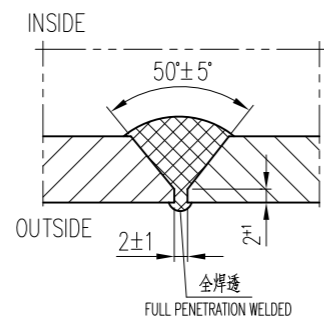


设计数据与制造技术条件表 DESIGN DATA AND MANUFACTURE SPECIFICATIONS						
设计压力 Bar(g)/Psi(g)	4.1/-1.013	设计、制造、检验、验收规范	ASME SEC.III-DIV.1, 2013			
DESIGN PRESSURE	60/-14.7	ASME 认证标志	U Stamp			
最大允许工作压力 Bar(g)/Psi(g)	4.1/-1.013	ASME 注册	YES			
MAMP	60/-14.7	NB 注册	YES			
操作压力 Bar(g)/Psi(g)	0.172/2.5	壳体	SA-240 316L			
OPERATION PRESSURE		壳头	SA-240 316L			
设计温度 (max./min.) °C/°F	250/-28.9	管法兰/法兰盖	SA-182 F316L			
DESIGN TEMP.	482/-20	地脚螺栓				
操作温度 °C/°F	45/113	锚杆螺栓				
OPERATION TEMP.						
最低设计金属温度 °C/°F	-28.9/-20					
M.D.M.T.						
物料名称	ACA RESIDUE	风压设计规范	IBC-2009			
FLUID		WIND DESIGN CODE				
介质特性	非腐蚀性	地震设计规范	IBC-2009			
FLUID PROPERTY		SEISMIC DESIGN CODE				
介质密度 Kg/m³/lb/ft³	1020/63.648	安全阀设定压力 barg/Psi(g)	N.A.			
FLUID DENSITY		OPEN. PRESS. OF RD.				
腐蚀裕量 mm/inch	0/0	换热面积	m²/ft²			
CORR. ALLOWANCE		HEATING SURFACE	N.A.			
焊缝系数	0.85/1.0	保温材料	N.A.			
JOINTS EFF.		MATERIAL OF INSULATION				
水压试验压力 Bar(g)/Psi(g)	5.96/86.5	保温厚度	mm/inch			
HYDRO. TEST PRESSURE		THICKNESS OF INSULATION	50.8/2			
气密性试验压力 Bar(g)/Psi(g)	/	搅拌器型式	N.A.			
PNEUMATIC TEST PRESSURE		AGITATOR TYPE				
材料应力分析	YES	搅拌器转速	(r/min)			
FINITE ELEMENT ANALYSIS		AGITATOR SPEED	N.A.			
公称容积 m³/gal	22.4/5917	电机功率 (KW) / 励磁等级	N.A.			
NOMINAL VOLUME		B.H.P./ENCLOSURE TYPE				
总容积 m³/Gal	26.93/7114	搅拌器重量	Kg/lb			
TOTAL VOLUME		WEIGHT OF AGITATOR	N.A.			
壳体容积 m³/Gal	22.77/6015	设备净重	Kg/lb			
SHELL VOLUME		DRY WT.	9442/20815			
封头容积 m³/Gal	2.08/549.5	充水重	Kg/lb			
HEAD VOLUME		FULL OF WATER WT.	33864/74655			
设计等级	/	操作重	Kg/lb			
DESIGN LEVEL		OPERATING WT.	36531/80535			
AB 类焊缝	射线检测 RT	其中不锈钢 kg/lb	/			
SHELL/HEAD SEAM		INCLUDE: S.S.				
(A,B)		保温层重量	Kg/lb			
		INSULATION WT.	/			
C, D 类焊缝	磁粉检测 MT	管口、支管方位	见本图			
NOZZLE/BRACKET		THE ORIENTATION OF NOZZLES-BRACKET	SEE THIS DWG.			
管口/支管方位		无因零件切割表面粗糙度	25			
ROUGHNESS OF CUT SURF. WITHOUT DR.						
热处理要求	N.A.	冲击试验	EXEMPTED			
HEAT TREATMENT (S.R.)		IMPACT REQUIREMENT				
总的说明 GENERAL SPECIFICATION						
焊接材料	详见 WPS ACCORDING TO WPS					
WELDING MATERIAL	SEE WPS					
焊接型式	所有焊接按工艺, 由制造厂提供工艺评定后确定。					
TYPE OF WELDING	ALL WELDING SHALL BE PROVIDED BY MANUFACTURER ACCORDING TO WPS AND PQR.					
焊接规范	W.P.S. 详见 WPS/PQR ACCORDING TO WPS/PQR					
WELDING SPEC.	SEE WPS/PQR					
公差	客户规范 TS 25-0108 TS 25-0108					
TOLERANCES	CUSTOMER SPEC. TS 25-0108					
焊接要求	WELD SPEC. A, B, C, D 类焊缝必须全焊透。					
WELDING REQUIREMENTS	JOINTS OF CATEGORY A, B & C, D SHALL BE FULL PENETRATION.					
其它要求	OTHERS					
NO.	图号及标准号	名称	数量	材料	重量	备注
DRAWING NO. OR STANDARD NO.	TITLE	QUANTITY	MATERIAL	UNIT	TOTAL	REMARKS
05	2015-11-03	ISSUED FOR FABRICATION		W.X.D	Y.W.T	F.Z
04	2015-10-08	FOR APPROVAL		W.X.D	Y.W.T	F.Z
03	2015-09-25	FOR APPROVAL		W.X.D	Y.W.T	F.Z
REV	DATE	DESCRIPTION		DRAWN	CHK.	APPR.
OWNER / DEVELOPER:						
昆山市贝色特材装备有限公司 Kunshan Bexceller Special Equipment Co., Ltd.						
项目名称: Mobile ACA Project PROJECT NAME:						
Evonik Corporation Mobile, AL, USA						
General arrangement for ACA Residue Storage Vessel						
图号: V-4510 生产号: 15-A3176						
版次: 05 图号: BSA15-303-00(1/3) 比例: 1:1 张数: 共 1 张, 第 1 张 日期: 2015.11.03						

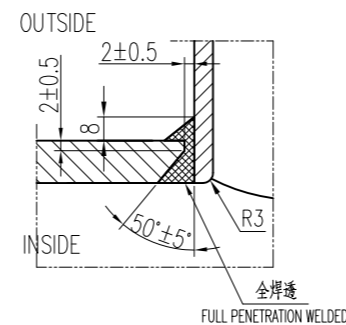
技术要求: TECHNICAL REQUIREMENTS:

- 本设备的设计、制造、检验及验收按ASME Sec. VIII Division 1 要求外, 还应满足下列规范及标准的相关要求:
20.230.013; 20.230.030; 20.230.036
THE DESIGN, FABRICATION, TESTING, INSPECTION AND ACCEPTANCE FOR THIS EQUIPMENTS SHOULD CONFORM TO ASME SEC. VIII DIVISION 1 CODE, AND APPLICABLE DIN STANDARDS, AND SPECIFICATION AS FOLLOWING:
20.230.013; 20.230.030; 20.230.036
- 所有不锈钢材料, 包括板、接管、法兰附件及焊缝应进行PMI检测。
PMI INSPECTION SHALL BE DONE FOR THE MATERIAL OF STAINLESS STEEL, WHICH INCLUDES PLATE, NOZZLES, FLANGE AND WELDING SEAM.
- 所有承压元件的焊接须全焊透, 并依据WPS。
WELDING OF ALL PRESSURE PARTS SHALL BE FULL PENETRATION AS PER QUALIFIED WPS.
- 焊接材料由制造厂按焊接工艺评定后确定。
THE WELDING CONSUMABLES SHALL BE PROVIDED BY VESSEL VENDOR ACCORDING TO WPS AND PQR.
- 所有对接焊缝全焊透, 焊缝表面圆滑过渡, 与壳体相焊的接管的外角应打磨圆滑R3mm。
ALL BUTT WELD SHALL BE FULL PENETRATION, THE SURFACE OF WELD SHOULD BE SMOOTH, SHARP OF NOZZLE WELD TO SHELL SHALL BE POLISHED TO R3mm.
- 法兰螺栓孔应跨设备自然中心线分布。
BOLT HOLES SHALL STRADDLE THE NATURE CENTRE LINES.
- ASME B16.5-2009法兰密封面粗糙度为 $\frac{1}{8}$ ~ $\frac{1}{16}$ 。
THE Ra SHALL BE 3.2-6.3 MICRO METERS FOR ALL ASME B16.5-2009 FLANGES.
- 补强圈低点应开NPT 1/4测试孔, 补强圈在设备水压试验前, 以1barg表压压缩空气进行肥皂水试验, 合格后, 试验孔用NPT 1/4螺塞堵塞。
REINFORCING PAD SHALL PROVIDED A NPT 1/4 TELL TALE HOLE AT LOWEST POINT, AIR LEAK TEST SHALL BE PERFORMED ON REINFORCING PAD ATTACHMENT WELDS AT A PRESSURE OF 1 barg PRIOR TO FINAL HYDROTEST WITH BUBBLE FORMING SOLUTION. TELL TALE HOLE FILLED WITH NPT 1/4 PLUG.
- 吊耳板与吊耳连接, 法兰与接管与筒体的焊接接头须100% PT检测, 符合ASME VIII-1附录8中规定, 具体要求应按WPS/卷第5章。
WELDING JOINT OF LIFTING LUG AND PAD, FLANGE WITH SHELL SHALL BE EXAMINED BY 100% PT. AND MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX 8). ARTICLE 6 OF SECTION V SHALL BE APPLIED FOR DETAIL REQUIREMENTS.
- 耳座与法兰以及接管与筒体的焊接接头须100% PT检测, 符合ASME VIII-1附录8中规定, 具体要求应按WPS/卷第5章。
THE WELDS BETWEEN BRACKETS AND SHELL, PAD AND BRACKETS SHALL BE EXAMINED BY 100% PT. MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX 8). ARTICLE 6 OF SECTION V SHALL BE APPLIED FOR DETAIL REQUIREMENTS.
- 水压试验时, 应用于干净的水, 且控制水的氯离子含量不超过50ppm; 水压试验后, 设备应保持干燥、清洁。
HYDROSTATIC TESTING SHALL BE DONE WITH CLEAN WATER AND THE MAXIMUM CHLORIDE CONTENT IS NOT MORE THAN 50ppm. AFTER HYDROSTATIC TEST, THE EQUIPMENT SHALL BE DRIED, CLEANED.
- 水压试验时需用工作垫片。
ORIGINAL WORK GASKETS TO BE USED FOR TESTING.
- 设备组装完毕后, 应对不锈钢进行表面处理, 按照规范 TS 25-0205-2, 所有不锈钢内外表面应做钝化, 钝化所形成的钝化膜用蓝点法检测, 无蓝点为合格。
THE STAINLESS STEEL SURFACE PREPARATION ACCORDING TO TS 25-0205-2. INNER AND OUTER SURFACE OF STAINLESS STEEL SHOULD BE PICKLED AND PASSIVATED, THE PASSVATED SURFACE SHALL BE EXAMINED USING BLUE-POINTING PENETRATION METHOD, NO BLUE-POINT TO BE ACCEPTED.
- 设备上管法兰用垫片为: 缠绕垫 内衬316SS, 填充物石墨, 厚度4.5mm。
FOR VESSEL GASKET: GRAPHITE WITH INSIDE, AND OUTSIDE RING OF 316SS, GALVANIZED 4.5 MM THK.
- 除了配有永久法兰的法兰以外, 所有的法兰应采用与法兰外径相等的6mm厚的钢板加以覆盖, 且至少用4个1/2"的螺栓和3mm厚的橡胶垫片固定。
FLANGE FACES OTHER THAN THOSE FURNISHED WITH PERMANENT BLINDS SHALL BE COVERED WITH 6MM STEEL PLATE, WITH AN OUTSIDE DIAMETER IDENTICAL TO THE FLANGE, AND SECURED WITH A MINIMUM OF 4 BOLTS, NOT LESS THAN 1/2" COMPLETE WITH 3mm THICK RUBBER GASKET
- 吊耳板设备空重。
LIFTING LUG ONLY FOR VESSEL EMPTY WEIGHT.
- 接地表面不得涂油漆, 接地电阻值不大于10Ω。
EARTH LUG SHALL NOT BE PAINTED, AND RESISTANCE OF THE EARTH WIRE SHALL NOT EXCEED 10Ω.
- 设备供货时, 试车备件: 垫片: 200%; 紧固件: 10% 不少于2套。
COMMISSIONING SPARE PARTS: 200% GASKETS AND 10% STUDS AND NUTS OR MIN. 2 SETS.
- 设备的开孔, 补强圈, 垫板等其他元件不得开在设备的板、环焊缝上。
LONGITUDINAL AND CIRCUMFERENTIAL WELD SEAMS SHALL NOT INTERFERE WITH NOZZLE OPENING, REINFORCING PLATE ETC.
- 板条接管的对接焊缝应做UW-51进行100%射线检测。
THE BUTT WELD OF PLATE ROLLED NOZZLE SHALL BE EXAMINED BY 100% RT PER UW-51.
- 设备要海运包装并加2Barg氮气保护。
SEAWORTHY PACKAGING WITH N2 FILLING(0.2BARG)
- 本设备碳钢部分油漆和表面处理涂装工程规定: 20-230-032 Painting of Equipment-REV 1 的相关规定要求进行。
THE CARBON STEEL SURFACE PREPARATION AND PAINTING ACCORDING TO 20-230-032 Painting of Equipment-REV 1.

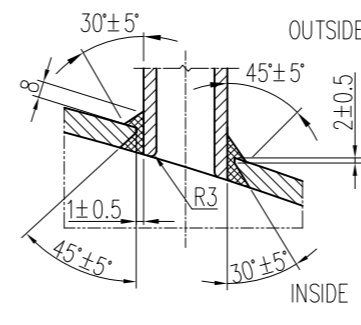
A,B类焊接接头详图
DETAIL OF A,B WELD
不按比例 NO SCALE



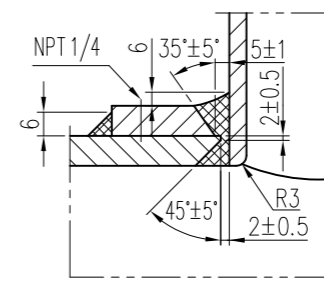
D类焊接接头
DETAIL OF D WELD
不按比例 NO SCALE



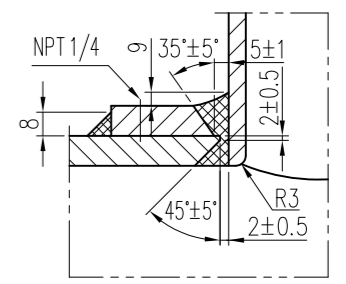
非径向D类焊接接头
D BUTT WELD DETAIL
不按比例 NO SCALE



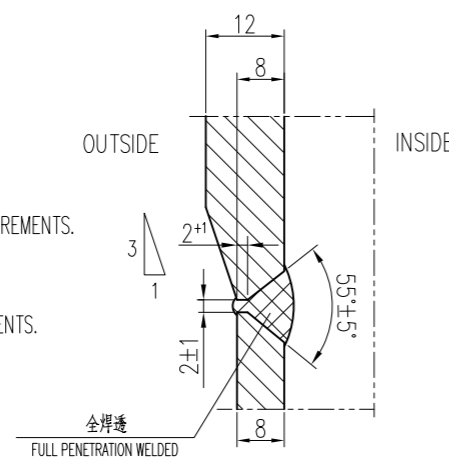
D类焊接接头(管口A7带补强圈)
DETAIL OF D WELD(A7 WITH REINFORCEMENT PAD)
不按比例 NO SCALE



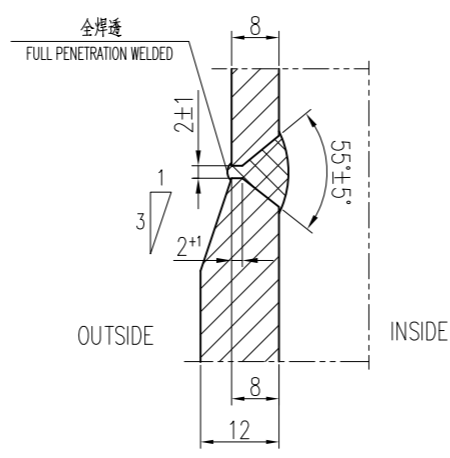
D类焊接接头(管口M1带补强圈)
DETAIL OF D WELD(M1 WITH REINFORCEMENT PAD)
不按比例 NO SCALE



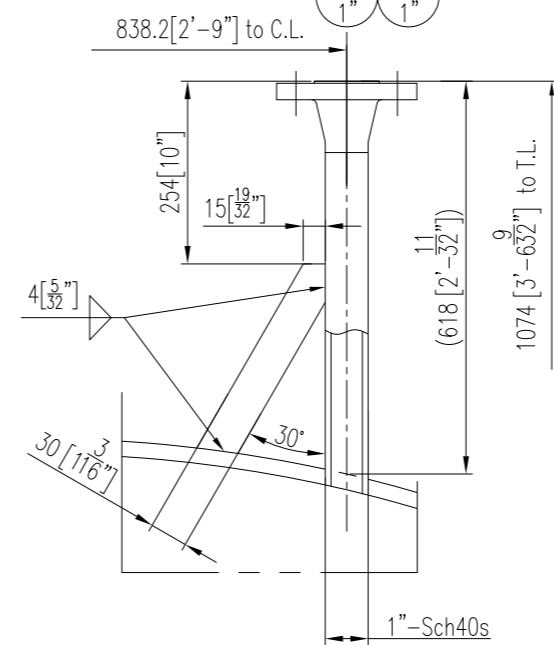
I
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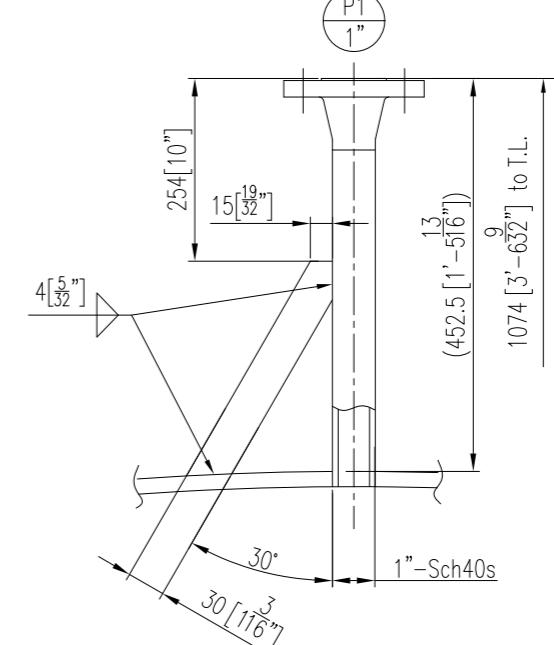
II
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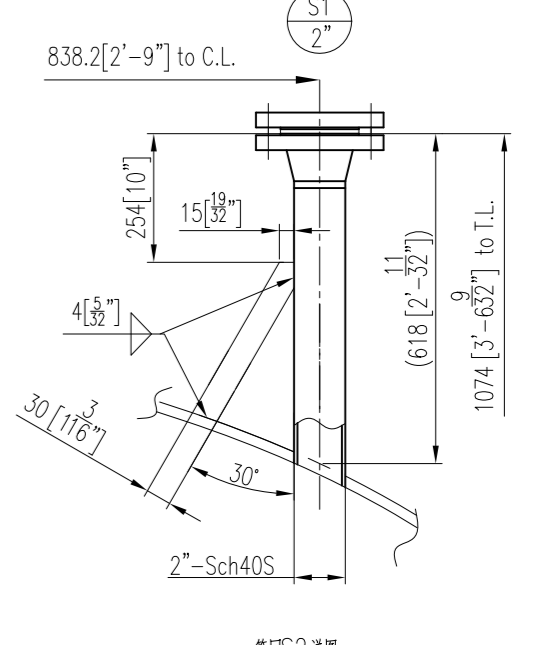
管口A5,N1详图
DETAIL OF NOZZLE A5,N1
不按比例 NO SCALE



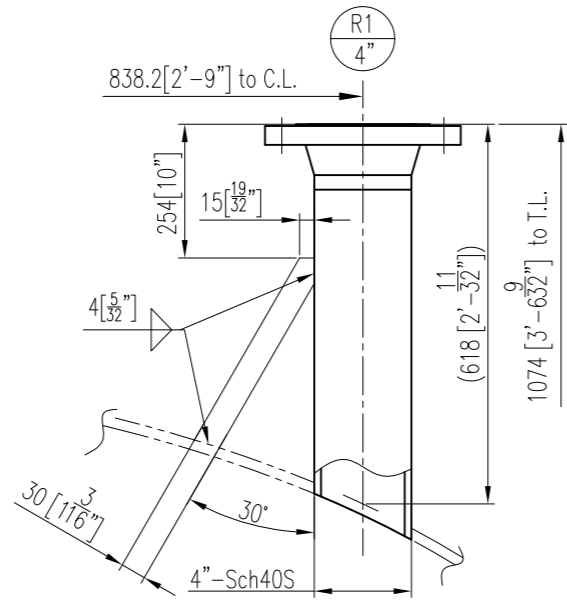
管口P1详图
DETAIL OF NOZZLE P1
不按比例 NO SCALE



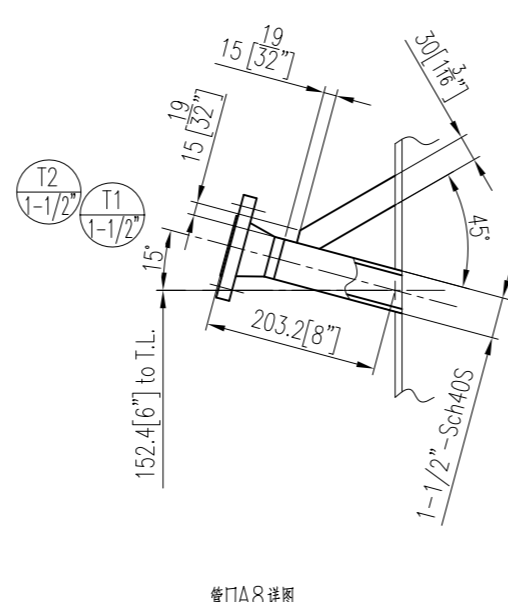
管口S1详图
DETAIL OF NOZZLE S1
不按比例 NO SCALE



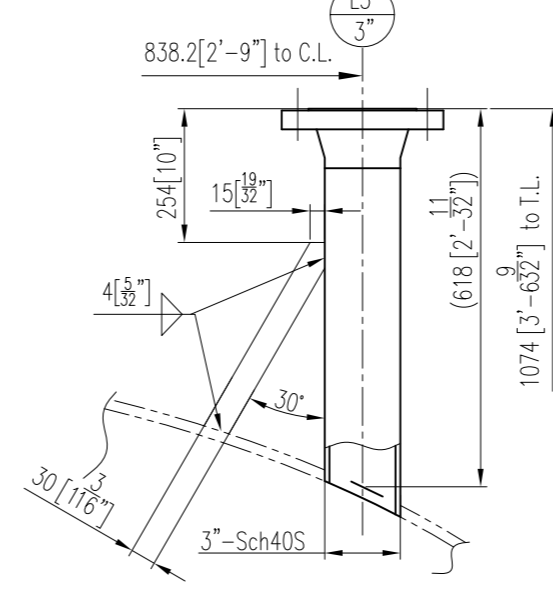
管口R1详图
DETAIL OF NOZZLE R1
不按比例 NO SCALE



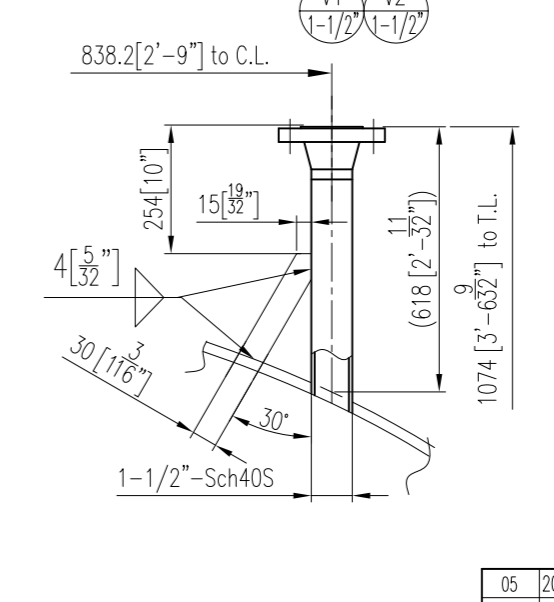
管口T1,T2详图
DETAIL OF NOZZLE T1,T2
1:6



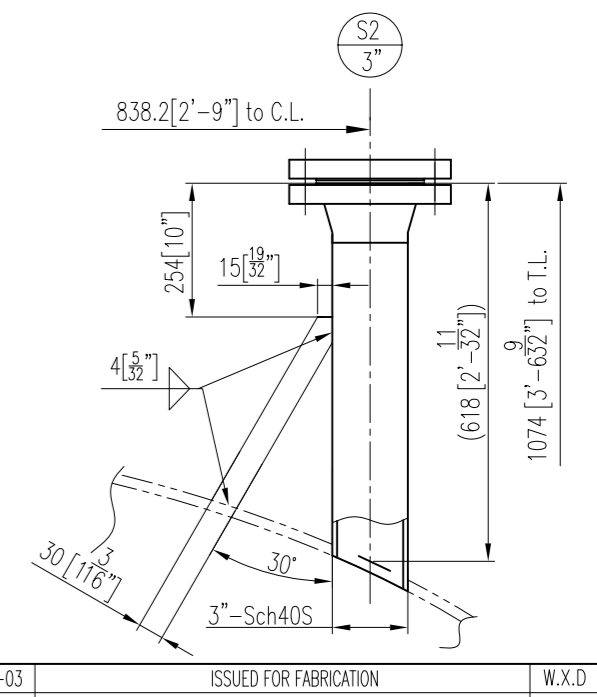
管口L3详图
DETAIL OF NOZZLE L3
不按比例 NO SCALE



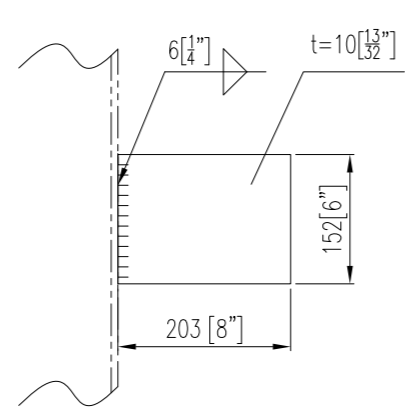
管口V1,V2详图
DETAIL OF NOZZLE V1,V2
不按比例 NO SCALE



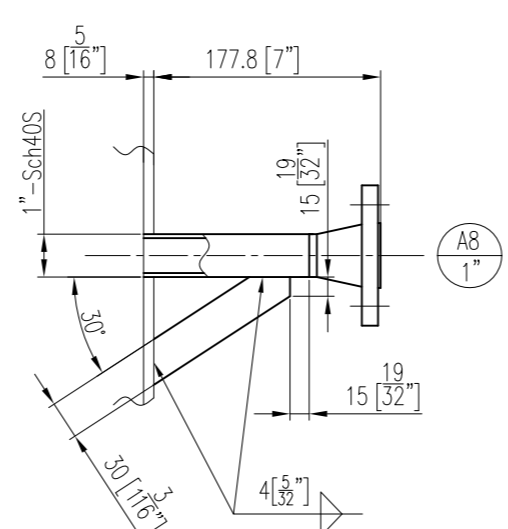
管口S2详图
DETAIL OF NOZZLE S2
不按比例 NO SCALE



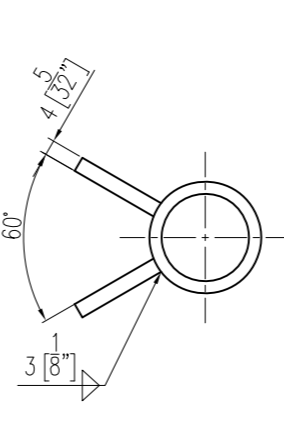
件号8支撑板详图
DETAIL OF PART NO. 8 SUPPORT CLIP
1:6



管口A8详图
DETAIL OF NOZZLE A8
1:4



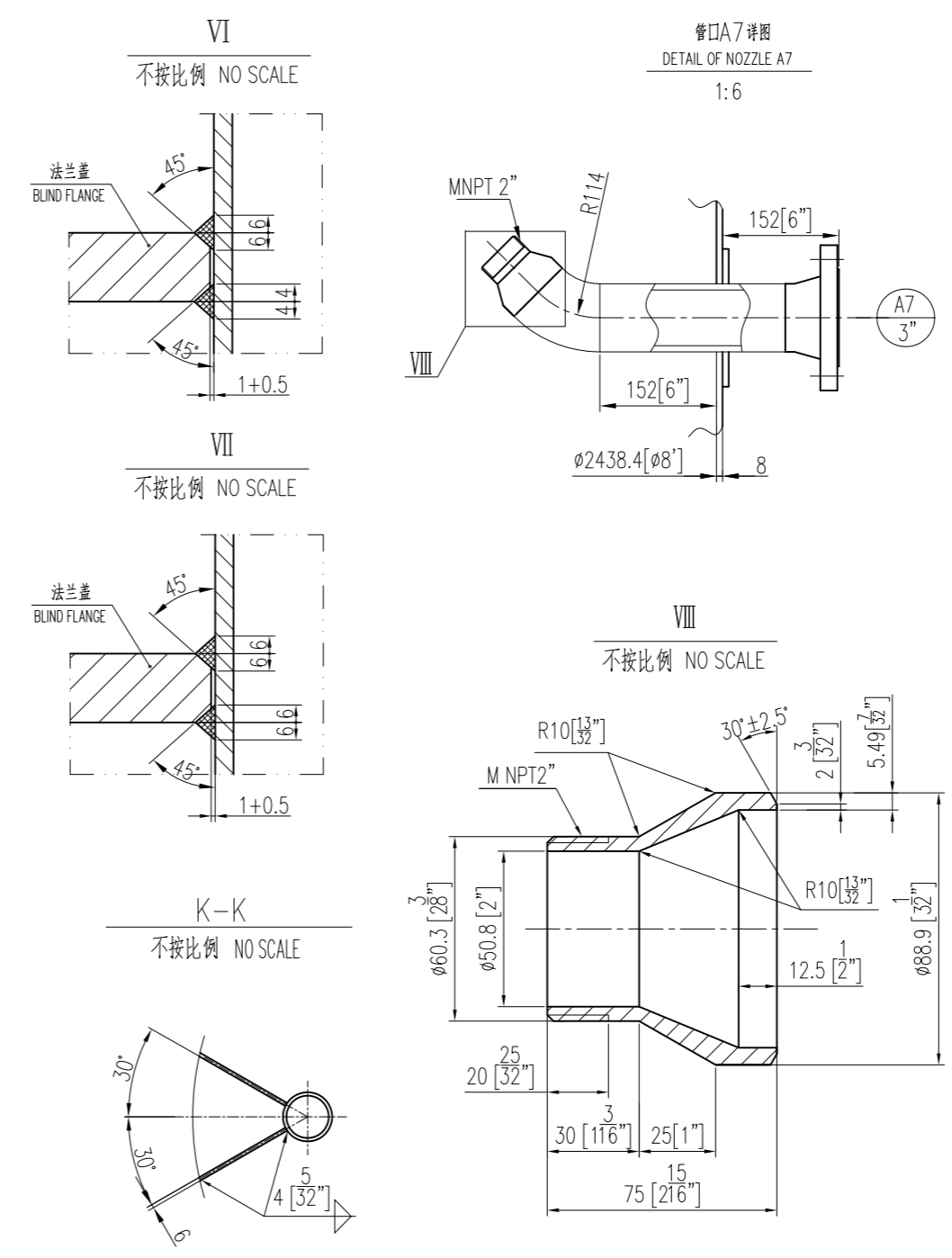
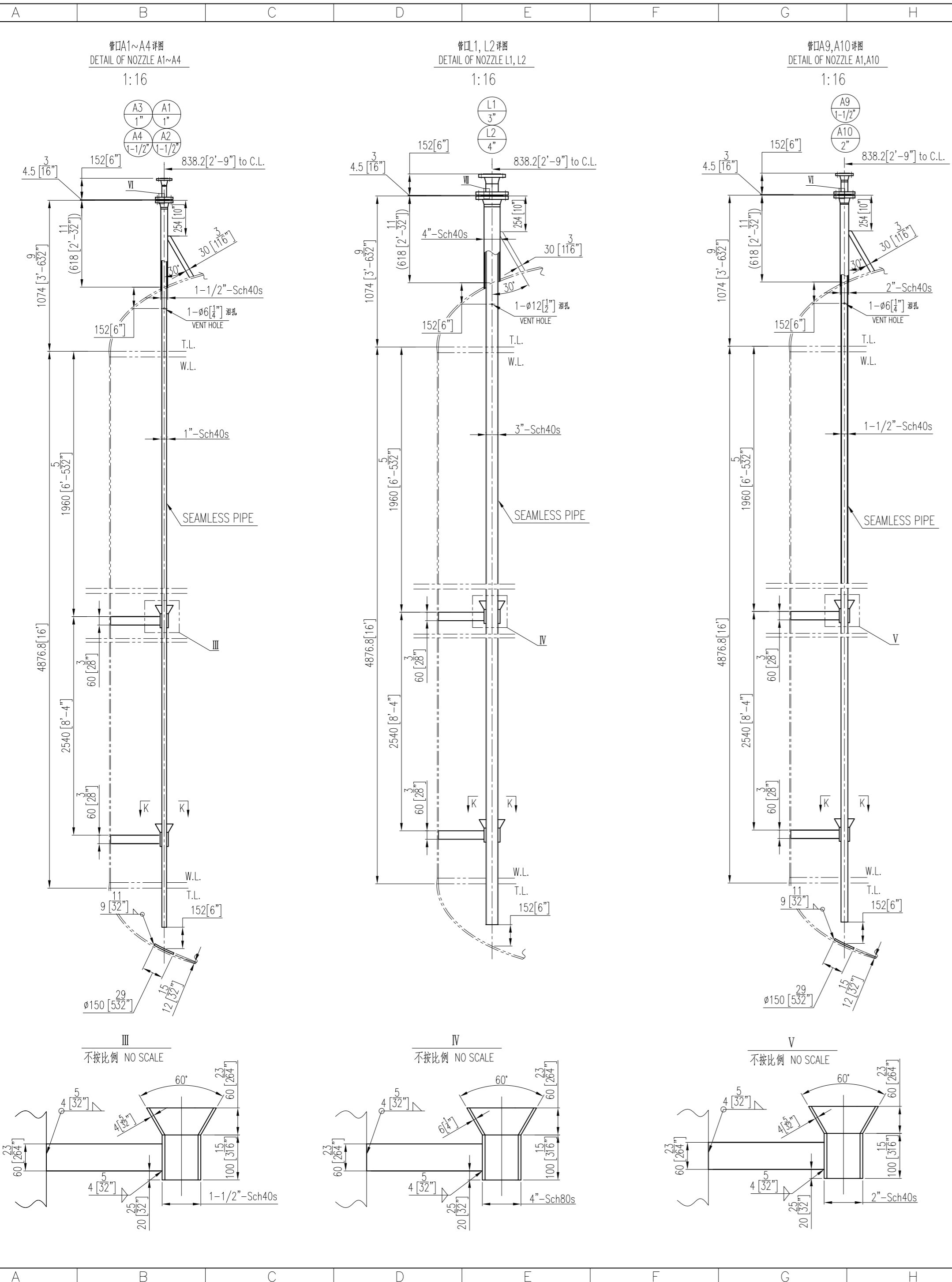
管口配两根筋板布置详图
ORIENTATION DETAIL OF 2 RIB PLATE FOR NOZZLE
不按比例 NO SCALE



05	2015-11-03	ISSUED FOR FABRICATION	W.X.D	Y.W.T	F.Z
04	2015-10-08	FOR APPROVAL	W.X.D	Y.W.T	F.Z
03	2015-09-25	FOR APPROVAL	W.X.D	Y.W.T	F.Z
02	2015-09-07	FOR APPROVAL	W.X.D	Y.W.T	F.Z
01	2015-08-26	FOR APPROVAL	W.X.D	Y.W.T	F.Z
REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.

OWNER / DEVELOPER:

昆山市贝色特材装备有限公司 Kunshan Bexcelle Special Equipment Co.,Ltd		项目名称: PROJECT NAME: Mobile ACA Project	
绘图 DRAW	设计 DESIGN	审核 CHECK	批准 APPROVE
Evonik Corporation Mobile, AL, USA		版次 REV: 05	
General arrangement for ACA Residue Storage Vessel		图号 DWG. NO. BSA15-303-00(2/3)	
比例 SCALE		共 3 页, 第 2 页 PAGE 2 OF 3	
标准号 STANDARD	生产号 ITEM NO. V-4510	图号 SERIAL NO. 15-A3176	图法 Dwg Work

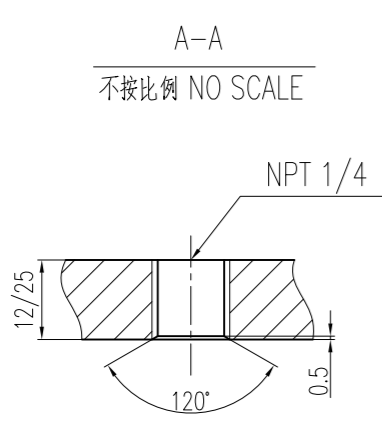
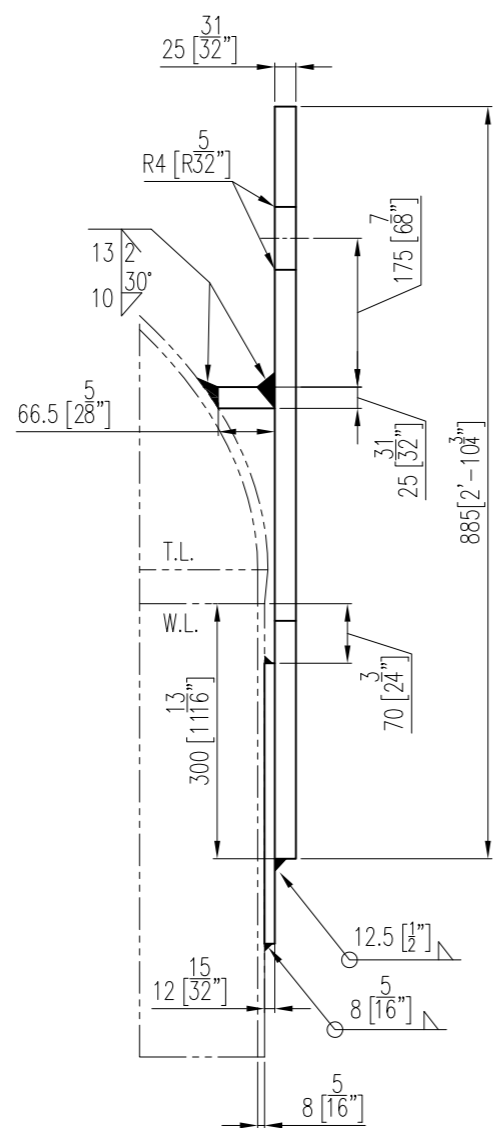
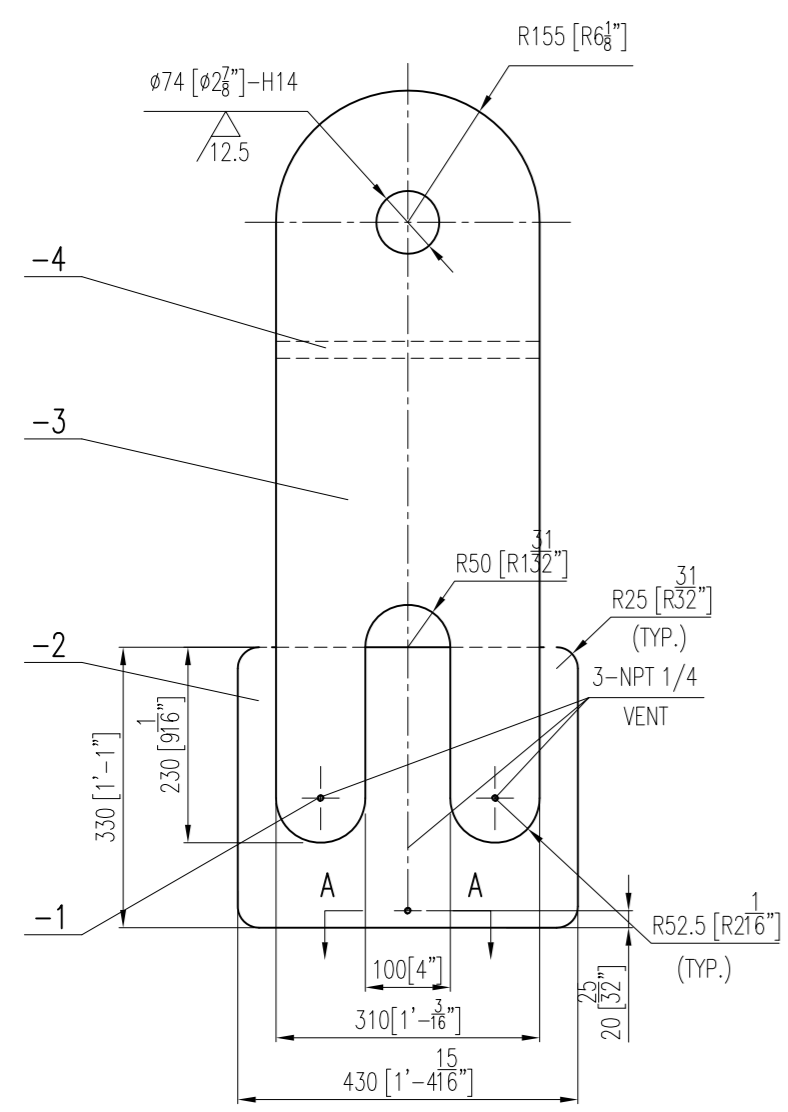


V1	ASME B36.19M	法兰 FB30x4 RIB PLATE	4	SA-240 316L	0.3	1.2		
V2	ASME B36.19M	接管 1-1/2"-Sch40S, L=581 PIPE	2	SA-312 TP316L	2.35	4.7		
	ASME B16.5-2009	法兰 WN 1-1/2"-150# RF Sch40S FLANGE	2	SA-182 F316L	1.81	3.62		
T1	ASME B36.19M	接管 1-1/2"-Sch40S, L=156 PIPE	2	SA-312 TP316L	0.47	0.94		
T2	ASME B16.5-2009	法兰 WN 1-1/2"-150# RF Sch40S FLANGE	2	SA-182 F316L	1.81	3.62		
	ASME B16.20	法兰 BL 2"-150# RF BLIND FLANGE	1	SA-182 F316L	1.82			
	ASME B18.2.2	螺栓 RF 2"-150# t=4.5 NUTS	8+4	SA-194 2H 热浸镀锌 HOT DIP GALVANIZED				
	ASME B18.2.1	全螺纹螺栓 5/8"-11UNCx90L TOTAL SCREW STUDS	4+2	SA-193 B7 热浸镀锌 HOT DIP GALVANIZED				
S1	ASME B36.19M	接管 2"-Sch40S L=582 PIPE	1	SA-312 TP316L	3.3			
	ASME B16.5-2009	法兰 WN 2"-150# RF Sch40S FLANGE	1	SA-182 F316L	2.72			
R1	ASME B36.19M	接管 4"-Sch40S L=584 PIPE	1	SA-312 TP316L	10			
	ASME B16.5-2009	法兰 WN 4"-150# RF Sch40S FLANGE	1	SA-182 F316L	7.49			
M1	BSA15-303-02	人孔 MANHOLE	1	组件 COMPONENT	410			
L3	ASME B16.5-2009	法兰 BL 3"-150# RF BLIND FLANGE	1	SA-182 F316L	4.1			FOR S2
	ASME B16.20	螺栓 RF 3"-150# t=4.5 CASSET	1+2	见技术要求 SEE TECHNICAL REQUIREMENTS				FOR S2
	ASME B18.2.2	螺母 5/8"-11UNC NUTS	8+4	SA-194 2H 热浸镀锌 HOT DIP GALVANIZED				FOR S2
S2	ASME B18.2.1	全螺纹螺栓 5/8"-11UNCx95L TOTAL SCREW STUDS	4+2	SA-193 B7 热浸镀锌 HOT DIP GALVANIZED				FOR S2
	ASME B36.19M	接管 3"-Sch40S, L=584 PIPE	2	SA-312 TP316L	6.85	13.7		
	ASME B16.5-2009	法兰 WN 3"-150# RF Sch40S FLANGE	2	SA-182 F316L	5.22	10.44		
B1	BSA15-303-06	防浪油分离器 VORTEX BREAKER	1	组件 COMPONENT	3.0			
	ASME B36.19M	接管 4"-Sch40S, L=89 PIPE	1	SA-312 TP316L	1.5			
	ASME B16.9	90°弯头 90°E(S) 4"-Sch40S ELBOW	1	SA-403 WP316L	2.74			
	ASME B36.19M	接管 4"-Sch40S, L=1321 PIPE	1	SA-312 TP316L	22.6			
	ASME B16.5-2009	法兰 WN 4"-150# RF Sch40S FLANGE	1	SA-182 F316L	7.49			

A7	ASME B16.9	连接 NPT2" CONNECTION	1	SA-182 F316L	1.0			
		45°弯头 45°E(L) 3"-Sch40S ELBOW	1	SA-403 WP316L	1.06			
		补强圈 180°/Ø97x8 REINFORCEMENT	1	SA-240 316L	1.3			
	ASME B36.19M	接管 3"-Sch40S, L=242 PIPE	1	SA-312 TP316L	2.84			
	ASME B16.5-2009	法兰 WN 3"-150# RF Sch40S FLANGE	1	SA-182 F316L	5.22			
A5		盖板 FB30x4 RIB PLATE	8	SA-240 316L	0.3	2.4		
A8	ASME B36.19M	接管 1"-Sch40S L=130 PIPE	1	SA-312 TP316L	0.32	1.6		FOR A8
N1	ASME B36.19M	接管 1"-Sch40S L=409 PIPE	1	SA-312 TP316L	1.0	5.0		FOR P1
P1	ASME B36.19M	接管 1"-Sch40S L=584 PIPE	2	SA-312 TP316L	1.43	2.86		FOR A5, N1
	ASME B16.5-2009	法兰 WN 1"-150# RF Sch40S FLANGE	4	SA-182 F316L	1.14	4.56		
	ASME B16.5-2009	法兰 BL 4"-150# RF BLIND FLANGE	1	SA-182 F316L	7.72			t=32 中径公差0.01
	ASME B16.20	螺栓 RF 4"-150# t=4.5 CASSET	1+2	见技术要求 SEE TECHNICAL REQUIREMENTS				FOR L2
	ASME B18.2.2	螺母 5/8"-11UNC NUTS	16+4	SA-194 2H 热浸镀锌 HOT DIP GALVANIZED				FOR L2
	ASME B18.2.1	全螺纹螺栓 5/8"-11UNCx105L TOTAL SCREW STUDS	8+2	SA-193 B7 热浸镀锌 HOT DIP GALVANIZED				FOR L2
L1		盖板 FB30x4 RIB PLATE	2	SA-240 316L	0.3	0.6		FOR L2
L2	ASME B36.19M	接管 4"-Sch40S L=584 PIPE	1	SA-312 TP316L	10			FOR L2
	ASME B16.5-2009	法兰 WN 4"-150# RF Sch40S FLANGE	1	SA-182 F316L	7.49			FOR L2
		盖板 FB60x6 RIB PLATE	4	SA-240 316L	1.05	4.2		FOR L1
		接管 4"-Sch80S, L=100 PIPE	2	SA-312 TP316L	2.3	4.6		FOR L1
		锥台 CONE	2	SA-240 316L	1.3	2.6		FOR L1
	ASME B36.19M	接管 3"-Sch40S, L=6328 PIPE	1	SA-312 TP316L	74.2			FOR L1
	ASME B16.5-2009	法兰 WN 3"-150# RF Sch40S FLANGE	1	SA-182 F316L	5.22			FOR L1
	ASME B16.5-2009	法兰 BL 2"-150# RF BLIND FLANGE	1	SA-182 F316L	1.82			t=26 中径公差0.5
	ASME B16.20	螺栓 RF 2"-150# t=4.5 CASSET	1+2	见技术要求 SEE TECHNICAL REQUIREMENTS				FOR A10
	ASME B18.2.2	螺母 5/8"-11UNC NUTS	8+4	SA-194 2H 热浸镀锌 HOT DIP GALVANIZED				FOR A10
	ASME B18.2.1	全螺纹螺栓 5/8"-11UNCx100L TOTAL SCREW STUDS	4+2	SA-193 B7 热浸镀锌 HOT DIP GALVANIZED				FOR A10
		盖板 FB30x4 RIB PLATE	2	SA-240 316L	0.3	0.6		FOR A10
	ASME B36.19M	接管 2"-Sch40S L=582 PIPE	1	SA-312 TP316L	3.3			FOR A10
A9		法兰 WN 2"-150# RF Sch40S FLANGE	1	SA-182 F316L	2.72			FOR A10
A10		接管 φ150, t=12 PIPE	1	SA-240 316L	1.7			FOR A9
		盖板 FB60x6 RIB PLATE	4	SA-240 316L	1.1	4.4		FOR A9
		接管 2"-Sch40S, L=100 PIPE	2	SA-312 TP316L	0.57	1.14		FOR A9
		锥台 CONE	2	SA-240 316L	0.8	1.6		FOR A9
	ASME B36.19M	接管 1-1/2"-Sch40S, L=6323 PIPE	1	SA-312 TP316L	25.6			FOR A9
	ASME B16.5-2009	法兰 WN 1-1/2"-150# RF Sch40S FLANGE	1	SA-182 F316L	1.81			FOR A9
	ASME B16.5-2009	法兰 BL 1-1/2"-150# RF BLIND FLANGE	2	SA-182 F316L	1.36	2.72		t=22 中径公差0.5, 5
	ASME B16.20	螺栓 RF 1-1/2"-150# t=4.5 CASSET	2+4	见技术要求 SEE TECHNICAL REQUIREMENTS				FOR A2, A4
	ASME B18.2.2	螺母 1/2"-13UNC NUTS	16+8	SA-194 2H 热浸镀锌 HOT DIP GALVANIZED				FOR A2, A4
	ASME B18.2.1	全螺纹螺栓 1/2"-13UNCx85L TOTAL SCREW STUDS	8+4	SA-193 B7 热浸镀锌 HOT DIP GALVANIZED				FOR A2, A4
A1		盖板 FB30x4 RIB PLATE	4	SA-240 316L	0.3	1.2		FOR A2, A4
A2	ASME B36.19M	接管 1-1/2"-Sch40S L=581 PIPE	2	SA-312 TP316L	2.35	4.7		FOR A2, A4
A3	ASME B16.5-2009	法兰 WN 1-1/2"-150# RF Sch40S FLANGE	2	SA-182 F316L	1.81	3.62		FOR A2, A4
A4		接管 φ150x12t PIPE	2	SA-240 316L	1.7	3.4		FOR A1, A3
		盖板 FB50x6 RIB PLATE	8	SA-240 316L	0.3	2.4		FOR A1, A3
	ASME B36.19M	接管 1-1/2"-Sch40S, L=100 PIPE	4	SA-312 TP316L	0.4	1.6		FOR A1, A3
		锥台 CONE	4	SA-240 316L	0.2	0.8		FOR A1, A3
	ASME B36.19M	接管 1"-Sch40S L=6329 PIPE	2	SA-312 TP316L	15.4	30.8		FOR A1, A3
	ASME B16.5-2009	法兰 WN 1"-150# RF Sch40S FLANGE	2	SA-182 F316L	1.14	2.28		FOR A1, A3

管口及附件 NOZZLE AND ACCESSORY				
05	2015-11-03	ISSUED FOR FABRICATION	W.X.D	Y.W.T F.Z
04	2015-10-08	FOR APPROVAL	W.X.D	Y.W.T F.Z
03	2015-09-25	FOR APPROVAL	W.X.D	Y.W.T F.Z
02	2015-09-07	FOR APPROVAL	W.X.D	Y.W.T F.Z
01	2015-08-26	FOR APPROVAL	W.X.D	Y.W.T F.Z
REV	DATE	DESCRIPTION	DRAWN	CHK. APPR.
OWNER / DEVELOPER:				
昆山市色特材装备有限公司 Kunshan Bxceller Special Equipment Co., Ltd		项目名称: Mobile ACA Project PROJECT NAME: Mobile ACA Project		
设计 DESIGN 校核 CHECK 审核 APPROVAL 标准号 STANDARD		图号: 05 规格: BSA15-303-00(3/3) 比例: 1:1 张数: 共 3 张, 第 3 张 批准: [Signature]		
图号 ITEM NO. V-4510		生产号 SERIAL NO. 15-A3176		

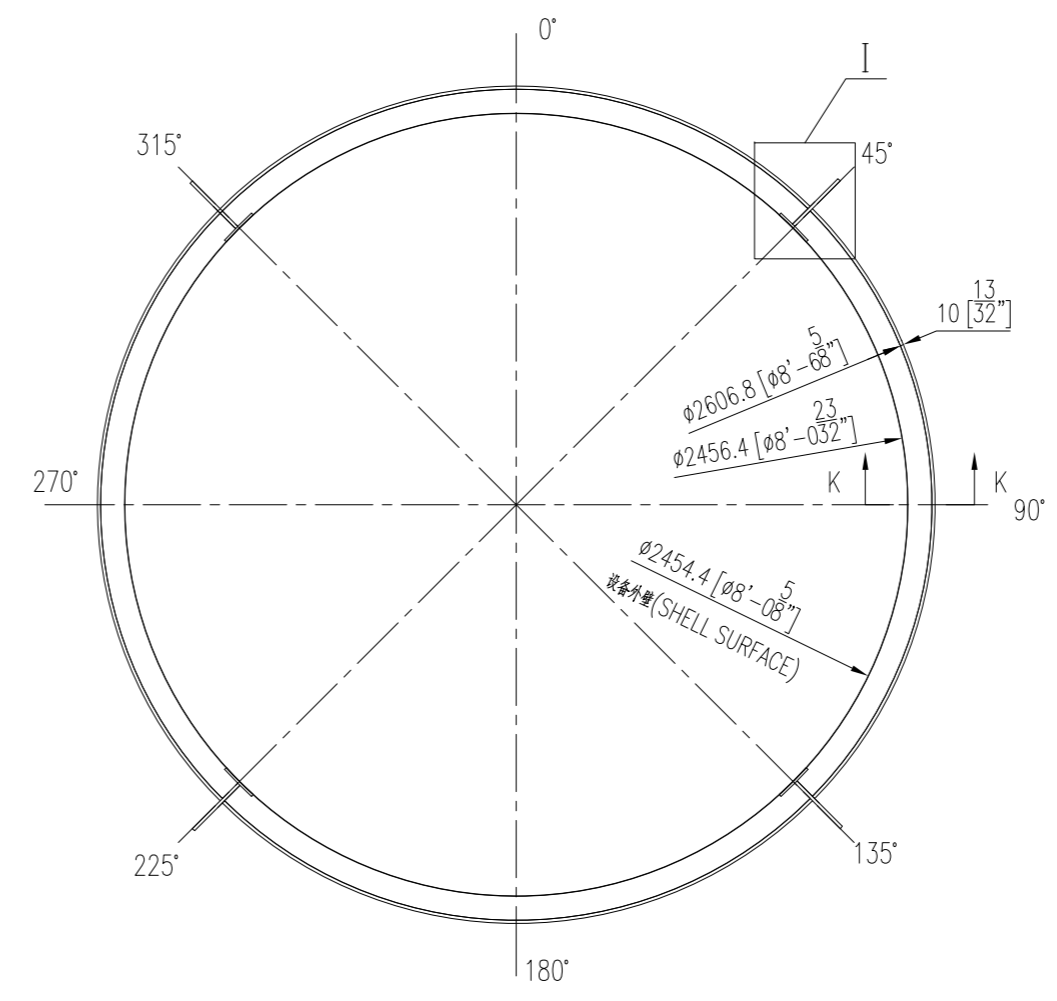
ANSI D



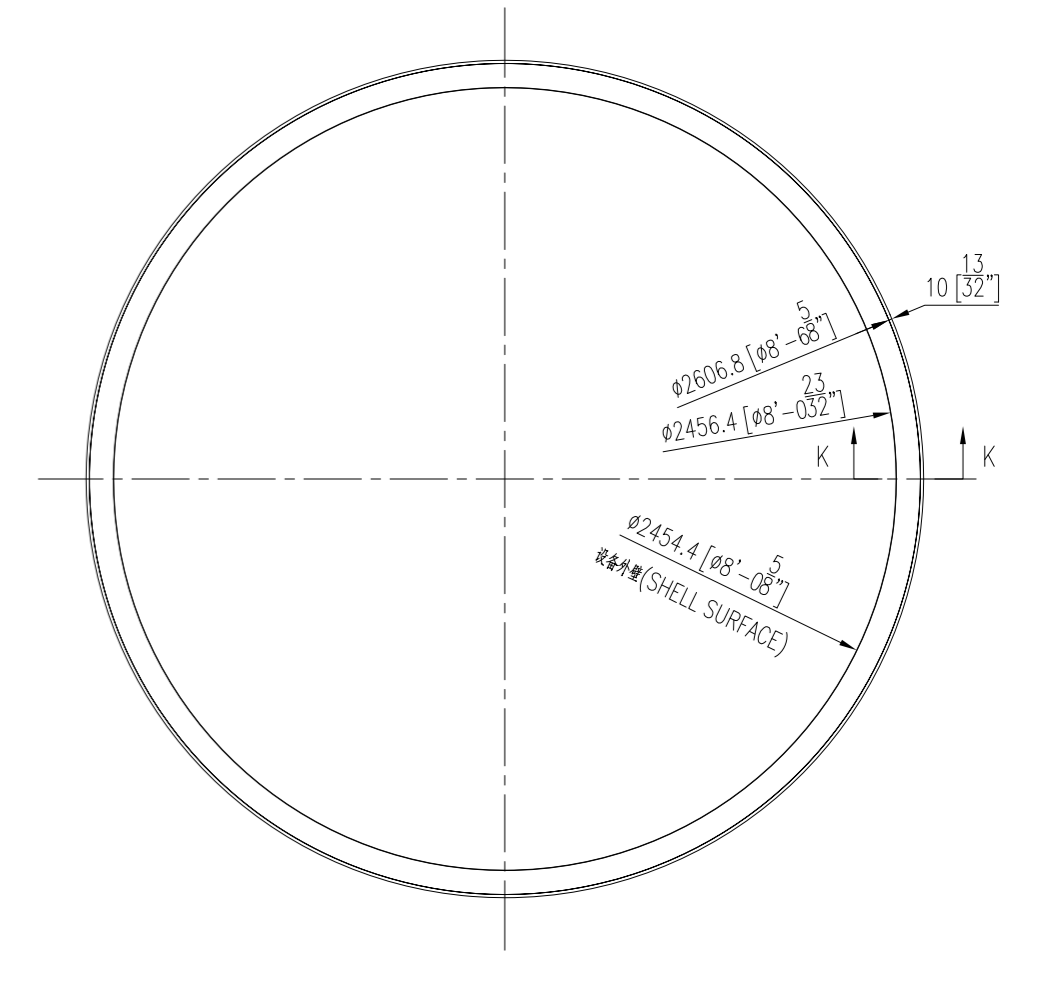
技术要求:
TECHNICAL REQUIREMENT:
1. 焊接采用电焊, 焊接程序按 WPS 的规定。
WHEN WELDING, WELDING PROCEDURE SPECIFICATION TO BE PER WPS.
2. 焊接接头型式及尺寸按图中注明, 按 ASME VIII-1 中规定。角焊缝的焊角尺寸按较薄板的厚度。
TYPES AND DIMENSION FOR WELDING JOINT SHALL MEET THE REQUIREMENTS OF ASME VIII-1. THE SIZE OF FILLETS PER THICKNESS OF THINNER PLATE WELDED.
3. 每耳与鞍板、鞍板与筒体的焊接接头要做 100% PT 检测, 符合 ASME VIII-1 附录 6 中规定。
WELDING JOINT OF LIFTING LUG, PAD AND SHELL SHOULD BE 100% PT. AND MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX 6).
4. 其余按规范和图中规定。
OTHER REQUIREMENTS SHALL BE INDICATED IN ASSEMBLY DRAWING.

序号 NO.	图号及标准号 DRAWING NO. OR STANDARD NO.	名称 TITLE	材料 MATERIAL	数量 QUANT.	重量 (Kg) WEIGHT	所在图号 DWG. NO.	备注 REMARKS
-4		筋板 t=25 RIB PLATE	SA-240 316L	1	4.0		
-3		吊耳板 t=25 LIFTING LUG	SA-283 C	1	51		
-2		鞍板 430x330x121 PAD	SA-240 316L	1	13		
-1	ASME B16.11	六角头螺栓 NPT 1/4-3000# HEX HEAD PLUG	SS304	3	/		
5		吊耳 LIFTING LUG	组合件 COMPONENT	1:6 2	68	BSA15-303-01	BSA15-303-00(1/3)

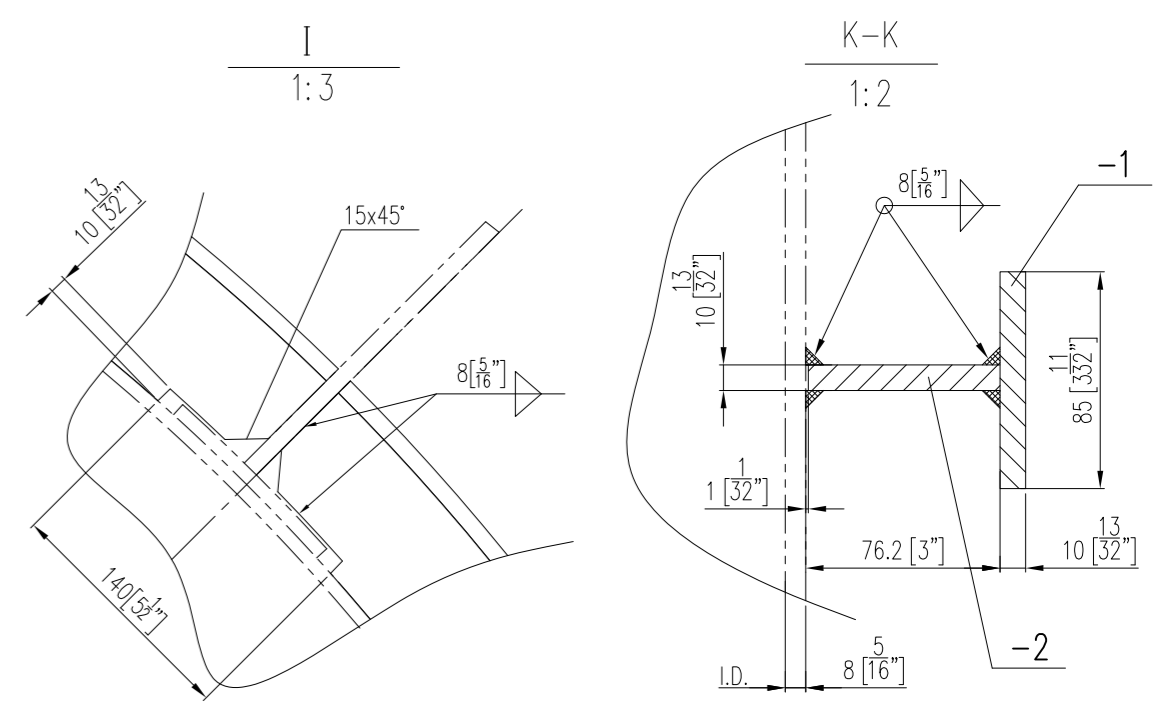
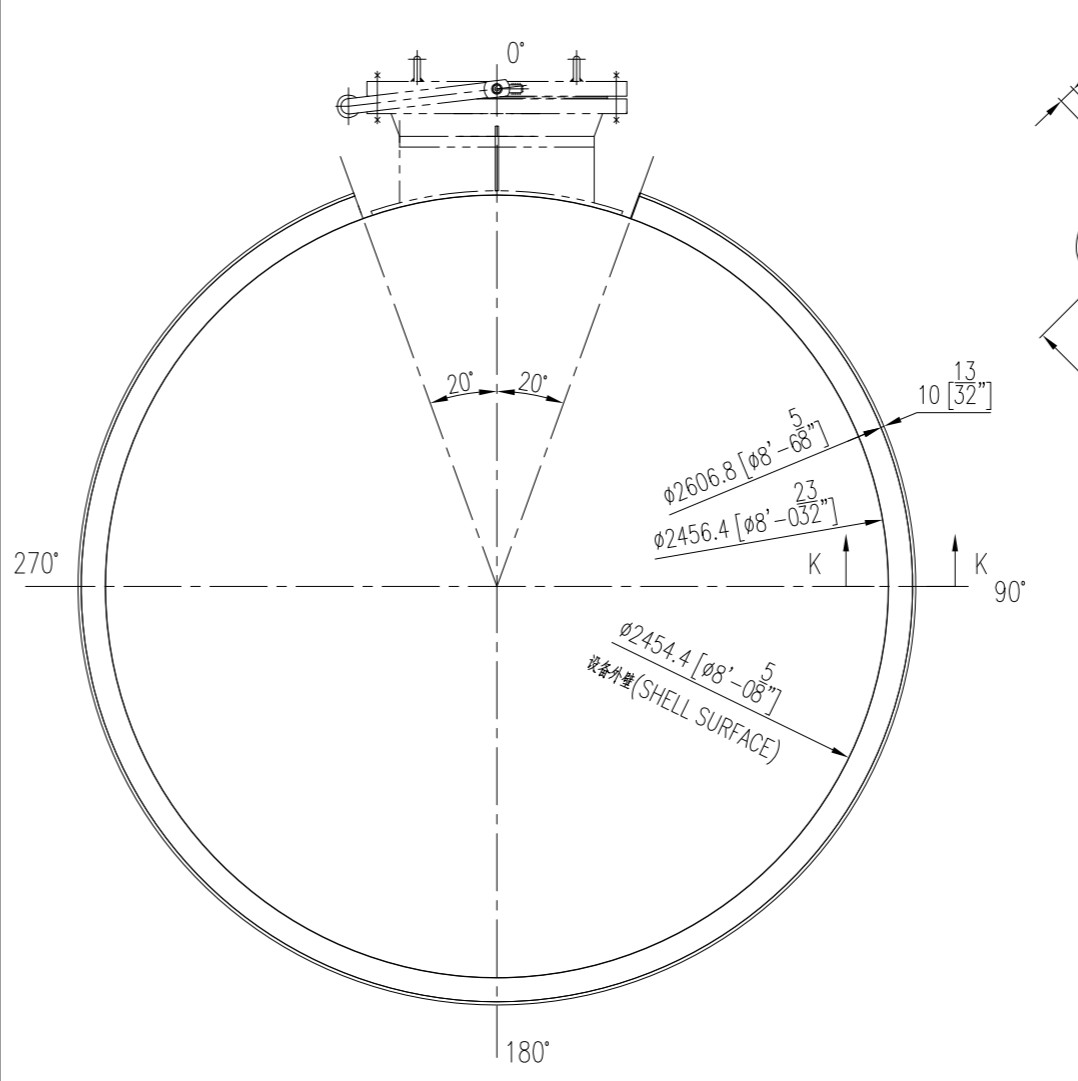
最顶部外压加强圈详图
THE DETAIL FOR TOP STIFFENING RING



中间两圈加强圈详图
THE DETAIL FOR MIDDLE TWO STIFFENING RING



最下方外压加强圈详图
THE DETAIL FOR BOTTOM STIFFENING RING



序号 NO.	图号及标准号 DRAWING NO. OR STANDARD NO.	名称 TITLE	数量 QUANT.	材料 MATERIAL	重量 (Kg) WEIGHT	所在图号 DWG. NO.	装配图号 ASSM. DWG. NO.
-2		板 2606.8/2456.4x10 PLATE	1	SA-240 316L	47.5		
-1		板 t=10 PLATE	1	SA-240 316L	55.5		
7		外压加强圈 STIFFENING RING	4	SA-240 316L	103	BSA15-303-01	BSA15-303-00(1/3)

REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
05	2015-11-03	ISSUED FOR FABRICATION			
04	2015-10-08	FOR APPROVAL			
03	2015-09-25	FOR APPROVAL			
02	2015-09-07	FOR APPROVAL			
01	2015-08-26	FOR APPROVAL			

OWNER / DEVELOPER:

Evonik Corporation
Mobile, AL, USA

Details for
ACA Residue Storage Vessel

昆山市贝色特材装备有限公司
Kunshan Bexcelle Special Equipment Co., Ltd

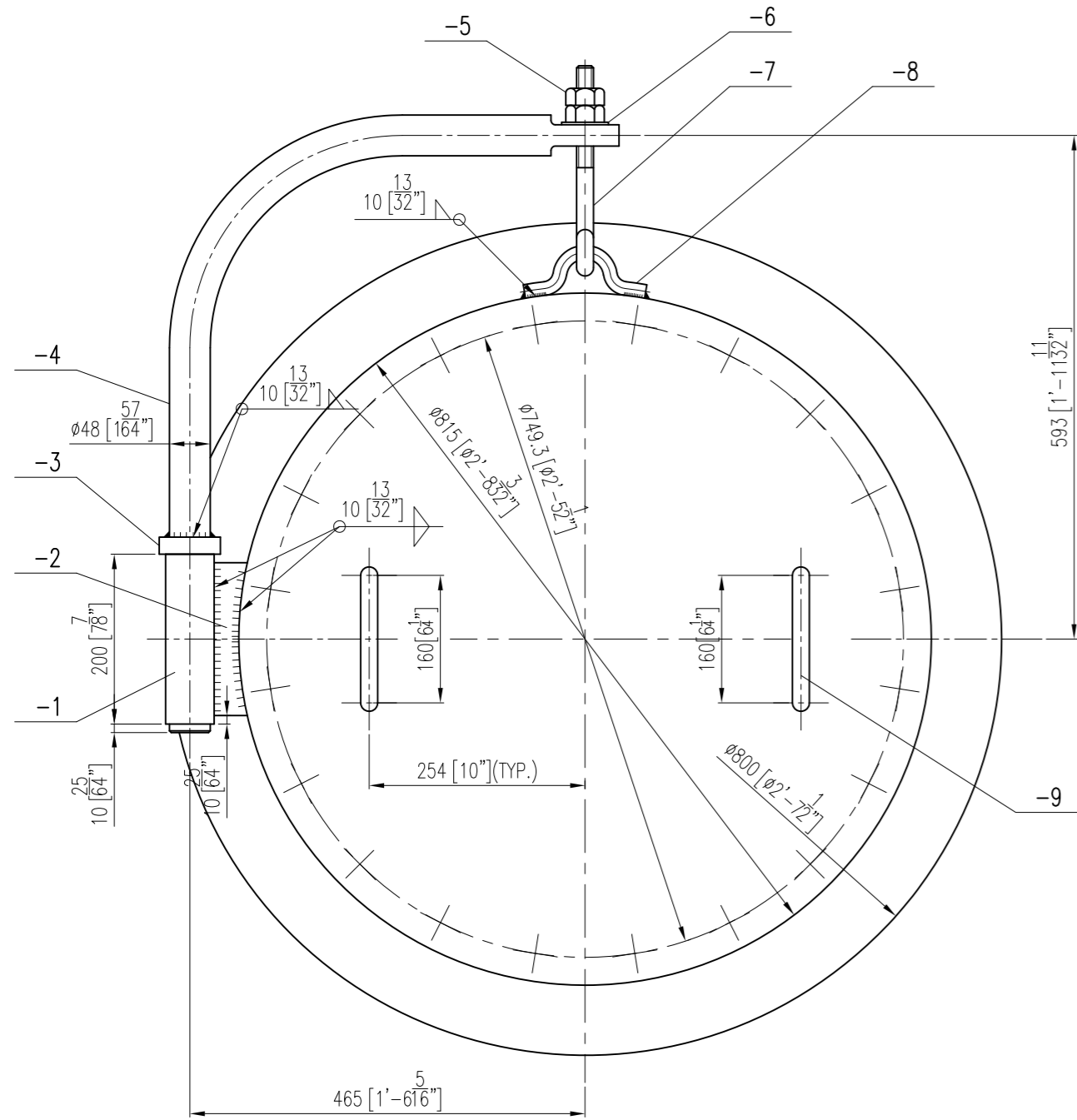
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图号: BSA15-303-01

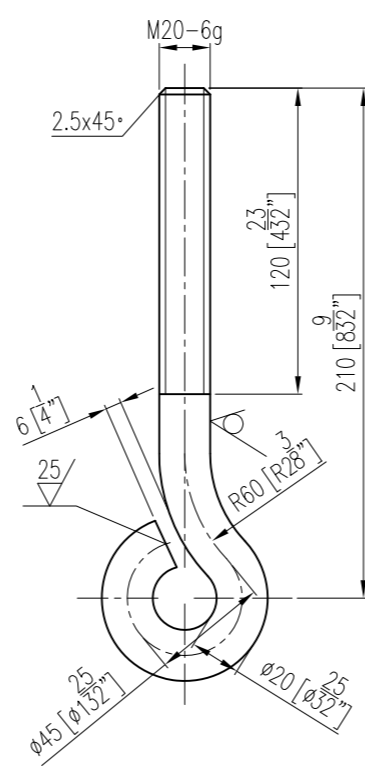
比例: 1:3

图号: V-4510

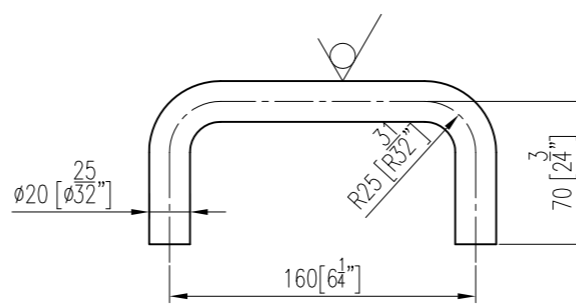
生产号: 15-A3176



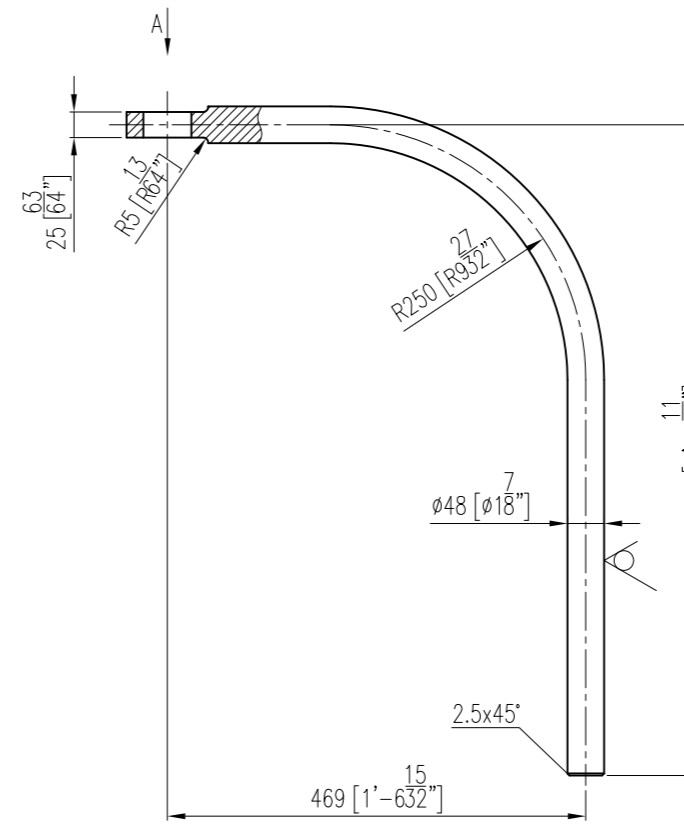
件-7 吊钩详图
DETAIL OF NO.-7
不按比例 NO SCALE



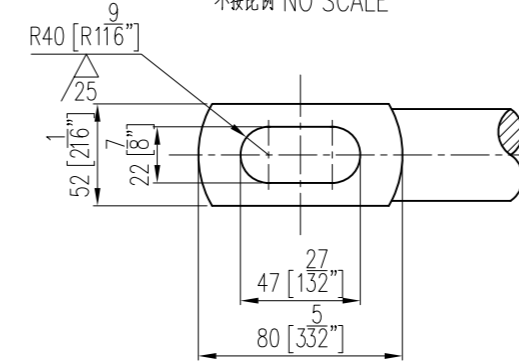
件-9 把手详图
DETAIL OF NO.-9
不按比例 NO SCALE



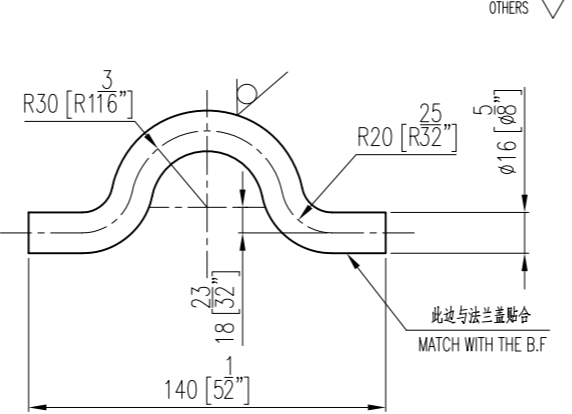
件-4 转臂接管详图
DETAIL OF NO.-4
不按比例 NO SCALE



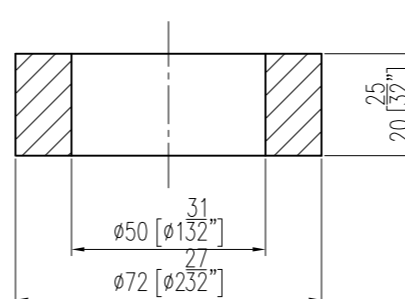
件-2 支撑板详图
DETAIL OF NO.-2
不按比例 NO SCALE



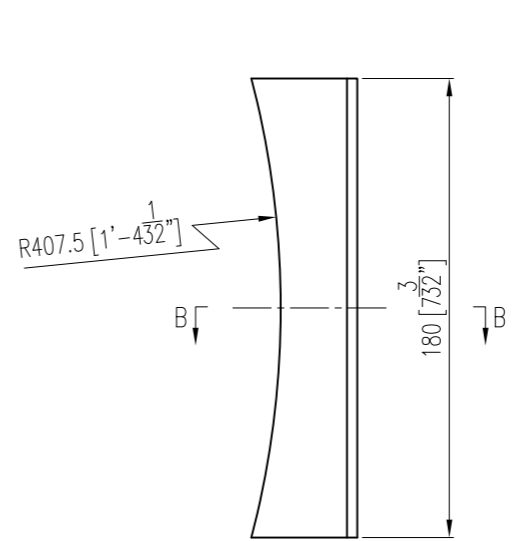
件-8 吊环详图
DETAIL OF NO.-8
不按比例 NO SCALE



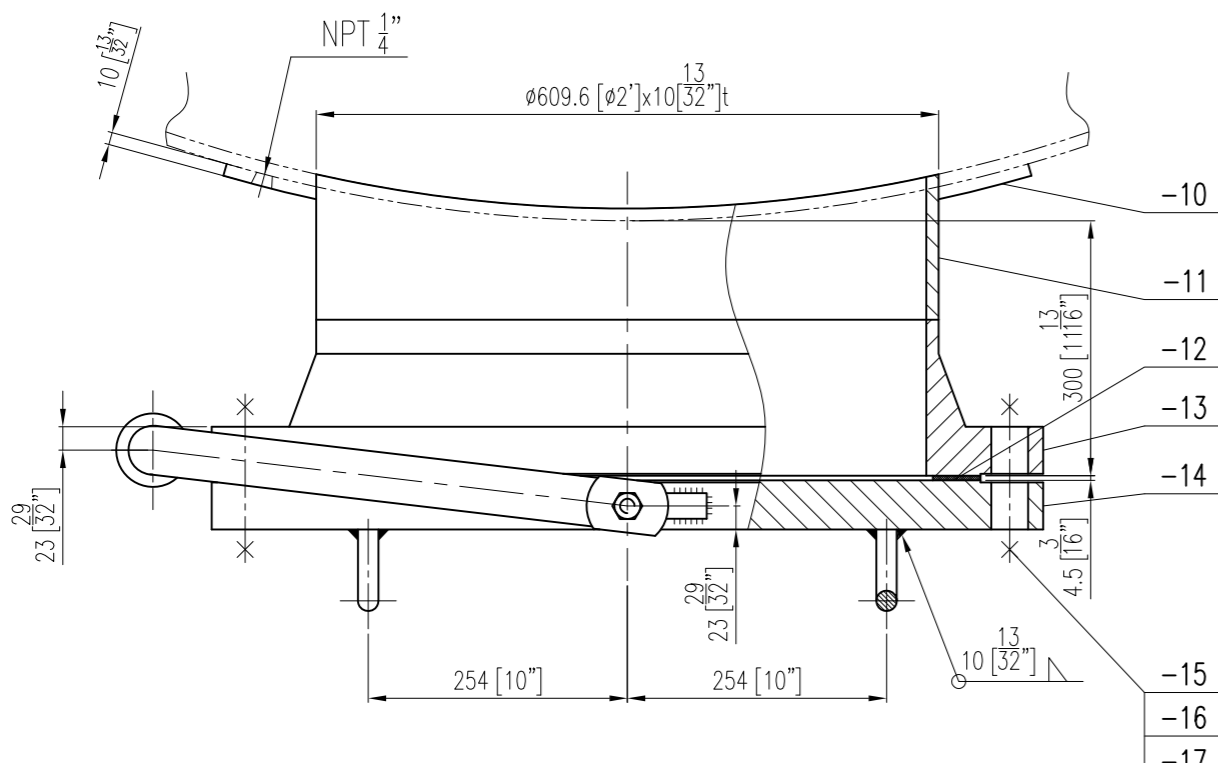
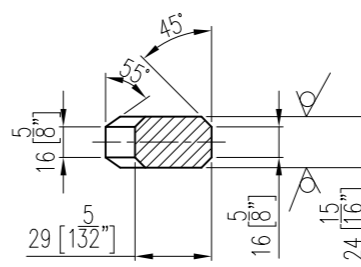
件-3 吊环详图
DETAIL OF NO.-3
不按比例 NO SCALE



件-1 吊钩详图
DETAIL OF NO.-1
不按比例 NO SCALE



件-5 吊钩详图
DETAIL OF NO.-5
不按比例 NO SCALE



技术要求：
TECHNICAL REQUIREMENT:
1. 焊接采用电焊，焊接规范按 WPS 的规定。
WHEN WELDING, WELDING PROCEDURE SPECIFICATION TO BE PER WPS.
2. 焊接接头形式及尺寸按图中注明，按 ASME VIII-1 中规定。角焊缝的焊角尺寸按被焊板的厚度。
TYPES AND DIMENSION FOR WELDING JOINT SHALL MEET THE REQUIREMENTS OF ASME VIII-1. THE SIZE OF FILLETS PER THICKNESS OF THINNER PLATE WELDED.
3. 其余按图集中规定。
OTHER REQUIREMENTS SHALL BE INDICATED IN ASSEMBLY DRAWING.

件号 NO.	图号及标准号 DRAWING NO. OR STANDARD NO.	名称 TITLE	数量 QUANT.	材料 MATERIAL	重量 (Kg) WEIGHT	所在图号 DWG. NO.	装配图号 ASSM. DWG. NO.	备注 REMARKS
-17		垫圈 WASHER	40+4	SS304	0.03	1.2		
-16	ASME B18.2.2	螺母 NUTS	1-1/4"-8UNC-2B	40+4	SA-194 2H	热浸镀锌 HOT DIP GALVANIZED	0.1	4
-15	ASME B18.2.1	全螺纹螺柱 1-1/4"-8UNC-2AL=200 TOTAL SCREW STUD	20+2	SA-193 B7	热浸镀锌 HOT DIP GALVANIZED	1.5	30	
-14	ASME B16.5-2009	法兰盖 BL 24"-150# RF	1	SA-182 F316L	188.4			
-13	ASME B16.5-2009	法兰 WN 24"-150# RF S=10	1	SA-182 F316L	121.7			
-12	REFER TO ASME B16.20	密封垫 RF 24"-150# t=4.5 GASKET	1+2	见技术要求 SEE TECHNICAL REQUIREMENTS	/			
-11		筒节 609.6x10 L=194 SHELL	1	SA-240 316L	29			
-10		衬垫圈 800/620 t=10 REINFORCING PAD	1	SA-240 316L	15.8			
-9	BSA15-303-02	把手 20 ROUND BAR	2	SA-479 304	0.7	1.4		
-8	BSA15-303-02	吊环 16 ROUND BAR	1	SA-479 304	0.3			
-7	BSA15-303-02	吊环 20 ROUND BAR	1	SA-479 304	0.8			
-6		垫圈 37/22 t=3 WASHER	1	SS304	/			
-5	ASME B18.2.2	螺母 M20 NUT	2	SS304	/			
-4	BSA15-303-02	衬垫圈 48 ROUND BAR	1	SA-479 304	15.3			
-3	BSA15-303-02	吊环 304 PLATE	1	SA-240 304	0.4			
-2	BSA15-303-02	支撑板 t=24 PLATE	1	SA-240 304	1.1			
-1		无缝钢管 57x3.5 L=200 PIPE	1	SA-312 TP 304	0.92			

件号 NO.	名称 PART NAME	材料 MATERIAL	比例 SCALE	数量 QUANT.	重量 (Kg) WEIGHT	所在图号 DWG. NO.	装配图号 ASSM. DWG. NO.	备注 REMARKS
M1	吊环 24 HANDLE	合金钢 ALLOY STEEL	1:5	1	410	BSA15-303-02	BSA15-303-00(1/3)	

REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
05	2015-11-03	ISSUED FOR FABRICATION			W.X.D
04	2015-10-08	FOR APPROVAL			Y.W.T
03	2015-09-25	FOR APPROVAL			Y.W.T
02	2015-09-07	FOR APPROVAL			Y.W.T
01	2015-08-26	FOR APPROVAL			Y.W.T

OWNER / DEVELOPER:

昆山市贝色特材装备有限公司
Kunshan Bexcelle Special Equipment Co., Ltd

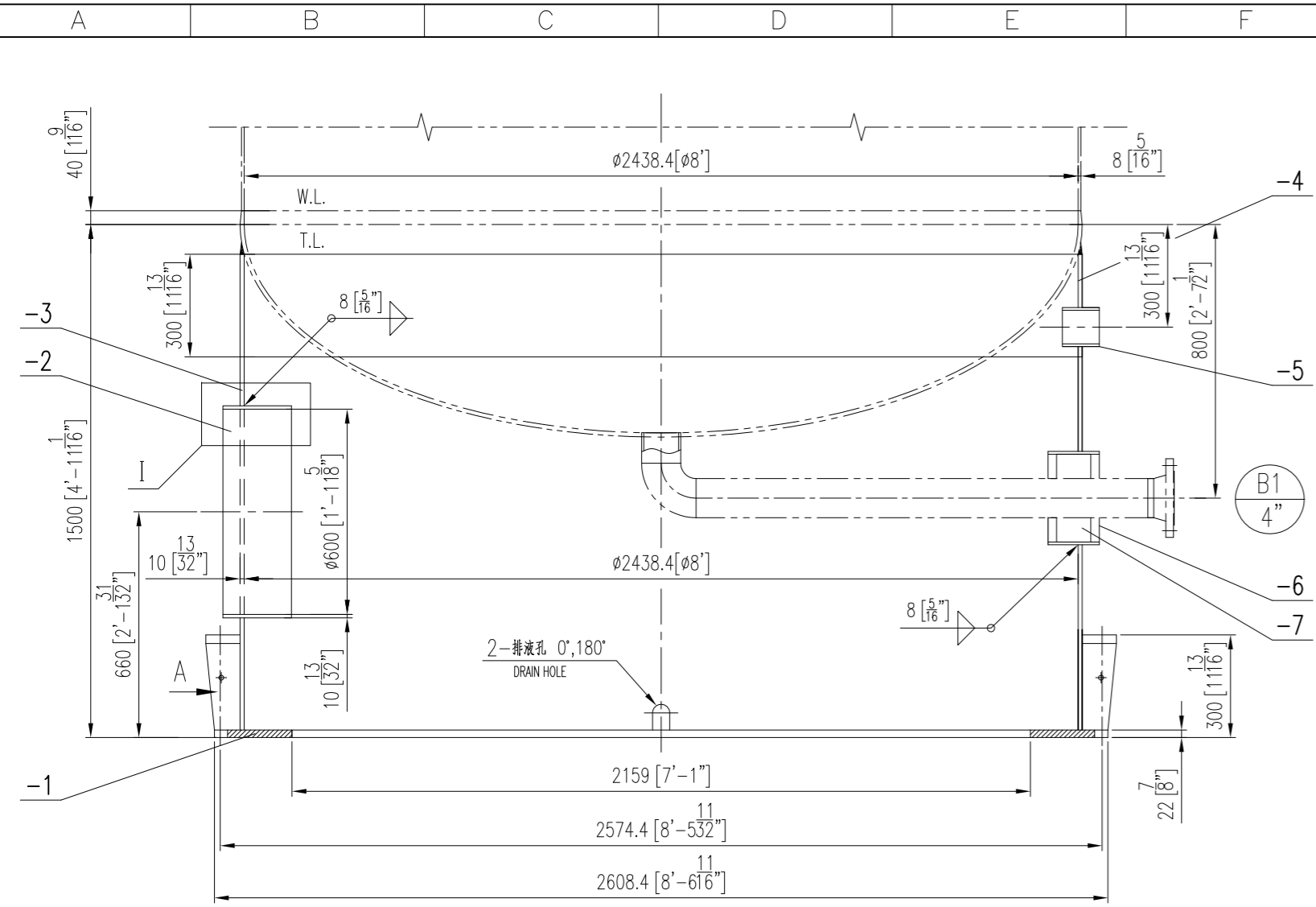
项目名称: Mobile ACA Project

Evonik Corporation
Mobile, AL, USA

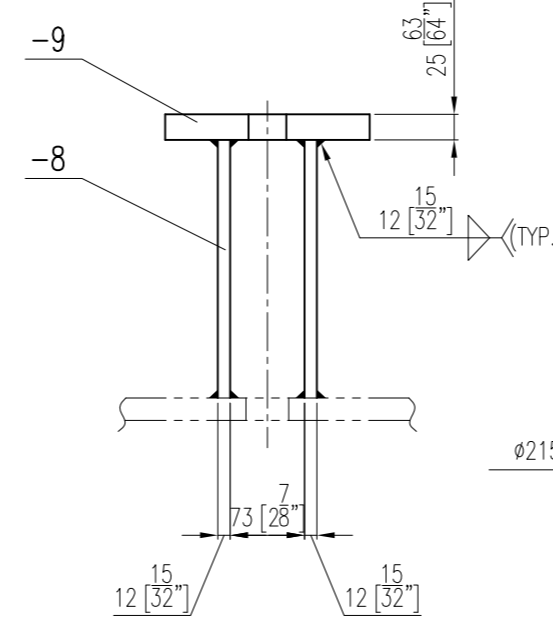
Details for
ACA Residue Storage Vessel

图号: 05
图号: BSA15-303-02
比例: 1:5
图号: 15-A3176

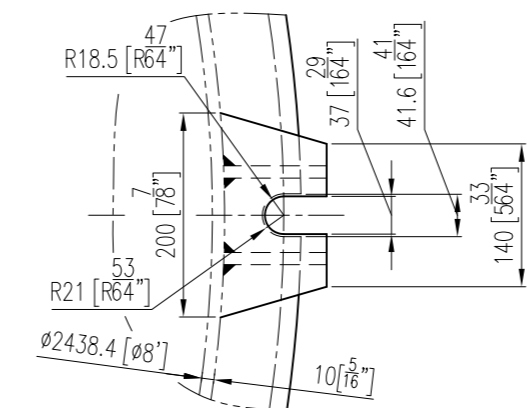
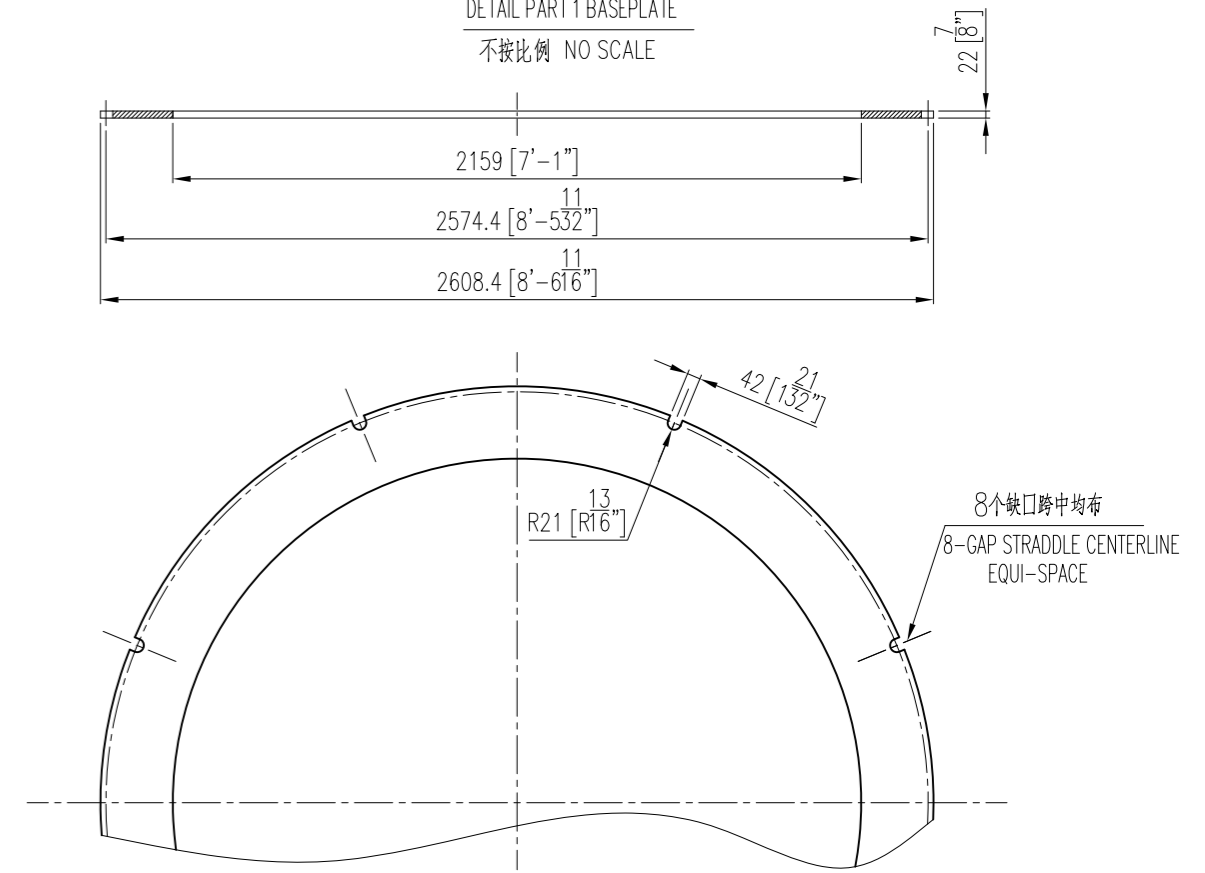
图号 DWG. NO.	比例 SCALE	图号 DWG. NO.	比例 SCALE
05	1:5	15-A3176	1:5



地脚螺栓座详图
DETAIL OF ANCHOR BOLT SEAT
不按比例 NO SCALE

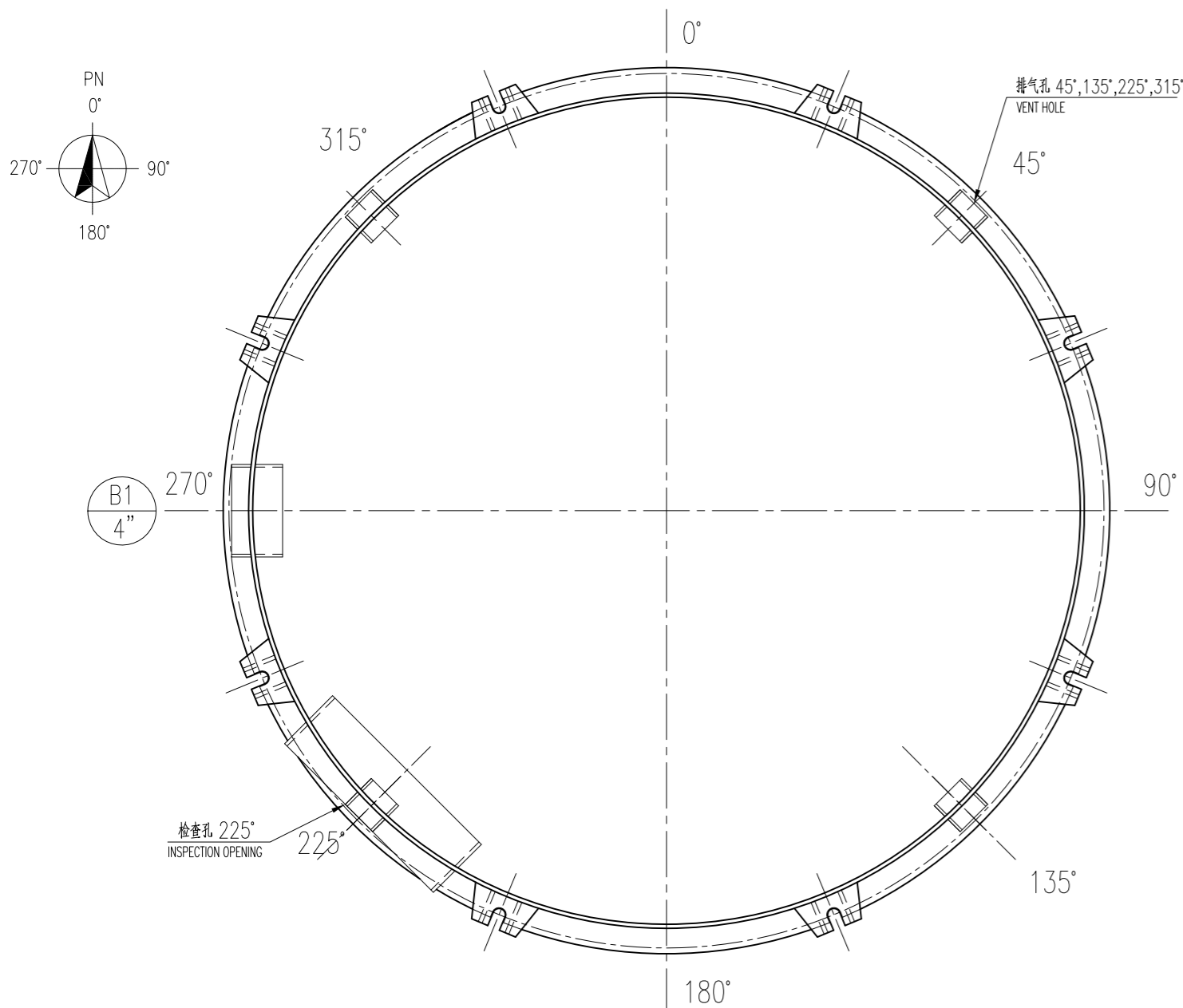
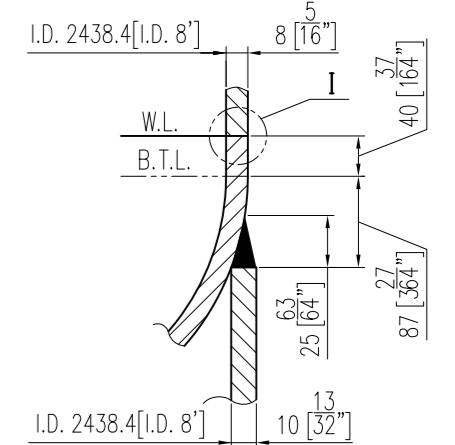
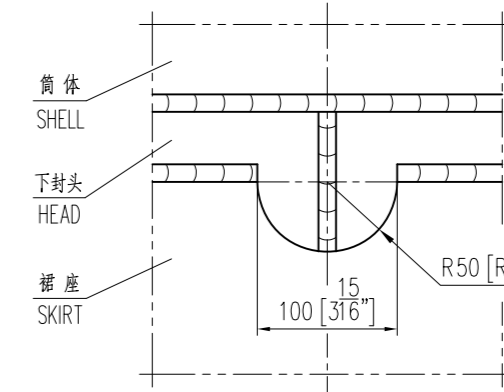


件1 底座详图
DETAIL PART 1 BASEPLATE
不按比例 NO SCALE

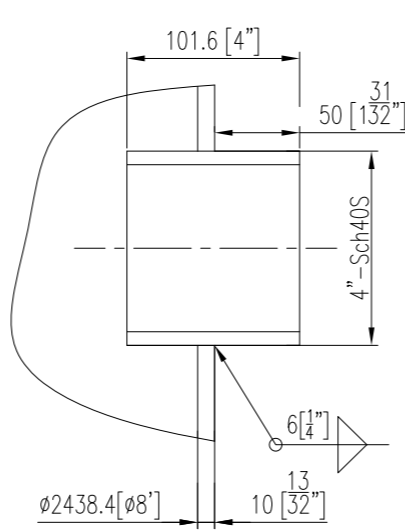


裙座位于封头搭接处焊缝的缺口尺寸
NOTCH SIZE AT CROSS POINT OF
SKIRT AND HEAD WELDING
不按比例 NO SCALE

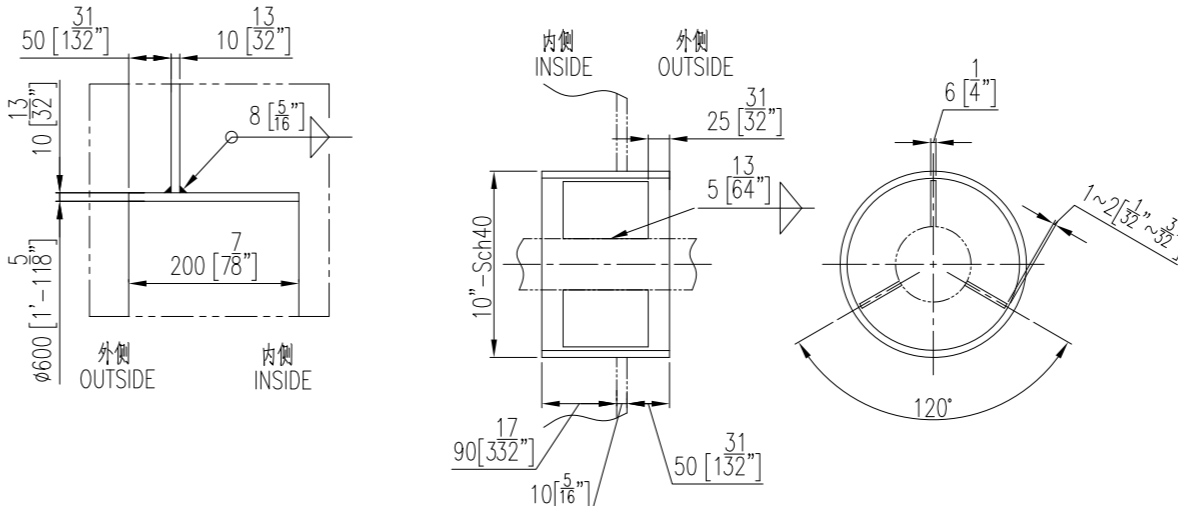
封头与裙座连接结构
HEAD AND SKIRT JOINT DETAIL
不按比例 NO SCALE



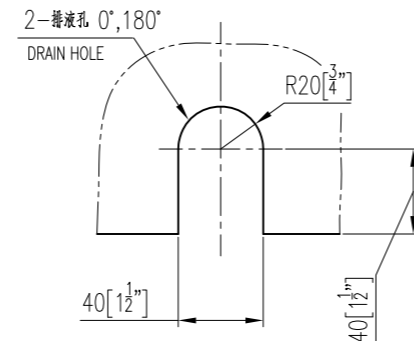
接管详图
DETAIL OF VENT HOLE
不按比例 NO SCALE



管口 B1 支撑管详图
DETAIL OF SUPPORT PIPE FOR NOZ. B1
不按比例 NO SCALE



排液孔详图
DETAIL OF DRAIN HOLE
不按比例 NO SCALE



- 技术要求:
- TECHNICAL REQUIREMENT:
- 焊接采用电焊, 焊接规格按 WPS 的规定。
WELDING OPERATION SHALL BE PER APPROVED WPS.
 - 焊接接头型式及尺寸除图中注明外, 按 ASME VIII-1 中规定, 角焊缝的焊角尺寸按被焊件的厚度。
TYPES AND DIMENSION FOR WELDING JOINT SHALL MEET THE REQUIREMENTS OF ASME VIII-1. THE SIZE OF FILLETS PER THICKNESS OF THINNER PLATE WELDED.
 - 裙座螺栓孔中心圆直径以及相邻两裙座螺栓孔之间弦长公差为 ±2mm。
THE ALLOWANCE OF SKIRT B.C.D AND THE CHORD LENGTH BETWEEN TWO ADJACENT BOLT AND TWO ARBITRARY BOLTS HOLES IS ±2mm.
 - 裙座与下封头的焊接接头需做 100% PT 检测, 符合 ASME VIII-1 附录 6 中规定。
THE WELDS BETWEEN SKIRT AND BOTTOM HEAD SHALL BE 100% PT, MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX 6).
 - 其余按装配图中规定。
OTHER REQUIREMENTS SHALL BE INDICATED IN ASSEMBLY DRAWING.

件号	图号及标准号	名称	材料	数量	重量	所在图号	备注
NO.	DRAWING NO. OR STANDARD NO.	TITLE	MATERIAL	QUANT.	WEIGHT (Kg)	DWG. NO.	REMARKS
-9		盖板 t=25	SA-283 C	8	24		
-8		裙板 t=12	SA-283 C	16	33.6		
-7		裙板 t=6	SA-240 316L	3	0.2		
-6		支撑管 10"-Sch40 L=150	SA-106 B	2	8.0		
-5		接管 8"-Sch40	SA-312 TP316L	4	1.7		
-4		裙座壳体 I.D.2438.4x10	SA-240 316L	1	184		H=300mm
-3		裙座壳体 I.D.2438.4x10	SA-283 C	1	659		H=1091mm
-2		检查孔 I.D.600x10, L=200	SA-283 C	1	30		
-1		底座 t=22	SA-283 C	1	285		

序号	图号及标准号	名称	材料	数量	重量	所在图号	备注
NO.	DRAWING NO. OR STANDARD NO.	TITLE	MATERIAL	QUANT.	WEIGHT (Kg)	DWG. NO.	REMARKS
1		裙座	SA-283 C	1	1231	BSA15-303-03	BSA15-303-00(1/3)

REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
05	2015-11-03	ISSUED FOR FABRICATION			
04	2015-10-08	FOR APPROVAL			
03	2015-09-25	FOR APPROVAL			
02	2015-09-07	FOR APPROVAL			
01	2015-08-26	FOR APPROVAL			



昆山市贝色特材装备有限公司
Kunshan Bexcelle Special Equipment Co., Ltd

项目名称: Mobile ACA Project

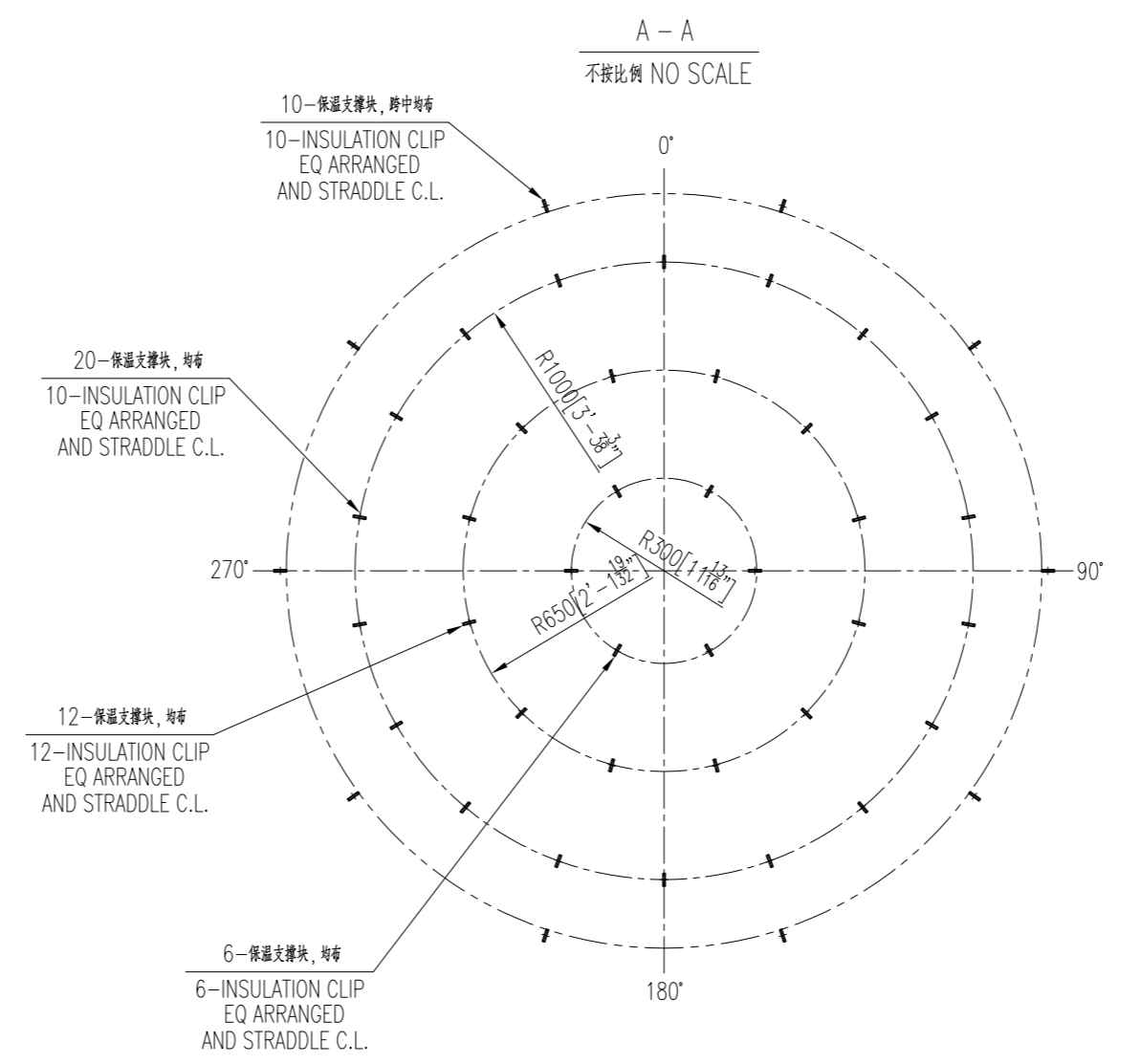
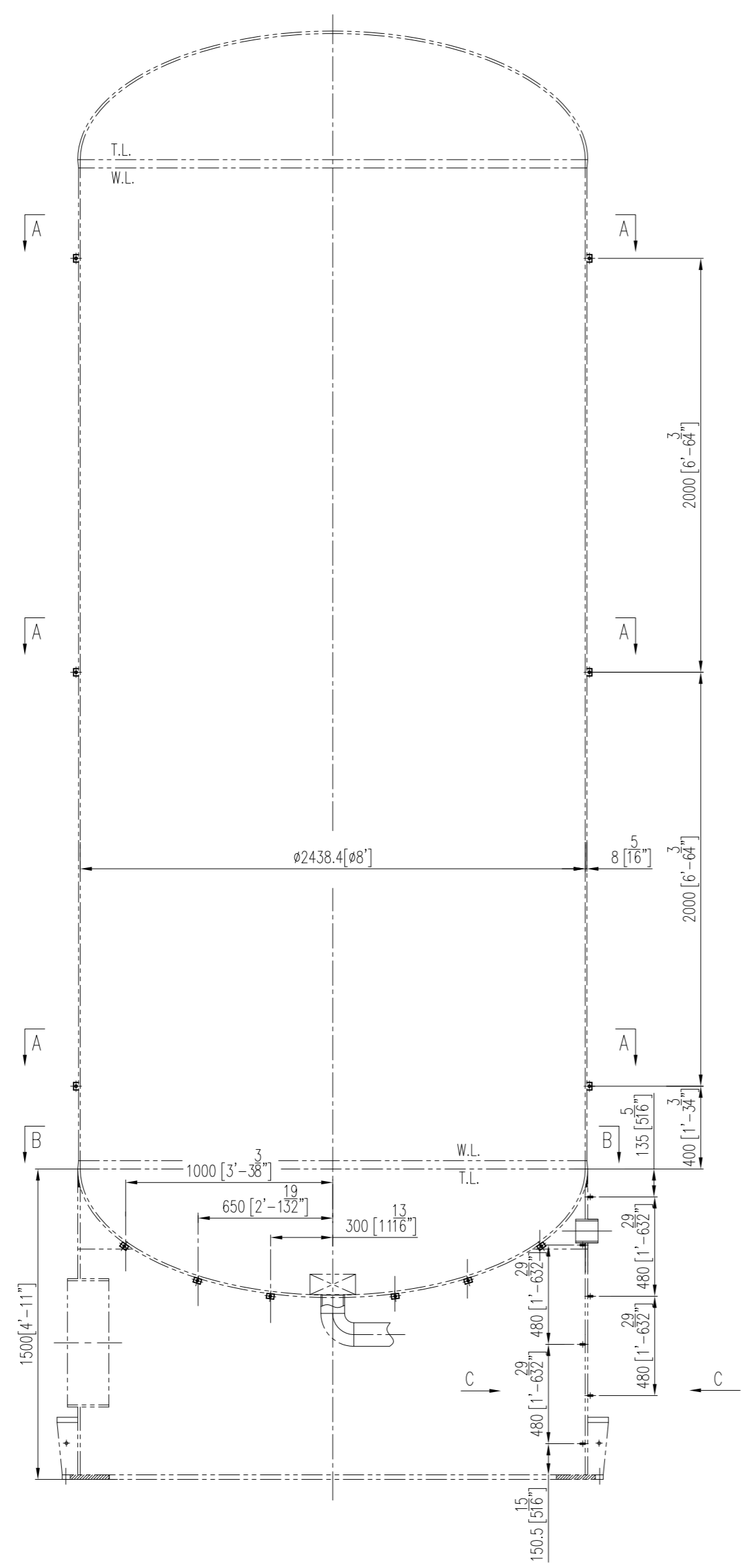
Evonik Corporation
Mobile, AL, USA

Details for
ACA Residue Storage Vessel

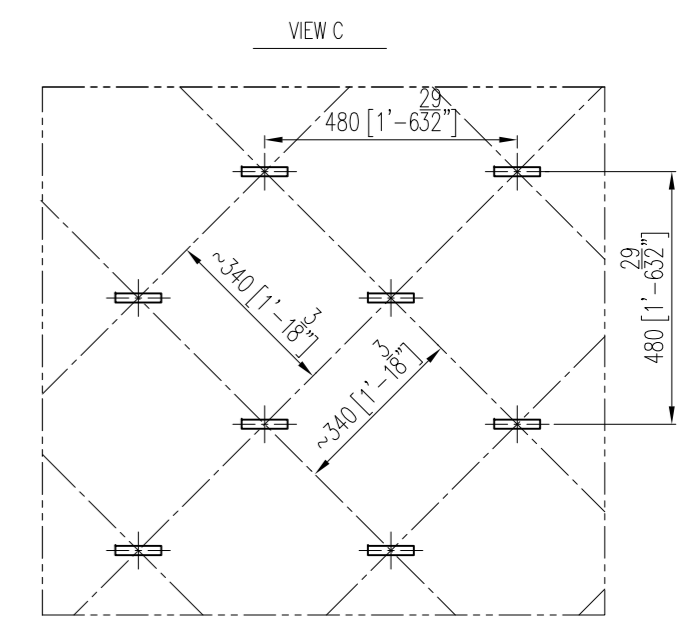
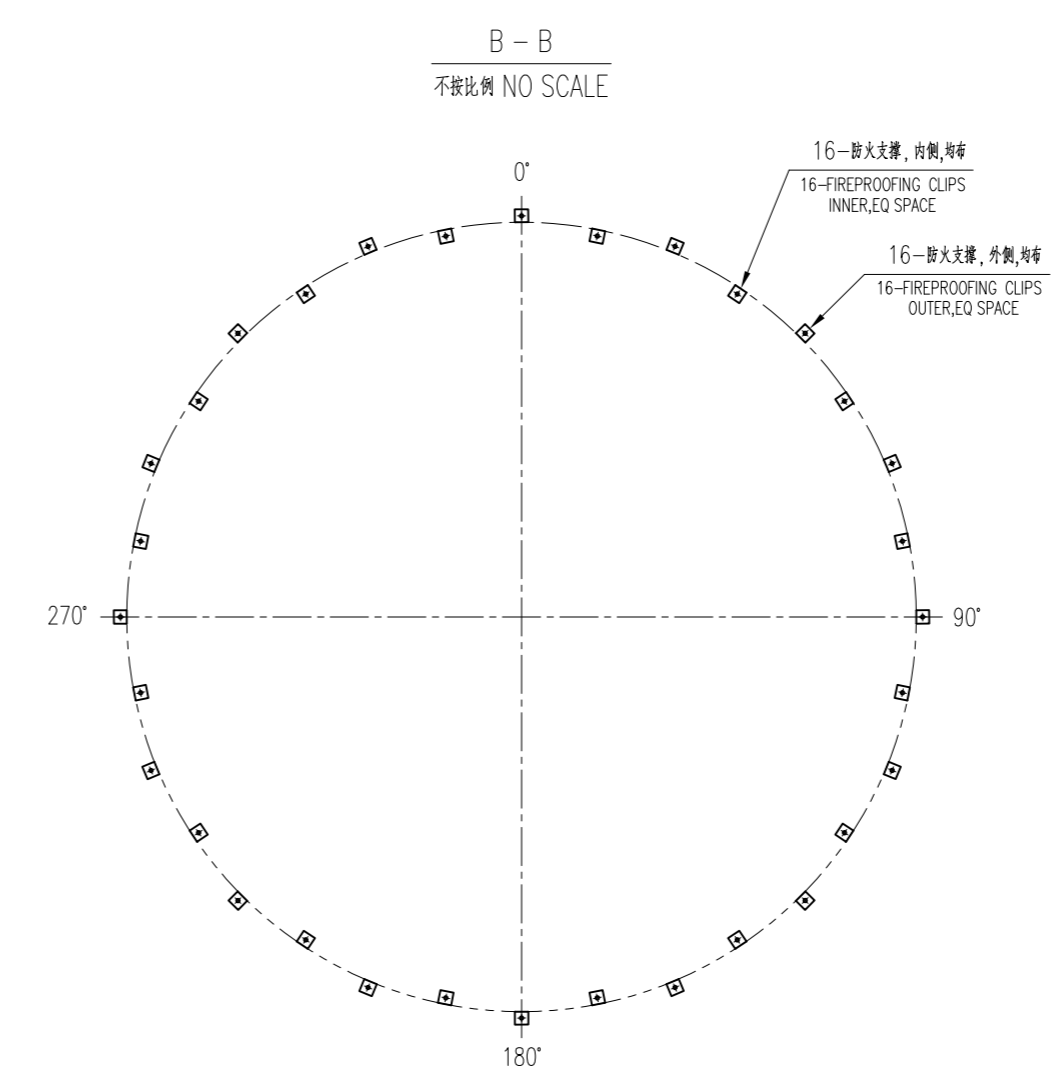
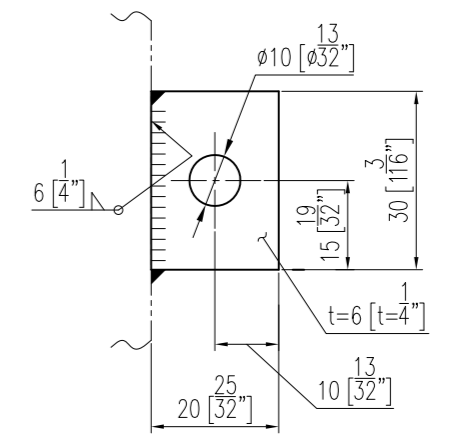
图号: V-4510
生产号: 15-A3176

图号: 05
图号: BSA15-303-03
图号: BSA15-303-03

共 13 页, 第 6 页
PAGES: 13 OF 13



保温/防火支撑块焊接细节
WELD OF INSULATION/FIREPROOFING CLIP
不按比例 NO SCALE

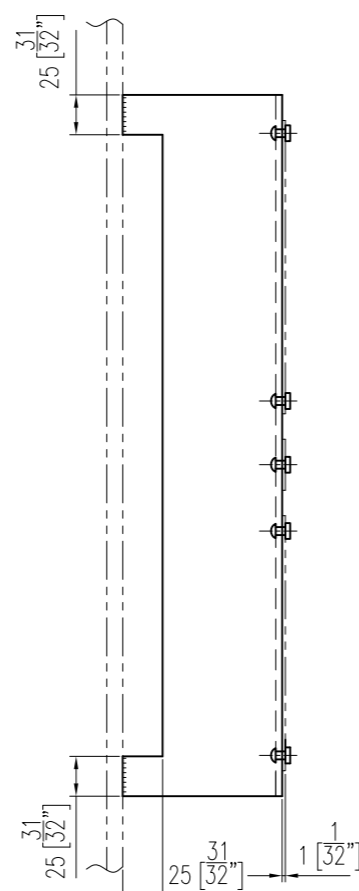
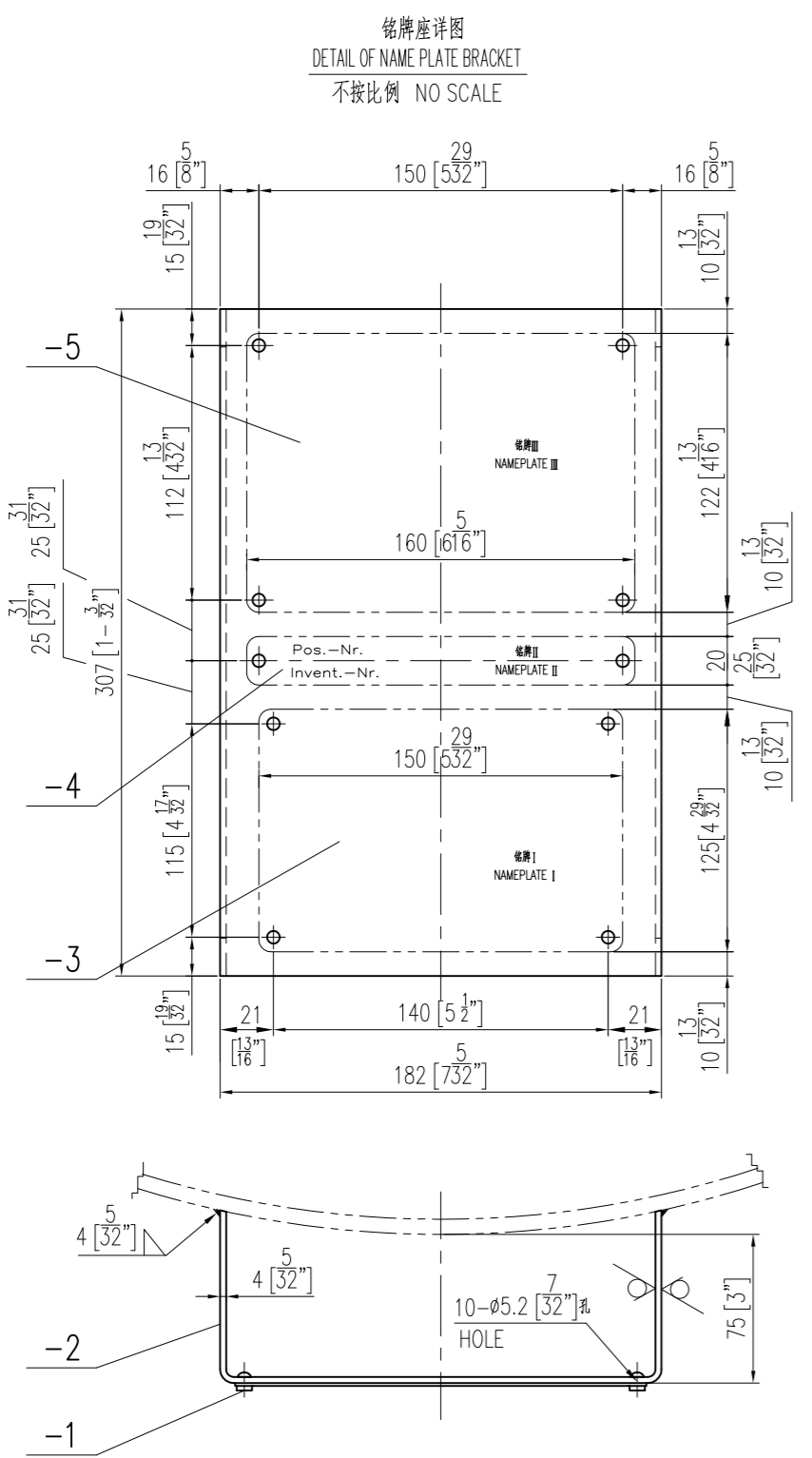
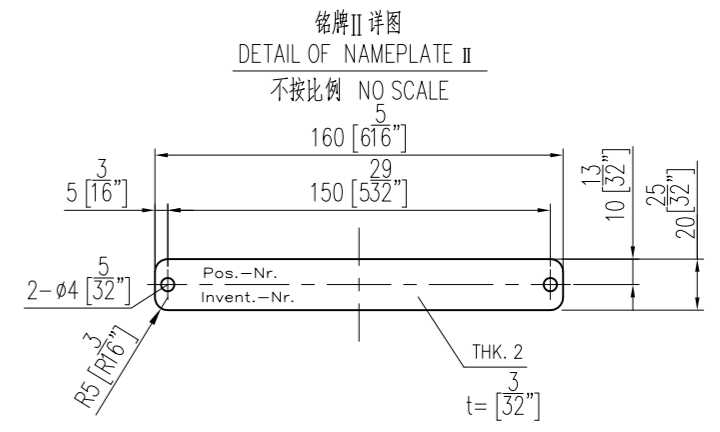
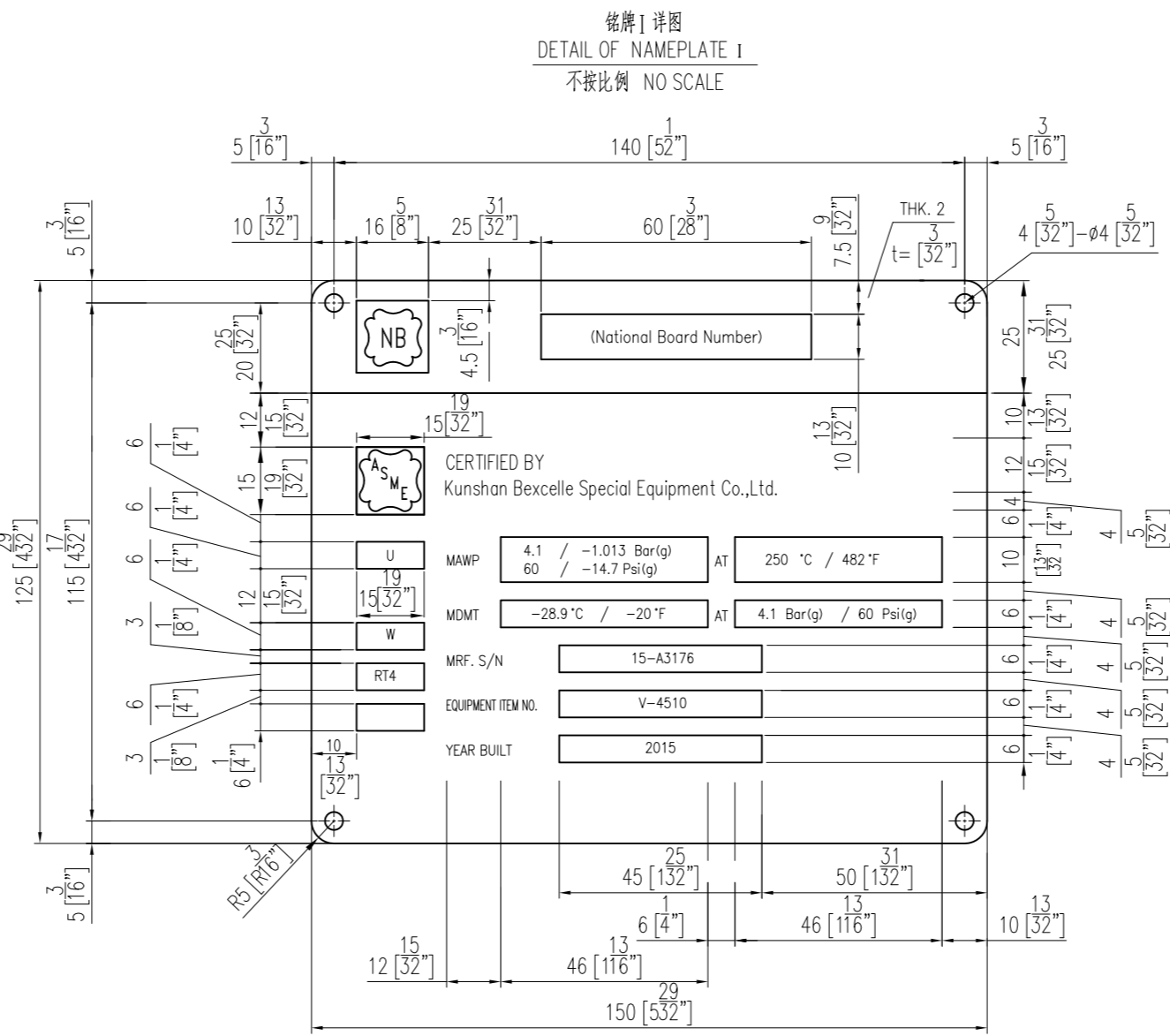
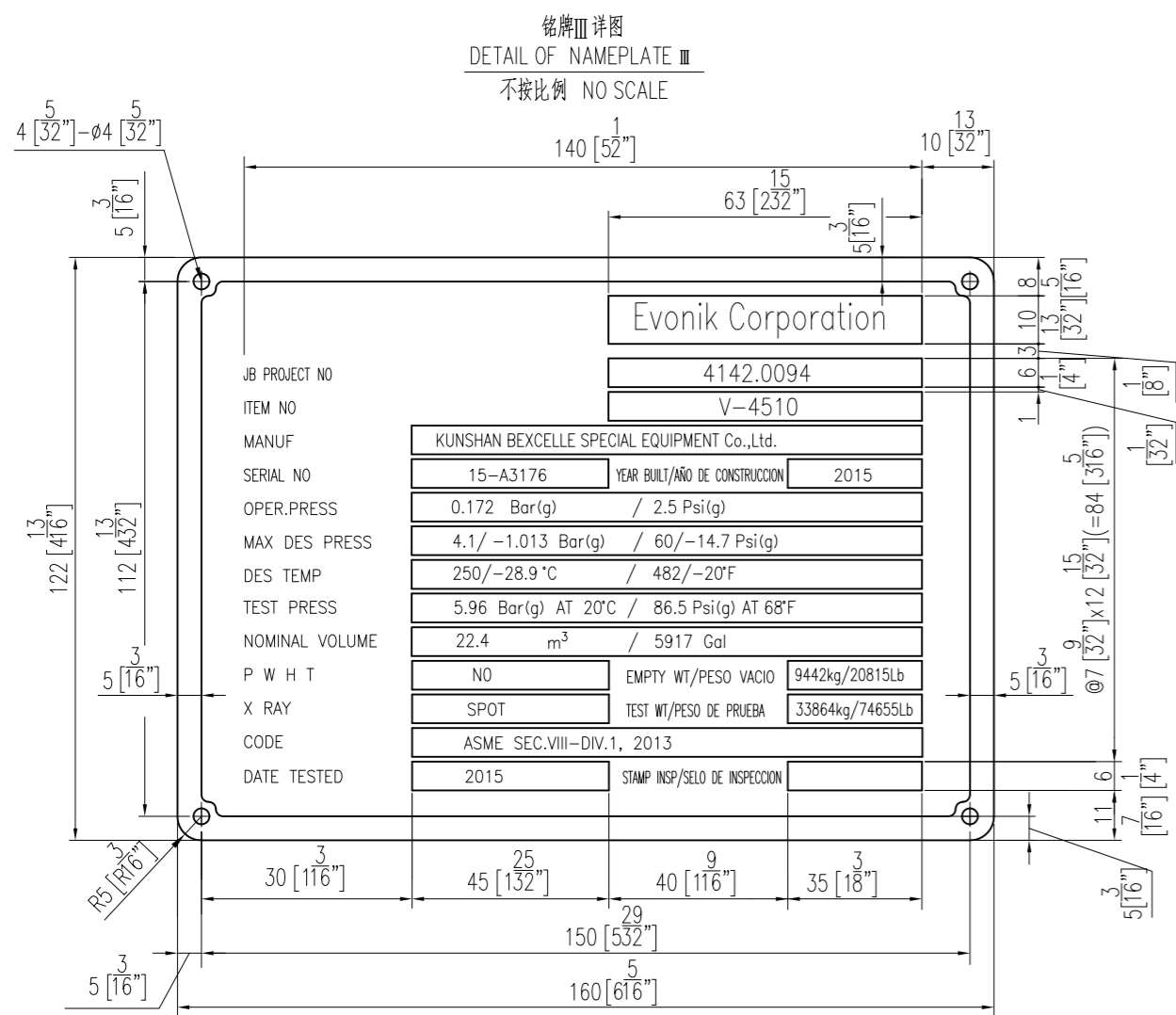


REV	NO.	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
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03	2015-09-25		FOR APPROVAL		W.X.D	Y.W.T F.Z
02	2015-09-07		FOR APPROVAL		W.X.D	Y.W.T F.Z
01	2015-08-26		FOR APPROVAL		W.X.D	Y.W.T F.Z

OWNER / DEVELOPER:

昆山市贝色特材装备有限公司 Kunshan Bexcelle Special Equipment Co.,Ltd		项目名称: PROJECT NAME: Mobile ACA Project	
绘图 DRAW	设计 DESN	Evonik Corporation Mobile, AL, USA	
校核 CHCK	审核 APPR	Details for ACA Residue Storage Vessel	
标准号 STANDARD	批准 AUTHD	图号 ITEM NO. V-4510	生产号 SERIAL NO. 15-A3176

ANSI D



技术要求:

- 铭牌表面不允许有明显的凹凸变形, 表面粗糙度在100mm范围内不得超过1mm.
ANY DISTINCT DEFORMATION OF WARPAGE ON THE NAMEPLATE IS NOT PERMITTED AND SHALL BE LESS THAN 1 mm PER 100mm.
- 铭牌表面应平整光滑, 色彩均匀, 不得有裂纹, 锈迹, 反色和明显的擦伤丝纹。
THE SURFACE OF THE NAMEPLATE SHALL BE FLAT, SMOOTH AND UNIFORM COLOR AND FREE OF ANY CRACK, RUST AND SCRATCH.
- 铭牌上的文字、符号、线条应清晰, 完整, 不得断裂和模糊, 不允许有影响其清晰度的斑点和暗纹。
LETTERS SYMBOLS AND LINES IN THE NAMEPLATE SHALL BE CLEAR AND COMPLETE AND SHALL NOT BE ANY STAIN AND SHADOW. THE HEIGHT OF THE LETTERING MUST BE NOT LESS THAN 4 mm.
- 漆膜在铭牌上的附着必须牢固, 漆膜上不得有裂纹, 脱落和明显的颗粒杂质。
THE FILM OF PAINTING ON THE NAMEPLATE SHALL BE FIRM AND FREE OF ANY WRINKLES, SHEDDING AND IMPURITY.
- 铭牌II上的位号和系列号用冲压或雕刻的方法清晰表示, 字高5mm。
THE ITEM AND THE INVENTORY-NUMBER OF NAMEPLATE II SHALL BE DONE IN GOOD LEGIBLE MANNER IN CHARACTERS OF 5mm HEIGHT BY PUNCHMARKING OR ENGRAVING.
- 本零件按照规范 TS_25-0902设计。
THIS PART IS DESIGNED ACCORDING TO TS_25-0902.

序号	图号及标准号	名称	数量	材料	重量	所在图号	装配图号	备注
NO.	DRAWING NO. OR STANDARD NO.	TITLE	QUANT.	MATERIAL	WEIGHT	DWG. NO.	ASSM. DWG. NO.	REMARKS
-5		铭牌II δ=2 NAMEPLATE II	1	SA-240 304	0.5			
-4		铭牌I δ=2 NAMEPLATE I	1	SA-240 304	0.1			
-3		铭牌I δ=2 NAMEPLATE I	1	SA-240 304	0.4			
-2		铭牌支板 δ=4 NAMEPLATE SUPPORT	1	SA-240 316L	5.5			
-1		铆钉 5x10 RIVET	10	铜 COPPER	/			
05	2015-11-03	ISSUED FOR FABRICATION				W.X.D	Y.W.T	F.Z
04	2015-10-08	FOR APPROVAL				W.X.D	Y.W.T	F.Z
03	2015-09-25	FOR APPROVAL				W.X.D	Y.W.T	F.Z
02	2015-09-07	FOR APPROVAL				W.X.D	Y.W.T	F.Z
01	2015-08-26	FOR APPROVAL				W.X.D	Y.W.T	F.Z
REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.			

OWNER / DEVELOPER:

昆山市贝色特材装备有限公司
Kunshan Bexcelle Special Equipment Co.,Ltd

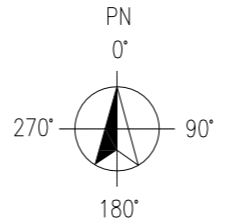
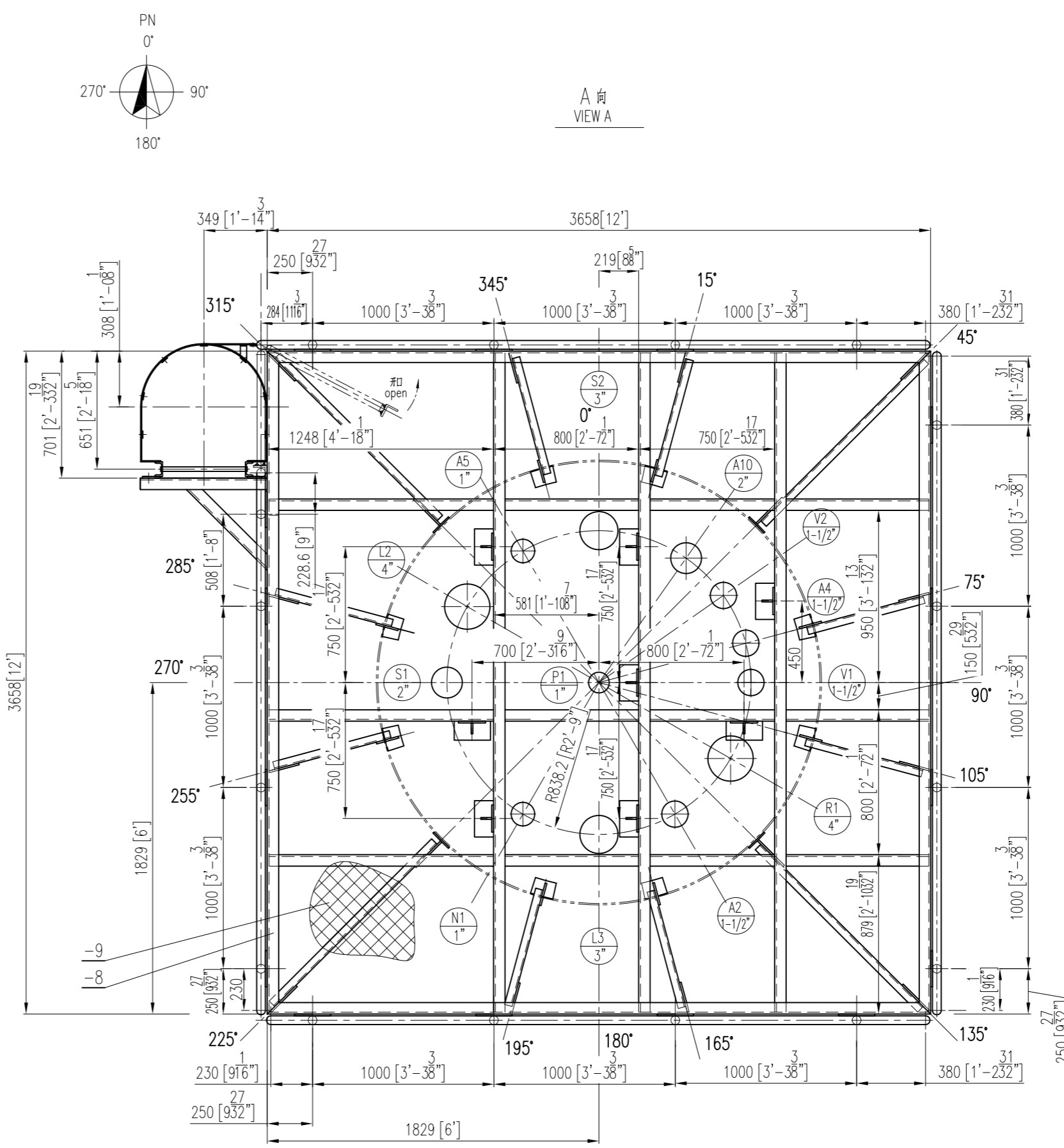
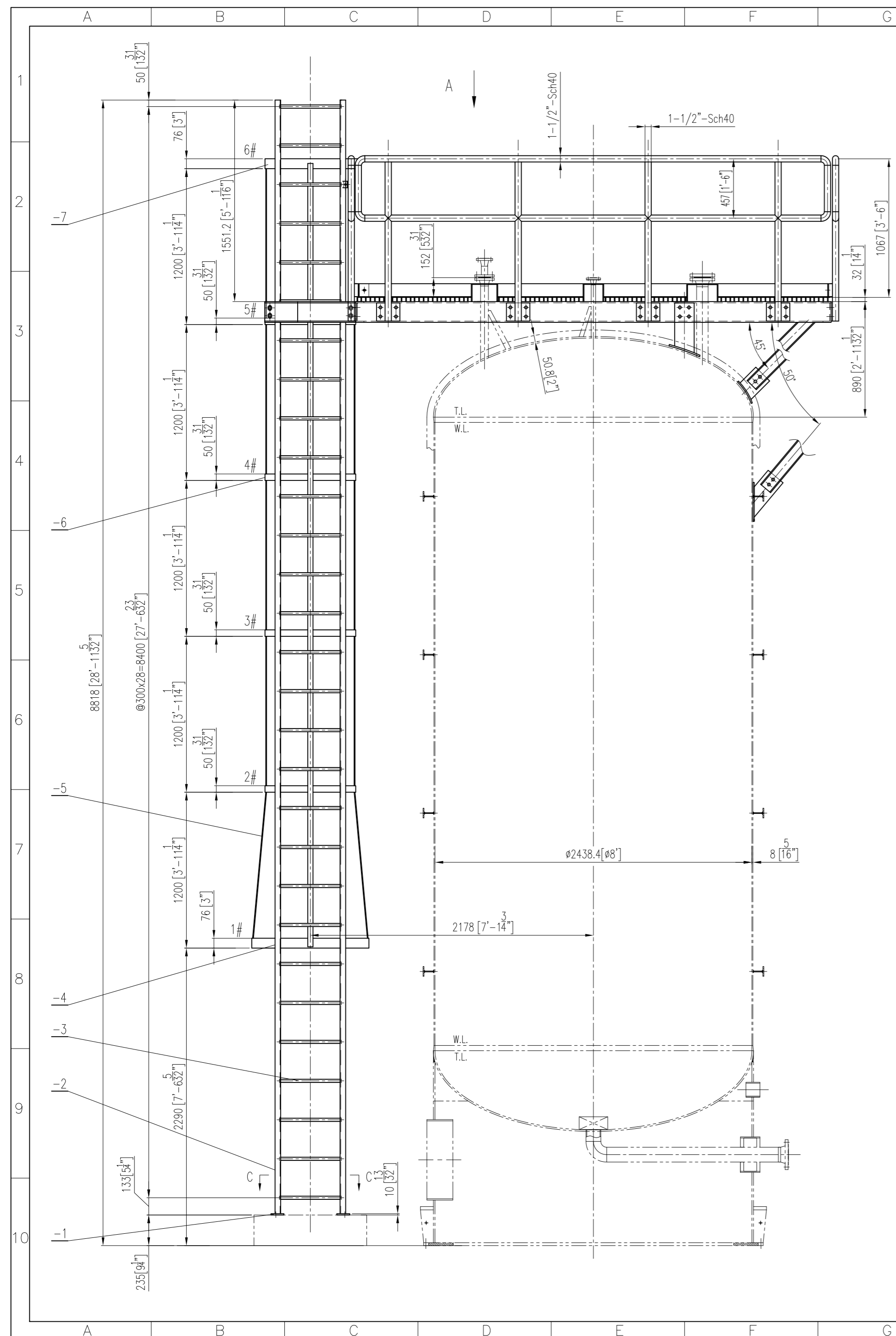
项目名称: Mobile ACA Project
PROJECT NAME:

Evonik Corporation
Mobile, AL, USA

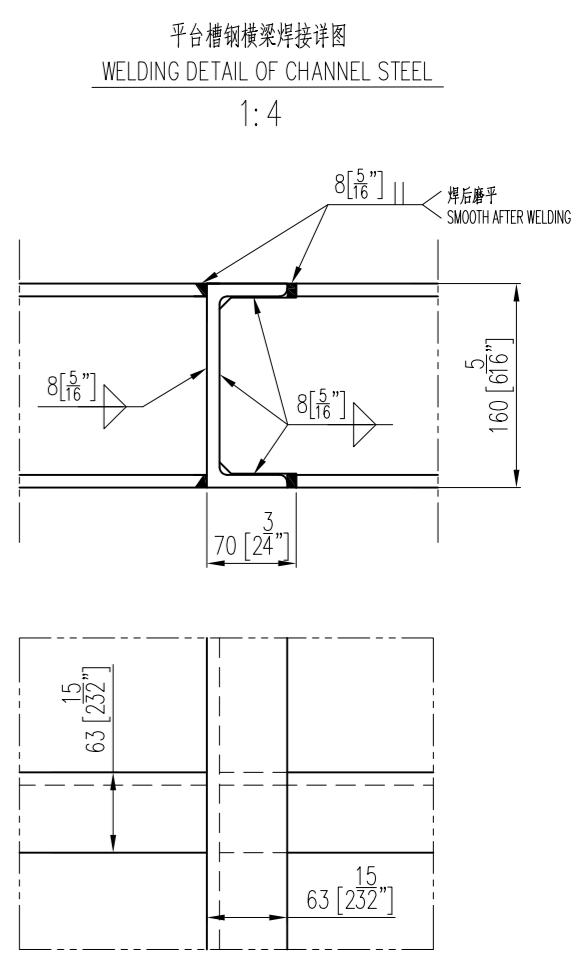
Details for
ACA Residue Storage Vessel

图号: 05
DWG. NO. BSA15-303-05
比例: 1:1
共 13 页, 第 13 页
PAGES: 13 OF 13

图号: V-4510
ITEM NO. 生产号: 15-A3176
SERIAL NO.



A 向
VIEW A



- 技术要求: SPECIFICATIONS:
- 本设备梯子平台按客户规范: CIV-ES-001, CIV-ES-004, CIV-ES-018 进行设计, 制造和装配。
DESIGN, MANUFACTURING AND ASSEMBLING OF PLATFORMS AND LADDERS SHALL COMPLY WITH OWNER SPEC.: CIV-ES-001, CIV-ES-004, CIV-ES-018.
 - 焊接结构全部采用电焊。
THE WELDING PARTS ADOPT ELECTRIC-ARC WELDING.
 - 所有物件表面光滑无毛刺, 安装后不能有歪斜, 扭曲, 变形及其他缺陷。
THE SURFACE OF ALL THE PART SHALL BE SMOOTH, NO BURRS, THERE SHALL BE NO SKEW, TWIST, TRANSMATATION AND OTHER BLEMISHES AFTER INSTALLATION.
 - 除注明外, 所有焊接的厚度均按原设计的厚度, 并且是连续焊接。
ALL HEIGHT OF WELDING FILLET IS EQUAL TO THE THINNER PLATE EXCEPT NOTED, THE WELDING SEAM IS CONTINUED.
 - 栏杆整体组装后, 在所有相邻两根栏杆扶手中点处, 从水平方向垂直施加 50kg/m 的荷载, 持续 2 分钟, 卸载后不得有损坏和永久变形。
AFTER MOUNTING OF HAND RAIL, APPLY HORIZONTAL LOADING OF 50kg/m IN CENTER POINT OF HAND RAILS BETWEEN EVERY TWO ADJACENT COLUMNS, AND LAST 2 MINUTES. NO DAMAGE AND ETHERNAL DEFORMATION WILL BE ALLOWED AFTER UNLOADING.
 - 除设备本体上平台预埋件外, 平台其他附件(如紧固件, 爬梯, 平台, 护栏板及踏板等)均应采用热镀锌。
THE PARTS OF FASTENER, LADDER, PLATFORM, HANDLE & GRATINGS SHALL BE HOT DIP GALVANIZED, UNLESS THE PLATE WELDED ON VESSEL.
 - 踏板按踏板平面图布置铺设, 每块踏板由不少于 4 个卡子卡住, 踏板间不留间隙, 踏板严禁现场切割。
GRATING SHALL BE INSTALL PER LAYOUT DRAWING, EVERY GRATING WAS CLAMPED BY 4 CLAMPED, NO GAP BETWEEN CLAMP. GRATING SHOULD NOT CUT AT SITE.
 - 所有外购附件按最低点应带一个 NPT 1/4" 的排气孔, 用不锈钢螺帽堵塞, 垫板应密封, 且垫板应密封 R10 圆角。
PAD SHALL PROVIDED A NPT 1/4" TELL TALE HOLE AT LOWEST POINT WITH SS PLUG.
AND PAD SHALL BE FULLY SEAL WELDED. SHARP OF PAD SHALL BE POLISHED TO R10 mm.

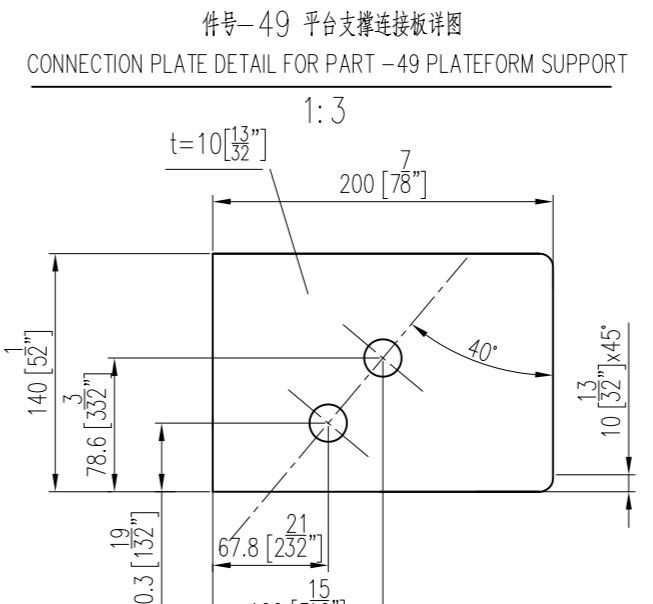
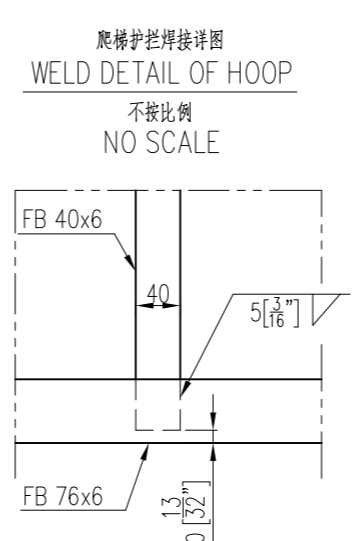
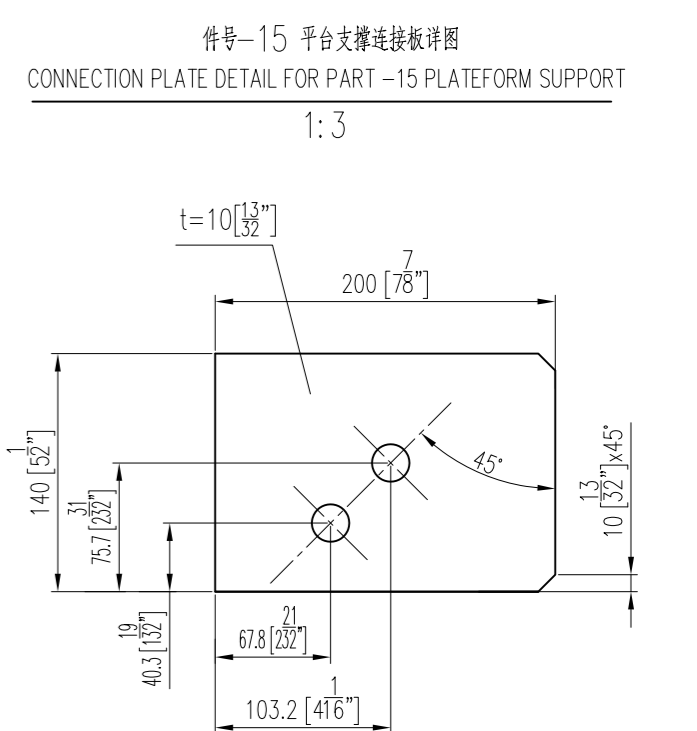
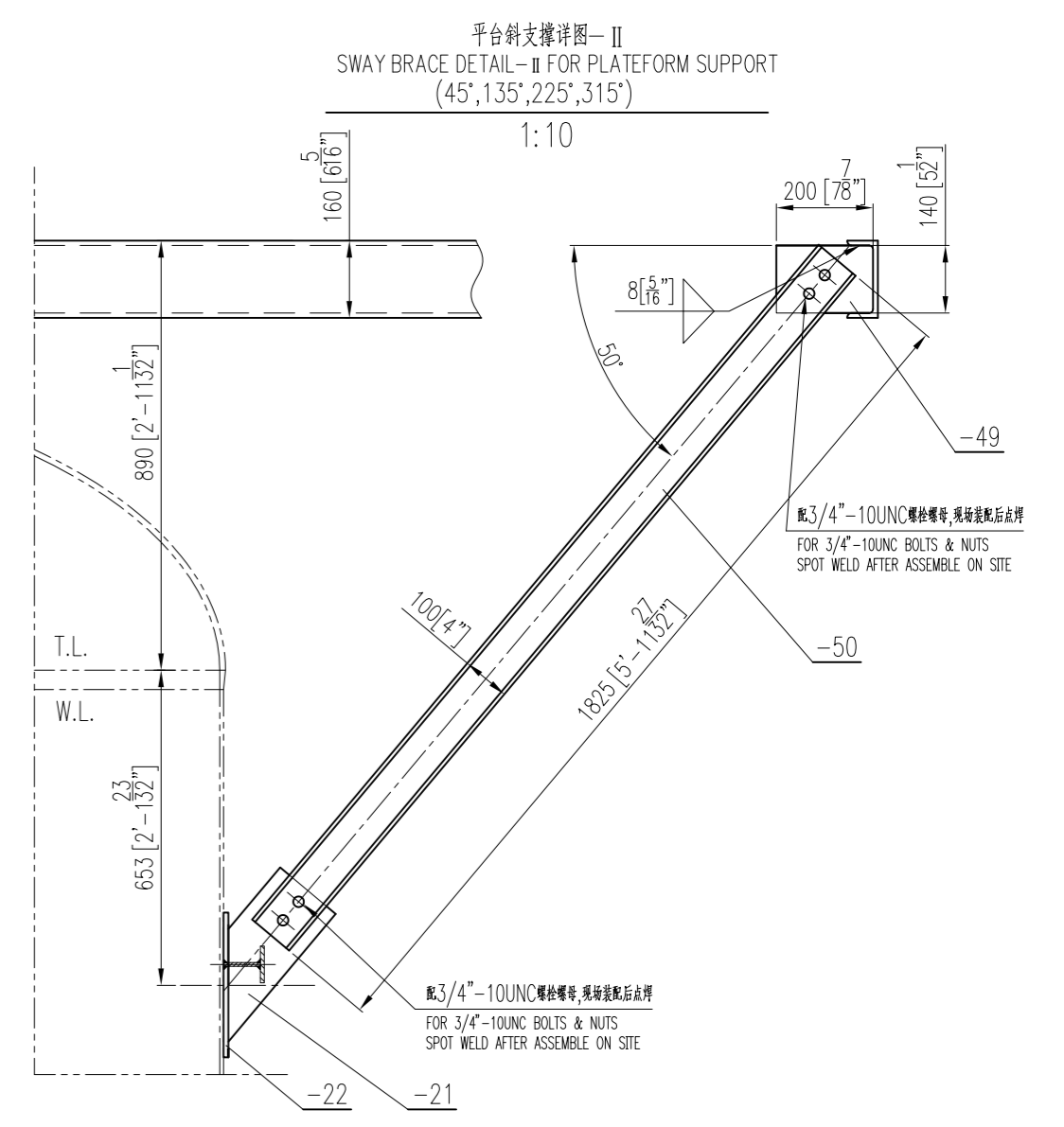
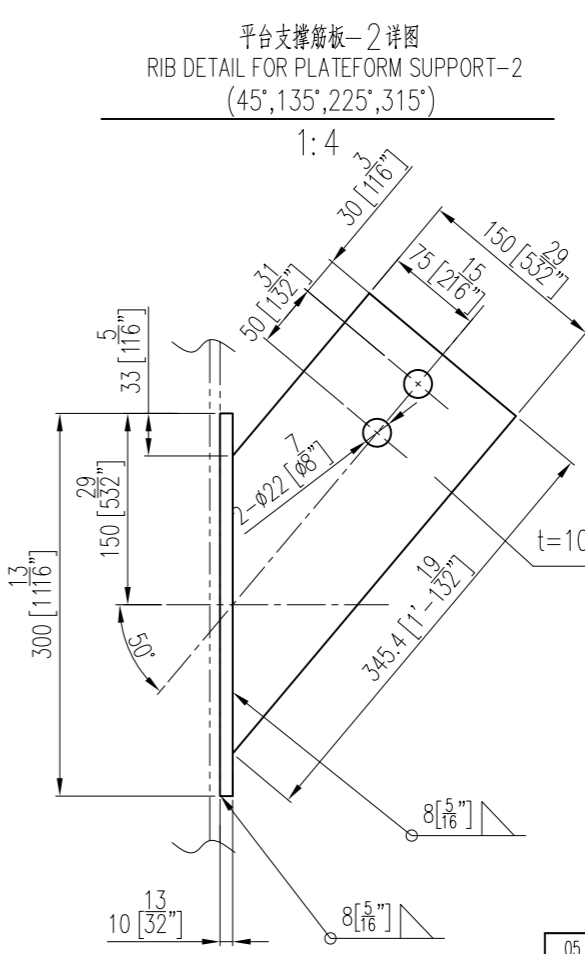
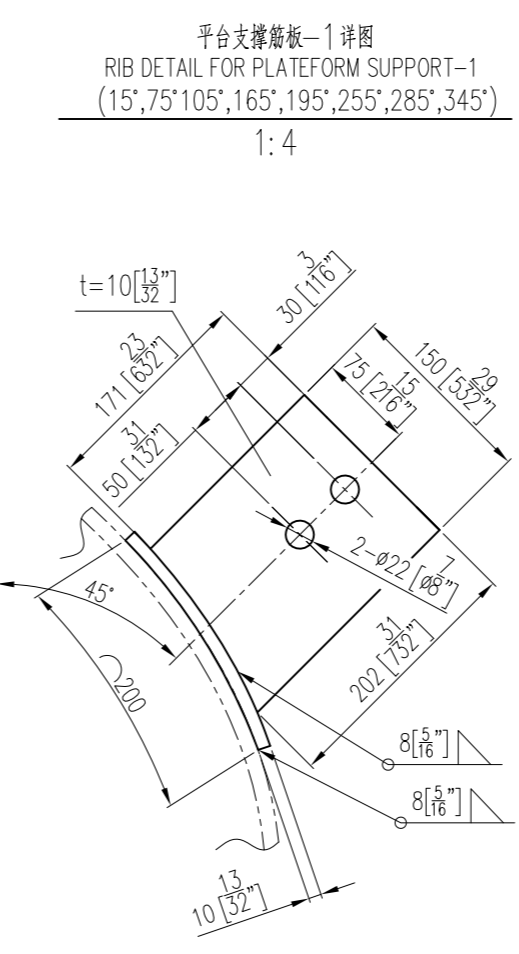
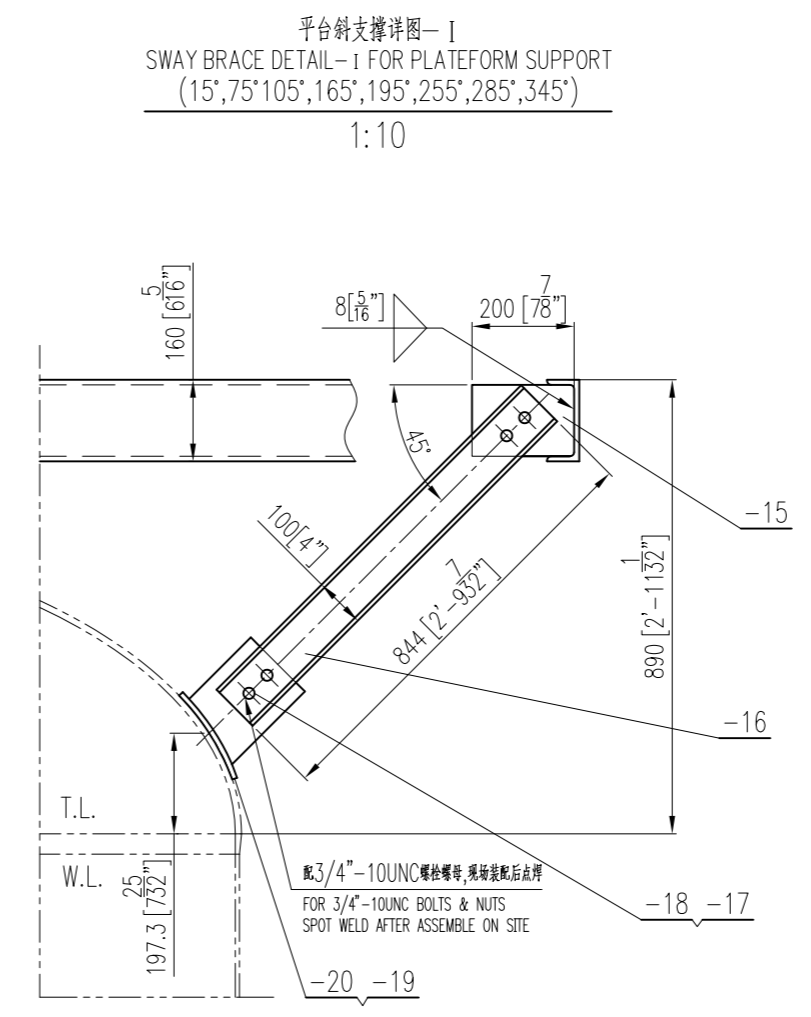
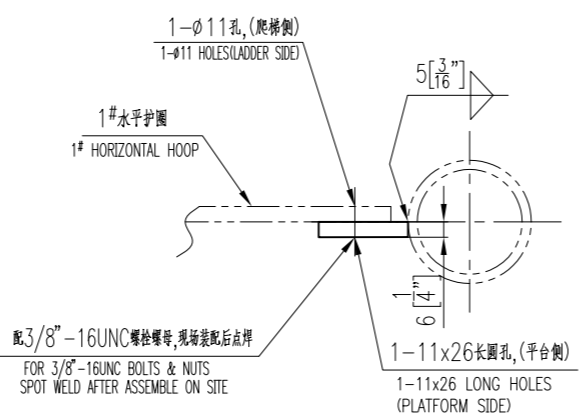
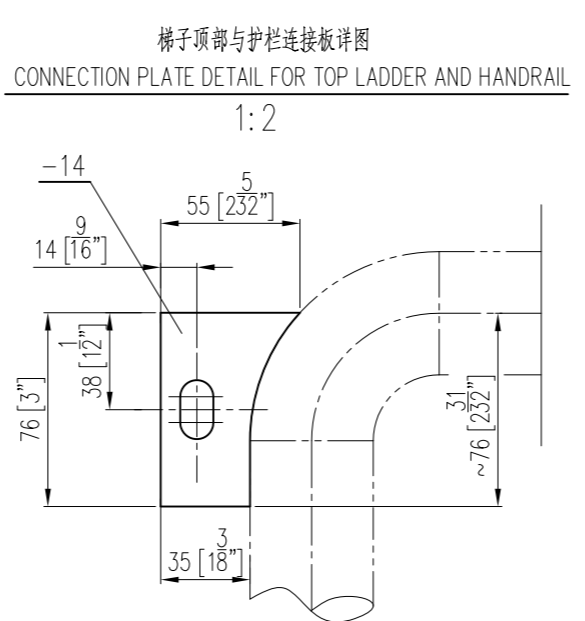
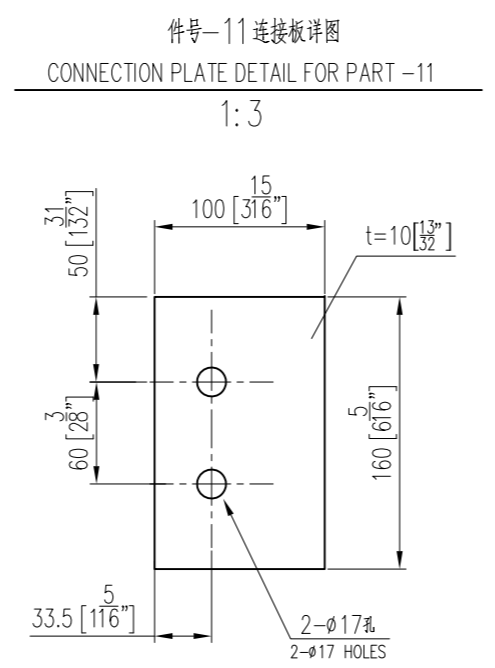
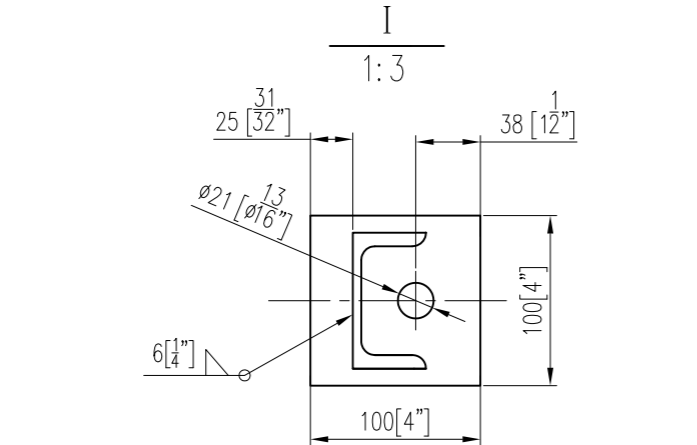
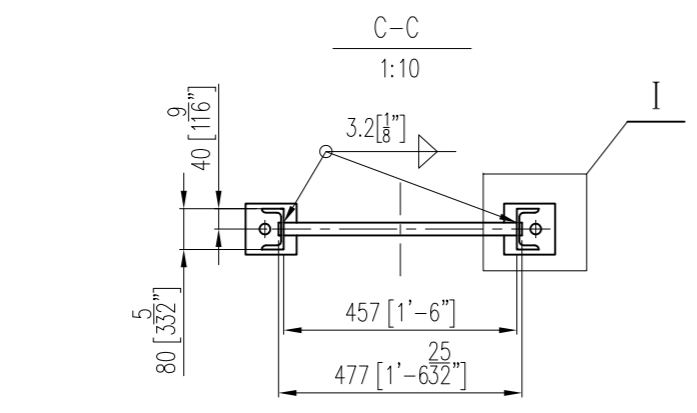
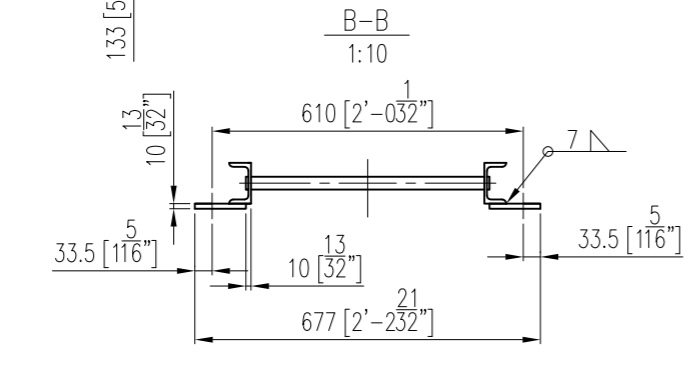
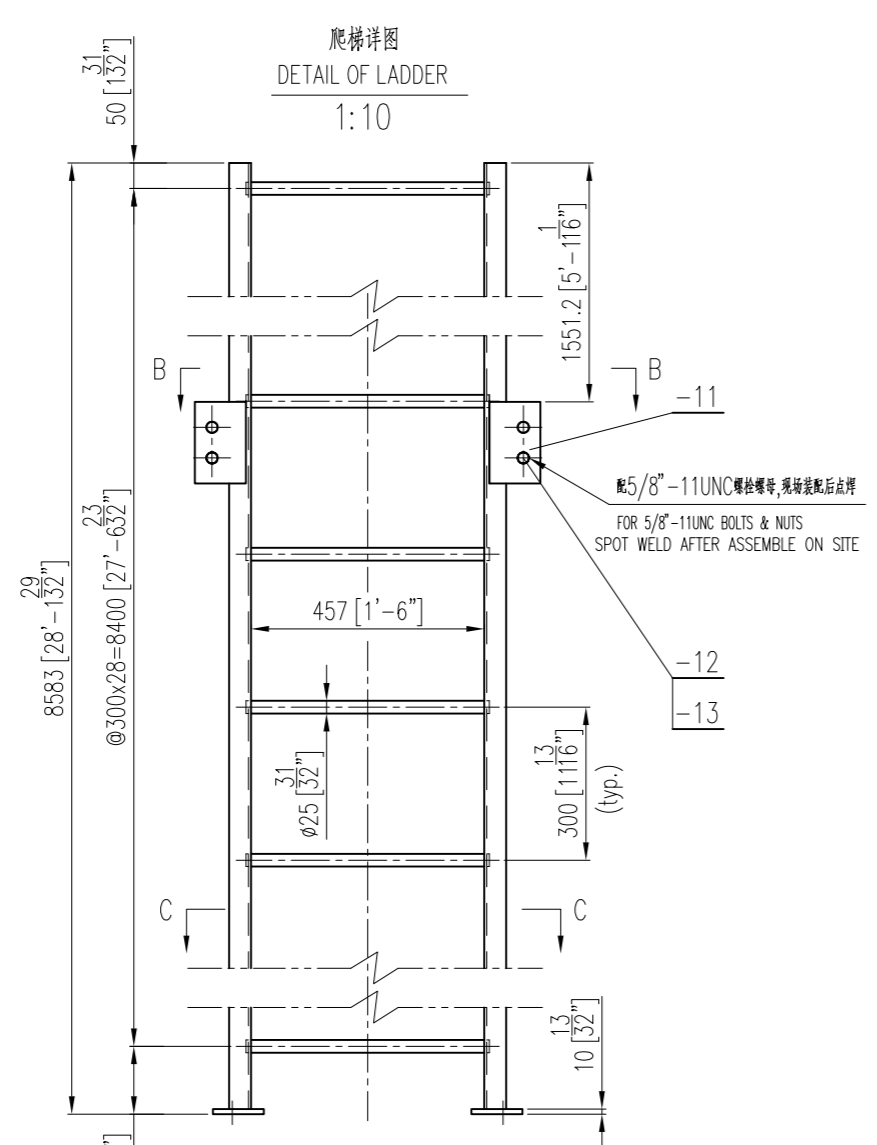
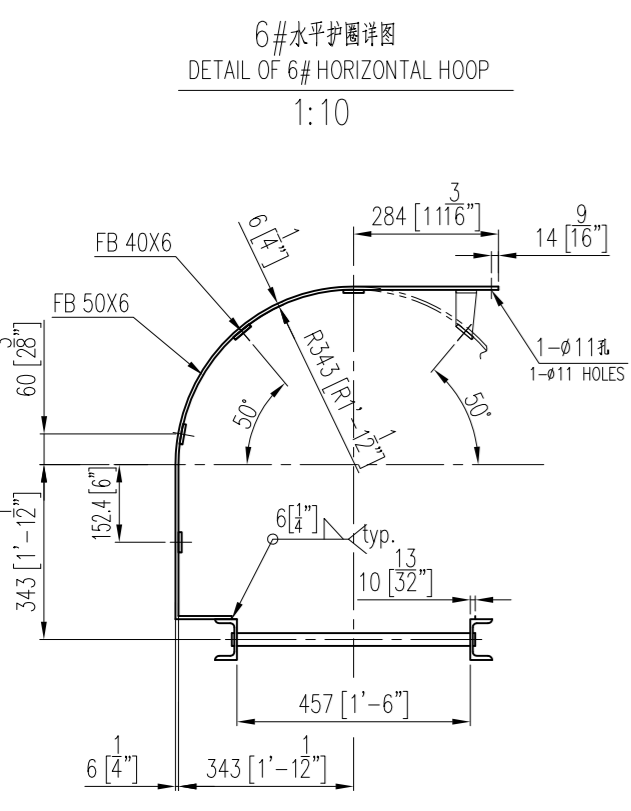
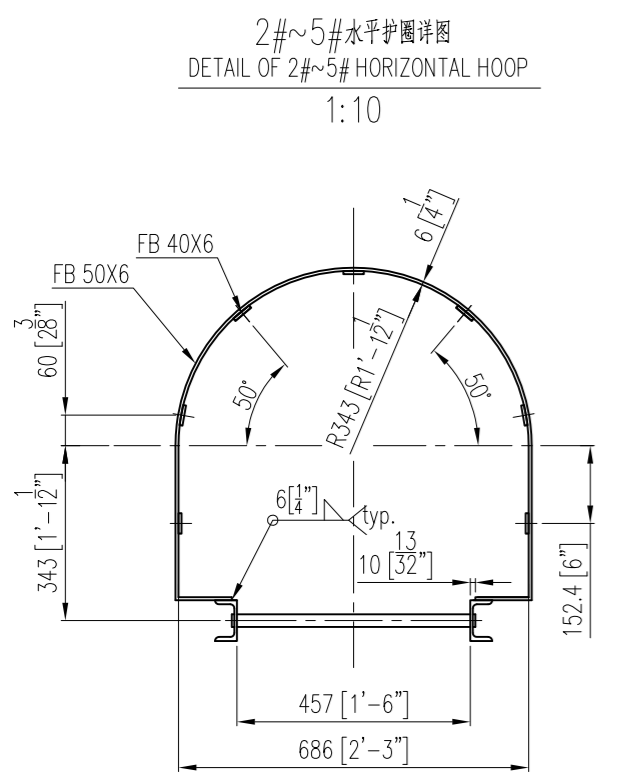
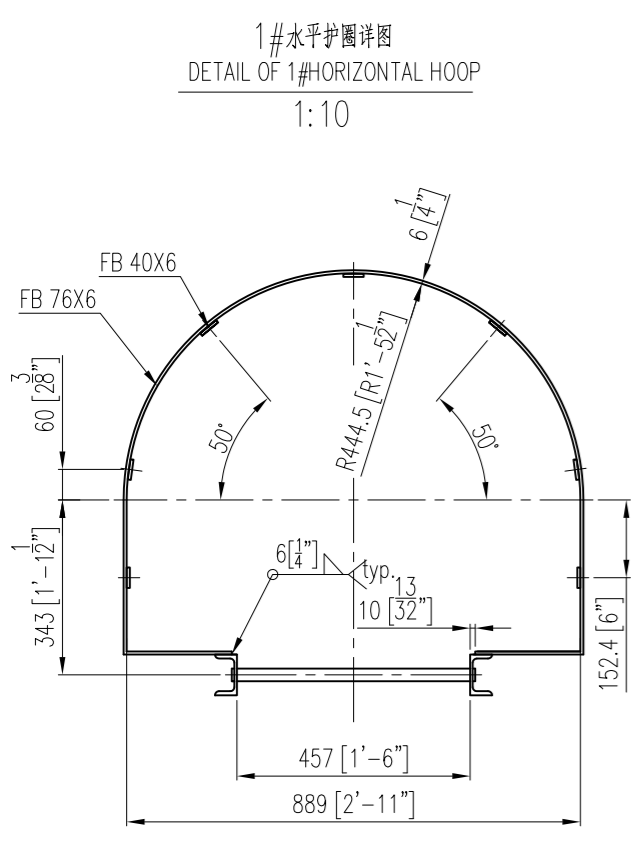
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03	2015-09-25	FOR APPROVAL	W.X.D	Y.W.T	F.Z
02	2015-09-07	FOR APPROVAL	W.X.D	Y.W.T	F.Z
01	2015-08-26	FOR APPROVAL	W.X.D	Y.W.T	F.Z

OWNER / DEVELOPER:

Evonik Corporation
Mobile, AL, USA

昆山市色特材装备有限公司 Kunshan Bexcelle Special Equipment Co., Ltd	项目名称: PROJECT NAME: Mobile ACA Project
Evonik Corporation Mobile, AL, USA	图号: Dwg. No. BSA15-303-07(1/4)
Details for ACA Residue Storage Vessel	比例: SCALE: /
图号: ITEM NO. V-4510	生产号: SERIAL NO. 15-A3176

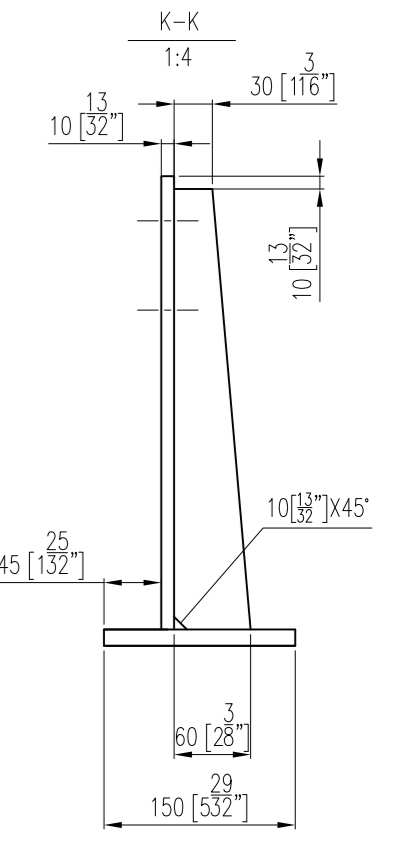
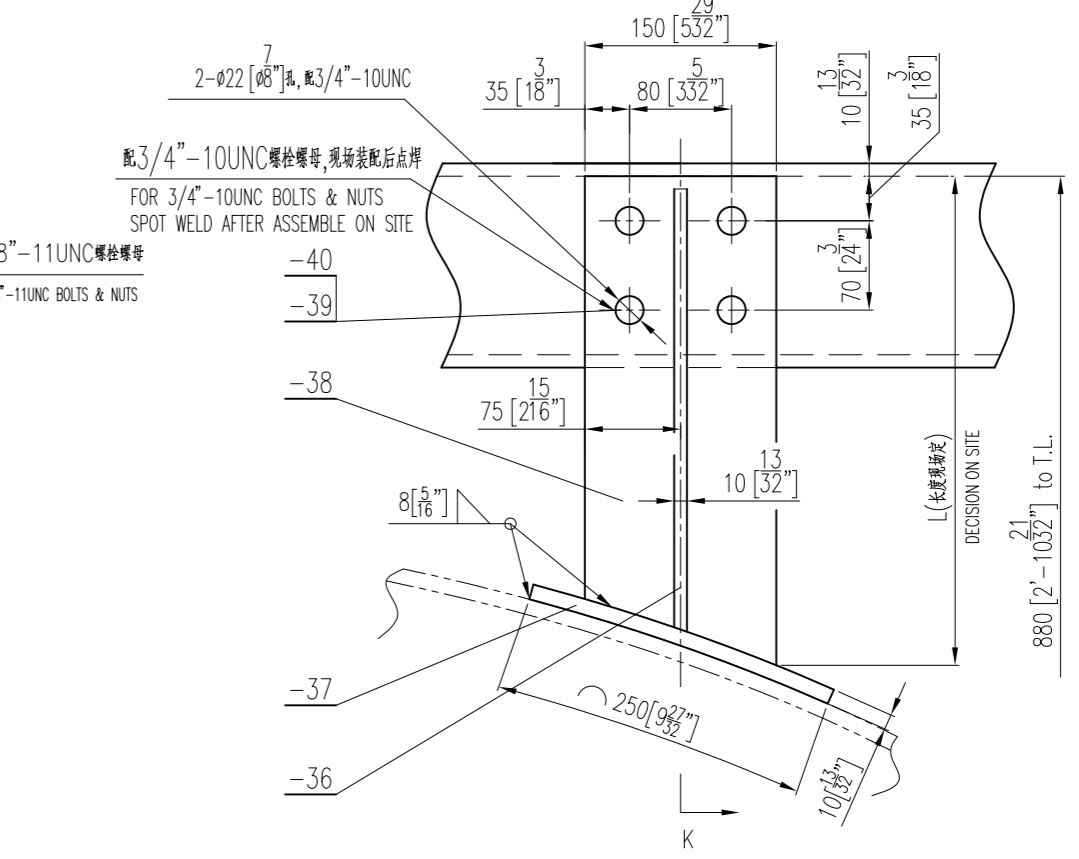
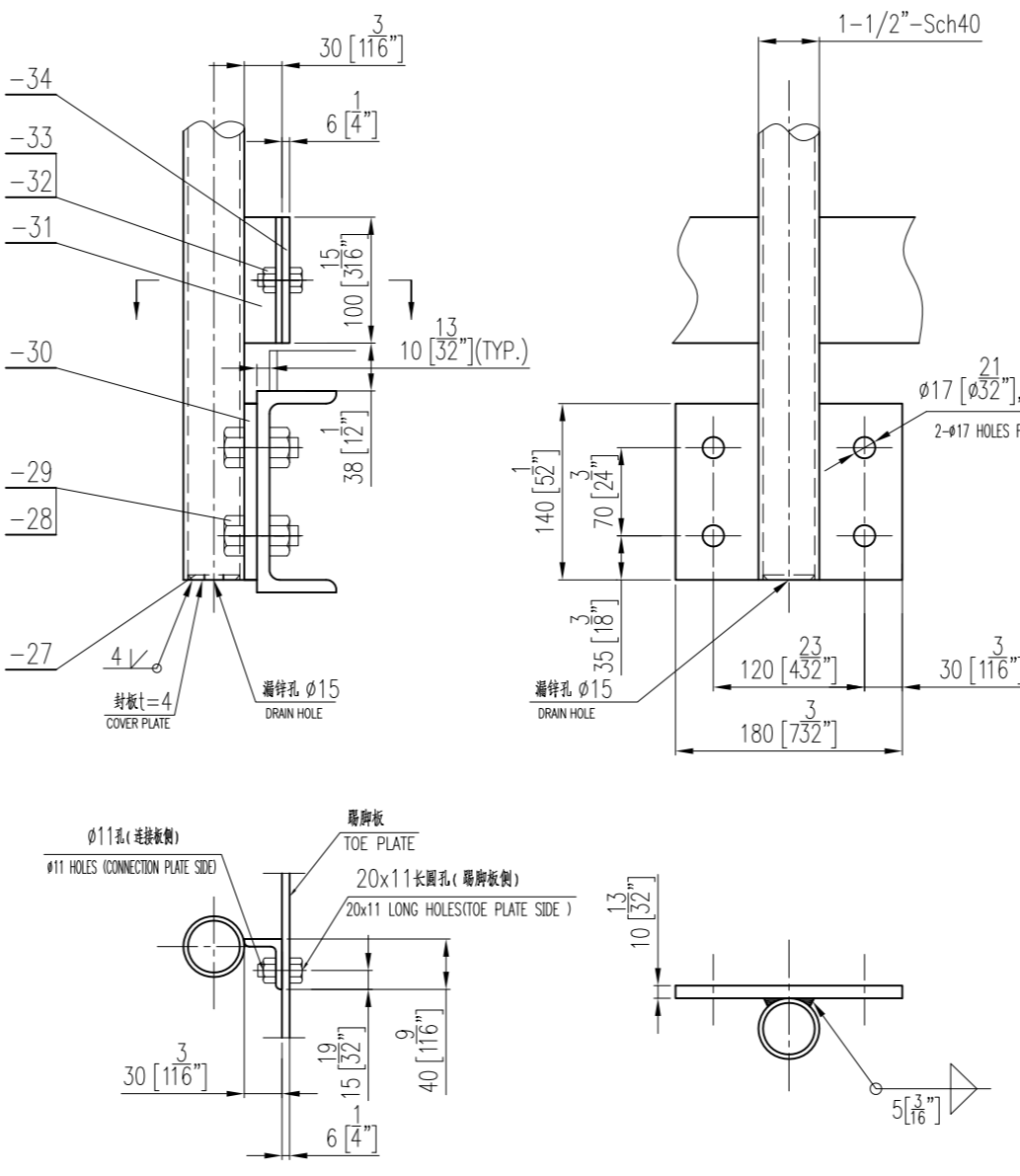
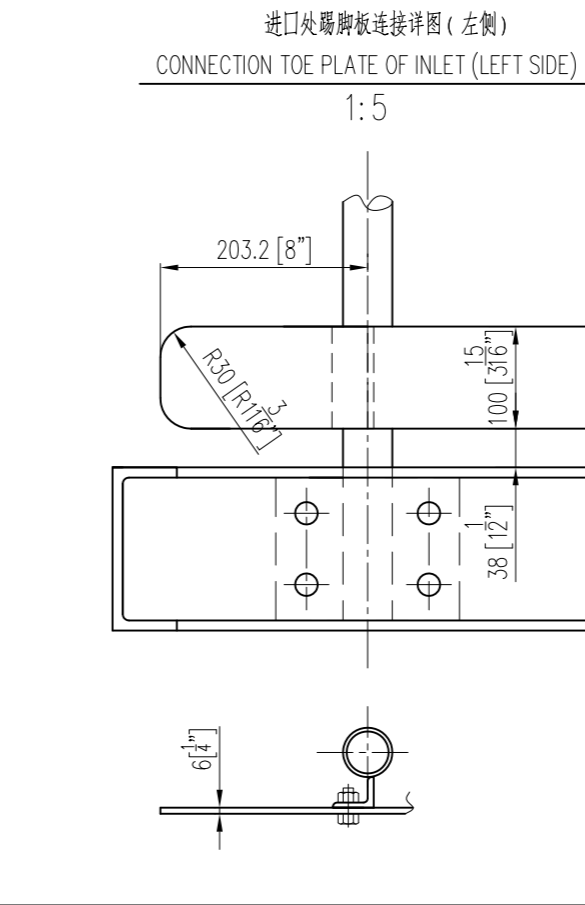
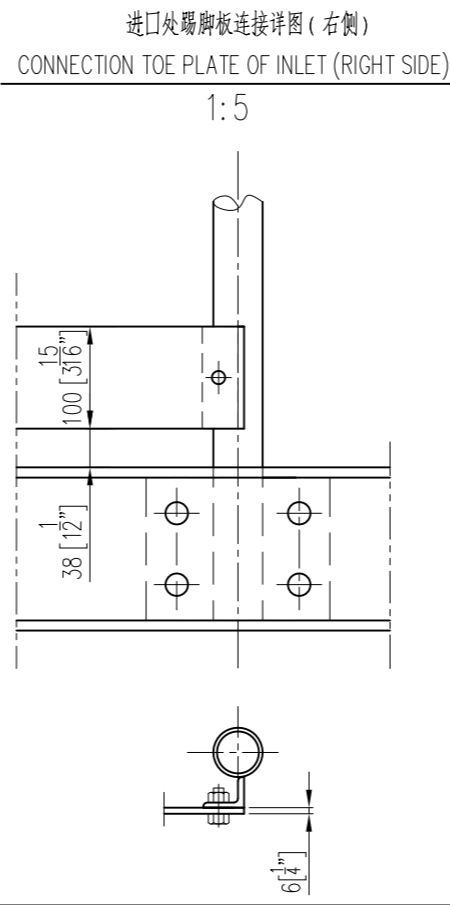
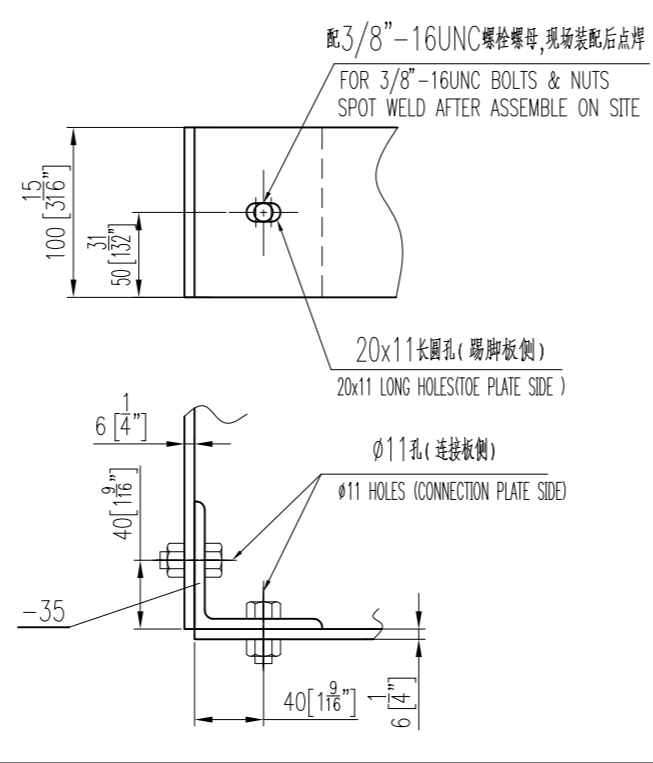
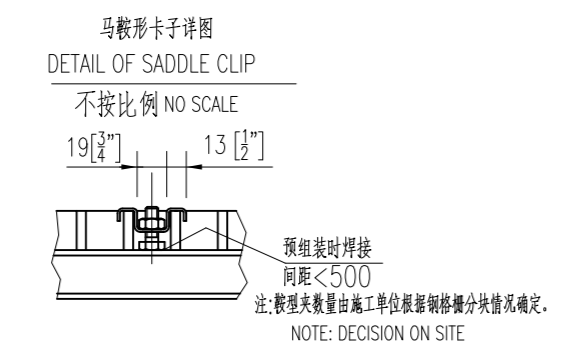
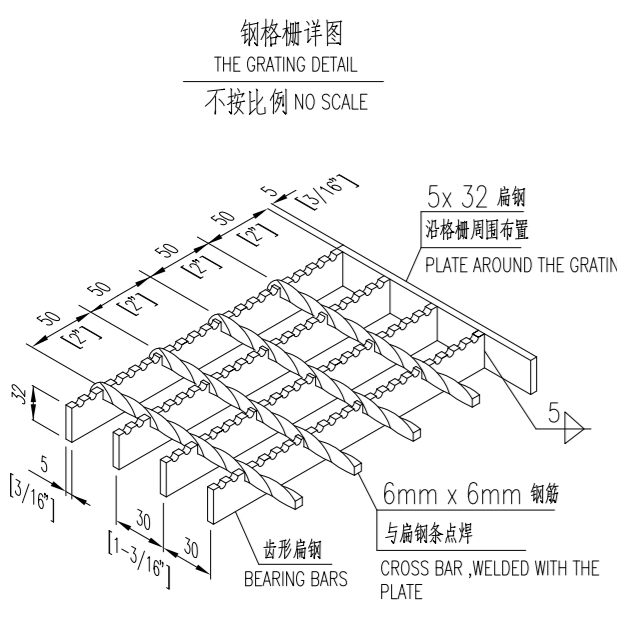
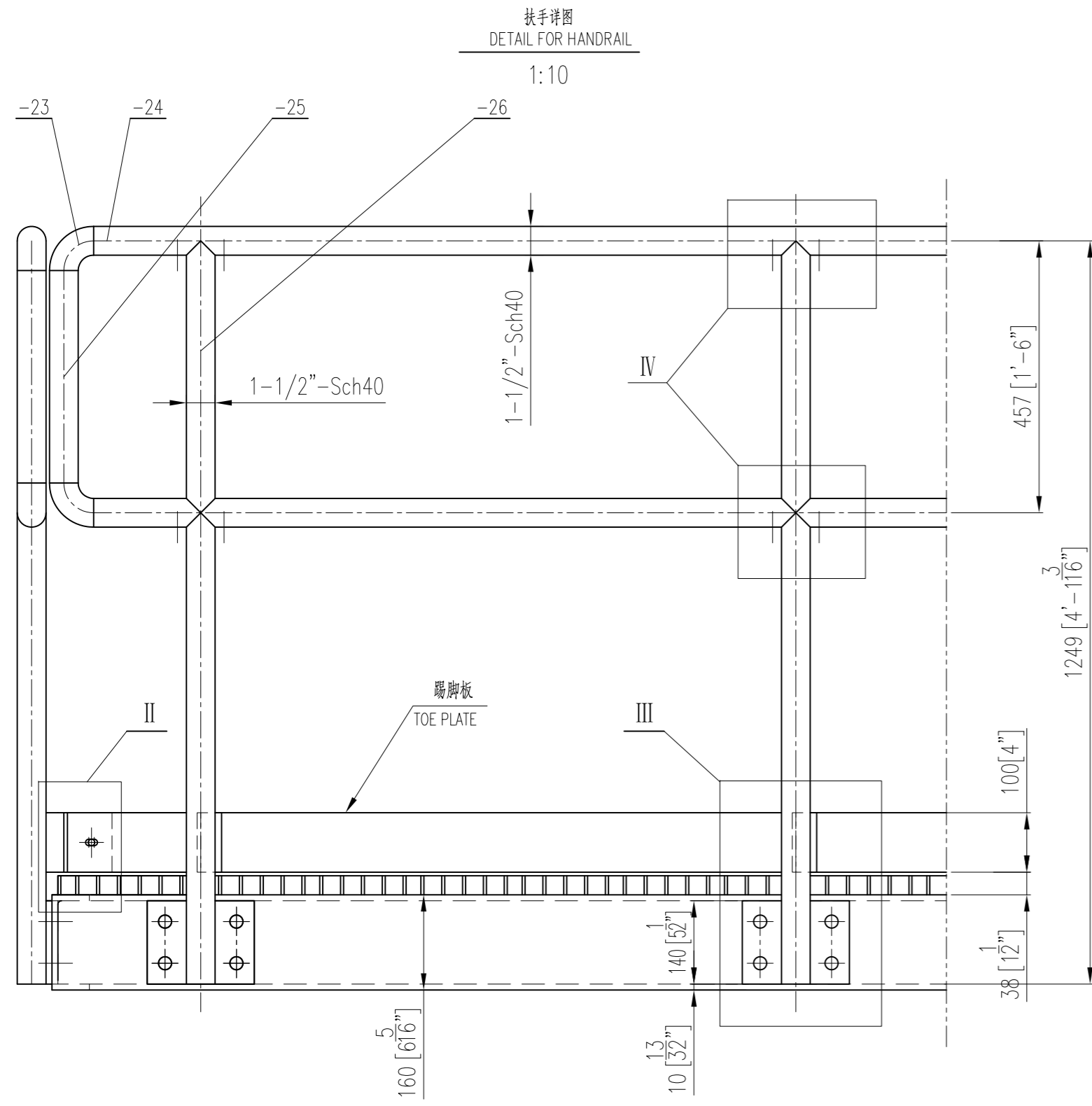
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REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
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03	2015-09-25	FOR APPROVAL	W.X.D	Y.W.T	F.Z
02	2015-09-07	FOR APPROVAL	W.X.D	Y.W.T	F.Z
01	2015-08-26	FOR APPROVAL	W.X.D	Y.W.T	F.Z

OWNER / DEVELOPER:

昆山市贝色特材装备有限公司 Kunshan Bexelle Special Equipment Co., Ltd		项目名称: PROJECT NAME: Mobile ACA Project	
Evonik Corporation Mobile, AL, USA		图号: DWG. NO. BSA15-303-07(2/4)	
Details for ACA Residue Storage Vessel		比例 SCALE: /	
图号 ITEM NO. V-4510	生产号 SERIAL NO. 15-A3176	图则 SHEET NO. 15	批准 APPROVED



管口表
NOZZLE TABLE

NOZZLE	NPS (")	DN (mm)	"D"值 VALUE	角度 Angle
S2	3"	80	ø220	0°
A10	2"	50	ø180	35°
V2	1-1/2"	40	ø155	55°
A4	1-1/2"	40	ø155	75°
V1	1-1/2"	40	ø155	90°
R1	4"	100	ø260	120°
A2	1-1/2"	40	ø155	150°
L3	3"	80	ø220	180°
N1	1"	25	ø140	210°
S1	2"	50	ø180	270°
L2	4"	100	ø260	300°
A5	1"	25	ø140	330°
P1	1"	25	ø140	设备中心线上 ON EQUIPMENT CENTER LINE

REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
05	2015-11-03	ISSUED FOR FABRICATION	W.X.D	Y.W.T	F.Z
04	2015-10-08	FOR APPROVAL	W.X.D	Y.W.T	F.Z
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02	2015-09-07	FOR APPROVAL	W.X.D	Y.W.T	F.Z
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OWNER / DEVELOPER:

Evonik Corporation
Mobile, AL, USA

Details for
ACA Residue Storage Vessel

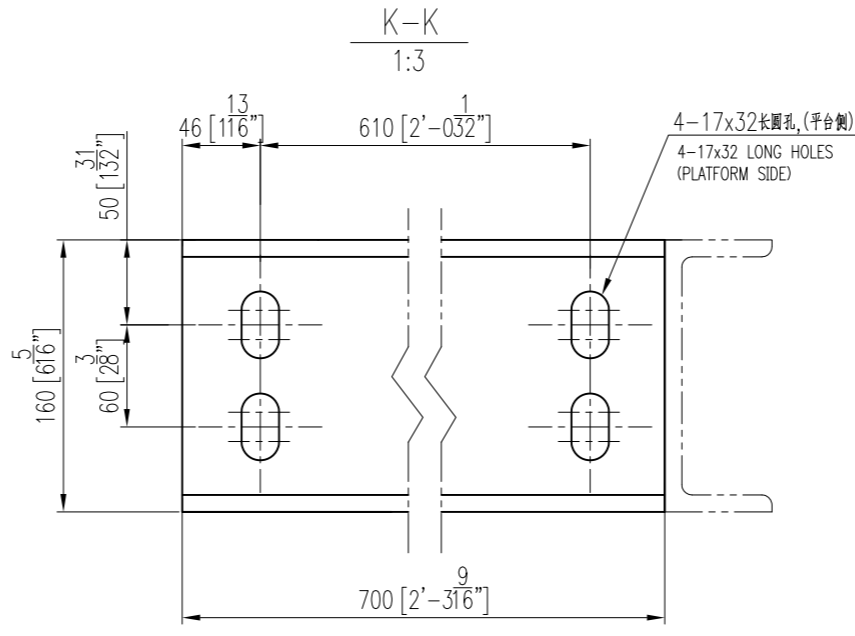
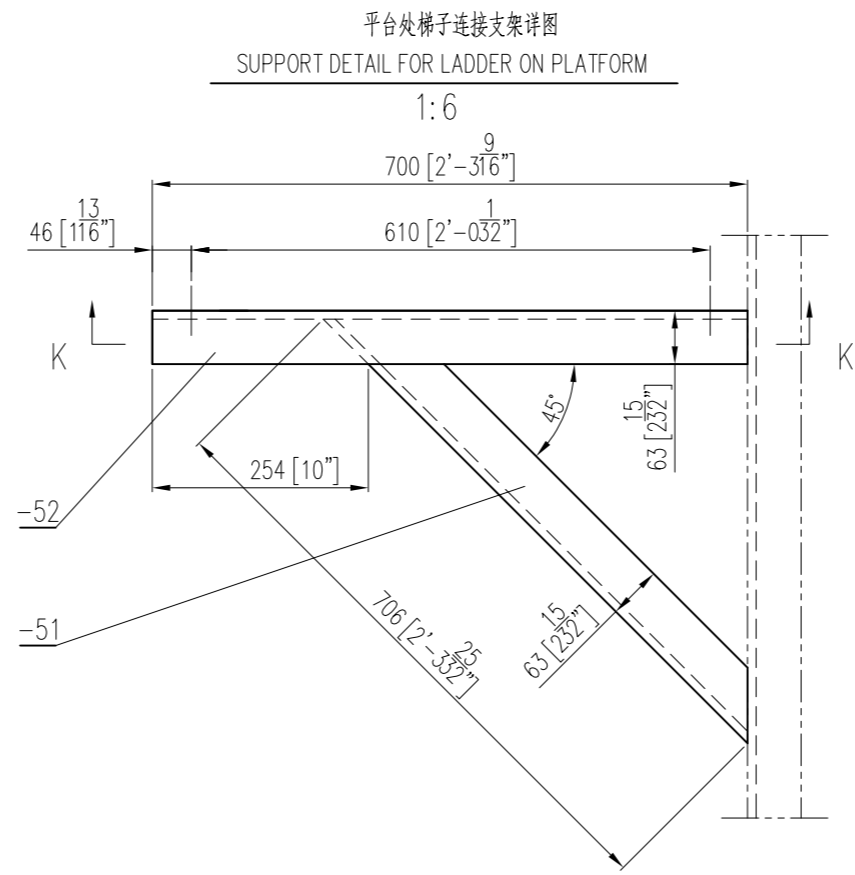
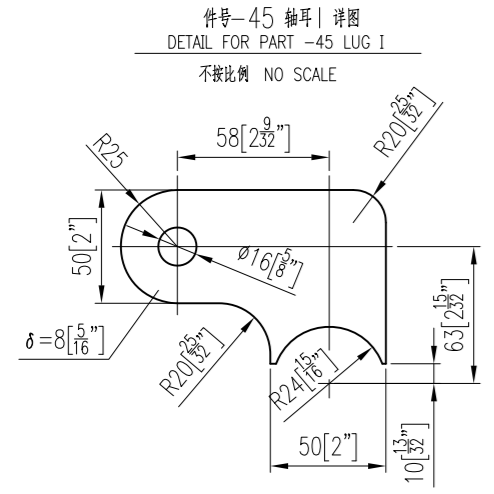
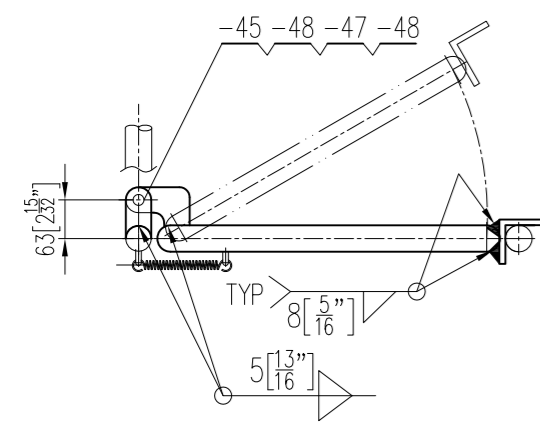
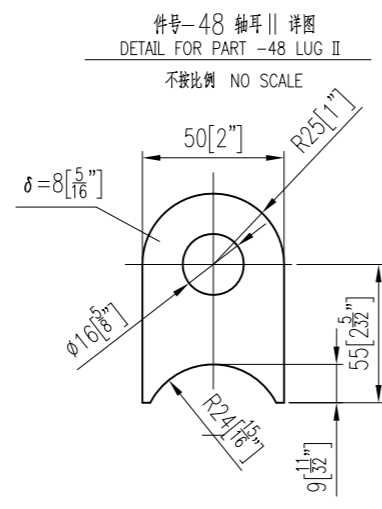
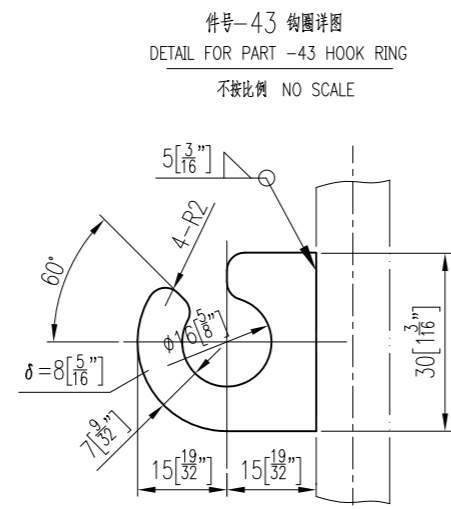
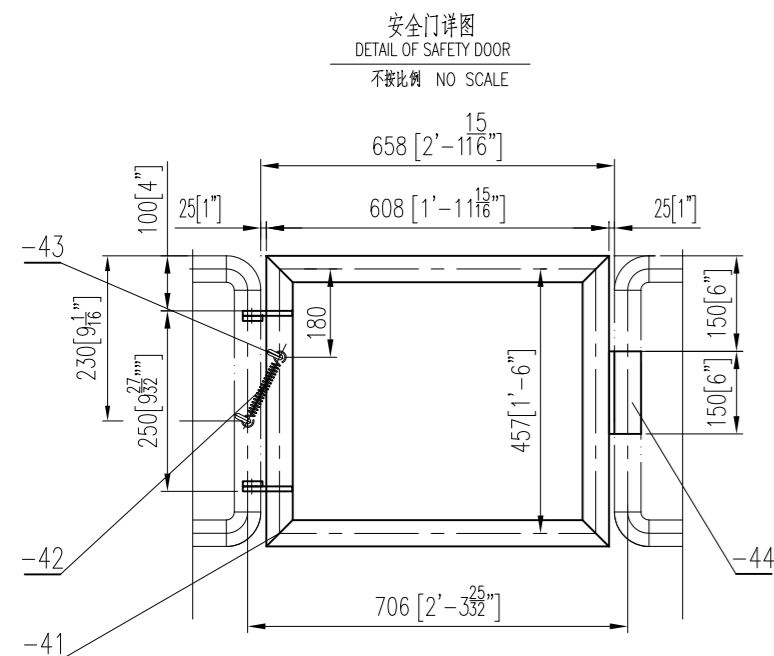
项目名称: Mobile ACA Project
PROJECT NAME:

昆山市贝色特材装备有限公司
Kunshan Bexcelle Special Equipment Co., Ltd

图号: 05
设计: W.X.D
审核: Y.W.T
批准: F.Z

标准号: BSA15-303-07(3/4)
比例: 1:4
图例: 第 12 页
共 13 页

图号: V-4510
生产号: 15-A3176



-52	槽钢料 [100X48X5.3 CHANNEL STEEL	1	Q235B	热浸镀锌	7	L=700
-51	槽钢料 [100X48X5.3 CHANNEL STEEL	1	Q235B	热浸镀锌	7.06	L=706
-50	槽钢料 [100X48X5.3 CHANNEL STEEL	8	Q235B	热浸镀锌	18.25	73 L=1825
-49	平台梯梯连接板-4, t=10 SWAY BRACE CONNECTION PLATE	4	Q235B	热浸镀锌	2.2	8.8
-48	梯耳 8t LADDER FRAME	2	Q235B	热浸镀锌	0.3	0.6
-47	螺栓 1/2"-13UNC	2	SA-194 2H	热浸镀锌	0.01	0.02
-46	螺栓 3/4"-10UNCx50 BOLTS	2	SA-193 B7	热浸镀锌	0.05	0.1
-45	梯耳 I 8t LADDER FRAME	2	Q235B	热浸镀锌	0.4	0.8
-44	梯板 L65X65X7X150L LADDER FRAME	1	Q235B	热浸镀锌	1	
-43	梯耳 8t LADDER FRAME	2	Q235B	热浸镀锌	0.1	0.2
-42	梯耳 L11 A 3.5x35x206 Ep LADDER FRAME	1	16Mn	冷镀锌	0.2	
-41	安全打眼 4x5 LADDER FRAME	1	20	热浸镀锌	12	
-40	螺栓 3/4"-10UNC	32	SA-194 2H	热浸镀锌		
-39	螺栓 3/4"-10UNCx50L BOLTS	32	SA-193 B7	热浸镀锌		
-38	平台梯板, t=10 CONNECTION PLATE	8	Q235B	热浸镀锌	4.5	36
-37	垫板 250x150x10 PAD	8	SA-240 316L	热浸镀锌	2.4	19.2
-36	肋板 t=10 RIB	8	Q235B	热浸镀锌	1.3	10.4
-35	连接角钢 L75x75x6, L=100 CONNECTION ANGLE STEEL	3	Q235B	热浸镀锌	0.7	2.1
-34	梯脚板 100x6 TISE PLATE	1set	Q235B	热浸镀锌	65	
-33	螺栓 3/8"-16UNC	23	SA-194 2H	热浸镀锌		
-32	螺栓 3/8"-16UNCx30L BOLTS	23	SA-193 B7	热浸镀锌		
-31	连接角钢 L30x40x6, L=100 CONNECTION ANGLE STEEL	16	Q235B	热浸镀锌	0.33	5.28
-30	连接板 180x140x10 CONNECTION PLATE	16	Q235B	热浸镀锌	2.0	32
-29	螺栓 5/8"-11UNC	64	SA-194 2H	热浸镀锌		

-28	ASME B18.2.1	螺栓 5/8"-11UNCx45L BOLTS	64	SA-193 B7	热浸镀锌			
-27		封板 41/815x4 COVER PLATE	16	Q235B	热浸镀锌	0.04	0.64	
-26		立柱 1-1/2"-Sch40 RAIL POST	16	20	热浸镀锌	4.96	79.36	L=1249
-25		立柱 1-1/2"-Sch40 RAIL POST	8	20	热浸镀锌	1.36	10.9	L=343
-24		扶手 1-1/2"-Sch40 HANDRAIL	4	根	热浸镀锌	109		L=27500
-23	ASME B16.9	梯架 250x120x10 SWAY BRACE CONNECTION PLATE	4	SA-240 316L	热浸镀锌	2.4	9.6	
-22		垫板 200x120x10 PAD	8	SA-240 316L	热浸镀锌	1.9	22.8	
-21		平台梯梯连接板-3, t=10 SWAY BRACE CONNECTION PLATE	4	Q235B	热浸镀锌	2.75	11.0	
-20		垫板 200x120x10 PAD	8	SA-240 316L	热浸镀锌	2.2	17.6	
-19	ASME B18.2.2	螺栓 3/4"-10UNC	48	SA-194 2H	热浸镀锌			
-18	ASME B18.2.1	螺栓 3/4"-10UNCx50L BOLTS	48	SA-193 B7	热浸镀锌			
-17		槽钢料 [100X48X5.3 CHANNEL STEEL	8	Q235B	热浸镀锌	8.44	67.52	L=844
-16		平台梯梯连接板-1, t=10 SWAY BRACE CONNECTION PLATE	8	Q235B	热浸镀锌	2.2	17.6	
-15		连接板-1 t=6 CONNECTION PLATE	1	Q235B	热浸镀锌	0.15		
-14		螺栓 5/8"-11UNC	4	SA-194 2H	热浸镀锌			
-13	ASME B18.2.2	螺栓 5/8"-11UNC	4	SA-194 2H	热浸镀锌			
-12	ASME B18.2.1	螺栓 5/8"-11UNCx45L BOLTS	4	SA-193 B7	热浸镀锌	1.25	2.5	
-11		连接板-1 160x100x10 CONNECTION PLATE	2	Q235B	热浸镀锌			
-10	DELETE							
-9	YB/T4001.1-2007	脚踏板, 镀锌 G325/30/50/SG GRATING	1	Q235B	热浸镀锌	714	3638x3638	
-8		槽钢料 [160X63X6.5 CHANNEL STEEL	1set	Q235B	热浸镀锌	630		L=36600
-7		水平护圈-3 FB 76x6 HORIZONTAL HOOP	1	Q235B	热浸镀锌	8.67		
-6		水平护圈-2 FB 50x6 HORIZONTAL HOOP	4	Q235B	热浸镀锌	4.47	17.88	
-5		垂直护圈 FB40x6 HORIZONTAL HOOP	7	Q235B	热浸镀锌	11	77	
-4		水平护圈-1 FB 76x6 HORIZONTAL HOOP	1	Q235B	热浸镀锌	8.64		
-3		螺栓 25, L=477 RING	29	Q235B	热浸镀锌	1.84	53.3	
-2		槽钢料主料 [80x43x5, L=857.3 CHANNEL LADDER FRAME	2set	Q235B	热浸镀锌	70.6	141.2	
-1		连接板-2 100x100x10 BASE CONNECTION PLATE	2	Q235B	热浸镀锌	0.79	1.58	

序号	图号及标准号	名称	数量	材料	重量	备注		
11	梯子平台 LADDER & PLATFORM	组合件 COMPONENT	1:18	2136	BSA15-303-07	BSA15-303-00(1/3)		
序号	名称	材料	比例	数量	重量 (Kg)	所在图号	装配图号	
05	2015-11-03	ISSUED FOR FABRICATION				W.X.D	Y.W.T	F.Z
04	2015-10-08	FOR APPROVAL				W.X.D	Y.W.T	F.Z
03	2015-09-25	FOR APPROVAL				W.X.D	Y.W.T	F.Z
02	2015-09-07	FOR APPROVAL				W.X.D	Y.W.T	F.Z
01	2015-08-26	FOR APPROVAL				W.X.D	Y.W.T	F.Z
REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.			

OWNER / DEVELOPER:

昆山市色特材装备有限公司
Kunshan Bexcelle Special Equipment Co., Ltd

项目名称: Mobile ACA Project

Evonik Corporation
Mobile, AL, USA

Details for
ACA Residue Storage Vessel

图号: V-4510
生产号: 15-A3176

图章: 05
图号: BSA15-303-07(4/4)
比例: /
图章: 第 13 页
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