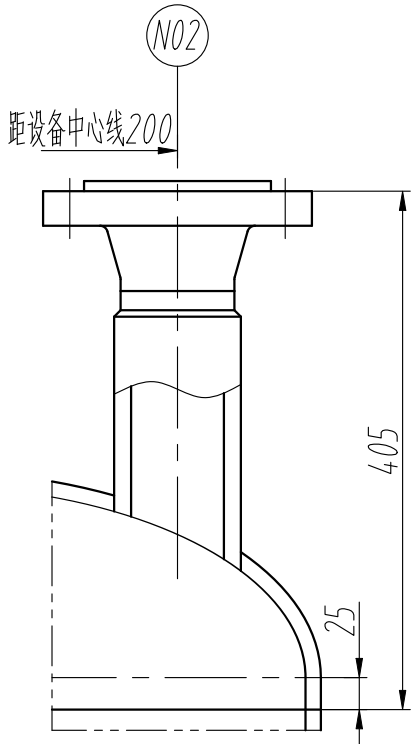
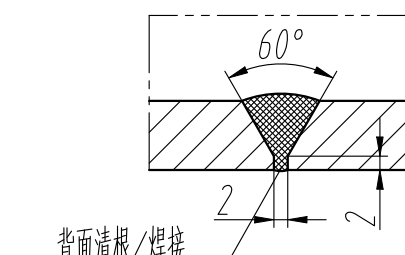


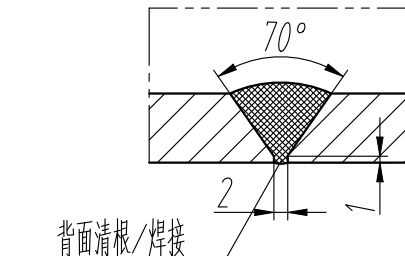
N02管口详图  
不按比例  
NOT TO SCALE



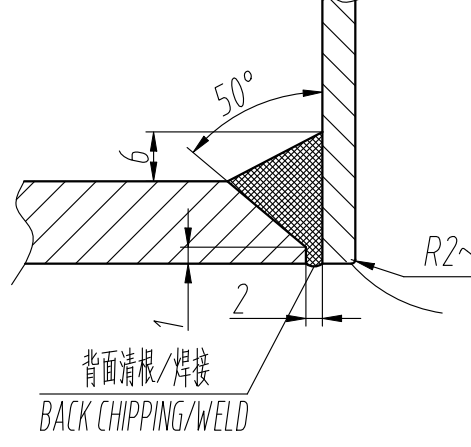
A类焊接接头  
"A" JOINT OF SHELL  
不按比例  
NOT TO SCALE



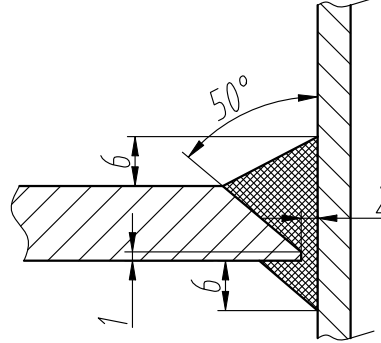
B类焊接接头  
"B" JOINT OF SHELL  
不按比例  
NOT TO SCALE



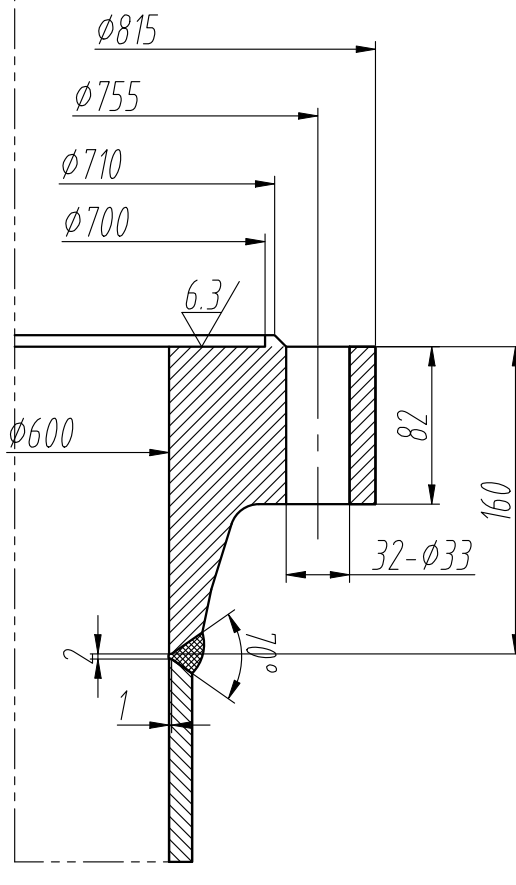
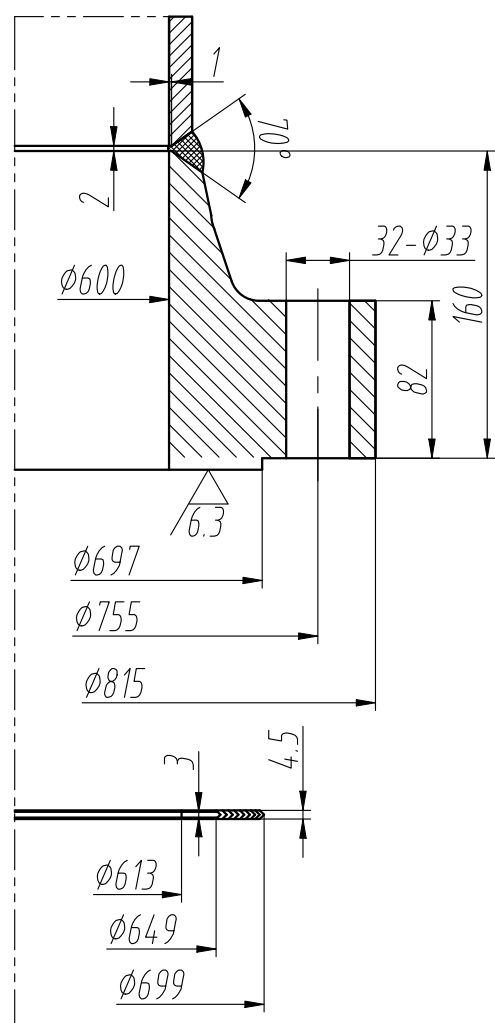
接管与壳体焊接接头  
NOZZLE JOINT TO SHELL  
不按比例  
NOT TO SCALE



接管与壳体焊接接头  
NOZZLE JOINT TO SHELL  
不按比例  
NOT TO SCALE



1  
不按比例  
NOT TO SCALE



GK	R25012-GK	管口规格 NOZZLE PARTS			86	
13		管口DN600×12(11.7) SHELL	1	S31603	55	H=300
12	HG/T21618-1998	管口DN600×12(11.7) SHELL	1	S31603	10	外购
11	NB/T47027-2012	管口DN600×12(11.7) SHELL	64×8	30CrMoA	0.05	3.2 外购
10	NB/T47027-2012	管口DN600×12(11.7) SHELL	32×4	35CrMoA	1.4	44.8 外购
9	NB/T47025-2012	管口DN600×12(11.7) SHELL	1×2	RSB/S31603		外购
8	NB/T47023-2012	管口DN600×12(11.7) SHELL	1	S31603	16.75	标准图
7	NB/T47023-2012	管口DN600×12(11.7) SHELL	1	S31603	16.37	标准图
6		管口DN600×12(11.7) SHELL	1	S31603	187	H=1030
5		管口DN600×12(11.7) SHELL	1	S31603	1	标准图
4	R25012-4	管口DN600×12(11.7) SHELL	1	S304.08	/	
3	GB/T25198-2023	管口DN600×12(11.7) SHELL	2	S31603	42	84
2	NB/T47065.2-2018	管口DN600×12(11.7) SHELL	3	Q235B/S31603	15	45 标准图
1		管口DN600×12(11.7) SHELL	2	S304.08	0.55	1.1 标准图
件号 PARTS NO.	图号或标准号 DWG NO. OR STD. NO.	名称 PARTS NAME	数量 QTY.	材料 MATL.	重量 SINGL/总重量 TOTAL MASS(Kg)	备注 REMARKS

设计、制造与检验主要数据表 DESIGN/FABRICATION/INSPECTION DATA			
规范、标准 CODE & STANDARD	《固定式压力容器安全技术监察规程》(含增补条款) TSG 21-2016 SUPERVISION REGULATION ON SAFETY TECHNOLOGY FOR STATIONARY PRESSURE VESSEL 《承压设备无损检测》GB/T 150.1-150.4-2014 PRESSURER VESSEL	《承压设备无损检测》NB/T 20584-2020 TECHNICAL STANDARD OF FABRICATION FOR STEEL CHEMICAL VESSELS	
	参 数 PARAMETER	压力容器类别 PRESS VESSEL CLASS	II
工作压力 WORKING PRESS.	kg/cm <sup>2</sup> G 35.7	焊接规范 WELDING SPEC.	NB/T47015-2023
设计压力 DESIGN PRESS.	kg/cm <sup>2</sup> G 40/-1.0	焊接材料 WELDING MATERIAL	S31603 CS A022, ER316L J427 S31603B.C.S A312
最高允许工作压力 MAX. ALLOWABLE OPERATING PRESS.	/	焊接接头形式 WELDING STRUCTURE	除注脚外按HG/T20584-2020规定执行
工作温度 WORKING TEMP.	℃ 35~40	角焊缝厚度 THICK. OF FILLET WELD	除注脚外按GB/T20584-2020规定执行
设计温度 DESIGN TEMP.	℃ 80	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
介质 FLUID (COMPONENT)	H <sub>2</sub> (氢气) H <sub>2</sub> (NOTE 1)	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
介质性能 FLUID PERFORMANCE	---/易燃 ---/INFLAMMABLE	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
安全阀整定压力 THE SET PRESSURE OF SAFETY VALVES	kg/cm <sup>2</sup> G 4.0	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
设计使用寿命 DESIGN WORKING LIFE(YEARS)	10	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
主要承压元件材料 MAIN MATERIAL	牌号 (Name) 标准 (Standard) S31603 GB/T713.7-2023	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
腐蚀裕量 CORR. ALLOW.	mm 0	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
焊接接头系数 JOINT EFF.	筒体/接头 1.0/1.0	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
耐压试验方法 (压力/介质) TYPE OF PROOF PRESS. TEST	52.5/52.2(HYDRO-H <sub>2</sub> V)	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
泄漏试验方法 (压力/介质) TYPE OF LEAK TEST	4.0(气密性试验) 4.0(GAS LEAK TEST PRESS)	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
容量 CAPACITY	m <sup>3</sup> 0.48	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
重量 FULL WT.	/	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
保温材料/厚度 INSULATION MATERIAL/THICKNESS	mm /	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行
防火材料/厚度 FIRE PREVENTION/THICKNESS	mm /	法兰与接管焊接 WELDING OF FLANGE AND PIPE	除注脚外按GB/T20584-2020规定执行

补充技术要求:  
Supplementary technical requirements:  
1. 除注脚外,所有尺寸单位为“mm”,法兰螺栓孔应沿设备中心线或其平行线均布。  
1. Except as specified, all dimension units are “mm”, and the flange bolt holes should be distributed along the center line of the equipment or its parallel lines.  
2. 设备用S31603钢板应符合GB/T713.7-2023《承压设备用钢板和钢带》的规定,且表面加工类型为1D,固溶状态供货。  
2. The S31603 steel plate for equipment shall comply with the provisions of GB/T713.7-2023 “Steel plates and steel belts for pressure-bearing equipment”, and the surface processing type is 1D, and the supply is solid solution.  
3. 与工艺介质接触的焊缝应采用氩弧焊打底。  
3. The welds in contact with the process medium should be basepased with argon arc welding.  
4. A、B类焊接接头的焊缝余高不得大于1mm;所有焊缝应打磨平滑,角焊缝应四圆角过渡,接管内径处角应倒圆,圆角半径取接管厚度1/4或19mm两者中的较小值。  
4. A、B类焊接接头的焊缝余高不得大于1mm;所有焊缝应打磨平滑,角焊缝应四圆角过渡,接管内径处角应倒圆,圆角半径取接管厚度1/4或19mm两者中的较小值。  
5. 筒体壁厚应考虑良好的成型措施(应无划痕、缺口等缺陷),设备制造过程中应保护承压元件表面,不得锤击、碰撞。  
5. Good molding measures should be considered on the inner wall of the equipment (no defects such as scratches, notches, etc.), during the manufacturing process of the equipment, the surface of the compressed component should be protected from hammering or collision.  
6. 筒体组焊完毕后,应按照GB/T150.4-2024第6.5.1条检查壳体的圆度。  
6. After the cylinder assembly is welded, the roundness of the shell should be checked according to Article 6.5.11 of GB/T150.4-2024.  
7. DN<250的接管与法兰的对接接头应按照NB/T47013.5-2015进行100%渗透检测,合格级别不低于1级。  
7. The butt joints of the connectors of the DN<250 and the flange should be tested 100% permeability according to NB/T47013.5-2015, and the pass level shall not be lower than Level I.  
8. 不锈钢设备水压试验用水的氯离子含量应小于25mg/L,试验合格后应立即将水排净吹干。  
8. The chloride ion content of water for water pressure testing of stainless steel equipment should be less than 25mg/L. After passing the test, the water should be drained and dried immediately.  
9. 泄漏试验合格后,介质接触的不锈钢表面应进行酸洗钝化处理,所形成的钝化膜按GB/T25150-2010规定的方法检测,合格后必须将酸洗介质清洗干净,不得有残留。  
9. After passing the leakage test, the surface of the stainless steel contacting the medium should be subjected to pickling and passivation. The passivation film formed should be tested according to the method specified in GB/T25150-2010. After passing the qualification, the pickling medium must be cleaned and there must be no residue.

注(Notes):  
1. 介质组成(wt%): 氢气≥99.9,氧气≤10PPm,一氧化碳≤1PPm。  
1. Media composition (wt%): hydrogen ≥99.9, oxygen ≤10PPm, carbon monoxide ≤1PPm.  
2. 设计使用寿命不等于实际使用寿命,压力容器使用单位应根据装置的操作状态和TSG 21-2016《固定式压力容器安全技术监察规程》第8章的要求,对该设备进行定期和不定期检验,并确认实际寿命和设计寿命的符合性。  
2. The design service life is not equal to the actual service life. The pressure vessel user unit shall conduct regular and irregular inspections of the equipment according to the operating status of the device and the requirements of Chapter 8 of TSG 21-2016 “Technical Supervision Regulations on Safety Supervision of Fixed Pressure Vessels” and confirm the compliance of the actual life and design service life.

管口表 LIST OF NOZZLE									
序号 ITEM	公称尺寸 NPS	公称压力 CLASS	连接标准 CONSDT.	连接法兰形式 TYPE	连接形式 FACING	用表名称 SERVICE	管子规格 NOZZLE SIZE	材料牌号 POLYMERICAL	备 注 REMARK
N01	3	300	ASME B16.5-2020	WN	RJ	管口 H2 INLET	φ99×13.25	520	
N02	3	300	ASME B16.5-2020	WN	RJ	管口 H2 OULET	φ99×13.25	见图	
N03	2	300	HG/T20615-2009	LWN	RJ	安全阀 PSV CIRCULATION	φ84×16	见图	
C31	2	300	HG/T20615-2009	LWN	RJ	管口 PI (CONNECTION TO B)	φ84×16	见图	
C41	2	300	HG/T20615-2009	LWN	RJ	管口 PG CONNECTION (W/B)	φ84×16	见图	
D01	1	300	ASME B16.5-2020	WN	RJ	管口 DRAIN	φ54×13.5	见图	

设备自重 (供货质量) NET MASS	(Kg)	850							
空质量 EMPTY MASS	(Kg)								
操作质量 OPERATING MASS	(Kg)								
盛水质量 MASS OF FULL WATER	(Kg)	1330							
最大可拆件质量 MAX. REMOV. PART MASS	(Kg)								
浙江诚泰化工机械有限公司 ZHEJIANG CHENGTAI CHEMICAL MACHINERY CO.,LTD	图号 DWG NO.	R25012-00	项目 SECTION	氢气流缓冲罐 HYDROGEN BUFFER TANK	版次 REV	A02	审核 CHECK	日期 DATE	
设计 DESIGN	校核 CHK		审核 DISC APP		编制 DISC APP		审核 CHK		
批准 APPR									
比例 SCALE	1:6	第 8 页 OF 共 8 页							