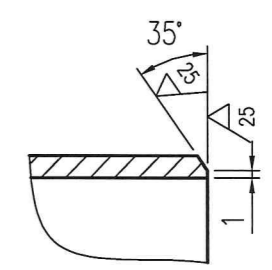


切割 50  
CUTTING

件1和件9两端坡口详图  
DETAIL OF END OF PART 1 AND 9

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。
- φ38x4和φ60x4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11.55Mpa,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 11.55MPa, 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 END CAP	1	20		0.1	
6	按本图 SEE THIS DWG	套管 φ70x4 L=300 SLEEVE	1	20		2	
5	按本图 SEE THIS DWG	钢管 φ60x4 L=5900 TUBE	1	SA-210 Gr.C		32.6	
4	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	ST12		50.1	下料高度加1mm
3	按本图 SEE THIS DWG	堵头φ101/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 φ38x4 L=6145 TUBE	1	SA-210 Gr.C		20.6	

件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 SINGLE	总 TOTAL	备注 REMARK
					重量(kg)	重量(kg)	

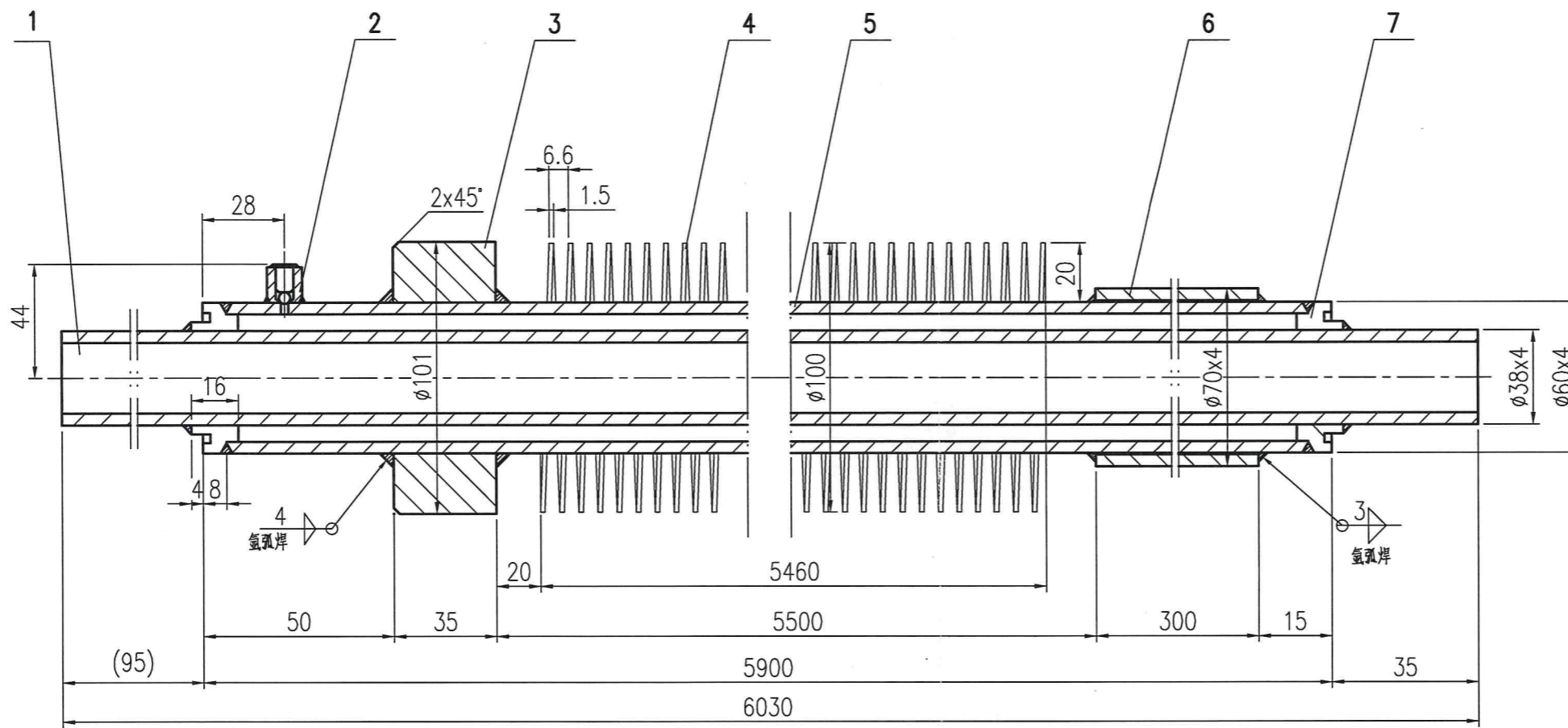
江苏索普赛瑞装备制造有限公司  
Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.

组合件  
ASSEMBLY

热管 I φ38x4/φ60x4/φ100  
HEAT PIPE I

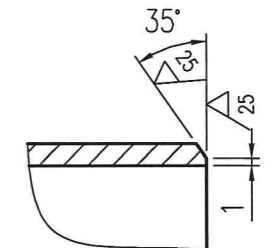
MARK 标记	TOTAL NO. 处数	FILE NO. 更改文件号	SIGN 签名	DATE 日期	WEIGHT(kg) 重量	SCALE 比例	REV. 版次	15SCG2402-1-2-8-0
DESIGN 设计	许大宇 2024.2.19		SERIAL# 产品编号		106.9	1:2	0	
APPROVE 批准	赵晓峰 2024.2.19		24-1004SM3AX/24-1005SM3AX 24-1006SM3AX/24-1007SM3AX		TOTAL-PAGES 共 张	No.-PAGE 第 张		

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件1和件9两端坡口详图  
DETAIL OF END OF PART 1 AND 9

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。
- φ38x4和φ60x4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11.55Mpa,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 11.55MPa, 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 END CAP	1	20		0.1	
6	按本图 SEE THIS DWG	套管 φ70x4 L=300 SLEEVE	1	20		2	
5	按本图 SEE THIS DWG	钢管 φ60x4 L=5900 TUBE	1	SA-210 Gr.C		32.6	
4	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	ST12		50.1	下料高度加1mm
3	按本图 SEE THIS DWG	堵头φ101/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 φ38x4 L=6030 TUBE	1	SA-210 Gr.C		20.2	

件号 PART NO.	图号或标准号 DRAWING NO. OR	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.

组合件  
ASSEMBLY

热管II φ38x4/φ60x4/φ100  
HEAT PIPE II

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	15SCG2402-1-2-9-0
DESIGN 设计	许大宇 2024.2.19		SERIAL# 产品编号		106.5	1:2	0	
APPROVE 批准	赵晓峰 2024.2.19		24-1004SM3AX/24-1005SM3AX 24-1006SM3AX/24-1007SM3AX		TOTAL-PAGES 共 张	No.-PAGE 第 张		

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