x6.3x6	112	Q235B	15.46	1731.5	L=2282
8	角钢 L6.3x6.3x6	112	Q235B	15.46	1731.5	L=2282
7	法兰 DN50-PN16 PL RF 1	20	20#	2.2	44	
6	管子 76.1x5.0 L=150	20	20	1.3	26	
5	管子 60.3x5.0 L=226.1m	2	20	1541.7	3083.4	
4	管子 60.3x5.0 L=383.6m	2	20	2615.7	5231.4	
3	管子 60.3x5.0 L=450.9m	2	20	3074.6	6149.2	
2	管子 60.3x5.0 L=490.9m	2	20	3347.4	6694.8	
1	管子 60.3x5.0 L=509.8m	2	20	3476.3	6952.6	

下件号	图号或标准号	名称	数量	材料	单位	数量	重量	备注
23	图号或标准号	组零件	32528	1:10	P01-323-JS-001-06	P01-323-JS-001-01		

设计	校核	审核	批准	日期
设计	校核	审核	批准	日期

比例 SCALE 1:100 图号 1 共 1 张