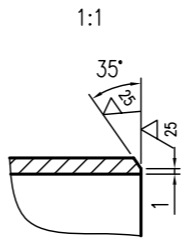


件1和件9两端切口详图
DETAIL OF END OF PART 1 AND 9



技术要求:

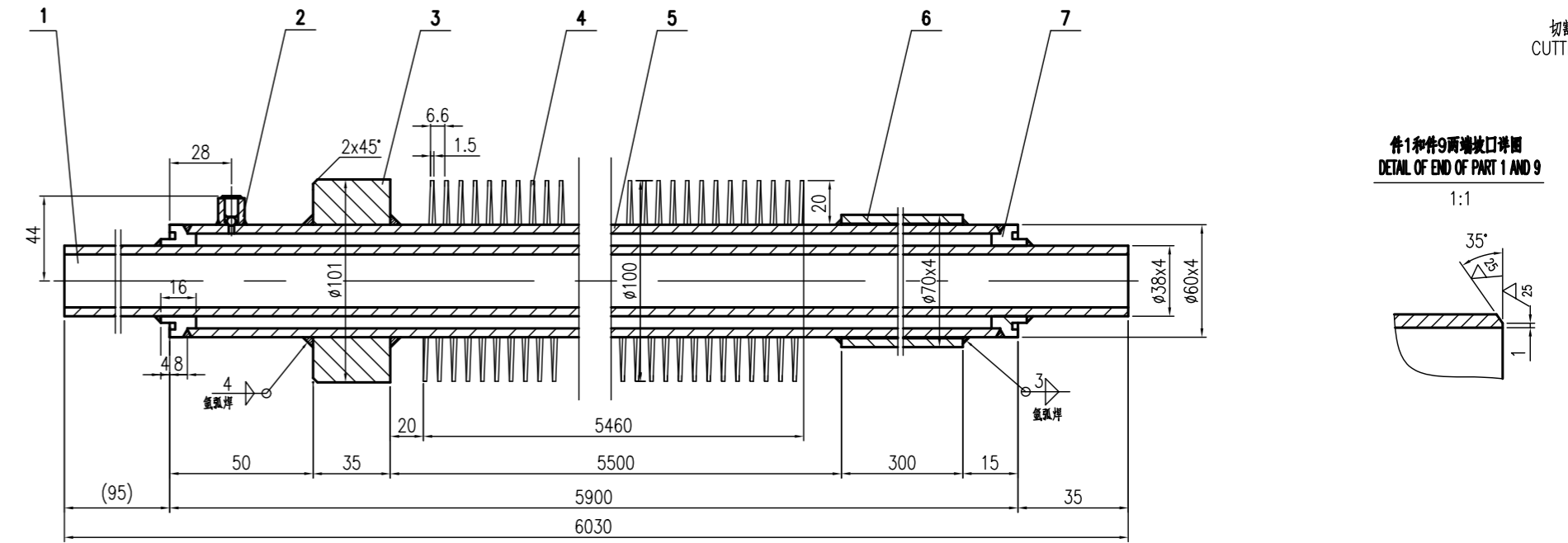
- 翅片管的制造和检验按NB/T47030-2022《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- $\phi 38 \times 4$ 和 $\phi 60 \times 4$ 的钢管要求逐根涡流检测。
- 内管和外套管两端留水压试验余量,按GB/T150《压力容器》进行水压试验,试验压力12.87Mpa,水压试验后切割管子两端,两端切口,倒角35°,钝边1mm。

Technical Notes:

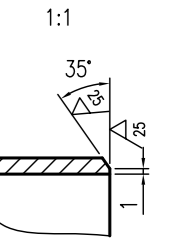
- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2022 Technical Conditions for High Frequency Resistance Welding of Spiral Finned Tubes for Boilers.
- Eddy current should be performed to each base tube.
- Both ends of pipes should remain Water pressure test margin, water pressure test should be according to GB/T150 《Pressure Vessel》, pressure of water pressure test is 12.87MPa, cut ends of the tube groove after water pressure test, chamfer 35°, blunt edge of 1mm.

件号	图号或标准号	名称	数量	材料	单重	总重	备注
PART NO.	DRAWING NO. OR	DESCRIPTION	QTY.	MATERIAL	SINGLE WEIGHT	TOTAL WEIGHT	REMARK
7	按本图 SEE THIS DWG	管封端盖 END CAP	1	20		0.1	
6	按本图 SEE THIS DWG	套管 $\phi 70 \times 4$ L=300 SLEEVE	1	20		2	
5	按本图 SEE THIS DWG	钢管 $\phi 60 \times 4$ L=5900 TUBE	1	SA-210 Gr.C		32.6	
4	按本图 SEE THIS DWG	翅片 L=1.5 H=21 DESCRIPTION	1	ST12		50.1	下料高度加1mm
3	按本图 SEE THIS DWG	堵头 $\phi 101/\phi 61$ 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 $\phi 38 \times 4$ L=6145 TUBE	1	SA-210 Gr.C		20.6	

MARK	TOTAL NO.	FILE NO.	SIGN	DATE	WEIGHT (kg)	SCALE	REV.	15SCG2402-1-2-8-0
标记	总数	更改文件号	签名	日期	重量	比例	版次	
DESIGN					106.9	1:2	0	
APPROVE								
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件1和件9两端切口详图
DETAIL OF END OF PART 1 AND 9



技术要求:

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- $\phi 38 \times 4$ 和 $\phi 60 \times 4$ 的钢管要求逐根涡流检测。
- 内管和外套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12.87Mpa,水压试验后切割管子两端,两端切口,倒角35°,钝边1mm。

Technical Notes:

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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 $\phi 38 \times 4$ L=6030 TUBE	1	SA-210 Gr.C		20.2	

MARK	TOTAL NO.	FILE NO.	SIGN	DATE	WEIGHT (kg)	SCALE	REV.	15SCG2402-1-2-9-0
标记	总数	更改文件号	签名	日期	重量	比例	版次	
DESIGN					106.5	1:2	0	
APPROVE								
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