

技术规程：

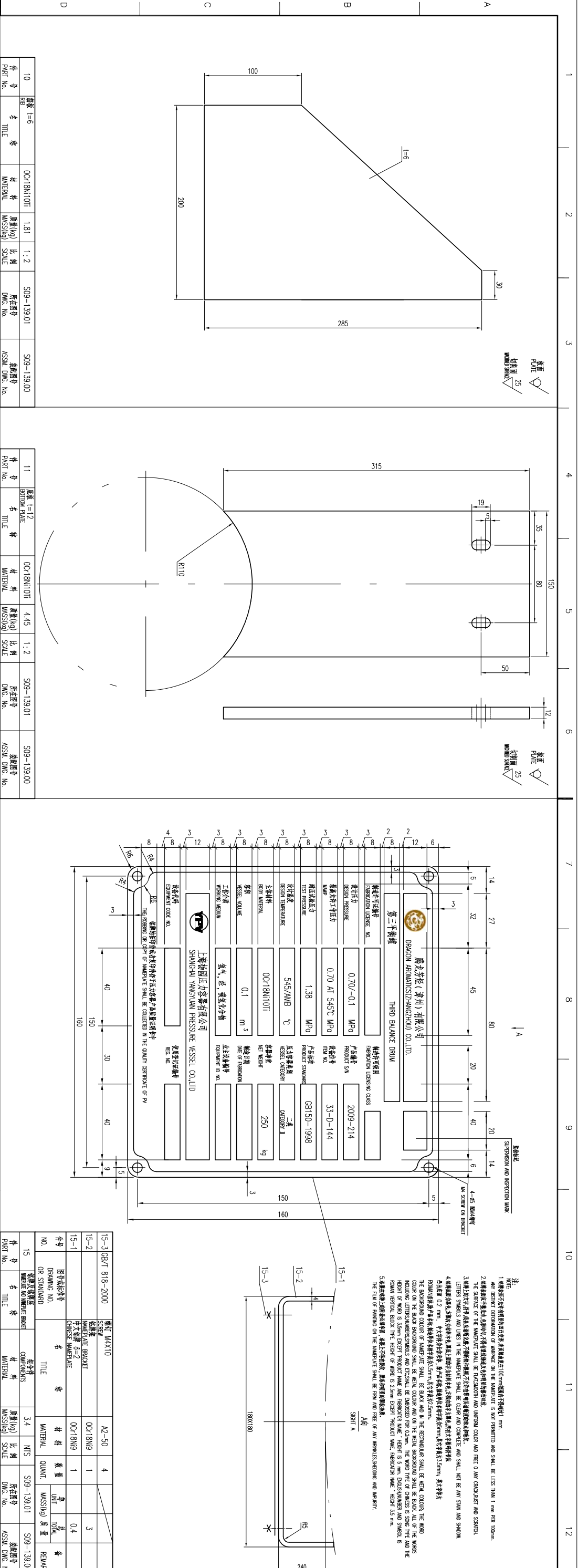
1. 排放标准GB20653-1998, 所用材料注明内，均为强制性。
2. 小面积材料按普通用途为分类控制，大面积材料按重点分类控制。
3. 焊接规范及焊接参数：表B/6/7/08-2000。
4. 着色材料OC18/NITON 蓝浆：B4728-2000合格。
5. 所有不得材料均当在任意位置机械老化。
6. DUK<25%厚度按与上述材料一致进行100%F，表B/6/7/20-2006中41 级合格。
7. 设备经三次冲击后应无裂纹等中点或裂纹行线。

| 设计数据表                     |                   |                                               |                              |                        |                                                      |                      |                       |                      |                             |
|---------------------------|-------------------|-----------------------------------------------|------------------------------|------------------------|------------------------------------------------------|----------------------|-----------------------|----------------------|-----------------------------|
| 设计参数                      |                   |                                               |                              |                        | 设计制造标准                                               |                      |                       |                      |                             |
| DESIGN PARAMETER          |                   |                                               |                              |                        | DESIGN, FABRICATION AND INSPECTION STANDARDS & NOTES |                      |                       |                      |                             |
| 容器类别<br>VESSEL CATEGORY   | 二类<br>CATEGORY II | 介质、环境、腐蚀介质物<br>MEDIUM, ENVIRONMENT, CORROSION | 介质特性<br>FLUAMIDE & EXPLOSIVE | 介质密度<br>MEDIUM DENSITY | 工作压力<br>WORKING PRESS.                               | 设计温度<br>DESIGN TEMP. | 设计压力<br>DESIGN PRESS. | 筒体厚度<br>CORR. ALLOW. | 焊接材料<br>WELDING METEORIAL   |
| 工作压力<br>WORKING TEMP.     | (°C)              | 5.65/AMB                                      |                              |                        | (MPa-G)                                              | 0.70/-0.1            |                       | 0                    | 焊接材料<br>WELDING METEORIAL   |
| 工作压力<br>WORKING PRESS.    | (MPa-G)           | 0.35                                          |                              |                        |                                                      |                      |                       | 1                    | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 筒体厚度<br>CORR. ALLOW.      | (mm)              | 0                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 焊接材料<br>WELDING METEORIAL | 材料牌号<br>MATERIAL  | 1                                             |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计温度<br>DESIGN TEMP.      | (°C)              | 545                                           |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL   |
| 设计压力<br>DESIGN PRESS.     | (MPa-G)           | 0.70/-0.1                                     |                              |                        |                                                      |                      |                       |                      | 焊接材料<br>WELDING METEORIAL</ |

| 管口表            |           |                 |            |                   |            |                |                          |                               |                   |
|----------------|-----------|-----------------|------------|-------------------|------------|----------------|--------------------------|-------------------------------|-------------------|
| LIST OF NOZZLE |           |                 |            |                   |            |                |                          |                               |                   |
| 序号<br>ITEM     | 数量<br>QTY | 公称尺寸<br>N. SIZE | 公称压力<br>PN | 技术标准<br>CON. STD. | 法兰<br>TYPE | 连接形式<br>FACING | 焊接或名称<br>WELDING SERVICE | 管口外径<br>SPAD OUT<br>PIPE SIZE | 接管规格<br>PIPE SIZE |
| 11             | 1         | 80(3/1)         | CL300      | ASME B16.5-2003   | WN         | RF             | 对接法兰<br>WELDING SERVICE  | 80                            | Φ89X5             |
| 01             | 1         | 80(3/1)         | CL300      | ASME B16.5-2003   | WN         | RF             | 对接法兰<br>WELDING SERVICE  | 80                            | Φ89X5             |

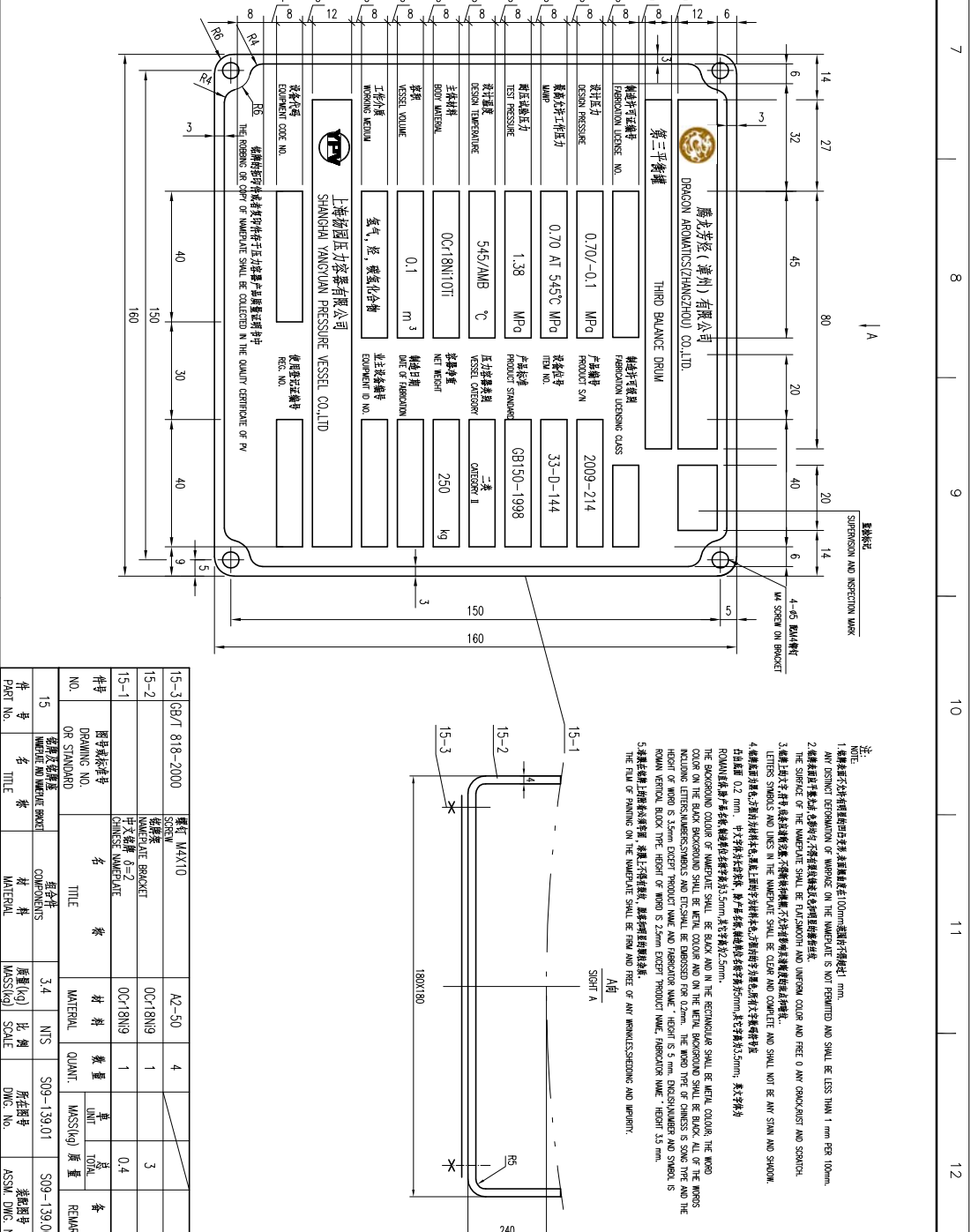
| 件号<br>NO. | 图号<br>DRAWING NO. | 图名<br>OR STANDARD | 名 称<br>TITLE | 材料<br>MATERIAL | 数量<br>QUANT. | 单 位 |     | 重量    | 备 注<br>REMARK |
|-----------|-------------------|-------------------|--------------|----------------|--------------|-----|-----|-------|---------------|
|           |                   |                   |              |                |              | 单 位 | 数 量 |       |               |
| 16        |                   |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 0.23  |               |
| 15        | S09-139.01        |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 3.4   |               |
| 14        | GB/T 14976-2002   |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 1.15  |               |
| 13        | S09-139.01        |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 4.80  |               |
| 12        | GB/T 14976-2002   |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 18.3  |               |
| 11        | S09-139.01        |                   | 螺母 M16       | OCr18Ni10Ti    | 2            |     |     | 8.90  |               |
| 10        | S09-139.01        |                   | 螺母 M16       | OCr18Ni10Ti    | 2            |     |     | 3.62  |               |
| 9         |                   |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | ~10   |               |
| 8         | GB/T 20631-2009   |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | ~1    |               |
| 7         | GB/T 20631-2009   |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 31.3  |               |
| 6         | S09-139.01        |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 2.64  |               |
| 5         | GB/T 20634-2009   |                   | 螺母 M16       | OCr18Ni10Ti    | 24           |     |     | 0.11  |               |
| 4         | GB/T 20634-2009   |                   | 螺母 M16       | OCr18Ni10Ti    | 12           |     |     | 7.32  |               |
| 3         | S09-139.01        |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 51.6  |               |
| 2         | GB/T 14976-2002   |                   | 螺母 M16       | OCr18Ni10Ti    | 1            |     |     | 2.61  |               |
| 1         | ASME B16.5-2003   |                   | 螺母 M16       | OCr18Ni10Ti    | 2            |     |     | 16.34 |               |

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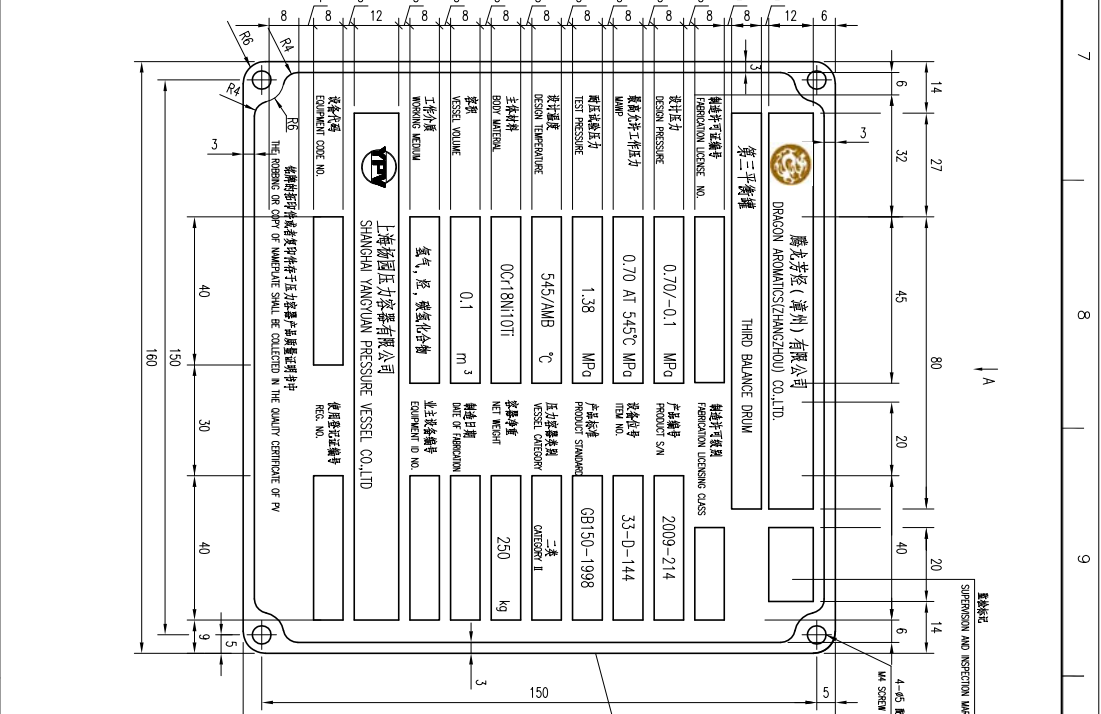


| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 10       | 法兰    | OC18Ni10Ti | 1.81     | 1:2   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |

| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 11       | 底盖    | OC18Ni10Ti | 4.45     | 1:2   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |

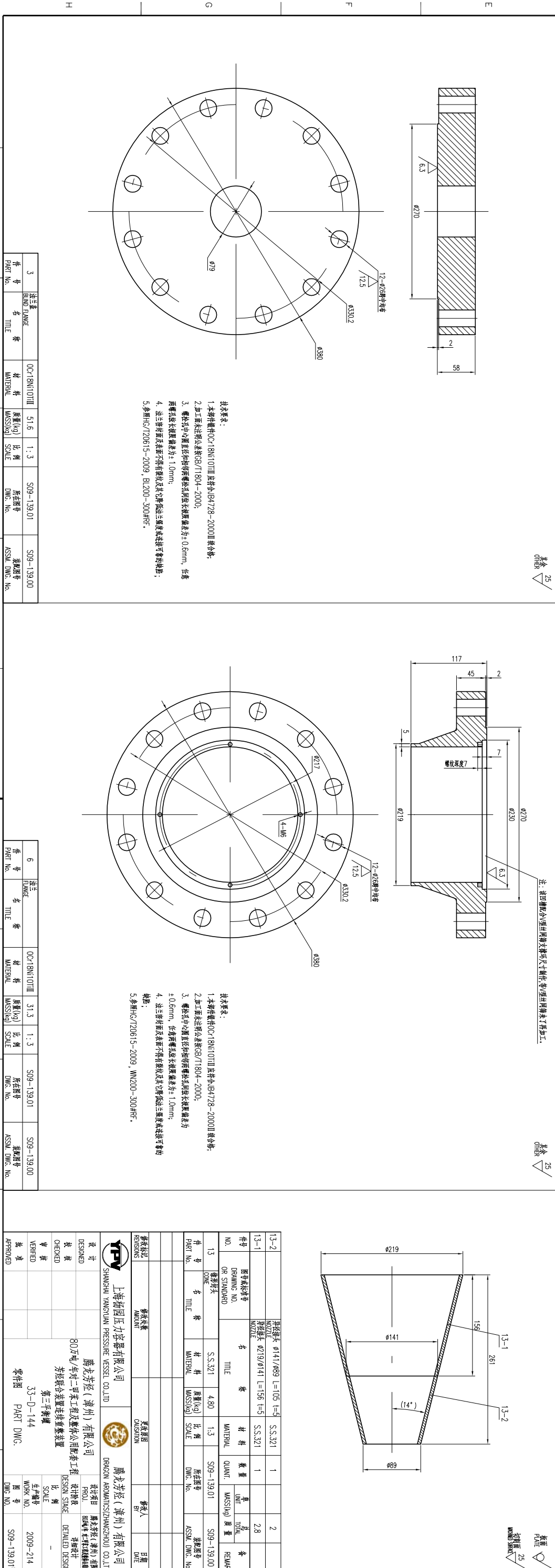


| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 15       | 法兰    | OC18Ni10Ti | 1.81     | 1:2   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |



| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 11       | 底盖    | OC18Ni10Ti | 4.45     | 1:2   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |

| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 10       | 法兰    | OC18Ni10Ti | 1.81     | 1:2   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |



| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 3        | 法兰    | OC18Ni10Ti | 51.6     | 1:3   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |

| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 6        | 法兰    | OC18Ni10Ti | 31.3     | 1:3   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |

| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 6        | 法兰    | OC18Ni10Ti | 31.3     | 1:3   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |

| 件号       | 名称    | 材料         | 质量(kg)   | 比例    | 所在图号       | 装配图号              |
|----------|-------|------------|----------|-------|------------|-------------------|
| 13       | 法兰    | OC18Ni10Ti | 4.80     | 1:3   | S09-139.01 | S09-139.00        |
| PART No. | TITLE | MATERIAL   | MASS(kg) | SCALE | DWG. No.   | ASSEMBLY DWG. No. |