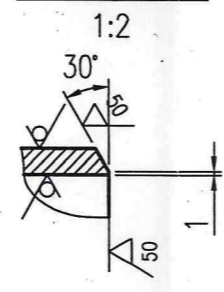
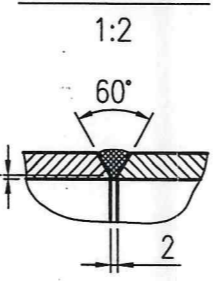


管端部坡口详图  
PIPE END DETAIL



管件对接详图  
PIPE BUTT JOINT DETAIL



技术要求

- 1.管子的制造按GB/T16507.5《水管锅炉 第5部分：制造》进行。
- 2.管子的检验按GB/T16507.6《水管锅炉 第6部分：检验、试验和验收》进行。
- 3.所有焊缝要求氩弧焊打底，并按NBT47013.2-2015进行100%射线检测，质量等级II级。
- 4.除现场焊接焊缝标记外，其余焊缝均在工厂内焊接。
- 5.件1长度为中心线展开长度，件2/3长度放40mm余量，供现场作补偿用，现场根据实际情况切割。
- 6.件4在图示法兰组件处（管子最底端）钻孔φ18，并在车间将法兰接管焊接完成，角焊缝需进行100%磁粉检测合格。
- 7.本组件出厂前须在厂里试组装，组装合格后在每段上标记S2/4/6/8。

Technical Requirements

- 1.The tubes shall be manufactured in accordance with GB/T16507.5 "Water-tube Boilers - Part 5: Manufacture".
- 2.The tubes shall be inspected in accordance with GB/T16507.6 "Water-tube Boilers - Part 6: Inspection, Testing and Acceptance".
- 3.All welds shall be root welded by argon arc welding and undergo 100% radiographic inspection according to NBT47013.2-2015, with quality level II.
- 4.Except for welds designated for site welding, all other welds shall be completed within the factory.
- 5.The length of Component 1 refers to the developed length along its centerline. An additional 40mm allowance is provided in the length of Component 2/3 for on-site compensation, and it shall be cut to the required length on-site based on actual conditions.
- 6.Drill a φ18mm hole at the indicated flange assembly location (at the lowest end of the tube) of Component 4, and complete the welding of the flange connection pipe in the workshop. The fillet welds shall be 100% qualified by magnetic particle testing (MT).
- 7.This assembly shall be trial-assembled in the factory prior to shipment. After passing the trial assembly, each segment shall be marked S2/4/6/8.

2609/0011/21

受控文件

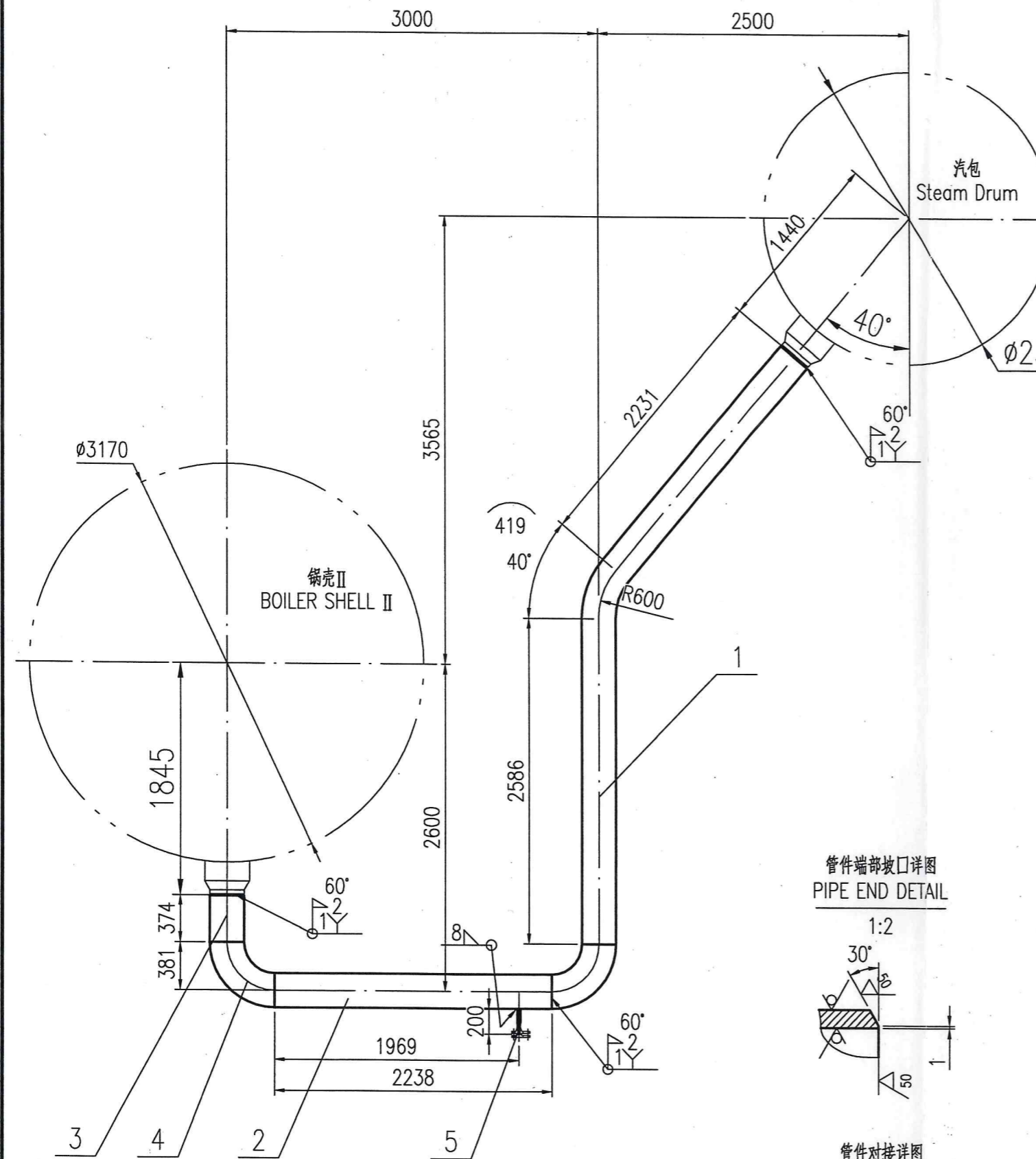
5	22SCG2506-1-5-0	疏水口组件 DRAIN ASSEMBLY	1	组合件 ASSEMBLY		5	
4	GB/T12459-2017	长半径90°弯头 DN250-II-14 LONG RADIUS 90°BEND	2	20G/GB/T5310	54	108	
3	按本图 SEE THIS DWG	管子 φ273×14 L=414 PIPE	1	20G/GB/T5310		37	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
2	按本图 SEE THIS DWG	管子 φ273×14 L=1778 PIPE	1	20G/GB/T5310		159	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
1	按本图 SEE THIS DWG	管子 φ273×14 L=5236 PIPE	1	20G/GB/T5310		468	
件号 PART NO.	图号或标准号 DRAWING OR STD. NO.	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 重量(kg) SINGLE	总 重量(kg) TOTAL	备注 REMARK

江苏索普赛瑞装备制造有限公司  
SOPO CERE Equipment Manufacturing Co., Ltd.

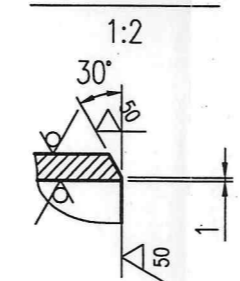
				组合件 ASSEMBLY			下降管 I DOWNCOMER
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	
DESIGN 设计	李学礼	2026.1.20	工艺	2026.1.20	777	1:40	0
CHECK 校对	黄杰	2026.1.20	批准	2026.1.20			
REVIEW 审核	许大宇	2026.1.20			TOTAL-PAGES 共 张 No.-PAGE 第 张		

22SCG2506-1-0

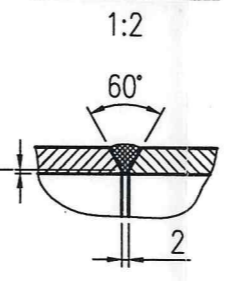
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管端部坡口详图  
PIPE END DETAIL



管件对接详图  
PIPE BUTT JOINT DETAIL



技术要求

- 管子的制造按GB/T16507.5《水管锅炉 第5部分：制造》进行。
- 管子的检验按GB/T16507.6《水管锅炉 第6部分：检验、试验和验收》进行。
- 所有焊缝要求氩弧焊打底，并按NBT47013.2-2015进行100%射线检测，质量等级II级。
- 除现场焊接焊缝标记外，其余焊缝均在工厂内焊接。
- 件1长度为中心线展开长度，件2/3长度放40mm余量，供现场作补偿用，现场根据实际情况切割。
- 件4在图示法兰组件处（管子最底端）钻孔 $\phi 18$ ，并在车间将法兰接管焊接完成，角焊缝需进行100%磁粉检测合格。
- 本组件出厂前须在厂里试组装，组装合格后在每段上标记S1/3/5/7。

Technical Requirements

- The tubes shall be manufactured in accordance with GB/T16507.5 "Water-tube Boilers - Part 5: Manufacture".
- The tubes shall be inspected in accordance with GB/T16507.6 "Water-tube Boilers - Part 6: Inspection, Testing and Acceptance".
- All welds shall be root welded by argon arc welding and undergo 100% radiographic inspection according to NBT47013.2-2015, with quality level II.
- Except for welds designated for site welding, all other welds shall be completed within the factory.
- The length of Component 1 refers to the developed length along its centerline. An additional 40mm allowance is provided in the length of Component 2/3 for on-site compensation, and it shall be cut to the required length on-site based on actual conditions.
- Drill a  $\phi 18$ mm hole at the indicated flange assembly location (at the lowest end of the tube) of Component 4, and complete the welding of the flange connection pipe in the workshop. The fillet welds shall be 100% qualified by magnetic particle testing (MT).
- This assembly shall be trial-assembled in the factory prior to shipment. After passing the trial assembly, each segment shall be marked S1/3/5/7.

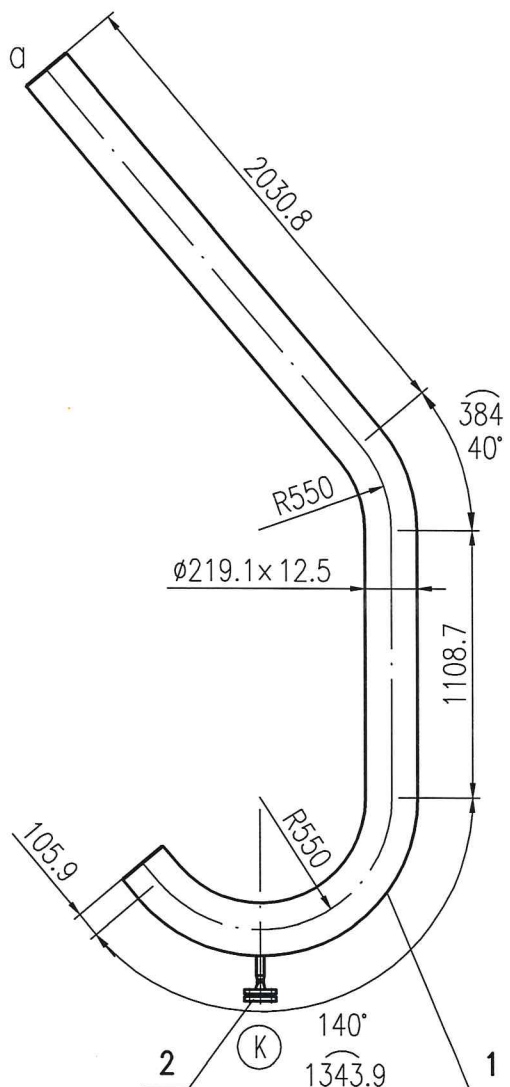
2600/2011/21

受控文件

5	22SCG2506-1-5-0	疏水口组件 DRAIN ASSEMBLY	1	组合件 ASSEMBLY		5	图纸复用 Drawing reuse
4	GB/T12459-2017	长半径90°弯头 DN250-II-14 LONG RADIUS 90° BEND	2	20G/GB/T5310	54	108	
3	按本图 SEE THIS DWG	管子 $\phi 273 \times 14$ L=414 PIPE	1	20G/GB/T5310		37	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
2	按本图 SEE THIS DWG	管子 $\phi 273 \times 14$ L=2278 PIPE	1	20G/GB/T5310		204	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
1	按本图 SEE THIS DWG	管子 $\phi 273 \times 14$ L=5236 PIPE	1	20G/GB/T5310		468	
件号 PART NO.	图号或标准号 DRAWING OR STD. NO.	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 重(kg) SINGLE	总 重(kg) TOTAL	备注 REMARK

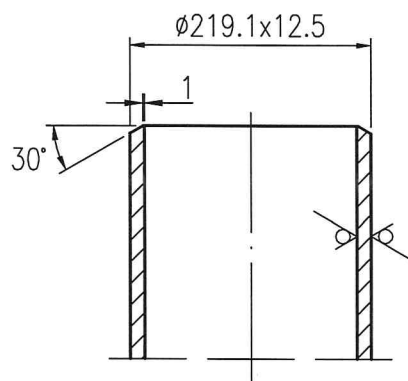
				江苏索普赛瑞装备制造有限公司 SOPO CERE Equipment Manufacturing Co., Ltd.			
				组合件 ASSEMBLY		下降管II DOWNCOMER	
				重量 WEIGHT(kg)	比例 SCALE		版次 REV.
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	822	1:40	0
DESIGN 设计	李学亮	2026.1.20	工艺 工艺	2026.1.20			
CHECK 校对	黄杰	2026.1.20	批准 批准	2026.1.20			
REVIEW 审核	许大宇	2026.1.20					
				TOTAL-PAGES 共 张	No.-PAGE 第 张		22SCG2506-2-0

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坡口详图

1:5



受控文件

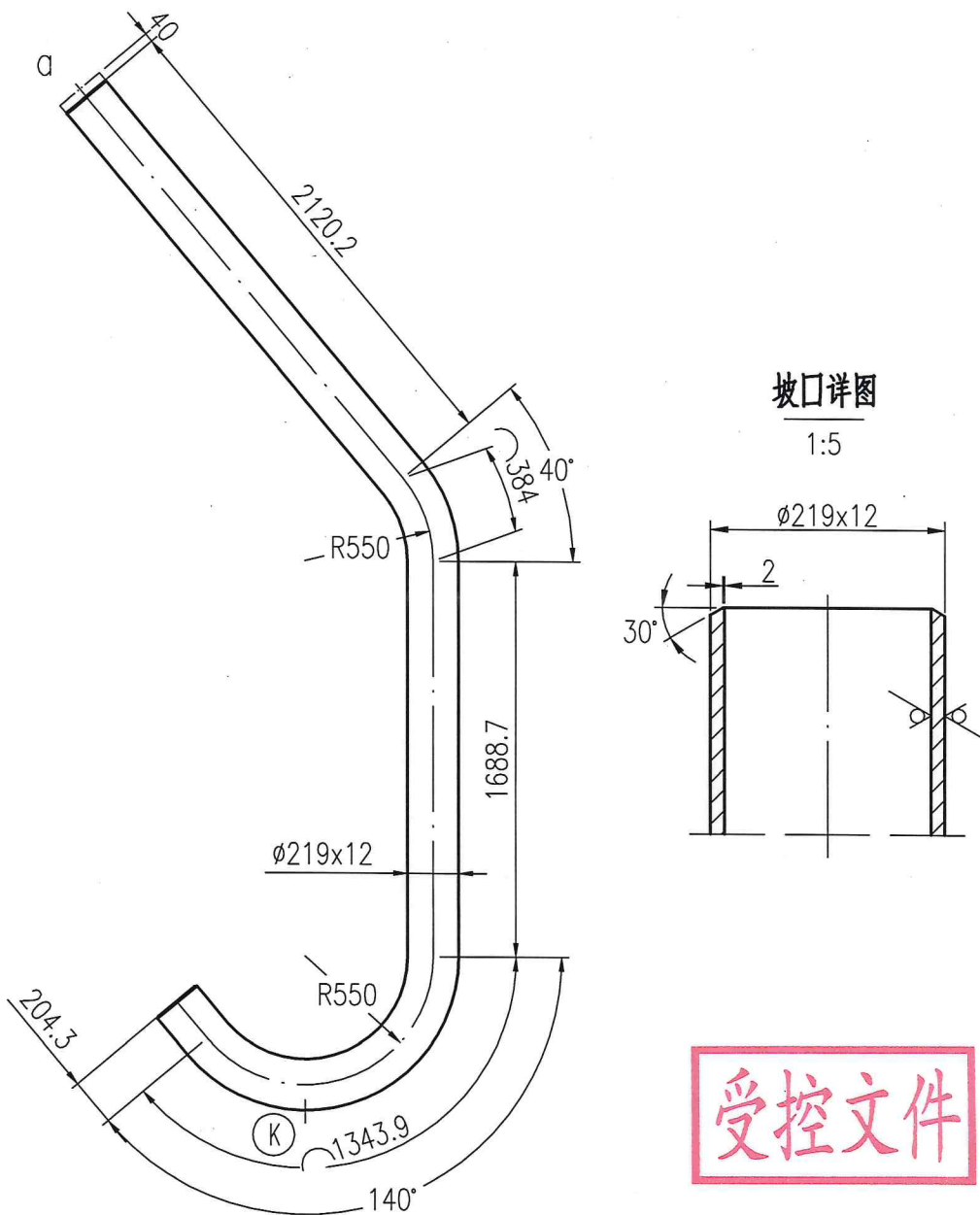
技术要求

- 1.管子的制造与检验按GB/T16507-2022《水管锅炉》进行。
- 2.本件a端放40mm余量，供预组装时切割。预组装合格后，按图加工两端坡口。其实际长度为：5013.3mm(含40mm余量)。
- 3.在K处(管子最底端)钻孔 $\phi 16$ 。

26007/0531

2	22SCG2508-1-2	疏水口组件	1	组合件	5.5		
1	按本图	下降管 $\phi 219.1 \times 12.5$	1	20G/GB/T5310	310		
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 重量(kg) SINGLE WEIGHT	总 重量(kg) TOTAL WEIGHT	备注 REMARK
<p><b>江苏索普赛瑞装备制造有限公司</b> SOPO CER E Equipment Manufacturing Co., Ltd.</p>							
				组合件	下降管 $\phi 219.1 \times 12.5$		
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期			
DESIGN 设计	李学亮	2026.1.8	工艺 内透	2026.1.8	315.5	1:30	0
CHECK 校对	黄杰	2026.1.8	批准 王德明	2026.1.8			
REVIEW 审核	许大宇	2026.1.8			TOTAL-PAGES 共 张		No.-PAGE 第 张
22SCG2508-1-0							

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受控文件

技术要求

1. 管子的制造按GB/T16507.5-2022《水管锅炉 第5部分：制造》进行。
2. 管子的检验按GB/T16507.6-2022《水管锅炉 第6部分：检验、试验和验收》进行。
3. 本件a端放40mm余量，供预组装时切割。预组装合格后，按图加工两端坡口。其实际长度为：5781.1mm(含40mm余量)。
4. 在K处（管子最底端）钻孔 $\phi 17$ 。

25057/171

					<b>江苏索普赛瑞装备制造有限公司</b> SOPO CERE Equipment Manufacturing Co., Ltd.		
					20G/GB/T5310		下降管 $\phi 219 \times 12$
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	
DESIGN 设计	李学亮	2025.12.24	工艺 陈德	2025.12.24	354.1	1:30	0
CHECK 校对	黄杰	2025.12.24	APPROVE 批准	王德明	2025.12.24		
REVIEW 审核	许大宇	2025.12.24			TOTAL-PAGES 共 张	No.-PAGE 第 张	22SCG2504-1

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