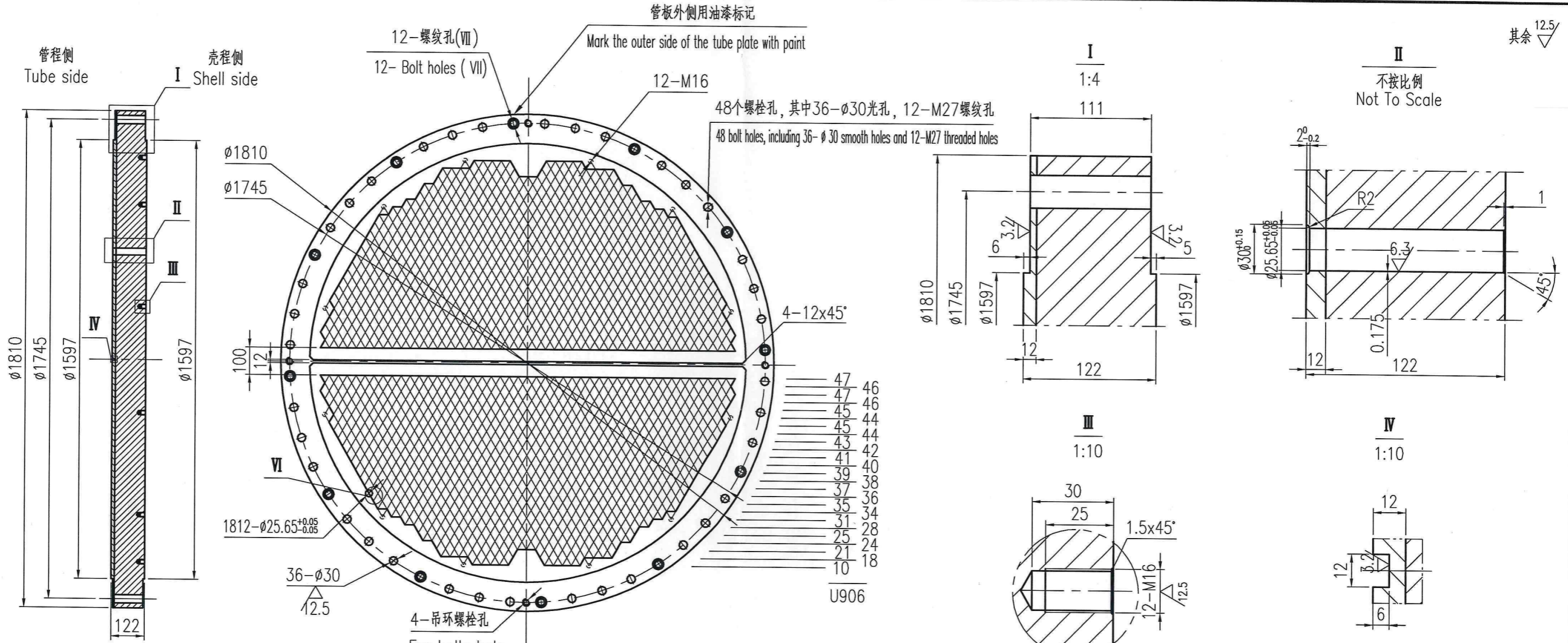


其余 12.5



技术要求:

1. 锻件按 SA-266 Gr.2N 的要求制造, 检验, 验收
2. 管板覆层材料符合 SA-240 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. 其他要求详见 MECS 412-005,
3. 复合管板要求满足标准 SA-264, 并按 SA-578 进行 100% UT 检测, 符合 SA-263 中 I 级要求,
4. 密封面应与管板轴线垂直, 其垂直度公差为 0.50mm.
5. 管板钻孔后, 终钻侧 ≥ 96% 孔桥宽度必须 ≥ 6.20mm, 允许最小孔桥宽度为 ≥ 4.41mm;
6. 管孔应严格垂直于管板密封面, 其垂直度公差为 0.12mm, 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大于 11mm.

Technical requirements:

1. Forgings are manufactured, inspected and accepted according to the requirements of SA-266 Gr.2N
2. The tube coating material meets the requirements of SA-240 310S, and the carbon content is required to be less than or equal to 0.06%, and the inter-granular corrosion test is carried out by ASTM A262E method. Other requirements are detailed in MECS 412-005,
3. The requirements of the composite tube plate meet the standard SA-264, and carry out 100% UT detection according to SA-578, which meets the requirements of SA-263 Level I.
4. The sealing surface should be perpendicular to the axis of the tube plate, and its verticality tolerance is 0.50mm.
5. After the tube plate is drilled, the final drilling side shall be ≥ 96% hole bridge width ≥ 6.20mm, and the maximum hole bridge width shall be ≥ 4.41mm;
6. The pipe hole should be strictly perpendicular to the sealing surface of the tube plate, the perpendicularity tolerance is 0.12mm, and the hole surface is not allowed to have longitudinal stripes through.
7. The sealing surface and surface of the tube plate shall not have cracks and other defects that reduce strength or reliable connection.
8. The dimensional tolerances not indicated on the machined surface in the drawing are as required by "TEMA R".
9. The minimum forming thickness of the tube plate coating after machining needs to be greater than 11mm.

|  |                 |                   |                 |            |                    |                 |                  |  |
|--|-----------------|-------------------|-----------------|------------|--------------------|-----------------|------------------|--|
| 江苏索普赛瑞装备制造有限公司<br>Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd. |                 |                   |                 |            |                    |                 | 管板<br>Tube Sheet |  |
| ASSEMBLY   |                 |                   |                 |            |                    |                 | SCR-20-1-2-1     |  |
| MARK<br>标记   | TOTAL NO.<br>处数 | FILE NO.<br>更改文件号 | SIGN<br>签名      | DATE<br>日期 | WEIGHT(kg)<br>重量   | SCALE<br>比例     | REV.<br>版次       |  |
| DESIGN<br>设计   | 许大宇             |                   | SERIAL#<br>产品编号 |            | 1540               | 1:15            | 1                |  |
| APPROVE<br>批准  | 赵晓娟             |                   | 24-2018~2021    |            | TOTAL-PAGES<br>共 张 | No.-PAGE<br>第 张 |                  |  |

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24/01/2018 v19 n20 n21