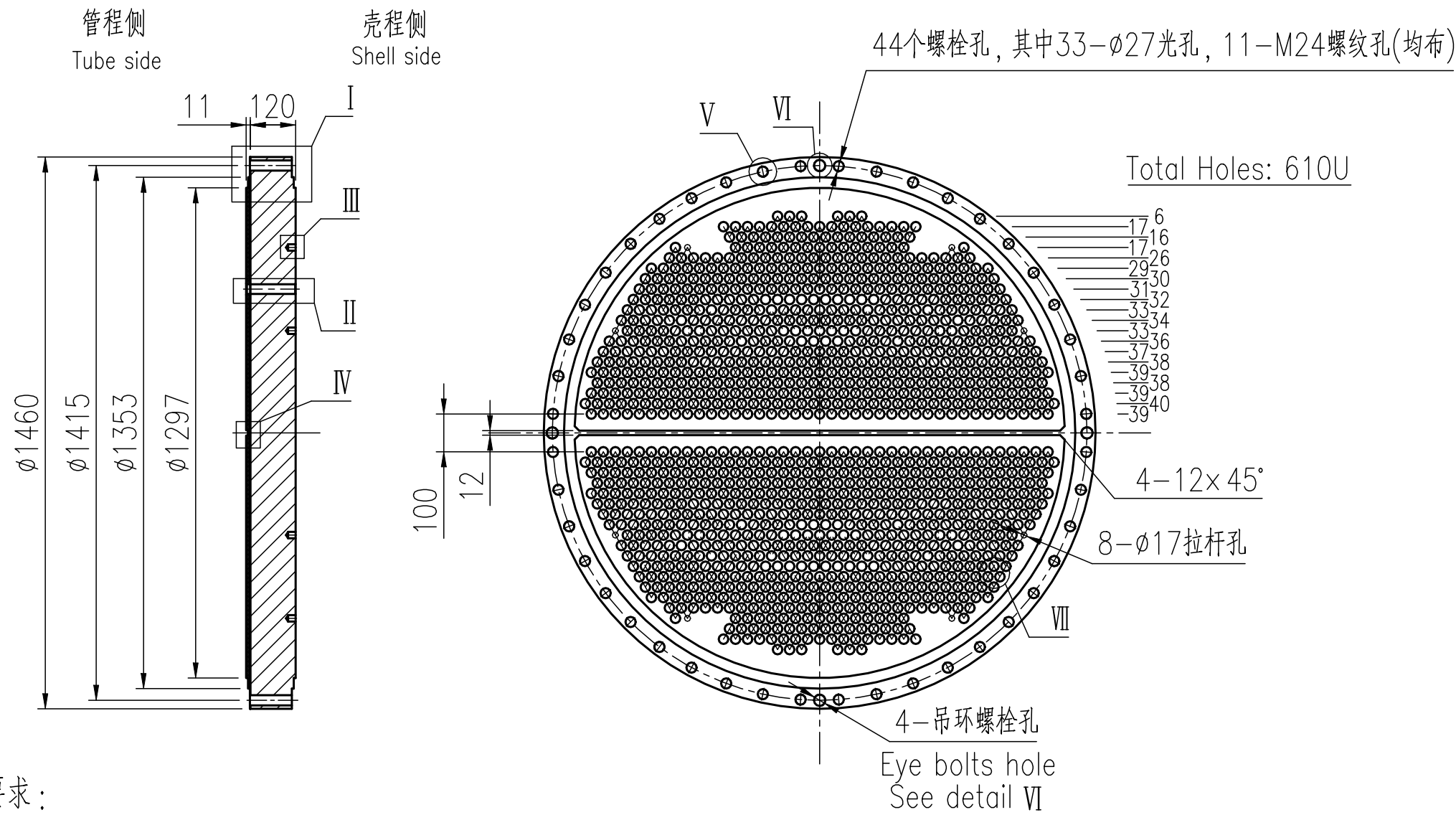
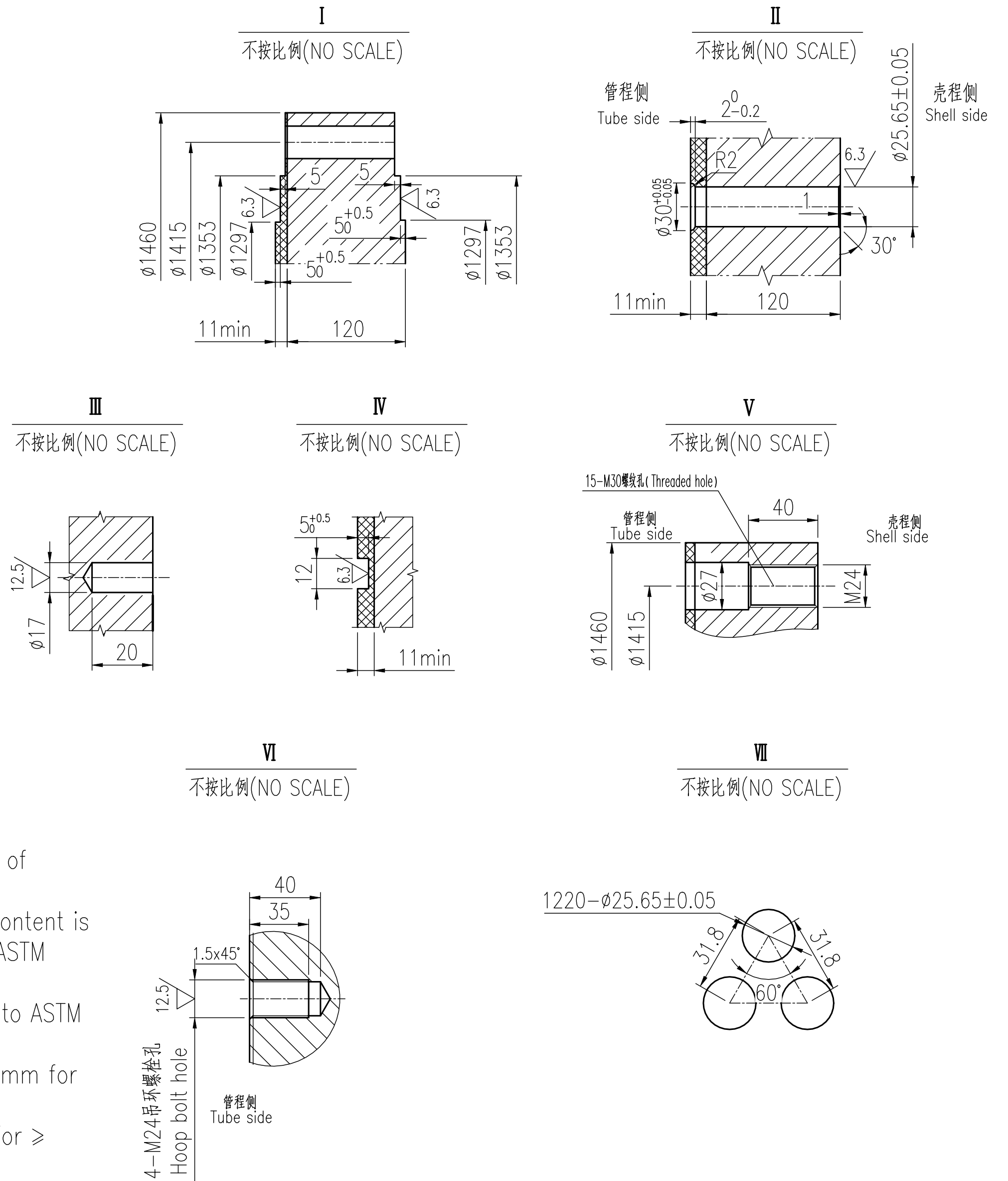


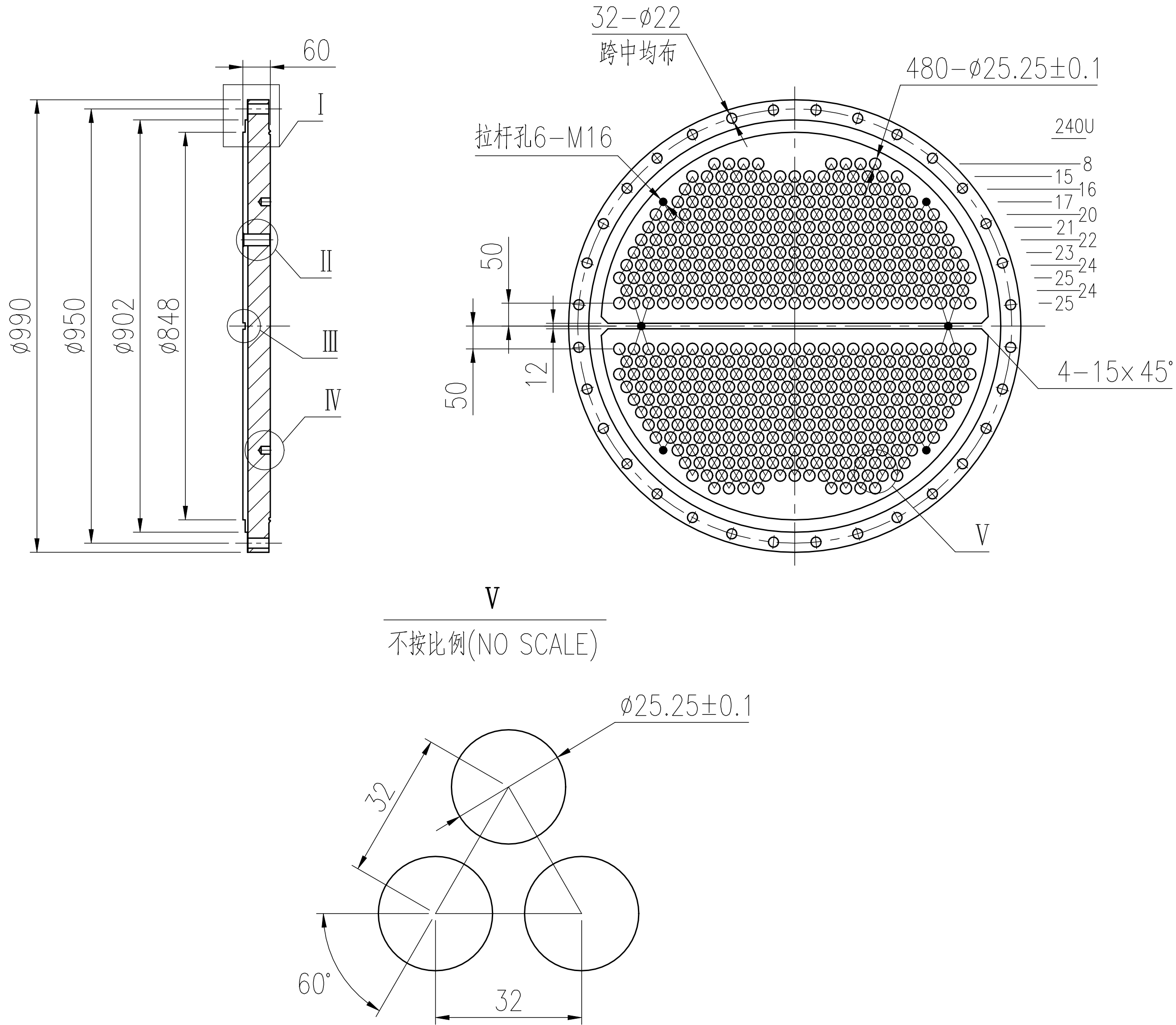


技术要求:

1. 基材按 SA-266 2 的要求制造, 检验, 验收, 供货状态为正火。
 2. 管板覆层材料符合SA-240M 310S要求, 同时要求碳含量小于等于0.06%, ASTM A262 E法进行晶间腐蚀试验。
 3. 复合管板要求满足标准SA-264, 并按ASTM A 578进行100%UT检测, 不允许有未贴合, 供货状态为正火。
 4. 密封面应与管板轴线垂直, 其垂直度允差为0.500mm。
 5. 管板钻孔后, 终钻侧 $\geq 96\%$ 孔桥宽度必须 $\geq 4.97\text{mm}$, 允许最小孔桥宽度为 $\geq 3.69\text{mm}$ 。
 6. 管孔应严格垂直于管板密封面, 其垂直度公差为0.120mm, 孔表面不允许存在贯通的纵向条纹。
 7. 管板密封面及表面不得有裂纹及其它降低强度或连接可靠的缺陷。
 8. 图中加工面的未注尺寸公差按"TEMA R"的要求。
 9. 管板覆层机加工后最小成型厚度需要不小于11mm。
 1. The substrate shall be manufactured, inspected, and accepted in accordance with the requirements of SA-266 2.
 2. The cladding material of the tube plate meets the requirements of SA-240 310S, and the carbon content is required to be less than or equal to 0.06%. The intergranular corrosion test shall be conducted using ASTM A262 E method
 3. The composite pipe plate shall meet the standard SA-264 and undergo 100% UT testing according to ASTM A 578. No non bonding is allowed and the supply status shall be normalized.
 4. The sealing surface should be perpendicular to the axis of the tube plate, with a tolerance of 0.500mm for perpendicularity.
- After drilling the tube plate, the bridge width of the hole on the final drilling side must be $\geq 4.97\text{mm}$ for $\geq 96\%$ of the holes, and the minimum allowable bridge width is $\geq 3.69\text{mm}$.
6. The pipe holes should be strictly perpendicular to the sealing surface of the pipe plate, with a perpendicularity tolerance of 0.120mm, and there should be no longitudinal stripes passing through the hole surface.
 7. The sealing surface and surface of the tube plate shall not have cracks or other defects that reduce strength or ensure reliable connection.
 8. The unmarked dimensional tolerances of the machined surface in the figure shall comply with the requirements of "TEMA R".
 9. The minimum forming thickness of the tube sheet coating after machining needs to be no less than 11mm.

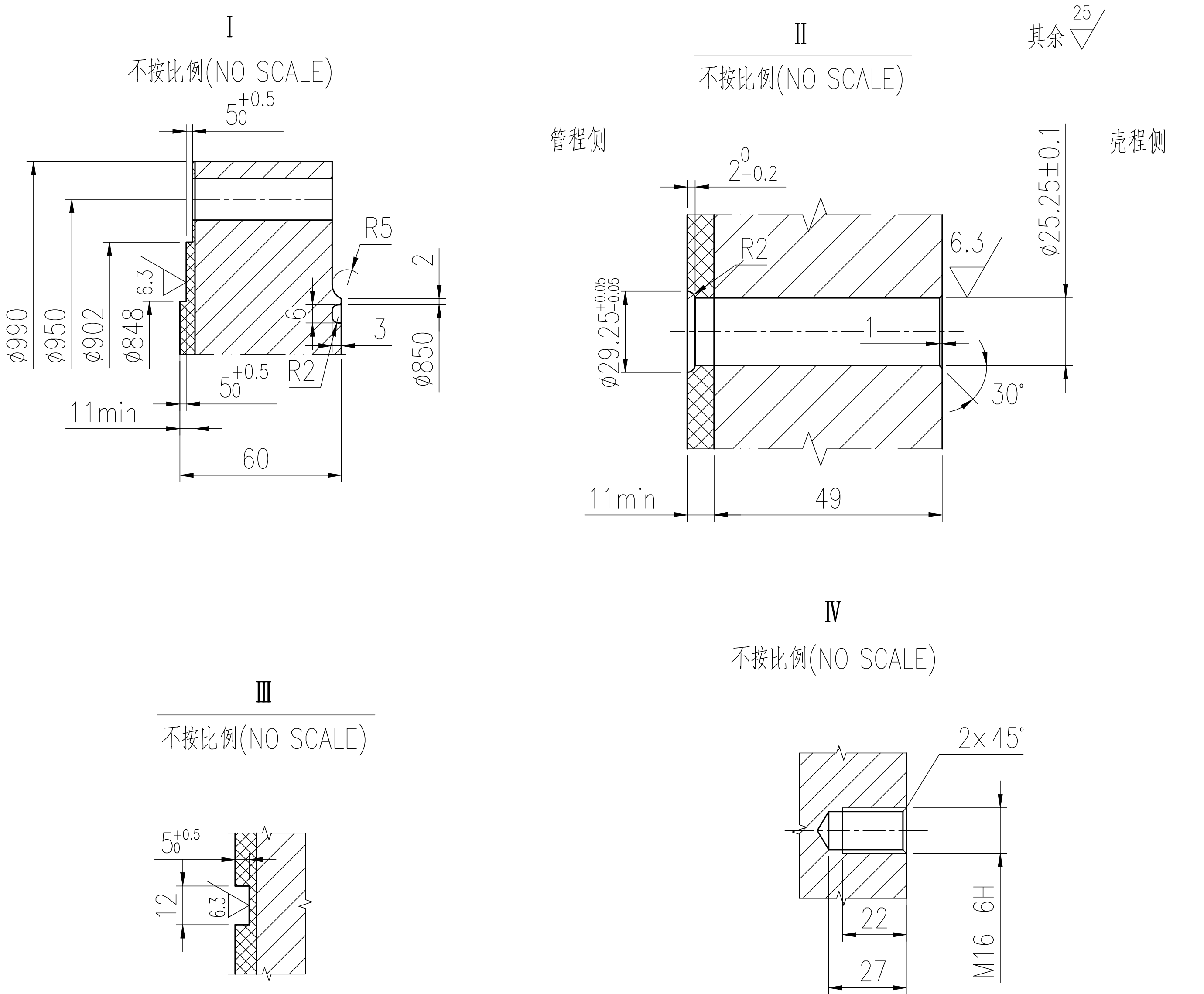


2-1	管板 Tube Sheet	SA-266 2+SA-240M 310S	1080	/	SCR-147-3	SCR-147-3
件号 PART NO.	名 称 DESCRIPTION	材 料 MATERIAL	重量(kg) WEIGHT	比例 SCALE	所在图号 DRAWING NO.	装配图号 ASS. DWG. NO.



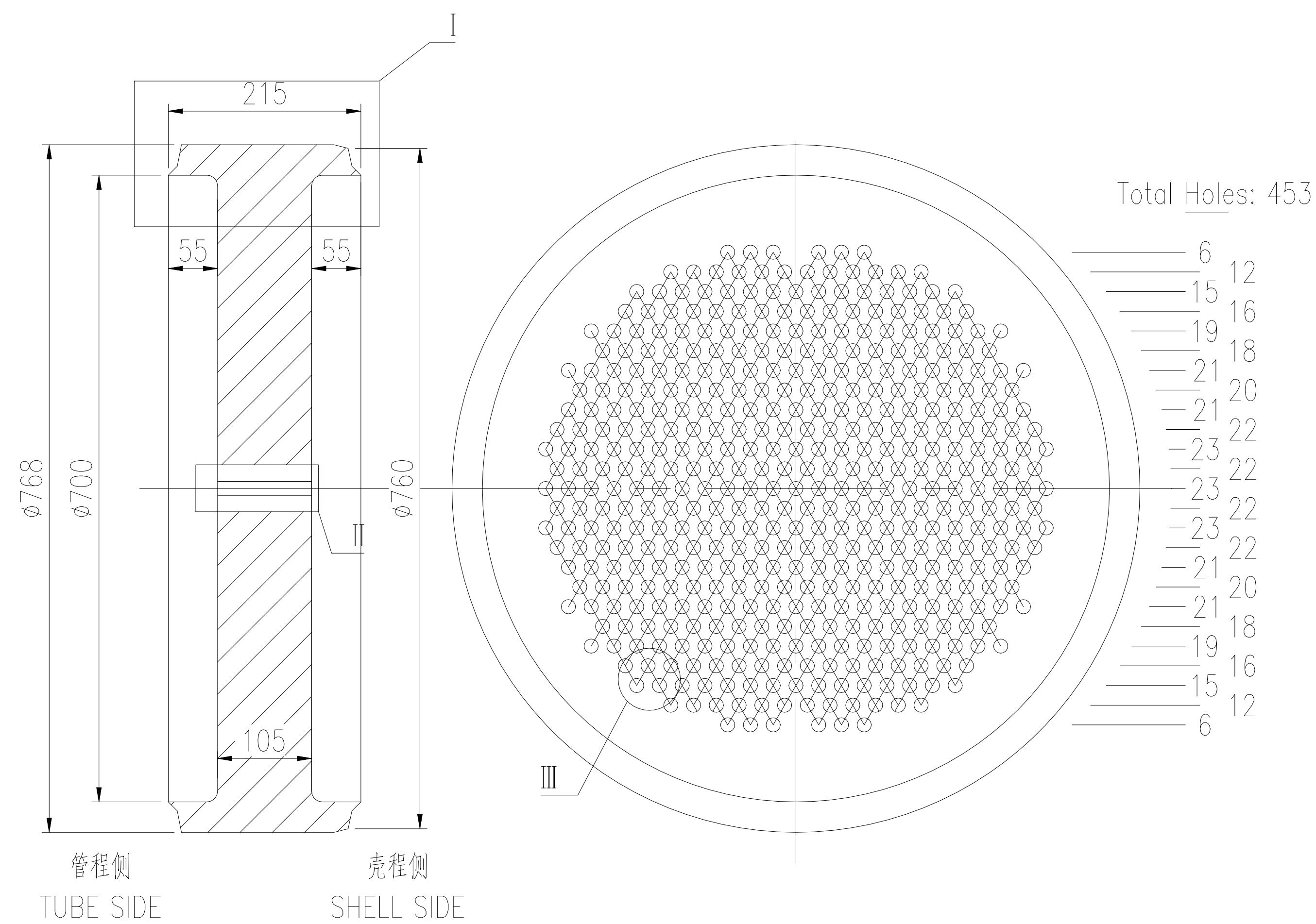
技术要求：

- 1.基材按 NB/T 47008-2017 的要求制造，检验，验收，供货状态为正火。
- 2.管板覆层材料符合GB/T 713.7-2023要求，供货状态为固溶
- 3.复合管板要求满足标准NB/T 47002.1-2019，贴合质量为B1级，不允许有未贴合，供货状态为正火。
- 4.密封面应与管板轴线垂直，其垂直度允差为0.30mm。
- 5.管板钻孔后，终钻侧≥96%孔桥宽度必须≥5.79mm，允许最小孔桥宽度为≥4.05mm。
- 6.管孔应严格垂直于管板密封面,其垂直度公差为0.08mm,孔表面不允许存在贯通的纵向条纹。
- 7.管板密封面及表面不得有裂纹及其它降低强度或连接可靠的缺陷。
- 8.管板覆层机加工后最小成型厚度需要不小于11mm。
- 9.除注明外，机械加工面线性尺寸极限偏差按GB/T 1804《一般公差未注公差的线性和角度尺寸的公差》第m级精度要求。



4	复合管板	16MnⅢ+S31008	243	/	SCR-154-2	SCR-154-0
件号 PART NO.	名 称 DESCRIPTION	材 料 MATERIAL	重(kg) WEIGHT	比例 SCALE	所在图号 DRAWING NO.	装配图号 ASS. DWG. NO.
版次	修 改 内 容	日期	修 改	校 对	审 核	
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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.					项目名称 ENTRY NAME	云南三环
设计 DESIGN			硫酸蒸发器 零件图		设计阶段 DESIGN PHASE	施工图
校对 CHECK					比例 SCALE	1:15 版本REV. 0
标准化审查 S.T.D					第 1 张 SHEET	共 1 张 TOT.
审核 REVIEW					图 号	SCR-154-2
批准 RATIFY					DWG NO.	

其余 25 /
the rest



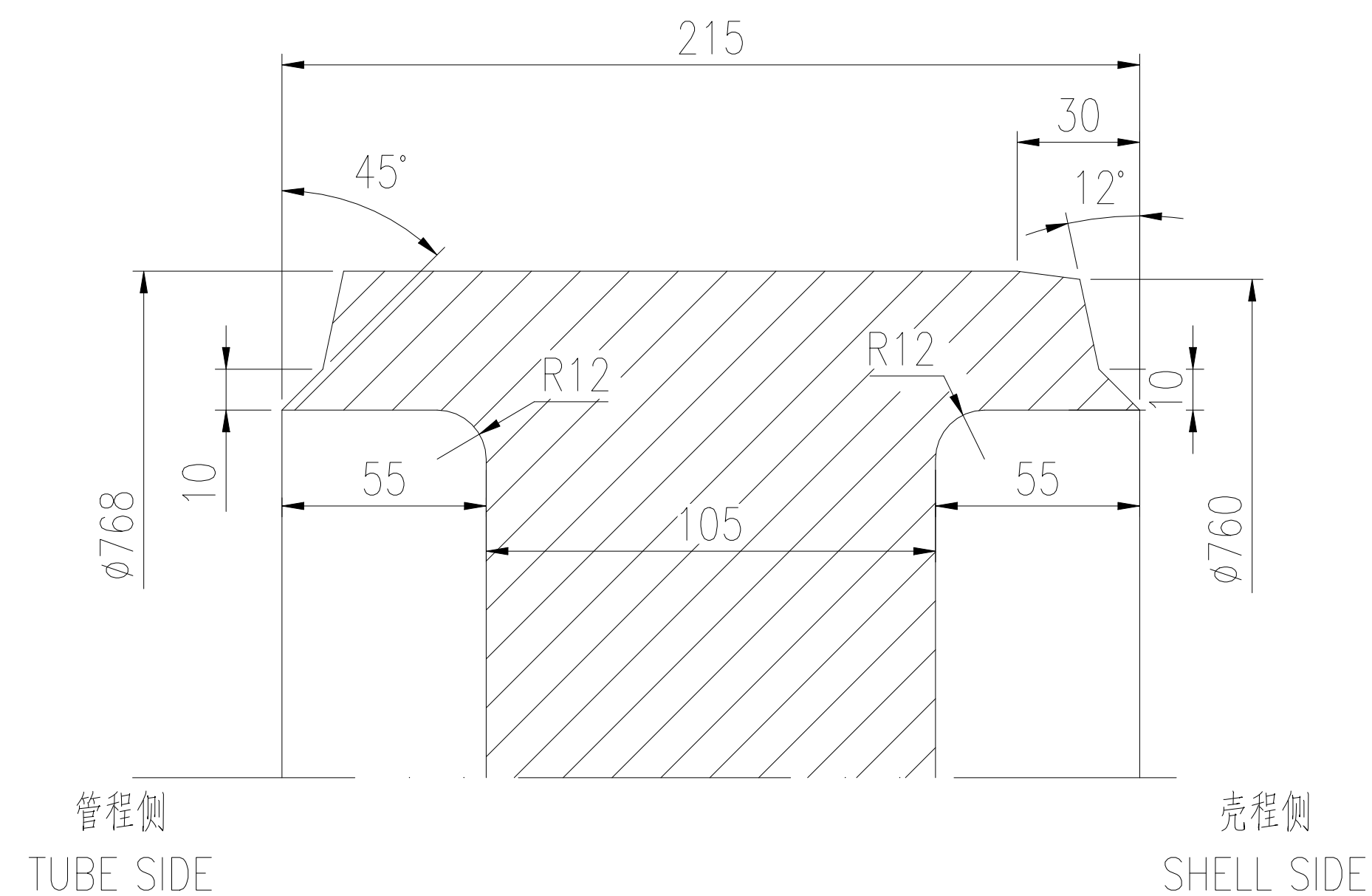
技术要求:

- 管板密封面应与轴线垂直, 其垂直度公差为0.300mm.
- 管孔应严格垂直于管板密封面, 其垂直度公差为0.120mm, 孔表面不允许存在贯通的纵向条痕.
- 管板钻孔后(出钻侧) $\geq 96\%$ 孔桥宽度必须 $\geq 8.674\text{mm}$, 允许的最小孔桥宽度($\leq 4\%$ 的孔桥数)为4.547mm.
- 图中加工面的未注尺寸公差按"TEMA R"的要求.

Technical requirements:

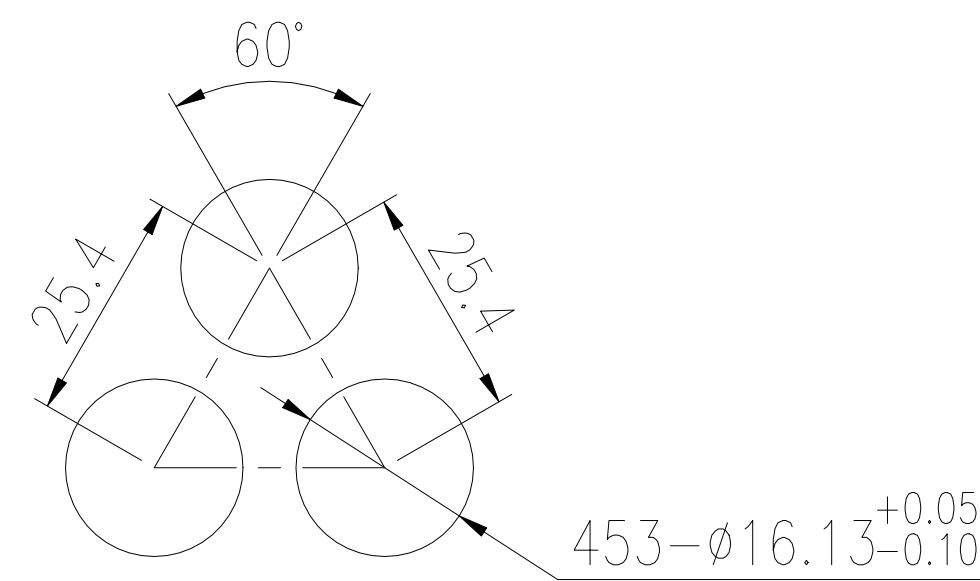
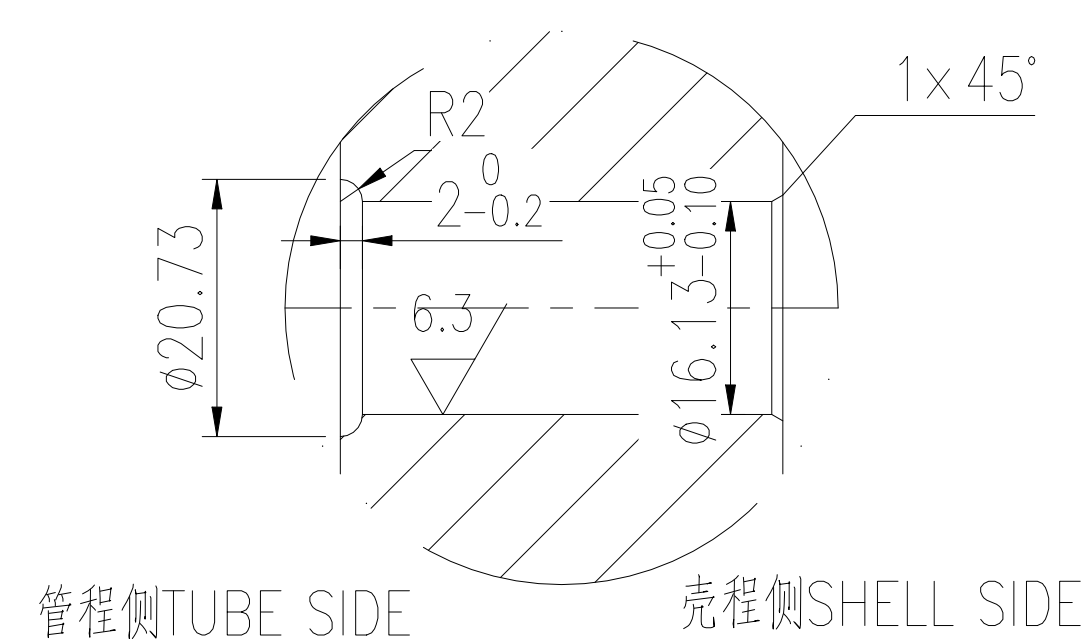
- The sealing surface of the tube plate should be perpendicular to the axis, with a perpendicularity tolerance of 0.300mm
- The pipe hole should be strictly perpendicular to the sealing surface of the pipe plate, with a perpendicularity tolerance of 0.120mm, and there should be no longitudinal stripes passing through the surface of the hole.
- After drilling the tube plate (exit side), the allowable hole bridge width must be $\geq 8.674\text{mm}$ for $\geq 96\%$, and the minimum allowable hole bridge width is 4.547mm.
- The unmarked dimensional tolerances of the machined surface in the figure shall comply with the requirements of "TEMA R".

I
不按比例(NO SCALE)

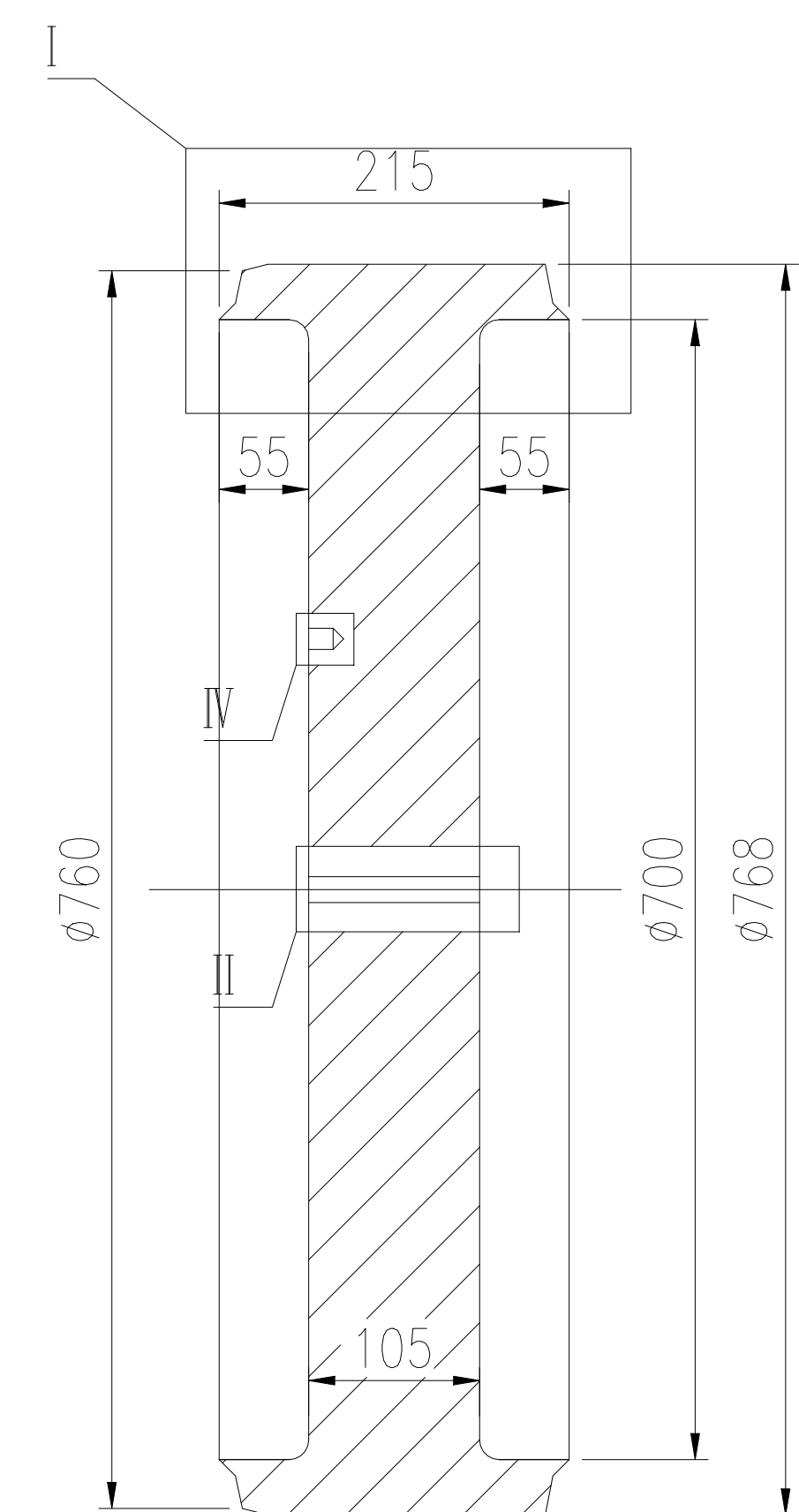


II
不按比例(NO SCALE)

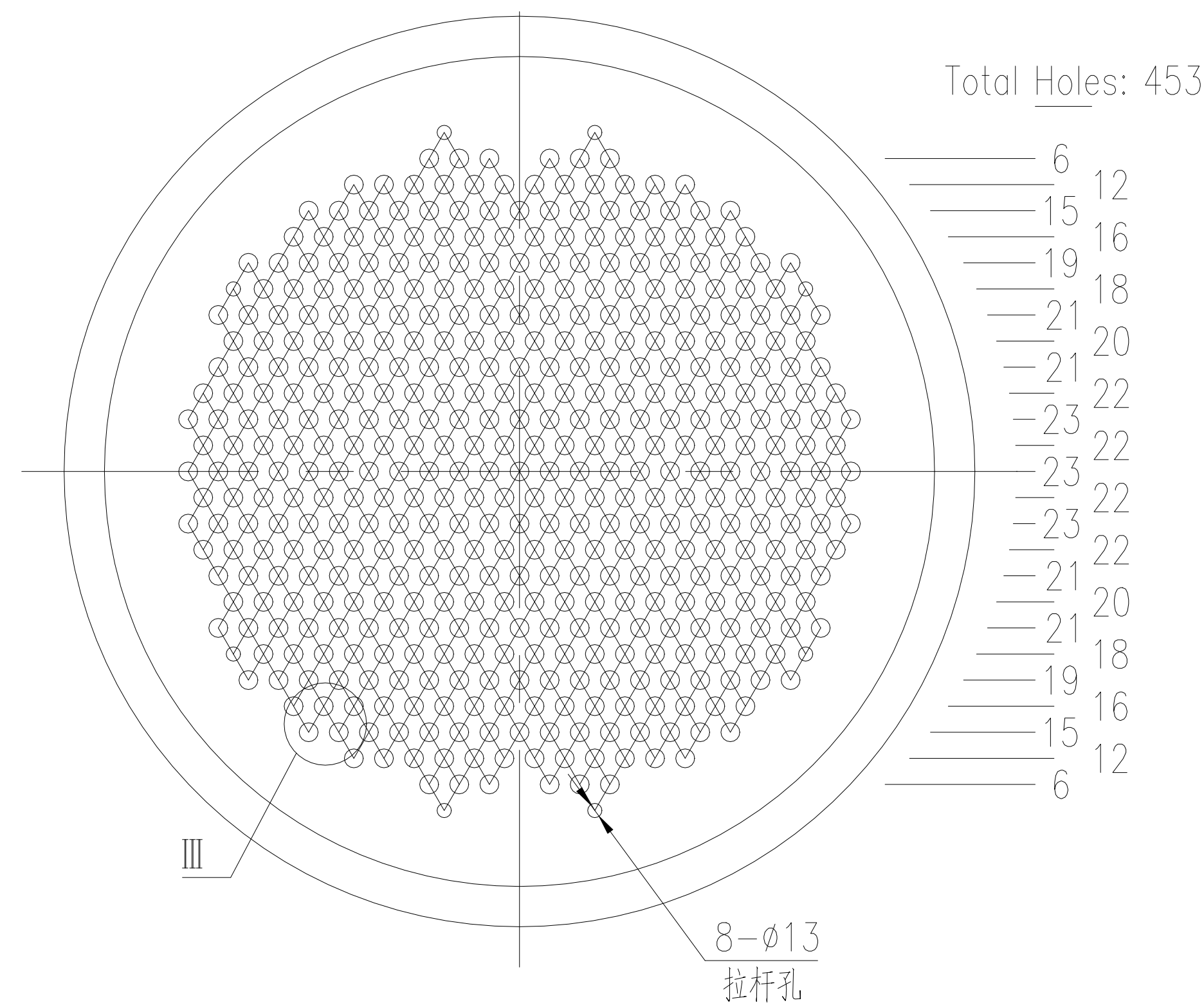
III
不按比例(NO SCALE)



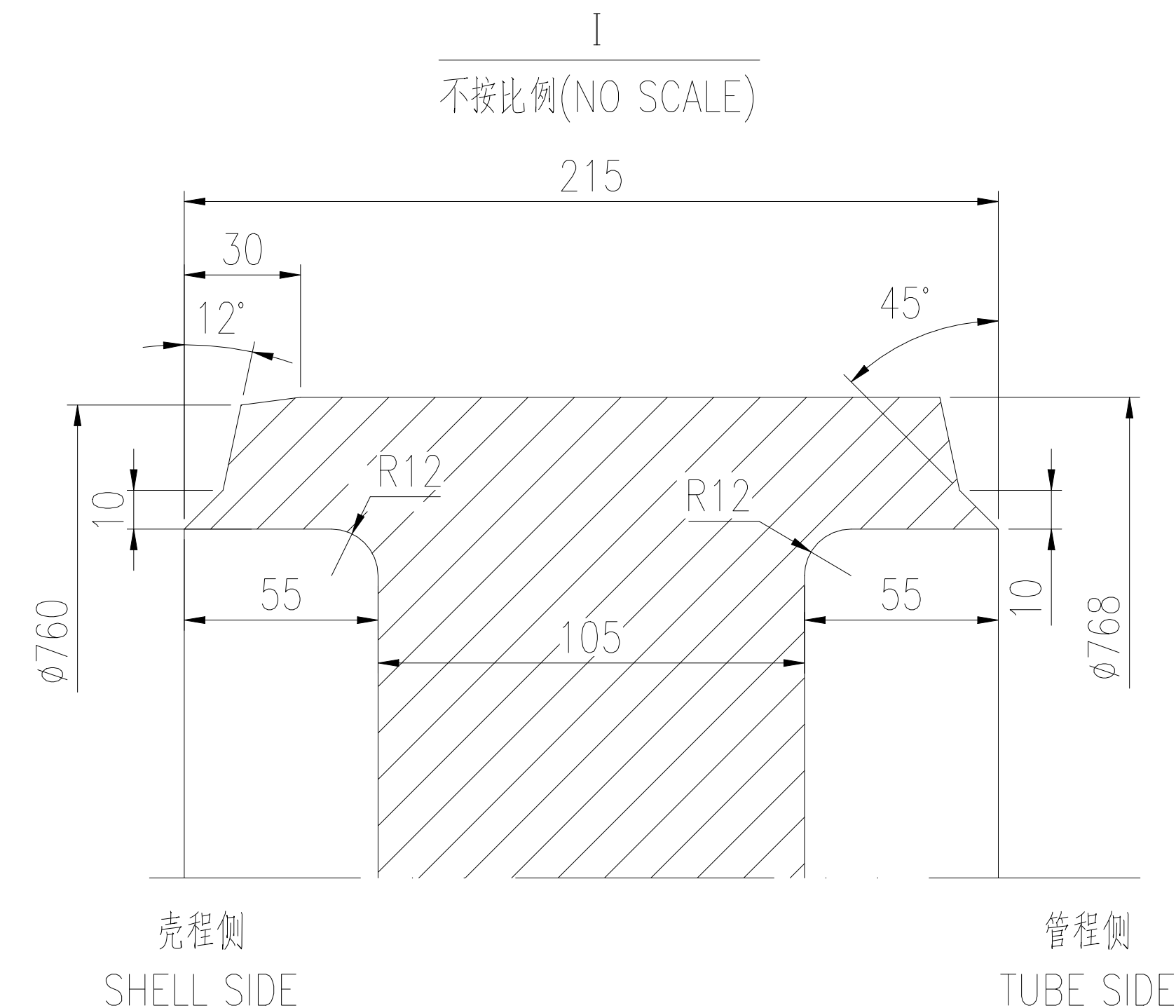
19	左管板 Left tube plate	SA-985 F310	370	/	SCR-149-2	SCR-149-0
件号 PART NO.	名 称 DESCRIPTION	材 料 MATERIAL	重(kg) WEIGHT	比例 SCALE	所在图号 DRAWING NO.	装配图号 ASS. DWG. NO.



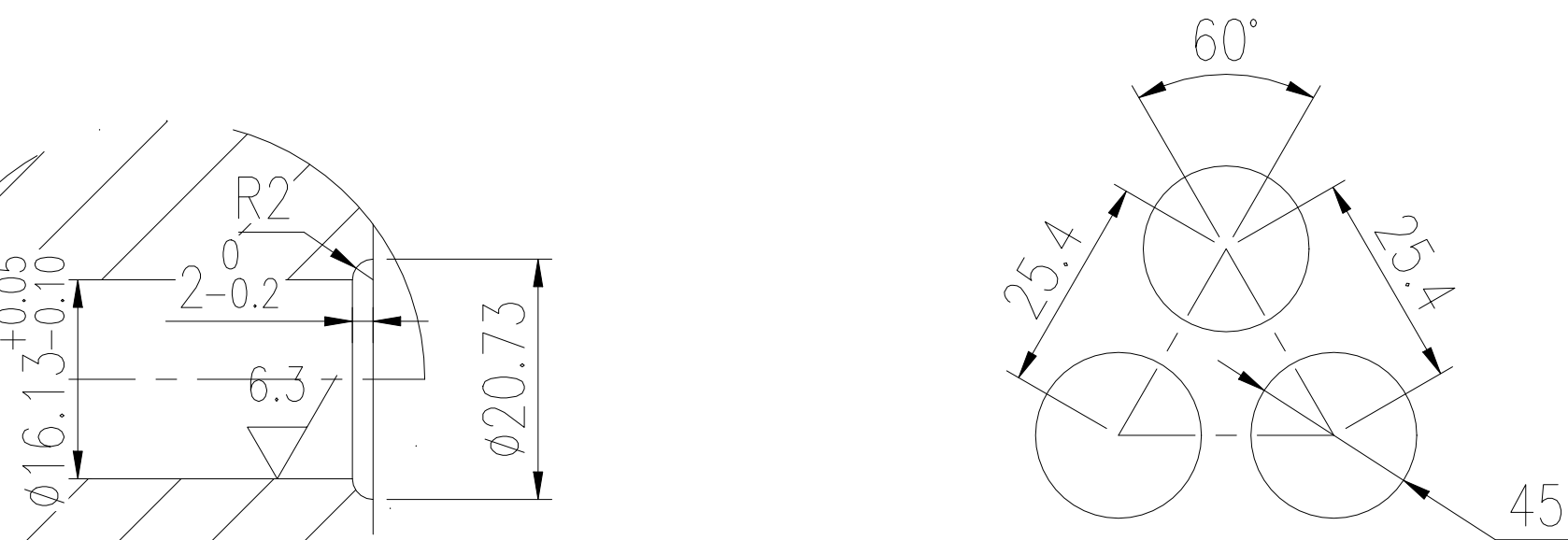
壳程侧
SHELL SIDE



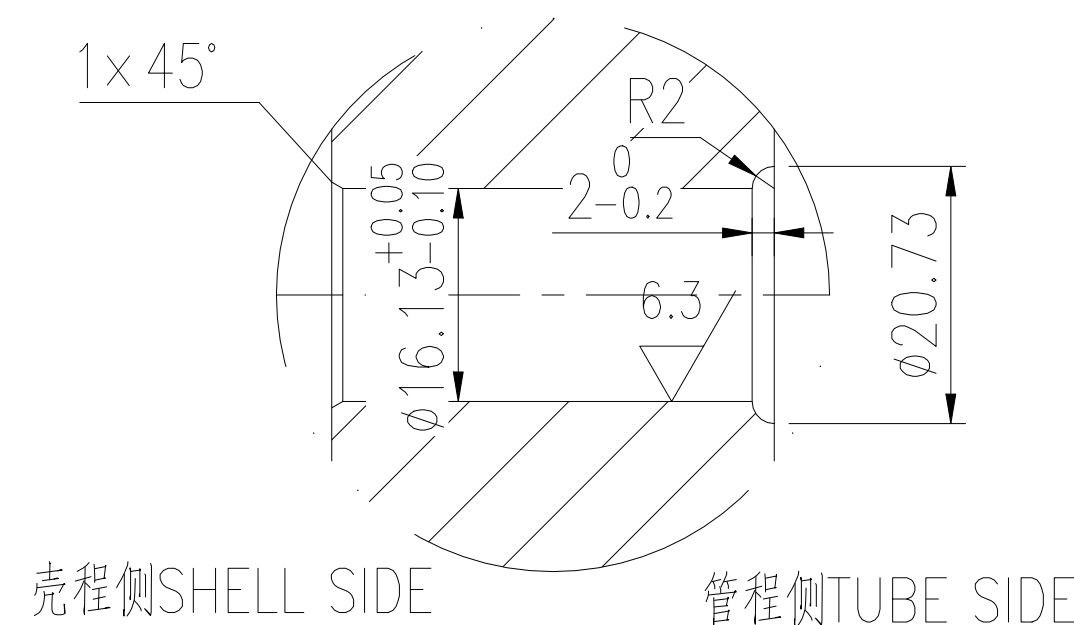
管程侧
TUBE SIDE



壳程侧
SHELL SIDE

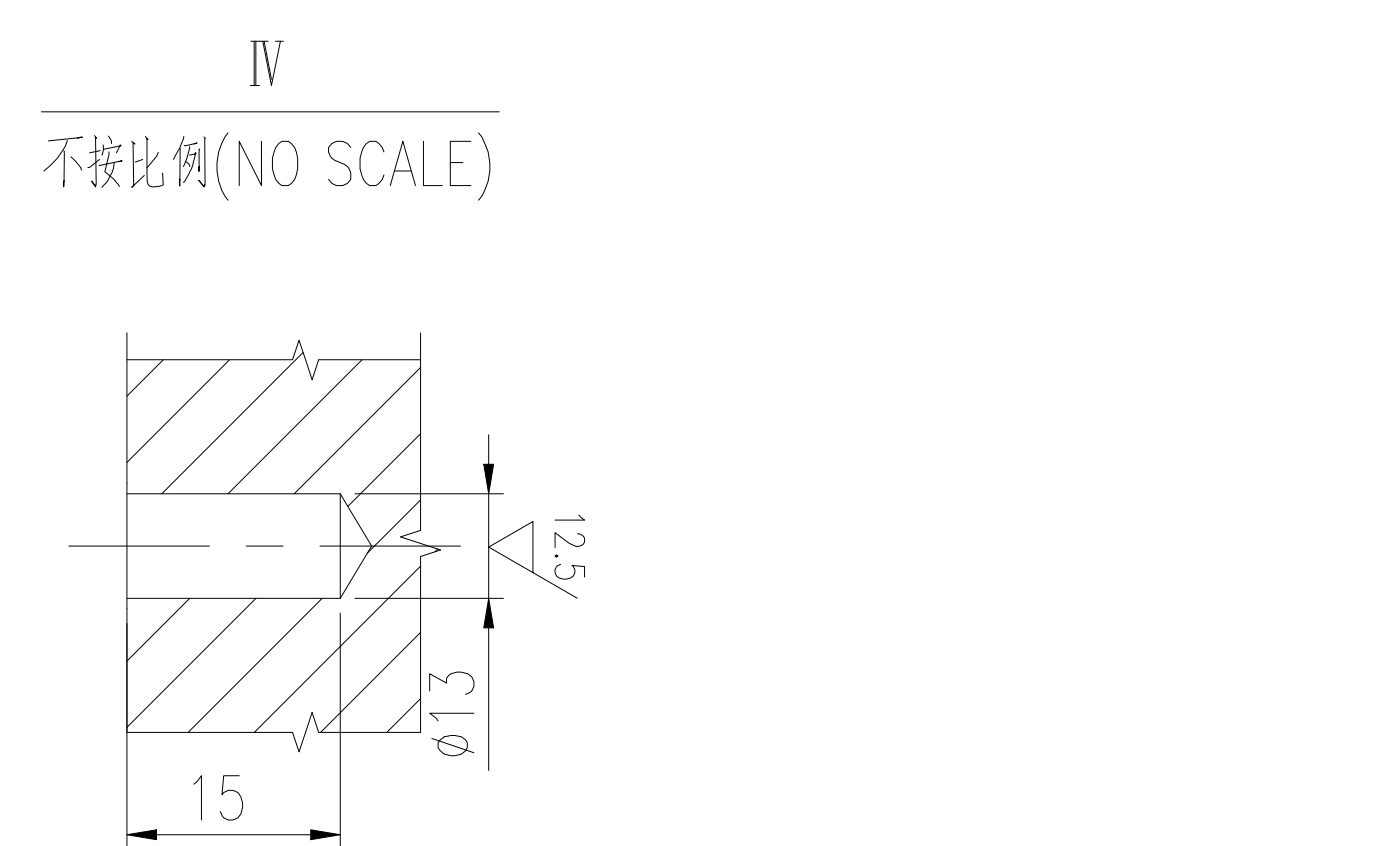


管程侧
TUBE SIDE



壳程侧
SHELL SIDE

管程侧
TUBE SIDE



管程侧
TUBE SIDE

技术要求：

- 1、管板密封面应与轴线垂直，其垂直度公差为0.300mm。
- 2、管孔应严格垂直于管板密封面，其垂直度公差为0.120mm，孔表面不允许存在贯通的纵向条痕。
- 3、管板钻孔后（出钻侧） $\geq 96\%$ 孔桥宽度必须 $\geq 8.674\text{mm}$ ，允许的最小孔桥宽度（ $\leq 4\%$ 的孔桥数）为4.547mm。
- 4、图中加工面的未注尺寸公差按“TEMA R”的要求。

Technical requirements:

1. The sealing surface of the tube plate should be perpendicular to the axis, with a perpendicularity tolerance of 0.300mm
2. The pipe hole should be strictly perpendicular to the sealing surface of the pipe plate, with a perpendicularity tolerance of 0.120mm, and there should be no longitudinal stripes passing through the surface of the hole.
3. After drilling the tube plate (exit side), the allowable hole bridge width must be $\geq 8.674\text{mm}$ for $\geq 96\%$, and the minimum allowable hole bridge width is 4.547mm.
4. The unmarked dimensional tolerances of the machined surface in the figure shall comply with the requirements of "TEMA R".

15	右管板 Right tube plate	SA-965 F310	370	/	SCR-149-2	SCR-149-0
件号 PART NO.	名 称 DESCRIPTION	材 料 MATERIAL	重(kg) WEIGHT	比例 SCALE	所在图号 DRAWING NO.	装配图号 ASS. DWG. NO.