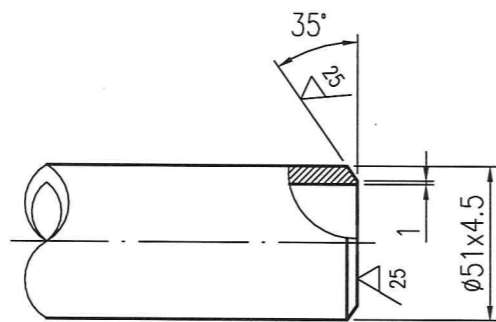
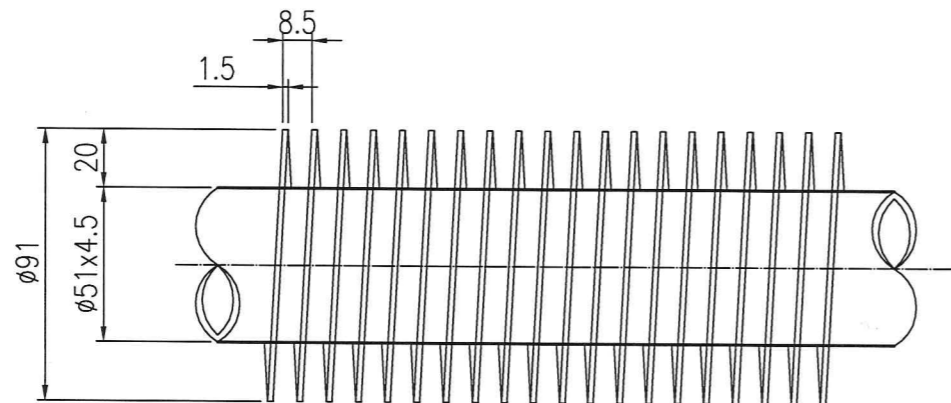


管端坡口详图
Tube end detail
1:2



I
1:2



技术要求:

- 翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- $\phi 51 \times 4.5$ 的钢管要求逐根涡流检测。
- 换热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11.22Mpa,水压试验后切割管子两端,两端坡口,倒角 30° ,钝边1mm。

Technical Notes:

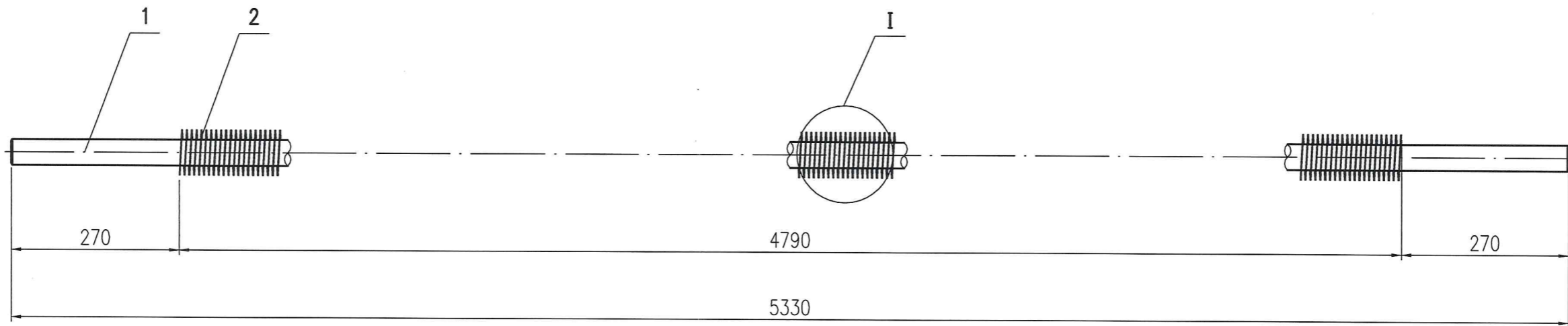
- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 Technical Conditions for High Frequency Resistance Welding of Spiral Finned Tubes for Boilers.
- Eddy current should be performed to each base tube.
- Both ends of pipes should remain Water pressure test margin, water pressure test should be according to GB/T150 《Pressure Vessel》, pressure of water pressure test is 11.22MPa, cut ends of the tube groove after water pressure test, chamfer 30° , blunt edge of 1mm.

602#

受控文件

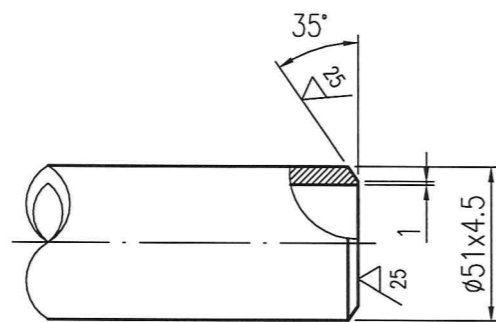
2	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	S41010		31.7	
1	按本图 SEE THIS DWG	管子 $\phi 51 \times 4.5$ L=5785 TUBE	1	SA-213 T12		30.2	
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 重量(kg) SINGLE	总 重量(kg) TOTAL	备注 REMARK
				江苏索普赛瑞装备制造有限公司 Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.			
				组合件 ASSEMBLY		螺旋翅片管A $\phi 51 \times 4.5 / \phi 91$ SPIRAL FINNED TUBE A	
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		61.9	1:8	0
APPROVE 批准	赵晓梅 2024.2.19		24-1004GR1B/24-1005GR1B 24-1006GR1B/24-1007GR1B		TOTAL-PAGES 共 张	No.-PAGE 第 张	14SCG2402-2-1-4-0

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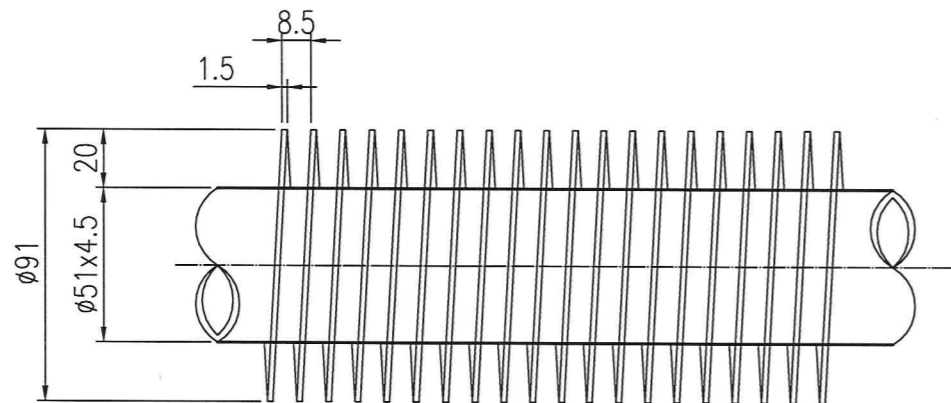


管端坡口详图
Tube end detail

1:2



I
1:2



技术要求:

- 翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- $\phi 51 \times 4.5$ 的钢管要求逐根涡流检测。
- 换热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11.22Mpa,水压试验后切割管子两端,两端坡口,倒角30°,钝边1mm。

Technical Notes:

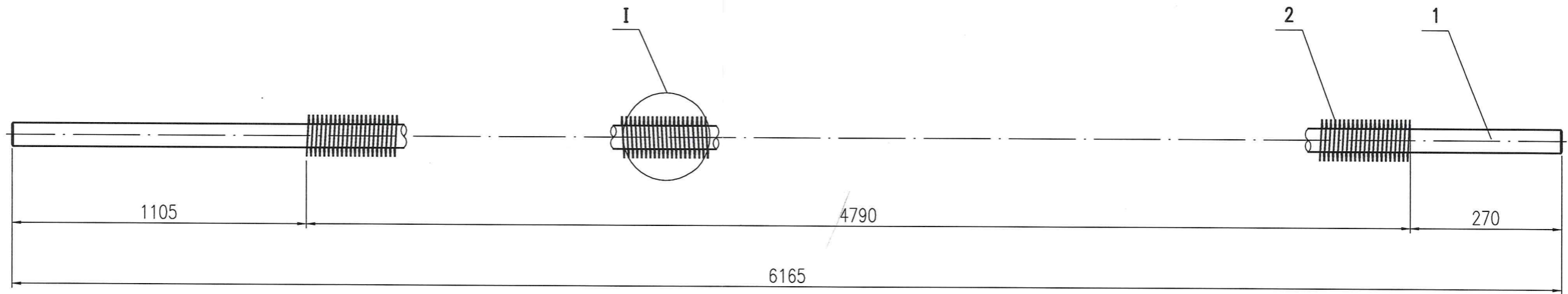
- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 Technical Conditions for High Frequency Resistance Welding of Spiral Finned Tubes for Boilers.
- Eddy current should be performed to each base tube.
- Both ends of pipes should remain Water pressure test margin, water pressure test should be according to GB/T150 《Pressure Vessel》, pressure of water pressure test is 11.22MPa, cut ends of the tube groove after water pressure test, chamfer 30°, blunt edge of 1mm.

240件

受控文件

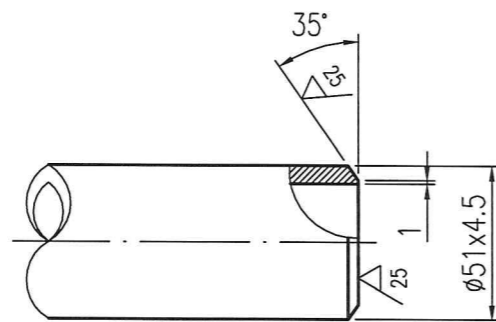
2	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	S41010		31.7	
1	按本图 SEE THIS DWG	管子 $\phi 51 \times 4.5$ L=5330 TUBE	1	SA-213 T12		27.8	
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 重量(kg) SINGLE	总 重量(kg) TOTAL	备注 REMARK
				江苏索普赛瑞装备制造有限公司 Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.			
				组合件 ASSEMBLY		螺旋翅片管B $\phi 51 \times 4.5 / \phi 91$ SPIRAL FINNED TUBE B	
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		59.5	1:8	0
APPROVE 批准	赵晓娟 2024.2.19		24-1004GR1B/24-1005GR1B 24-1006GR1B/24-1007GR1B		TOTAL-PAGES 共 张	No.-PAGE 第 张	14SCG2402-2-1-5-0

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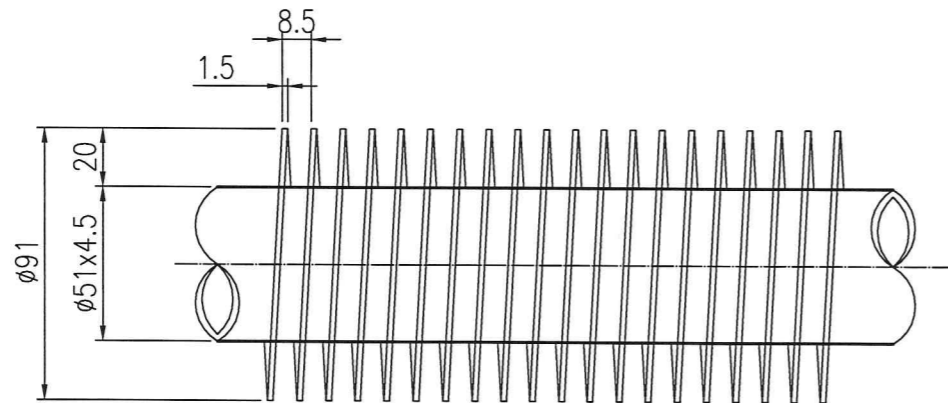


管端坡口详图
Tube end detail

1:2



I
1:2



技术要求:

- 翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- $\phi 51 \times 4.5$ 的钢管要求逐根涡流检测。
- 换热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11.22Mpa,水压试验后切割管子两端,两端坡口,倒角30°,钝边1mm。

Technical Notes:

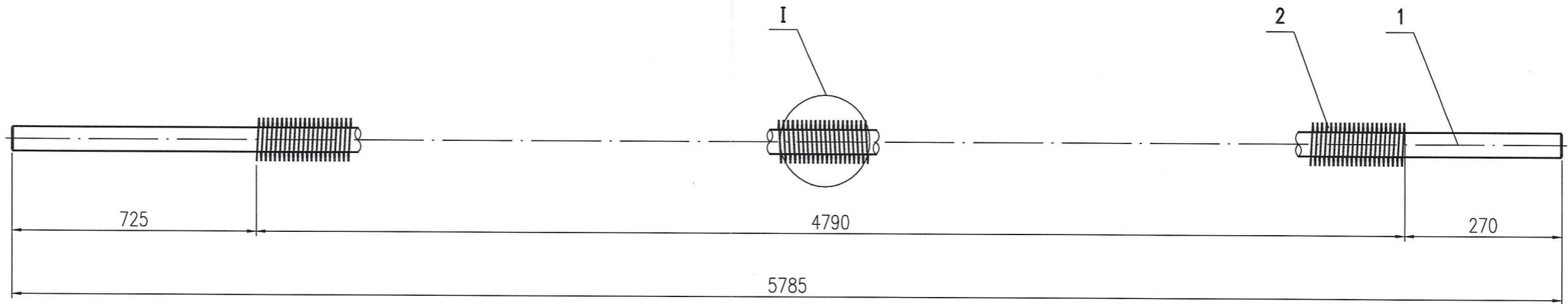
- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 Technical Conditions for High Frequency Resistance Welding of Spiral Finned Tubes for Boilers.
- Eddy current should be performed to each base tube.
- Both ends of pipes should remain Water pressure test margin, water pressure test should be according to GB/T150 《Pressure Vessel》, pressure of water pressure test is 11.22MPa, cut ends of the tube groove after water pressure test, chamfer 30°, blunt edge of 1mm.

63件

受控文件

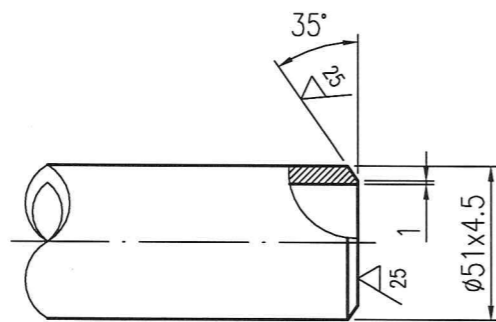
2	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	S41010		31.7	
1	按本图 SEE THIS DWG	管子 $\phi 51 \times 4.5$ L=6165 TUBE	1	SA-213 T12		32.1	
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 SINGLE 重量(kg) WEIGHT	总 TOTAL 重量(kg) WEIGHT	备注 REMARK
江苏索普赛瑞装备制造有限公司 Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.							
组合件 ASSEMBLY							螺旋翅片管C $\phi 51 \times 4.5 / \phi 91$ SPIRAL FINNED TUBE C
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		63.8	1:8	0
APPROVE 批准	赵晓娟 2024.2.19		24-1004GR1B/24-1005GR1B 24-1006GR1B/24-1007GR1B		TOTAL-PAGES 共 张	No.-PAGE 第 张	14SCG2402-2-1-6-0

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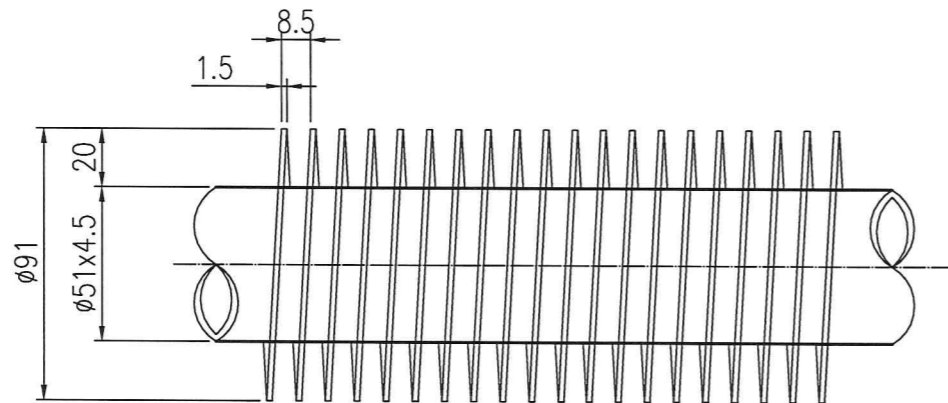


管端坡口详图
Tube end detail

1:2



I
1:2



技术要求:

- 翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- $\phi 51 \times 4.5$ 的钢管要求逐根涡流检测。
- 换热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11.22Mpa,水压试验后切割管子两端,两端坡口,倒角30°,钝边1mm。

Technical Notes:

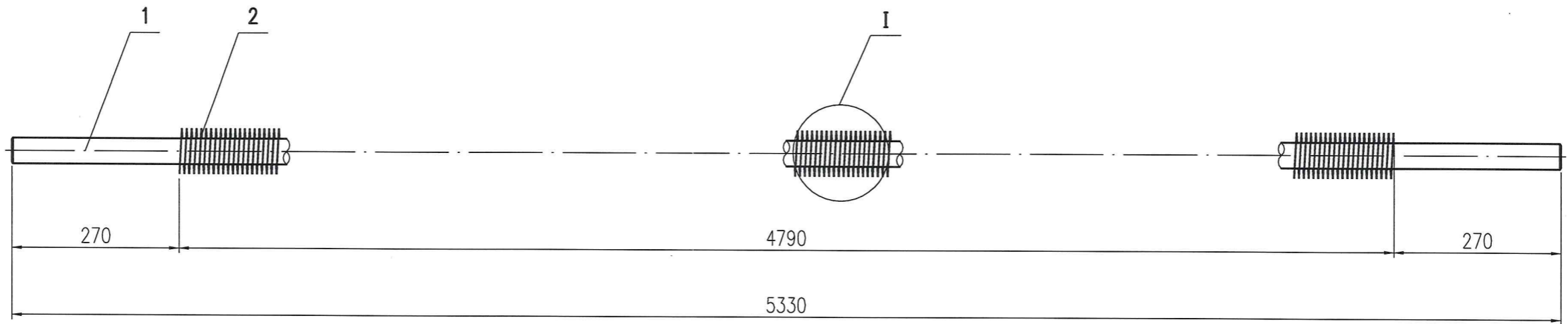
- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 Technical Conditions for High Frequency Resistance Welding of Spiral Finned Tubes for Boilers.
- Eddy current should be performed to each base tube.
- Both ends of pipes should remain Water pressure test margin, water pressure test should be according to GB/T150 《Pressure Vessel》, pressure of water pressure test is 11.22MPa, cut ends of the tube groove after water pressure test, chamfer 30°, blunt edge of 1mm.

60件

受控文件

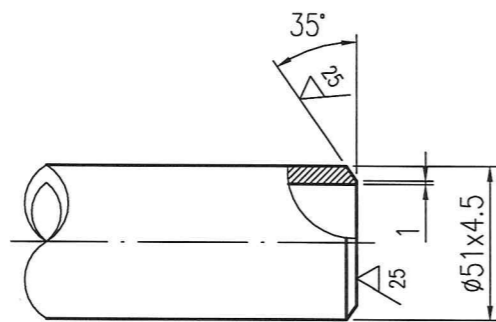
2	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	S30408		31.7	
1	按本图 SEE THIS DWG	管子 $\phi 51 \times 4.5$ L=5785 TUBE	1	SA-213 TP321		30.2	
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 SINGLE 重量(kg)	总 TOTAL WEIGHT	备注 REMARK
				江苏索普赛瑞装备制造有限公司 Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.			
				组合件 ASSEMBLY		螺旋翅片管D $\phi 51 \times 4.5 / \phi 91$ SPIRAL FINNED TUBE D	
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		61.9	1:8	0
APPROVE 批准	赵晓娟 2024.2.19		24-1004GR1B/24-1005GR1B 24-1006GR1B/24-1007GR1B		TOTAL-PAGES 共 张	No.-PAGE 第 张	4SCG2402-2-1-12-0

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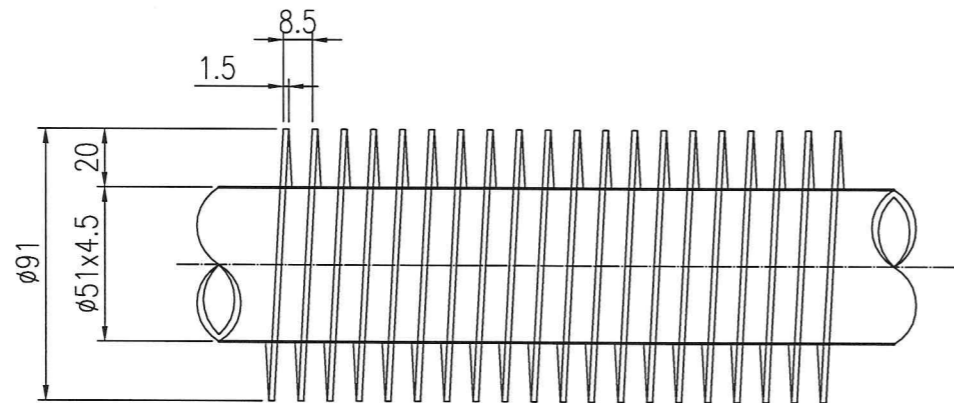


管端坡口详图
Tube end detail

1:2



I
1:2



技术要求:

- 翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- $\phi 51 \times 4.5$ 的钢管要求逐根涡流检测。
- 换热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11.22Mpa,水压试验后切割管子两端,两端坡口,倒角30°,钝边1mm。

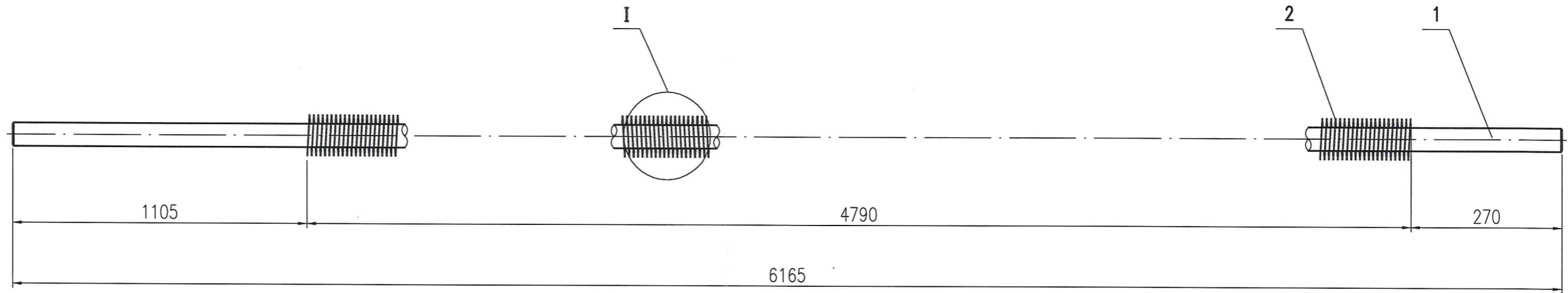
Technical Notes:

- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 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 11.22MPa, cut ends of the tube groove after water pressure test, chamfer 30°, blunt edge of 1mm.

受控文件

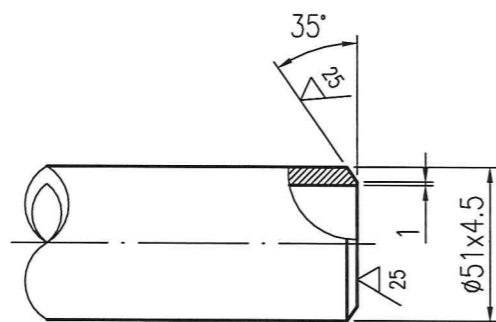
2	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	S30408	31.7			
1	按本图 SEE THIS DWG	管子 $\phi 51 \times 4.5$ L=5330 TUBE	1	SA-213 TP321		27.8		
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 SINGLE 重量(kg) WEIGHT	总 TOTAL 重量(kg) WEIGHT	备注 REMARK	
江苏索普赛瑞装备制造有限公司 Jiangsu SOPO-CERE Equipment Manufacturing CO. Ltd.								
组合件 ASSEMBLY							螺旋翅片管E $\phi 51 \times 4.5 / \phi 91$ SPIRAL FINNED TUBE E	
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		59.5	1:8	0	
APPROVE 批准	赵晓娟 2024.2.19		24-1004GR1B/24-1005GR1B 24-1006GR1B/24-1007GR1B		TOTAL-PAGES 共 张	No.-PAGE 第 张		4SCG2402-2-1-13-0

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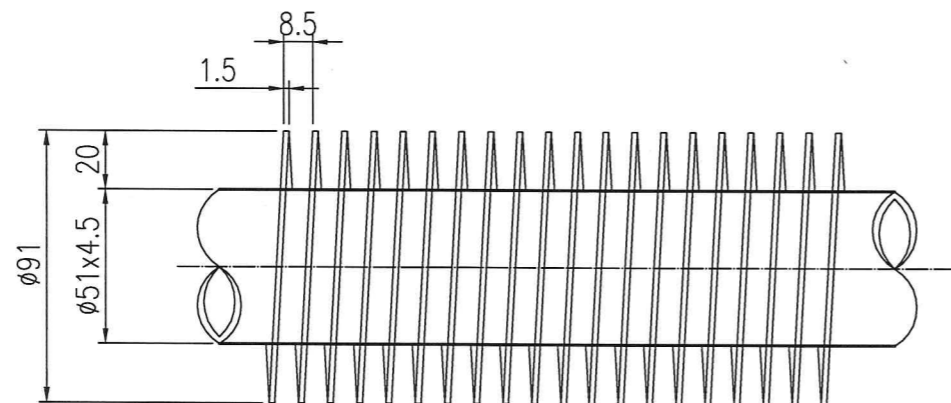


管端坡口详图
Tube end detail

1:2



I
1:2



技术要求:

- 翅片管的制造和检验按NB/T47030-2013《锅炉用高频电阻焊螺旋翅片管技术条件》进行。
- $\phi 51 \times 4.5$ 的钢管要求逐根涡流检测。
- 换热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11.22Mpa,水压试验后切割管子两端,两端坡口,倒角 30° ,钝边1mm。

Technical Notes:

- The manufacture and inspection of finned tubes are carried out in accordance with NB/T47030-2013 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 11.22MPa, cut ends of the tube groove after water pressure test, chamfer 30° , blunt edge of 1mm.

603件

受控文件

2	按本图 SEE THIS DWG	翅片 t=1.5 H=21 DESCRIPTION	1	S30408		31.7	
1	按本图 SEE THIS DWG	管子 $\phi 51 \times 4.5$ L=6165 TUBE	1	SA-213 TP321		32.1	
件号 PART NO.	图号或标准号 DRAWING NO. OR	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单 重量(kg) SINGLE	总 重量(kg) TOTAL	备注 REMARK
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							螺旋翅片管F $\phi 51 \times 4.5 / \phi 91$ SPIRAL FINNED TUBE F
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		63.8	1:8	0
APPROVE 批准	赵晓梅 2024.2.19		24-1004GR1B/24-1005GR1B 24-1006GR1B/24-1007GR1B		TOTAL-PAGES 共 张	No.-PAGE 第 张	4SCG2402-2-1-14-0

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