F001CJQ001D131

M–M

60°±2.5'×2~3 2008-0430(XI) IBR:FIG.28(ix)(b)

后屏过热器入口集箱 Φ508 SH PEND PLATEN INLET HEADER

顶棚管中心线 CL OF ROOF TUBES

Φ51X6.5 SA-213T12

Φ42X6 SA-213T22

Φ42X6 SA-210A1

管子A尺寸 DIMENSION OF PIPE A

管子B尺寸 DIMENSION OF PIPE B

75°±2.5'×2~3 2008-0430(X) IBR:FIG.28(ix)(b)

管子焊接详图(IBR:FIG.28(ix)(b)) WELDING DETAIL

工地焊接坡口详图 GROOVE DETAIL FOR FIELD WELDING

Note:
1. THIS PART/BOILER (FLUID COOLED SPACERS) IS DESIGNED, FABRICATED, EXAMINED AND INSPECTED PER IBR-1950 WITH THE LATEST AMENDMENT,SPECIFICATION HG.5.1.1(2).
2. DESIGN PRESSURE IS 19.95MPa(203.5Kgf/cm²), DESIGN TEMPERATURE IS Φ42x6 SA-210A1 366℃,Φ51x6.5 SA-213T12 437℃; Φ42x6 SA-213T22 400℃.
WORKING PRESSURE IS 19MPa(193.8Kgf/cm²),WORKING TEMPERATUER IS THE SAME AS DESIGN TEMPERATUER.
MAXIMUM WORKING PRESSURE IS 19.95MPa(203.5Kgf/cm²),
MAXIMUM WORKING TEMPERATUER IS THE SAME AS DESIGN TEMPERATUER.
3. ALL TUBE BUTT-JOINTS SHALL BE PERFORMED WITH RADIOGRAPH EXAMINATION PER. IBR CODE NDE REQUIREMENTS.
4. POST-WELD HEAT TREATMENT SHALL BE PERFORMED PER IBR CODE REQUIREMENTS.
5. HYDRO-TEST SHALL BE PERFORMED AT THE PRESSURE OF 29.93MPa(305.3Kgf/cm²). THE METAL WALL TEMPERATURE SHALL BE NOT LESS THAN 20℃ AND NOT GREATER THAN 50℃ DURING THE HYDRO-TEST.
6. THE MINIMUM REQUIRED THICKNESS OF TUBE SEE FOLLOWING LIST:

TUBE	MATERIALS	THICKNESS
Φ51x6.5	SA-213T12	4.7
Φ42x6	SA-213T22	3.6
Φ42x6	SA-210A1	3.8

7. DETAILS DRAWINGS,H-H CUTAWAY VIEW AND POSITION ABOUT ASSEMBLING ON SITE OF P.NO.24 WERE DRAWED AT DRAWING F001CJQ002D131.
8. WELD METAL: SA-213T12+SA-351CH20 USE E309Mo.
SA-210A1+SA-210A1,SA-210A1+SA213T12,SA-210A1+15CrMo USE E50
SA-213T12+SA213T12 SA-213T12+SA-213T22 USE E55-B2
9. ✕SHOW POSITION OF P.NO.24.
10. THE PART/BOILER (FLUID COOLED SPACERS) SHALL BE CERTIFIED AND STAMPED PER IBR REQUIREMWNTS.
11. UNNOTED TOLERANCE ACCORDING TO HG-C-990-941.
12. THE BUTT-JOINT BETWEEN TUBES SHALL BE WELDED PER WELDING DETAIL I (IBR:FIG.28(x)(b)).
13. MACHINING TUBE GROOVING ENDS OF PANEL PER.2008-0430(✕).
14. METRIC SCALE 1:40 IN THIS DRAWING IS EQUAL TO 1INCH:3.33 FEET.
15. THE DETAILLED BILL OF MATERIALS SEE F022CJQ001D131.

注 1.此部件(流体冷却间隔管)设计、制造、检验按BR1950及最新版和技术条件HG.5.1.1(2).
2.设计压力:19.95MPa(203.5Kgf/cm²) ,设计温度:Φ42x6 SA-210A1 366℃; Φ51x6.5 SA-213T12 437℃; Φ42x6 SA-213T22 400℃.
工作压力:19MPa(193.8Kgf/cm²) 工作温度同设计温度.
最大允许工作压力为19.95MPa(203.5Kgf/cm²) ,最大允许工作温度同设计温度.
3.所有管对接焊缝按 IBR NDE要求进行X光探伤.
4.焊后热处理按按 IBR 要求.
5.水压试验压力P=29.93MPa(305.3Kgf/cm²),温度20~50℃.
6.本部件中管子理论计算最小壁厚见下表

管子规格	材质	最小壁厚
Φ51x6.5	SA-213T12	4.7
Φ42x6	SA-213T22	3.6
Φ42x6	SA-210A1	3.8

7.详图,H-H 剖示及件号24的工地安装位置见图F001CJQ002D131.
8.焊焊金属: SA-213T12+SA-351CH20用 E309Mo.
SA-210A1+SA-210A1,SA-210A1+SA213T12,SA-210A1+15CrMo用 E50
SA-213T12+SA-213T12 SA-213T12+SA-213T22用 E55-B2
9.✕表示件号24挡板位置.
10.此部件(流体冷却间隔管)应按IBR要求进行检验及标记.
11.未注明公差按技术条件HG-C-990-941.
12.管子对接焊缝按焊接详图 (IBR FIG.28(ix)(b)).
13.所有管端坡口按2008-0430(XI)型加工.
14.图中比例:40相当于1in:3.33feet.
15.材料详表见零件编号F022CJQ001D131

Job NO:T116053.T116054

Boiler No.3456(Unit 1) and
Boiler No.3457(Unit 2) are identical

件号 NO.	图号 DRAWING NO.	名称 DESCRIPTION	材料牌号 MAT'L	数量 REQ'D	单重 SGL. WT. kg	总重 TOT. WT. kg	备注 REMARKS
27	YT15-4975	支撑板 FACING BAR	SA-351CH20	2	0.33	0.66	
26	YT15-4976	定位板 SETTING PLATE	SA-351CH20	4	0.5	2	
25	YT15-4973	支撑板 FACING BAR	SA-351CH20	4	0.25	1	
24	YT15-4970	挡板 BAFFLE	SA-351CH20	24	0.112	2.69	
23	YT15-4972	定位板 SETTING PLATE	SA-351CH20	128	0.195	25	
22	YT15-4974	定位板 SETTING PLATE	SA-351CH20	2	0.33	0.58	
21	按本图 AS DRAWING	管子 TUBE Φ51×6.5×L=3500	SA-213T12	4	25	100	见注13 SEE NOTE 13
20	F002CJQ015D131	管子 TUBE	装配件 ASS'Y	1		31.5	
19	F002CJQ014D131	管子 TUBE	装配件 ASS'Y	1		30	
18	F002CJQ013D131	管子 TUBE Φ51×6.5×L=5281	SA-213T12	1		37.8	
17	F002CJQ012D131	管子 TUBE	装配件 ASS'Y	1		39	
16	F002CJQ011D131	管子 TUBE Φ51×6.5×L=4830	SA-213T12	1		34.5	
15	F002CJQ010D131	管子 TUBE Φ42×6×L=2214	SA-213T22	1		11.7	
14	F002CJQ009D131	管子 TUBE Φ51×6.5×L=2128	SA-213T12	1		15.2	
13	按本图 AS DRAWING	圆钢 ROD Φ12×L=100	15CrMo	4	0.088	0.35	
12	按本图 AS DRAWING	管子 TUBE Φ51×6.5×L=2745	SA-213T12	4	19.58	78.32	见注13 SEE NOTE 13
11	按本图 AS DRAWING	管子 TUBE Φ51×6.5×L=2830	SA-213T12	3	20.19	60.57	见注13 SEE NOTE 13
10	按本图 AS DRAWING	管子 TUBE Φ51×6.5×L=3000	SA-213T12	3	21.4	64.2	见注13 SEE NOTE 13
9	按本图 AS DRAWING	管子 TUBE Φ51×6.5×L=3060	SA-213T12	8	21.83	174.64	见注13 SEE NOTE 13
8	F002CJQ008D131	管子 TUBE	装配件 ASS'Y	1		48.2	
7	F002CJQ007D131	管子 TUBE Φ51×6.5×L=4067	SA-213T12	1		29	
6	F002CJQ006D131	管子 TUBE	装配件 ASS'Y	1		42.8	
5	F002CJQ005D131	管子 TUBE	装配件 ASS'Y	1		44.5	
4	F002CJQ004D131	管子 TUBE	装配件 ASS'Y	1		34.1	
3	F002CJQ003D131	管子 TUBE	装配件 ASS'Y	1		33	
2	F002CJQ002D131	管子 TUBE	装配件 ASS'Y	1		42.9	
1	F002CJQ001D131	管子 TUBE	装配件 ASS'Y	1		42.4	

OWNER: COASTAL ENERGEN PRIVATE LIMITED
OWNER'S ENGINEERS: TCE CONSULTING ENGINEERS LIMITED BANGALORE
CONTRACTOR: HARBIN POWER ENGINEERING COMPANY LIMITED

DES. 设计	杨凤芳	2011.3.14
CK. 审核	王秋研	2011.3.14
REV. 审定	徐和平	2011.3.14
CHIEF ENGR. 总工程师	许加明	2011.3.14
STD. 标准审查	王秋研	2011.3.14
TECH. 工艺审查		
APPRO. 批准		
EDITION 基本号	A	

流体冷却间隔管总图(一)
GENERAL ARRANGEMENT OF FLUID COOLED SPACER NO.1

流体冷却间隔管 FLUID COOLED SPACERS
HG-2060/17.5-YM9 锅炉 BOILER

DRAWING NO. 图号	F001CJQ001D131
PART LIST NO. 零件表编号	F022CJQ001D131
REF. LIST NO. 参考图表号	F001CJQ001D121
CHNG. MARK 变更标记	Y
WT. 重量	1027
SCALE 比例	1:40

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