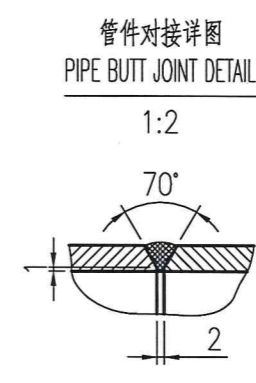
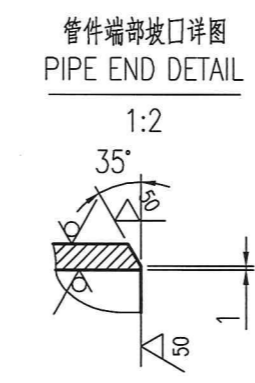
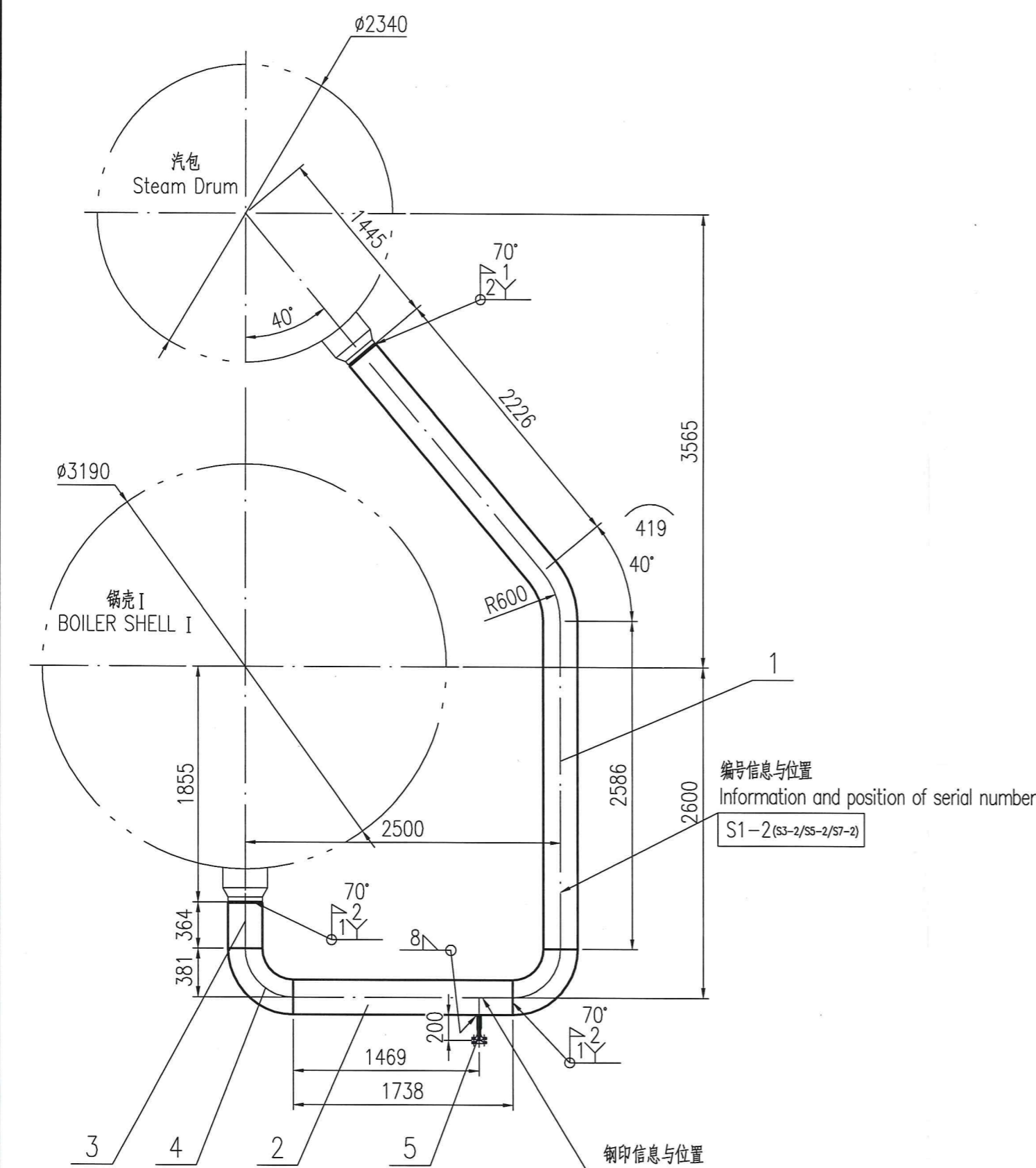


受控文件



- 技术要求:
- 管段采用无缝钢管加工, 管端坡口35°坡角, 钝边1mm。
 - 下料时, 件2、3一端留有40mm余量, 锅炉现场安装前需进行预组装, 合格后按照实际尺寸进行切割并打磨坡口。
 - 所有组件按图敲钢印和编号, 并按图要求现场组焊。管道对接焊缝 (DN>250) 应进行100%RT检测, 其余焊缝应进行100%PT或MT检测。

- Technical Notes:
- The pipe is seamless steel pipe with 35° groove on both side and 1mm blunt edge.
 - When it is blanking, 40mm cutting allowance should be remained on one end of part2,3 pre-assembly shall be carried out before install, cut according to the actual size and polished the groove after qualified.
 - All parts delivery along with ASME stamp and serial number and welding on site as per the drawing. Pipe butt welds (DN>250) shall be tested for 100%RT, and the remaining welds shall be tested for 100% PT or MT.

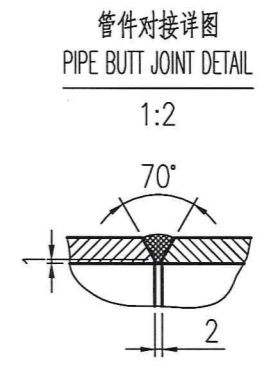
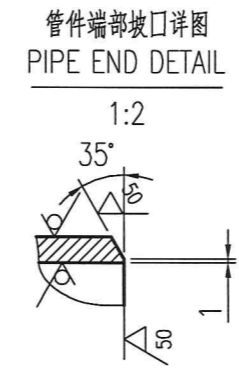
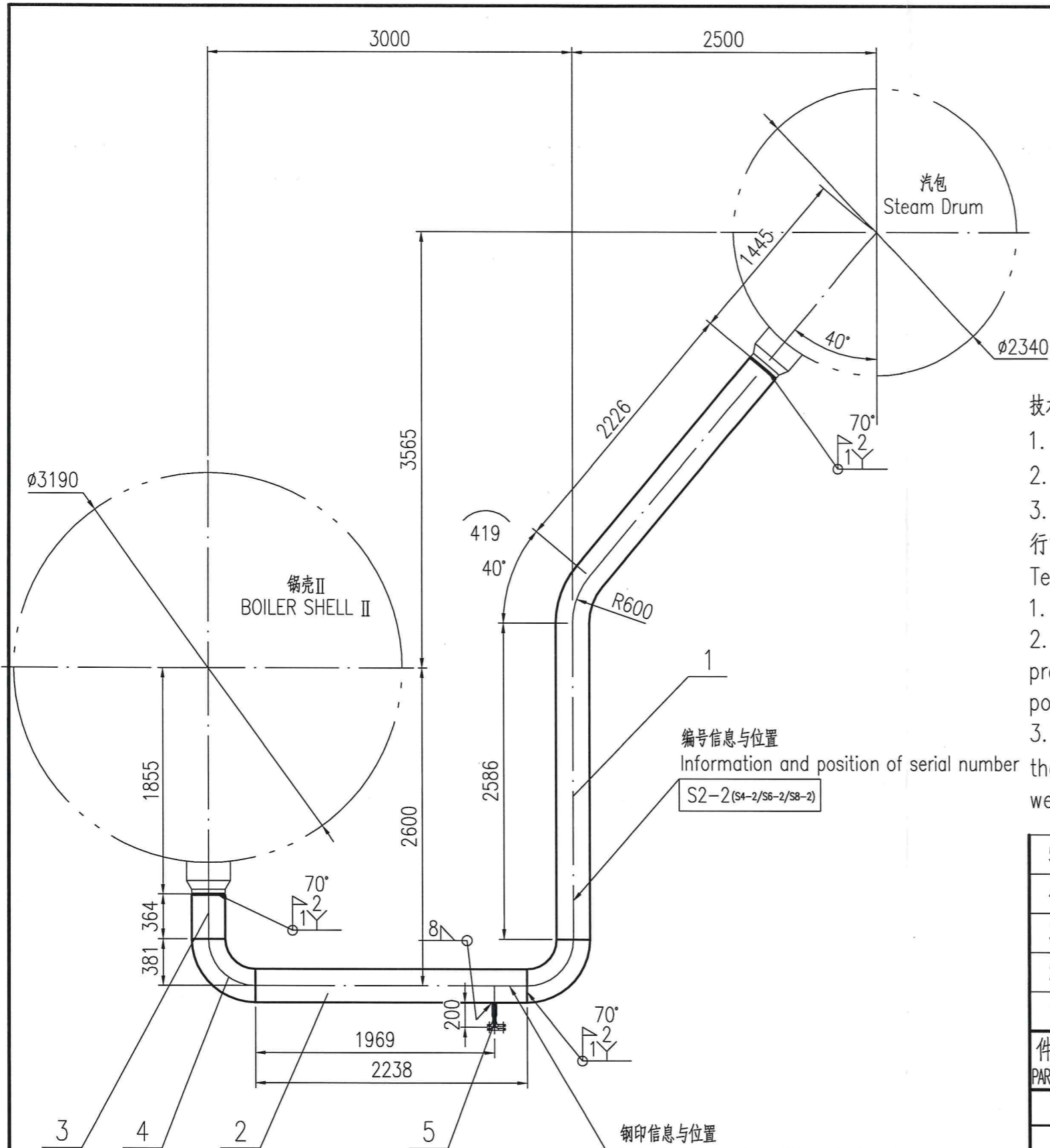
5	22SCG2402-1-5-0	疏水口组件 DRAIN ASSEMBLY	1	组合件 ASSEMBLY		5.2	
4	ASME B16.9-2018	长半径90°弯头 NPS10-Sch80 LONG RADIUS 90°BEND	2	SA-234 WPB	57.4	114.8	
3	按本图 SEE THIS DWG	管子 φ273x15.09 L=404 PIPE	1	SA-106 Gr.B		38.8	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
2	按本图 SEE THIS DWG	管子 φ273x15.09 L=1778 PIPE	1	SA-106 Gr.B		170.7	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
1	按本图 SEE THIS DWG	管子 φ273x15.09 L=5231 PIPE	1	SA-106 Gr.B		502.1	
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)	总 重量(kg)	备注 REMARK

钢印信息与位置
Information and position of stencils

ASME CERTIFIED BY: SOPO-CERE
S/N: 24-1004GX/24-1005GX
24-1006GX/21-1007GX
YEAR/BUILT: 2024
S1-1(c3-1/S5-1/S7-1)

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						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	REV. 版次
DESIGN 设计	许大宇 2024.2.19		SERIAL# 产品编号		832	1:40	0
APPROVE 批准	赵陈博 2024.2.19		24-1004GX/24-1005GX 24-1006GX/24-1007GX		TOTAL-PAGES 共 张	No.-PAGE 第 张	
					22SCG2402-1-0		

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受控文件

技术要求:

1. 管段采用无缝钢管加工, 管端坡口35°坡角, 钝边1mm。
2. 下料时, 件2、3一端留有40mm余量, 锅炉现场安装前需进行预组装, 合格后按照实际尺寸进行切割并打磨坡口。
3. 所有组件按图敲钢印和编号, 并按图要求现场组焊。管道对接焊缝 (DN>250) 应进行100%RT检测, 其余焊缝应进行100%PT或MT检测。

Technical Notes:

1. The pipe is seamless steel pipe with 35° groove on both side and 1mm blunt edge.
2. When it is blanking, 40mm cutting allowance should be remained on one end of part 2,3 pre-assembly shall be carried out before install, cut according to the actual size and polished the groove after qualified .
3. All parts delivery alone with ASME stamp and serial number and welding on site as per the drawing. Pipe butt welds (DN>250) shall be tested for 100%RT, and the remaining welds shall be tested for 100% PT or MT.

编号信息与位置
Information and position of serial number
S2-2(S4-2/S6-2/S8-2)

钢印信息与位置
Information and position of stencils

ASME CERTIFIED BY: SOPO-CERE
S/N: 24-1004GX/24-1005GX
24-1006GX/21-1007GX
YEAR/BUILT: 2024
S2-1(S4-1/S6-1/S8-1)

5	22SCG2402-1-5-0	疏水口组件 DRAIN ASSEMBLY	1	组合件 ASSEMBLY	5.2	图纸复用 Drawing reuse
4	ASME B16.9-2018	长半径90°弯头 NPS10-Sch80 LONG RADIUS 90° BEND	2	SA-234 WPB	57.4	114.8
3	按本图 SEE THIS DWG	管子 φ273x15.09 L=404 PIPE	1	SA-106 Gr.B	38.8	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
2	按本图 SEE THIS DWG	管子 φ273x15.09 L=2278 PIPE	1	SA-106 Gr.B	218.6	含40mm切割余量 CONTAIN CUTTING ALLOWANCE
1	按本图 SEE THIS DWG	管子 φ273x15.09 L=5231 PIPE	1	SA-106 Gr.B	502.1	

件号 PART NO.	图号或标准号 DRAWING OR STD. NO.	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

下降管II
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	REV. 版次	22SCG2402-2-0
DESIGN 设计	许大宇 2024.2.19		SERIAL# 产品编号		880	1:40	0	
APPROVE 批准	赵晓峰 2024.2.19		24-1004GX/24-1005GX 24-1006GX/24-1007GX		TOTAL-PAGES 共 张	No.-PAGE 第 张		

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