

The masonry of the lining should be flat and full, and the excess cement extruded in the masonry should be scraped off in time, the surface masonry inspection should be done with a 5-10 times magnifier, and no cracks, bubbles, etc.

2. 耐酸瓷砖衬里施工完后,需进行固化处理和酸化处理;

After the construction of acid-resistant ceramic tile lining is completed, curing treatment and acidification treatment shall be carried out;

3. 衬砖砌好后不得在进行任何焊接;

After the brick is lined, no welding shall be performed;

4. 设备外壁涂漆防腐:环氧富锌底漆2道,~40μm(干膜)/道·云铁环氧中间·漆1道~50μm(干膜)/道;氟碳面漆2道,~40μm(干膜)/道。

Anti corrosion coating of equipment outer wall: 2 coats of epoxy zinc rich primer, ~40μm(dry film)/channel; Micaceous iron epoxy intermediate; One coat of paint. ~50μm(dry film)/channel; 2 fluorocarbon finishing coats, ~40μm(dry film)/channel.

5. 所有法兰螺栓孔必须跨中均布。

All flange bolt holes must be evenly distributed across the middle span.

6. 所有补强圈焊好后,由M10螺孔通入0.4~0.5MPa的压缩空气,检查补强圈连接焊缝的质量,角焊缝不得有渗漏现象。

After all reinforcing rings are welded, inject 0.4~0.5MPa compressed air through M10 screw hole to check the quality of connecting welds of reinforcing rings, and the fillet welds shall be free of leakage.

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注:除N1a, N1b, N2, N3, N5, L1~L2, M1~M2法兰以外,其余壳体上法兰与接管均需内衬PTFE材料。

Note: Except for N1a, N1b, N2, N3, N5, L1~L2, M1~M2 flanges, all flange connections on the shell must be lined with PTFE material.

主要受压元件材料

MATERIAL OF MAIN PRESSURE PART

名称 NAME	标准 CODE	牌号 BRAND	供货状态 STATUE	附加要求 ADDTIONING REQUIREMENT
板材 PLATES	GB/T 3274-2017	Q235B	热轧 Hot rolled	
板材 PLATES	GB/T 713.7-2023	S31603	固溶 Solid solution	
板材 PLATES	GB/T 713.2-2023	Q245R	热轧 Hot rolled	
管材 PIPES	GB/T 8163-2018	20	热轧 Hot rolled	
管材	GB/T 14976-2013	S31603	固溶 Solid solution	

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is properly seated;
according to the process nozzle orientation map;

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L1 L2	GB/T9124.1-2019	法兰 DN100-PN16 PL RF I Flange	2	S31603	4.4	8.8	
	GB/T8163-2018	接管 $\phi 114.3 \times 6.3$ L=258 Steel Pipe	2	S31603	4.3	8.6	
M1 M2	NB/T11025-2022	补强圈 DN600X14-D reinforcing pad	2	Q235B	48.2	96.4	
	HG/T21522-2014	人孔 RF X t(NM-PTFE) 600-6 Manhole	2	组合件 ASSEMBLY	199	398	
N8、N10	GB/T8163-2018	接管 $\phi 60.3 \times 5.6$ L=273 Steel Pipe	2	20	2.1	4.2	
	GB/T9124.1-2019	法兰 DN50-PN6 PL RF I reinforcing pad	2	Q235B	1.5	3	
N7	GB/T8163-2018	接管 $\phi 168.3 \times 7.1$ L=272 Steel Pipe	1	20		7.7	
	GB/T9124.1-2019	法兰 DN150-PN6 PL RF I Flange	1	Q235B		6	
N4 N6 N11	NB/T11025-2022	补强圈 DN150-14-D reinforcing pad	1	Q235B		19	N4
	GB/T8163-2018	接管 $\phi 168.3 \times 7.1$ L=482 Steel Pipe	1	20		13.7	N4
	GB/T8163-2018	接管 $\phi 168.3 \times 7.1$ L=272 Steel Pipe	2	20	7.7	15.4	
	GB/T9124.1-2019	法兰 DN150-PN6 PL RF I Flange	3	Q235B	5	15	
N5	NB/T11025-2022	补强圈 DN150-14-D reinforcing pad	1	Q235B		5.48	
	GB/T8163-2018	接管 $\phi 168.3 \times 7.1$ L=158 Steel Pipe	1	20		7.3	
	GB/T9124.1-2019	法兰 DN150-PN16 PL RF I Flange	1	Q235B		7.14	
N9、N12	NB/T11025-2022	补强圈 DN200-14-D reinforcing pad	1	Q235B		19	N9
	GB/T9124.1-2019	法兰 DN200-PN6 PL RF I Steel Pipe	2	Q235B	6.88	13.76	
	GB/T8163-2018	接管 $\phi 219.1 \times 8$ L=271 Steel Pipe	2	20	11.4	22.8	
N3		接管 $\phi 813 \times 12$ L=616 Steel Pipe	1	Q235B		146	
	GB/T9124.1-2019	法兰 DN800-PN6 PL RF I Flange	1	Q235B		75	
	9250-B04B-JS15-TK-101/201/301-Q3	补强圈(1) reinforcing pad	1	Q235B		50.8	
N2	9250-B04B-JS15-TK-101/201/301-Q3	补强圈(2) reinforcing pad	1	Q235B		60.9	
		接管 $\phi 1016 \times 12$ L=636 Steel Pipe	1	Q235B		189	
	GB/T9124.1-2019	法兰 DN1000-PN6 PL RF I Flange	1	Q235B		105	
件号 No.	图号或标准号 DWG. OR STAND. No.	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单UNIT 重量 WEIGHT(kg)	总TOTAL	备注 REMARKS

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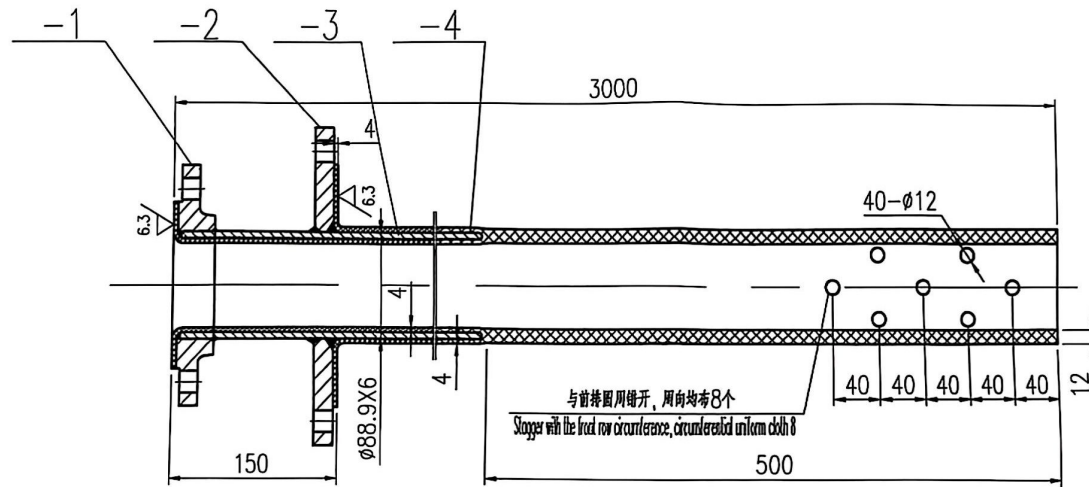
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管口组件明细表
LIST OF NOZZLE COMPONENTS

12-10	NB/T47065.1-2018	支座 BII 3200-F Saddle support	1	Q235B		1071	
12-9	NB/T47065.1-2018	支座 BII 3200-S Saddle support	2	Q235B	1071	2142	
12-8		设备铭牌座 Equipment nameplate seat	1	S30408		2.5	
12-7		接地板 t=10	3	S30408	0.25	0.75	



技术要求:

Technical requirements

1. 焊接采用电弧焊, 焊条型号: E4315;
1. Arc welding is adopted for welding, the model of welding rod is E4315;
2. 接管与法兰的焊接按相应法兰标准中的规定, 要求内侧焊缝填满;
2. The welding between the nozzle and the flange shall be filled in accordance with the relevant flange standards;
3. 贴衬面的凹圆弧R大于等于10mm, 凸圆弧R大于4mm;
3. Concave arc R of lining surface is greater than or equal to 10mm, convex arc R is greater than 4mm;

注
MARK

11/301-10

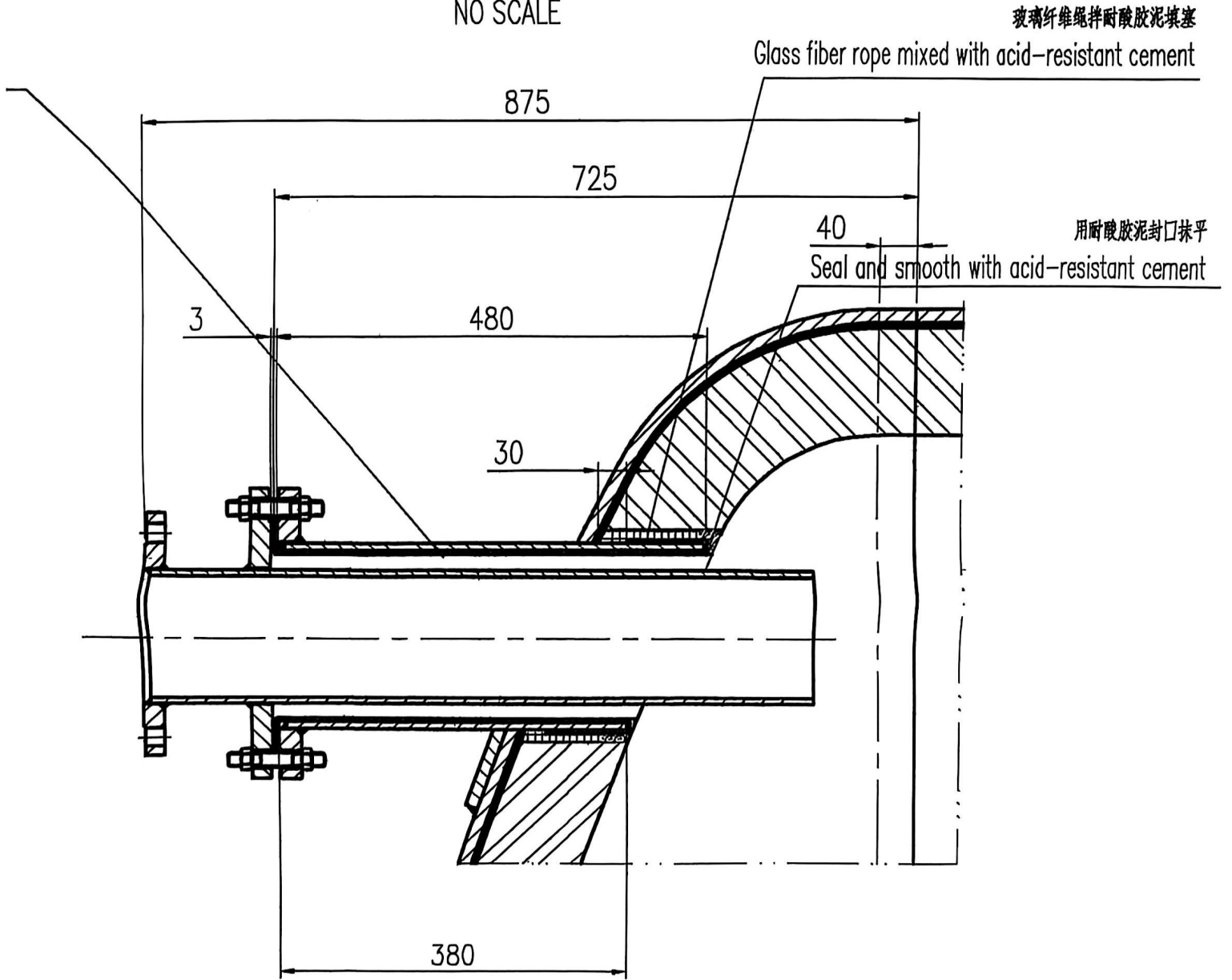
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注: 此件用于接管N11;
Note: This piece is used to Nozzle N11.

-4		纯四氟衬里 Pure tetrafluoro lining	1	PTFE		12	
-3		接管 $\phi 88.9 \times 6$ L ≈ 2495 Steel Pipe	1	20		13.6	
-2	GB/T9124.1-2019	法兰盖 DN150-PN6 BL RF Flange cover	1	Q235B		7.51	中心开孔 $\phi 92$ Center hole $\phi 92$
-1	GB/T9124.1-2019	法兰 DN80-PN16 SO RF I Flange	1	20II		7.5	
下级件号 DOWN LV. NO.	图号或标准号 DWG. OR STAND. NO.	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单重 SINGLE WEIGHT(kg)	总重 TOTAL WEIGHT(kg)	备注 REMARK
接管(N11)	接管(N11) casing(N11)	组合件 Assembly	40.6	/	9258-804B-IS15-IX-101/201/301-04	9258-804B-IS15-IX-101/201/301-01	
上级件号 UP LV. NO.	名称 DESCRIPTION	材料 MATERIAL	重量 WEIGHT	比例 SCALE	所在图号 DRAWING NO.	装配图号 ASS. DWG. NO.	

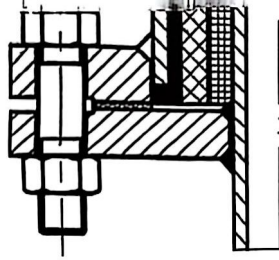
接管N4详图
NOZZLE N4 DETAIL

不按比例
NO SCALE



其余接管开孔砌砖详图
Detail of the rest of the take-over opening brickwork

不按比例
NO SCALE



内衬四氟接管开孔砌砖详图
 Detail of Connecting Pipe with Tetrafluoroethylene Lining, Hole Opening and Brickwork

不按比例
 NO SCALE

