



Supplementary technical requirements:

- 1、受压焊接口 GB/T7173-2023 新增规定：16Mn 钢制承压管 NB/T4708-2019 中 II 类焊缝，Q345R 碳钢复合板 GTB/T6479-2013 明确规定。Equipment materials Q345R should comply with the provisions of GB/T7173-2023; 16Mn forgings should comply with the provisions of Class II in NB/T4708-2019; Q345R steel pipe should comply with the provisions of GB/T6479-2013.
- 2、凡与主罐体的接管壁厚不得大于其 10%（SIS 除外）。
- 2 The negative deviation of the thickness of the connecting pipe using seamless steel pipe shall not exceed 10% S/S as the thickness of the tank body).
- 3、胎头有缺陷时，均应为对接结构；焊接接头在母材表面应圆滑过渡，无咬边、未熔合、夹渣气孔、裂纹。无漏磁和肉眼可见的宏观缺陷，不得存在交叉；焊缝与母材应圆滑过渡；筒体内壁及四侧须做无损检测。
- 3 Unless otherwise stated, all are fully welded structures.Welded joints must have defects such as surface cracks, unwelded, unfused, surface pores, arc pits, unrefined and visible slag inclusions, and must not have edge bites.The weld and the base metal interface must be smoothly transitioned,the shape of the fillet weld must be concave and smoothly transitioned.
4、壳体纵缝焊完后，应按 HG/TJ504-2024 表 5.1 条要求进行探伤检测，最大允差值不大于 10mm。
After the tower body assembly is welded, the roundness of the shell should be checked according to Article 6.5.1Tf of GB/T504-2024, the maximum allowable deviation should not be greater than 10mm
5、筒体经 3000mm 有效长度测量者不大于 3mm，简体每米的直线度偏差不得超过 3mm，筒体任意垂直直径不得超过 1mm。
The linearity deviation of any 3000mm length of the cylinder shall not be greater than 3mm;The total linearity deviation of the tower body shall not be greater than 6 mm, the verticality deviation of the lower body installation shall not be greater than 1mm;
6、裙座圈螺栓中心间距公差以及相邻两螺距公差为最大值正负 ±3mm。
The tolerance for the diameter of the center circle of the skirt anchor bolt hole and the tolerance for the chord length of the adjacent two holes and any two holes shall not be greater than ±3mm
- 7、垫层钢板尺寸和最大允许公差应符合 HG/TJ2054-2020 中的 2.3 条款有关规定。
- 7 The installation dimension formulae of the on-site level liquid gauge part is in accordance with Article 6 of Article 14.2.13 in HG/TJ2054-2020
- 8、DN<250mm 接管与端盖的连接处按照 NB/T4703.4-2015 执行 100%射线检测，合格等级不低于Ⅰ级。
The butt joints of the connectors with DN <250mm and flange should be tested 100% RT according to NB/T4703.4-2015, and the pass level shall not be better than Level I.
- 9、DN≥250mm 接管与壳程的连接按 NB/T4703.3-2015 执行 100%射线检测，合格等级不低于Ⅱ级。
The welded joints of the connectors with DN ≥250mm and the shell should be tested 100% UT according to NB/T4703.3-2015, and the pass level shall not be better than Level II.
- 10、多层板多组缠绕设备，当按照 NB/T4703.2-2015 执行 100%RT 检测，合格等级不得低于 A 级。
If the plate type is rolled with a plate, the longitudinal seams should be tested 100% RT according to NB/T4703.2-2015, the pass level shall not be below Grade A and the Technical level shall not be lower than Level AB
- 11、所有安全设施设置《全塔型》安全技术方案并经设计审核合格后，应在中国特种设备安全协会备案人一手持原件一份，交当地市场监管总局一份用于监管使用，在中国市场监管局特种设备综合平台（全国特种设备公示），最上端的结构设计符合并满足国家强制性标准。
All safety facilities are prepared by Party A.A fully open safety valve is installed at the top port NDS and connected to the housing.Safety valve setting pressure :5MPa.The safety valve should be installed vertically.If equipped with valve,during normal operation of the pressure vessel, the shutdown valve must be fully opened(lead seal or lock).The structure and diameter of the shut-off valve shall not hinder the safe discharge of the overpressure discharge device.
- 12、吊耳安装空载状态下满载。
- 12 The lifting ears are only allowed to be lifted if empty installation
- 注：
Note:
- 1、在设计寿命期内，压力容器使用寿命，应按照最高工作压力等级或 TSG RZ1-2016 第 8 章“定期检验”的要求，对设备进行常规检查并接受政府有关部门的安全监督检查。
During the design life period, the pressure vessel user unit should support regular inspections of the equipment according to the operating status of the device or the requirements of TSG RZ1-2016 Chapter 8 “Regular Inspection”and confirm the compliance of the actual life and design life.
- 2、加强横纹密封带，不得拆除，遇到异物应及时及时人工清除，发现损坏要及时更换 500mm。
The strengthening ring used as interlayer support shall not be disconnected When encountering the pipe mouth and platform support ears, they can move up and down .The maximum distance must not exceed 500mm.
- 3、裙座圈螺栓采用双螺母加防松保险丝固定，必须同时与裙座基座一起进行防腐处理，基座需涂富锌底漆+环氧面漆。
The skirt anchor bolts are in place with anchor bolt foundation templates .The foundation template and the skirt base plate are equipped with drilled bolt holes .The foundation template needs to be sent to the installation site in advance

GK	R2502Z-GK	管口零件 PIPE PARTS		1		965.5	
13		把手 HANDLE		3	Q345R	0.4	1.2
12		爬梯 LADDER		1	Q345R		1.8
11	GB/T25198-2023	接头 [CHA3000×14(118)]		2	Q345R	1090	2180
10		可拆卸保温材料 REMOVABLE TYPE INSULATION RING		1	组焊件 ASSEMBLY		50.34
9	HG/T21574-2018	轴封带 AXA-4-30-14 SHaft OFfSeALing		2	Q235B/Q345R	52.4	104.8
8		壳体 DN3000×14 SHELL		1	Q345R		H=6000
7		加强圈 L100~100×12 STReNGTHENING RiNG		2	Q345R	174.1	348.2 L≈9827
6	R2502Z-6	防腐蚀板 ANTI-CORROSION PLATE		1	Q345R		1.4
5	R2502Z-5	裙座 SkIRT		1	组焊件 WELDiNG PARTS		4385
4	R2502Z-4	钢罩 MONOPATE		1	S30408	--	
3		标准腿A STANDARD STAND A		1	Q345R	1	H=140
2		垫板 FLoATPLATE		2	S30408	0.5	L=110
1		基础模板 BASIC TEMPLATE		1	组焊件 WELDiNG PARTS		430
料号 PARTS NO.	图号或标准号 DWG. NO. OR STD. NO.	名称 PARTS NAME	数量 QTY.	材料 MAT'L	重量TOTAL WEIGHT(MASS)(KG)		备注 REMARKS
	设备自重 (供货质量) NET MASS	(Kg)	14715				
	空煤重 EMPTY MASS	(Kg)					
	操作质量 OPERATING MASS	(Kg)					
	盛水质量 MASS OF FULL WATER	(Kg)	64715				
	最大可操作质量 MAX.REMOV.PART MASS	(Kg)					
				标记 MARK	页数 PAGE	更改文件号 CHANGE FILE NO.	签字 SIGN
							日期 DATE
 浙江诚泰化工机械有限公司 ZHEJIANG CHENGTAI CHEMICAL MACHINERY CO., LTD				图号 DWG. NO.	R2502Z-00		
设计 DESIGN	CND	0.4MPAG蒸汽平衡罐 0.4MPAG STEAM BALANCE TANK		项目 SECTION	WUHUAN ENGINEERING CO.LTD		
审核 CHECK	DSC APP			项号 ITEM NO.	3000D IPA NEOPENTYL GLYCOL PROJECT		
核算 CODE APP				版次 REV	V-2601		
工艺审查 PRO SIGN		总装配图 Assembly DWG		A02	审核人: 王德林		
批准 APPR				比例 SCALE	1 : 25		
					(The second revised drawing)		