

符号	数量	尺寸	管表号	连接法兰标准及密封面形式	用途或名称	外伸长度 (法兰密封面至设备外表面) PROJ. FROM FLANGE FACE TO VESSEL OUTSIDE
A1	1	10"	Sch40S	ASME B16.5-2009 150# WNRF.	Tank Farm Emergency Vent	见 DWG.
A3	1	2"	Sch40S	ASME B16.5-2009 150# WNRF.	Proc. Structure Emergency Vent	见 DWG.
A4	1	10"	Sch40S	ASME B16.5-2009 150# WNRF.	Emergency Vent From Collection Header	见 DWG.
V1	1	2"	Sch40S	ASME B16.5-2009 150# WNRF.	Vent-Off Gas	见 DWG.
D1	1	2"	Sch40S	ASME B16.5-2009 150# WNRF.	Drain	见 DWG.
L1	1	2"	Sch40S	ASME B16.5-2009 150# WNRF.	Level Indication-Bottom Connection	见 DWG.
L2	1	2"	Sch40S	ASME B16.5-2009 150# WNRF.	Level Indication-Top Connection	见 DWG.
L3	1	3"	Sch40S	ASME B16.5-2009 150# WNRF.	Level Transmitter W/ Stilling Well	见 DWG.
L4	1	3"	Sch40S	ASME B16.5-2009 150# WNRF.	Level Switch-High W/ Stilling Well	见 DWG.
L5	1	4"	Sch40S	ASME B16.5-2009 150# WNRF.	Connection For L3	见 DWG.
M1	1	24"	S=10	ASME B16.5-2009 150# WNRF.	Manway W/ Davit Arm	见 DWG.
M2	1	24"	S=10	ASME B16.5-2009 150# WNRF.	Manway W/ Davit Arm	见 DWG.
N1	1	1-1/2"	Sch40S	ASME B16.5-2009 150# WNRF.	Nitrogen Inlet	见 DWG.
P1	1	1"	Sch40S	ASME B16.5-2009 150# WNRF.	Pressure Transmitter	见 DWG.
R1	1	10"	Sch40S	ASME B16.5-2009 150# WNRF.	Emergency Pressure Relief-Emergency Vent Case	见 DWG.
R2	1	3"	Sch40S	ASME B16.5-2009 150# WNRF.	Emergency Pressure Relief-N2 Failure Case	见 DWG.
S1	1	3"	Sch40S	ASME B16.5-2009 150# WNRF.	Spare W/Blind	见 DWG.
S2	1	2"	Sch40S	ASME B16.5-2009 150# WNRF.	Spare W/Blind	见 DWG.
T1	1	1 1/2"	Sch40S	ASME B16.5-2009 150# WNRF.	Temperature Transmitter	见 DWG.

设计数据与制造技术条件表 DESIGN DATA AND MANUFACTURE SPECIFICATIONS			
设计/制造/检验/验收规范 CODE FOR DESIGN/MANUFACTURE AND ACC.	ASME SEC.III-DIV.1, 2013		
设计压力 Bar(g)/Psi(g) DESIGN PRESSURE	3.1/-1.013 45/-14.7	ASME 认证标志 ASME CERTIFICATION MARK	U Stamp
最大允许工作压力 Bar(g)/Psi(g) MAWP	3.1/-1.013 45/-14.7	NB 注册 NB REGISTRATION	YES
操作压力 Bar(g)/Psi(g) OPERATION PRESSURE	0.17 / 2.5	壳体 SHELL	SA-240 316L
设计温度 (max./min.) °C/°F DESIGN TEMP.	250 / -28.9 482 / -20	封头 HEAD	SA-240 316L
操作温度 °C/°F OPERATION TEMP.	25/76.99	管法兰/法兰盖 PIPE FLANGE/B.L.	SA-182 F316L
最低设计金属温度 °C/°F M.D.M.T.	-28.9/-20	地脚螺栓 ANCHOR BOLTS	
物料名称 FLUID	Proc.Vapor	ASME 设计规范 WIND DESIGN CODE	IBC-2009
介质特性 FLUID PROPERTY	非易燃 NONLETHAL	地震设计规范 SEISMIC DESIGN CODE	IBC-2009
介质密度 Kg/m³/lb/ft³ FLUID DENSITY	1025/64	安全阀整定压力 barg/Psi(g) OPEN. PRESS. OF RD.	N.A.
腐蚀裕量 mm/inch CORR. ALLOWANCE	0/0	换热面积 HEATING SURFACE	N.A.
焊缝系数 JOINTS EFF.	0.85/1.0	保温材料 MATERIAL OF INSULATION	V
水压试验压力 Bar(g)/Psi(g) HYDRO. TEST PRESSURE	4.5 / 65.25	保温厚度 mm/inch THICKNESS OF INSULATION	50.8 / 2
气密性试验压力 Bar(g)/Psi(g) PNEUMATIC TEST PRESSURE	/	搅拌器型式 AGITATOR TYPE	N.A.
材料应力光谱分析 FEM	YES	搅拌器转速 AGITATOR SPEED	N.A.
公称容积 m³/gal NOMINAL VOLUME	5.0/1321	电机功率 (KW) / 马力 B.H.P./ENCLOSURE TYPE	N.A.
总容积 m³/Gal TOTAL VOLUME	43.01/11359.5	搅拌器重量 WEIGHT OF AGITATOR	N.A.
壳体容积 m³/Gal SHELL VOLUME	35.59/9400.9	设备净重 DRY WT.	10081/22224
封头容积 m³/Gal 2:1 ELLIPTICAL VOLUME	3.71/979.3	充水重 FULL OF WATER WT.	53061/116978
设计等级 DESIGN LEVEL	/	操作重 OPERATING WT.	54135/119347
A,B 类焊缝 SHELL/HEAD SEAM	射线检测 RT	其中不锈钢(g/lb) INCLUDE: S.S	/
C,D 类焊缝 NOZZLE/ANCHOR BOLTS	磁粉检测 MT	保温层重量 INSULATION WT.	/
热处理要求 HEAT TREATMENT (S.R.)	N.A.	冲击试验 IMPACT REQUIREMENT	EXEMPTED

总的说明 GENERAL SPECIFICATION			
焊接材料 WELDING MATERIAL	详见 WPS	按照 WPS	ACCORDING TO WPS
焊接型式 TYPE OF WELDING	所有焊接按焊接工艺,由制造厂提供工艺评定后确定。 ALL WELDING SHALL BE PROVIDED BY MANUFACTURER ACCORDING TO WPS AND PQR.		
焊接规范 W.P.S.	详见 WPS/PQR	按照 WPS/PQR	ACCORDING TO WPS/PQR
公差 TOLERANCES	客户规范 TS 25-0108	TS 25-0108	
焊接要求 WELD SPEC.	A,B,C,D 类焊缝必须全焊透。 JOINTS OF CATEGORY A,B & C,D SHALL BE FULL PENETRATION.		
其它要求 OTHERS			

序号	图号及标准号	名称	数量	材料	重量	备注
7	BSA15-306-01	壳盖加宽圈 SHROUDING RING	2	SA-240 316L	313	616
6	BSA15-306-00(2/3)	铭牌 NAMEPLATE	2	SA-240 304	0.2	0.4
5	BSA15-306-01	螺母 NUT	2	SA-240 316L	441	882
4	BSA15-306-04	螺母及垫圈 NUT AND WASHER	1	SA-240 316L	8.73	
3	BSA15-306-01	螺母 NUT	1	SA-240 316L	3655	L=4797
2	BSA15-306-01	螺母 NUT	4	SA-240 316L	26	104
1	BSA15-306-01	螺母 NUT	2	SA-240 316L	972	1944

OWNER / DEVELOPER:

Evonik Corporation
Mobile, AL, USA

General arrangement for
Emergency Relief System Knock-Out Tank

项目名称: Mobile ACA Project

图号: 04

设计: []

校核: []

审核: []

批准: []

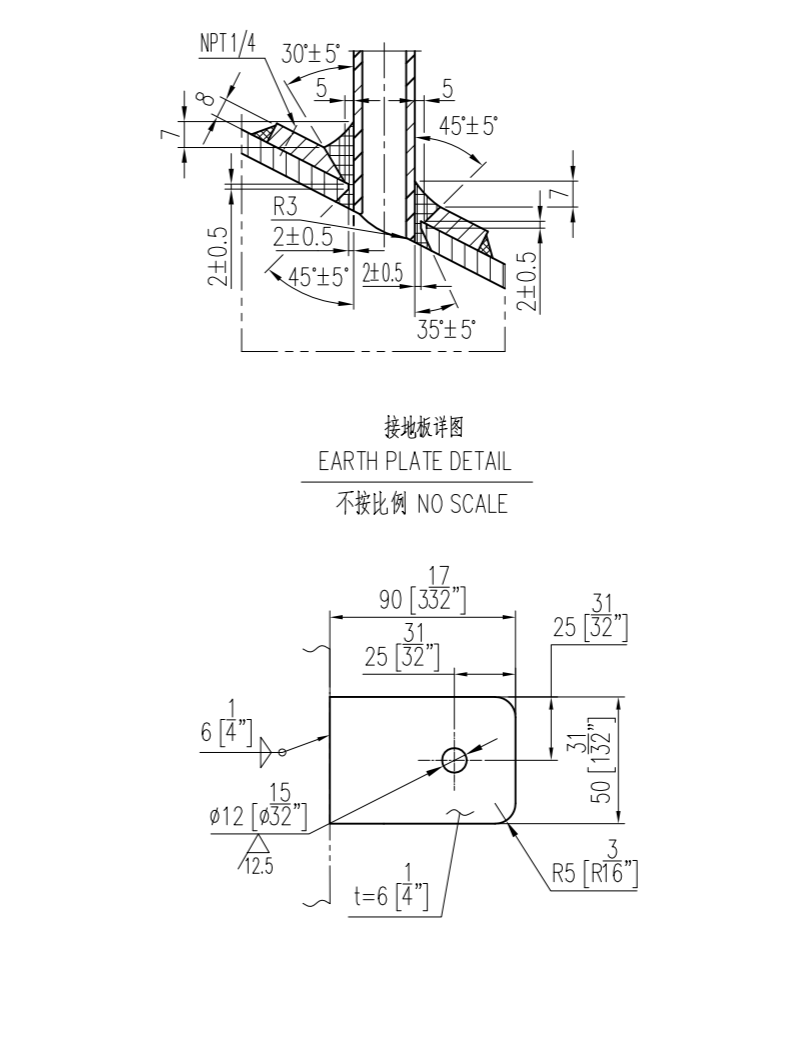
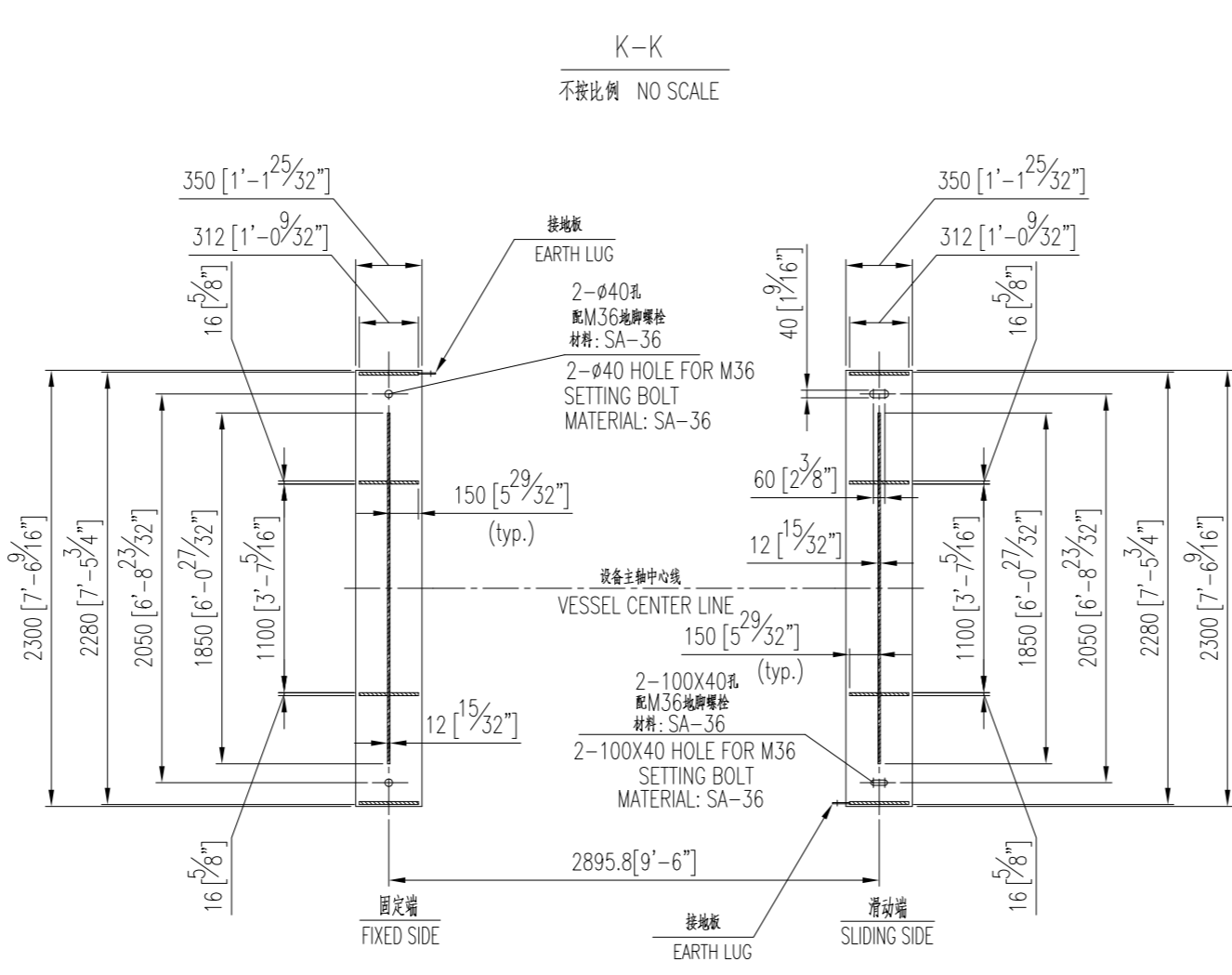
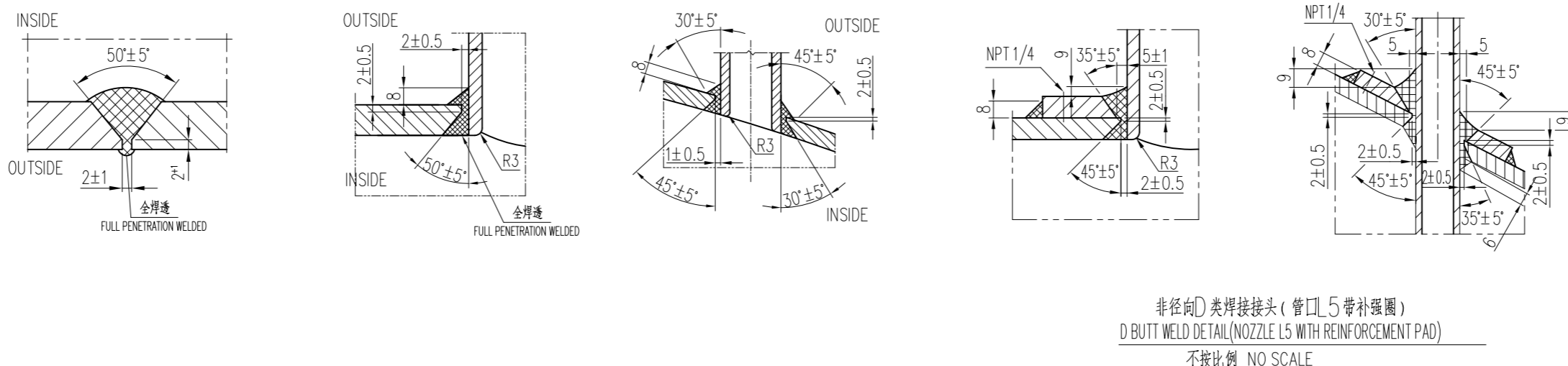
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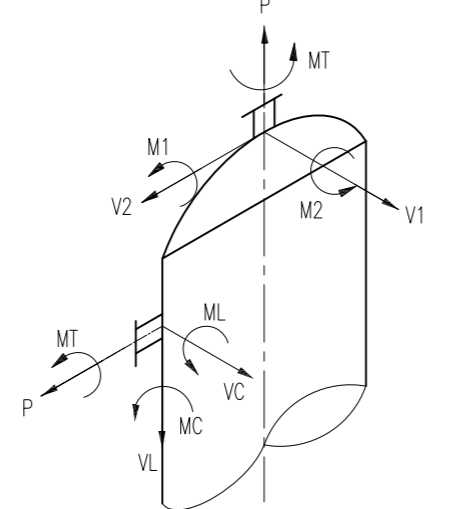


- 技术要求: TECHNICAL REQUIREMENTS:
- 本设备的设计, 制造, 检验及验收按ASME Sec. VIII Division 1要求, 还应满足下列规范及标准的相关要求: 20.230.013; 20.230.030; 20.230.036. THE DESIGN, FABRICATION, TESTING, INSPECTION AND ACCEPTANCE FOR THIS EQUIPMENT SHOULD CONFORM TO ASME SEC. VIII DIVISION 1 CODE, AND APPLICABLE DIN STANDARDS, AND SPECIFICATION AS FOLLOWING: 20.230.013; 20.230.030; 20.230.036.
 - 所有不锈钢材料, 包括板材, 接管, 法兰及焊缝按API 1104进行 PMI 检测。PMI INSPECTION SHALL BE DONE FOR THE MATERIAL OF STAINLESS STEEL, WHICH INCLUDES PLATE, NOZZLES, FLANGE AND WELDING SEAM.
 - 所有受压元件的焊接按WPS, 并按WPS。
 - 焊接材料由设计提供并经过工艺评定后确定。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, 与壳体相焊接的接管角应打磨磨圆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布置。BOLT HOLES SHALL STRADDLE THE NATURE CENTRE LINES.
 - ASME B16.5-2009 法兰密封面圆度为 R_a \sim R_z . THE R_a SHALL BE 3.2-6.3 MICRO METERS FOR ALL ASME B16.5-2009 FLANGES.
 - 补强圈最低点应设NPT 1/4 泄孔, 补强圈在设备水压试验前, 以1barg 表压压缩空气进行泄孔水压试验, 合格后, 试验孔用NPT 1/4 螺栓堵塞。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.
 - 吊耳板与吊耳接管, 法兰及接管与筒体的焊接接头按100% PT 检测, 符合ASME VIII-1 附录B 中规定。具体要求按第 V 章第 8 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 B). ARTICLE 6 OF SECTION V SHALL BE APPLIED FOR DETAIL REQUIREMENTS.
 - 耳座与法兰及接管与筒体的焊接接头按100% PT 检测, 符合ASME VIII-1 附录B 中规定。具体要求按第 V 章第 8 章。THE WELDS BETWEEN BRACKETS AND SHELL, PAD AND BRACKETS SHALL BE EXAMINED BY 100% PT. MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX B). ARTICLE 6 OF SECTION V SHALL BE APPLIED FOR DETAIL REQUIREMENTS.
 - 水压试验时, 应用于干净的水, 且氯离子的含量不超过 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纸。ORIGINAL WORK GASKETS TO BE USED FOR TESTING.
 - 设备组装完成后, 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酸洗钝化, 钝化所形成的钝化膜用蓝点法检验, 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 PASSIVATED SURFACE SHALL BE EXAMINED USING BLUE-POINTING PENETRATION METHOD, NO BLUE-POINT TO BE ACCEPTED.
 - 设备上法兰用垫片为: 缠绕垫 内外环316SS, 橡胶物石墨, 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
 - 吊耳板用设备空重。LIFTING LUG ONLY FOR VESSEL EMPTY WEIGHT.
 - 接地板表面不得涂油漆, 接地电阻值不大于10 Ω . EARTH LUG SHALL NOT BE PAINTED, AND RESISTANCE OF THE EARTH WIRE SHALL NOT EXCEED 10 Ω .
 - 设备应提供: 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纵、环焊缝上。LONGITUDINAL AND CIRCUMFERENTIAL WELD SEAMS SHALL NOT INTERFERE WITH NOZZLE OPENING, REINFORCING PLATE ETC.
 - 板卷接管的对接焊缝按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.
 - 设备要求海运包装并充N2 氮气保护。SEAWORTHY PACKAGING WITH N2 FILLING (0.2BARC)
 - 本设备碳钢管部分的油漆表面处理按涂装工程规范: 20-230-032 Painting of Equipment-REV 1 的有关要求执行。THE CARBON STEEL SURFACE PREPARATION AND PAINTING ACCORDING TO 20-230-032 Painting of Equipment-REV 1.



管口载荷表
NOZZLE LOADING TABLE

NOZZLE	NPS (")	DN (mm)	N			N.m		
			P	VL	VC	MT	ML	MC
				V1	V2		M1	M2
A3, D1, L1, L2, S2, V1	2"	50	2300	3100	2300	800	500	400
L4, R2, S1	3"	80	3500	4100	3000	1800	1400	900
L5	4"	100	4300	4800	3500	2600	2100	1400
A1, A4, R1	10"	250	12600	12200	8000	10200	9100	6100



REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
04	2015-11-03	ISSUED FOR FABRICATION		W.X.D	Y.W.T
03	2015-09-25	FOR APPROVAL		W.X.D	Y.W.T
02	2015-09-07	FOR APPROVAL		W.X.D	F.Z
01	2015-08-21	FOR APPROVAL		W.X.D	Y.W.T
00	2015-05-15	FOR APPROVAL		W.X.D	Y.W.T

OWNER / DEVELOPER:	PROJECT NAME:	ISSUED FOR:	SCALE:
昆山特色器材装备有限公司 Kunshan Bexcelle Special Equipment Co., Ltd	Mobile ACA Project	FOR APPROVAL	1:1

NO.	DESCRIPTION	REV.	DATE	BY	CHK.	APPR.
04	04					



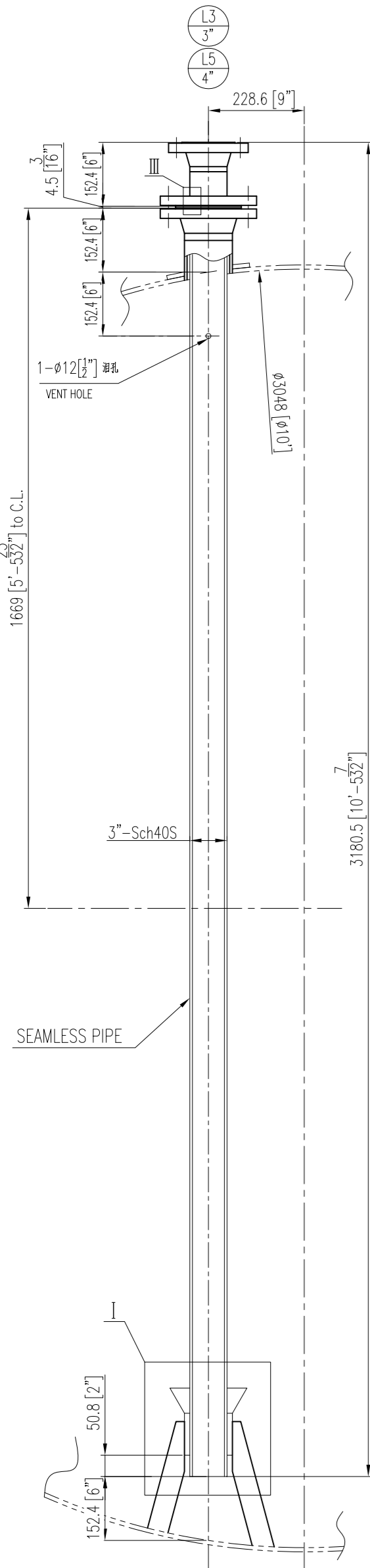
Evonik Corporation
Mobile, AL, USA

General arrangement for
Emergency Relief System Knock-Out Tank

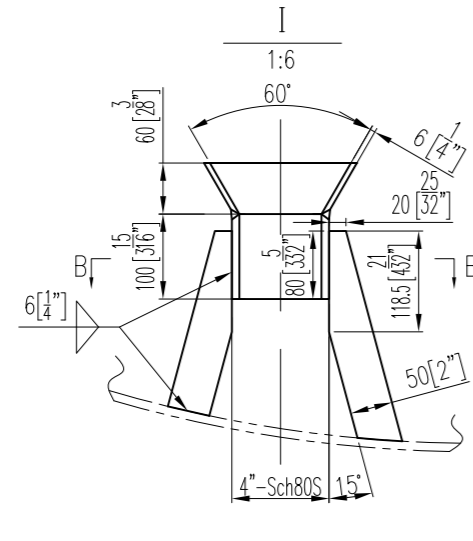
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图名: BSA15-306-00(2/3)
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批准: [Signature]



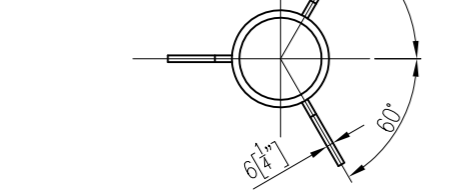
管口 L3, L5 详图
DETAIL OF NOZZLE L3, L5
1:8



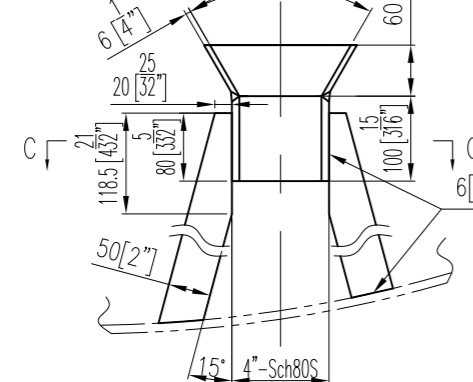
管口 L4 详图
DETAIL OF NOZZLE L4
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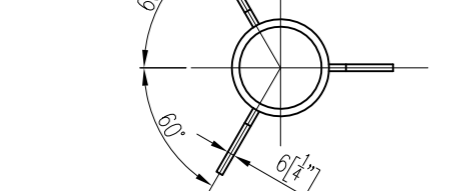
B-B
1:6



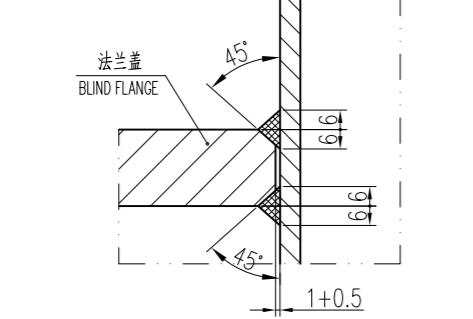
II
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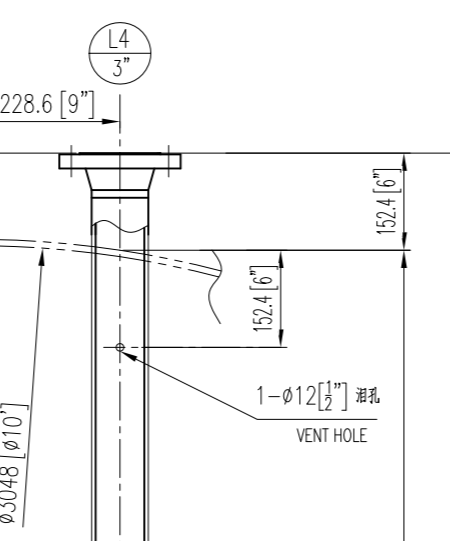
C-C
1:6



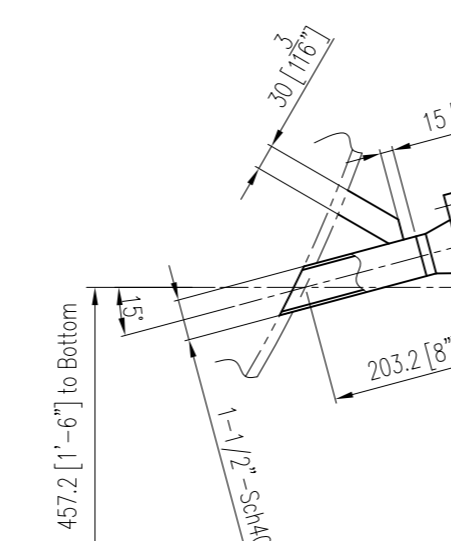
III
不按比例 NO SCALE



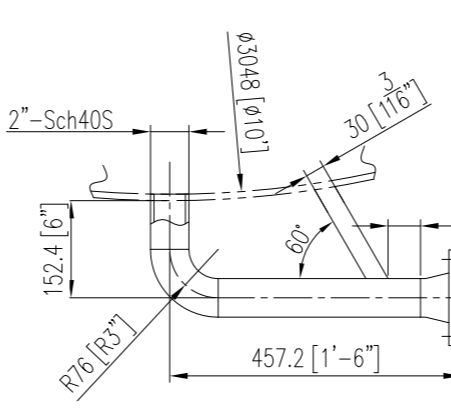
管口 T1 详图
DETAIL OF NOZZLE T1
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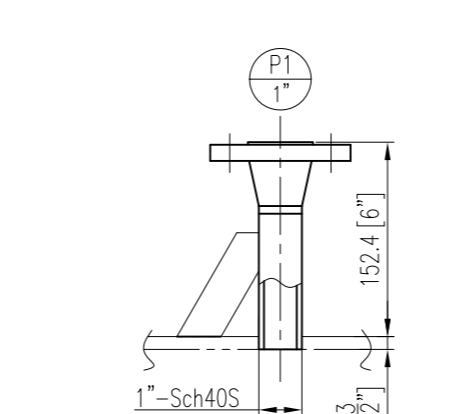
管口 T1 详图
DETAIL OF NOZZLE T1
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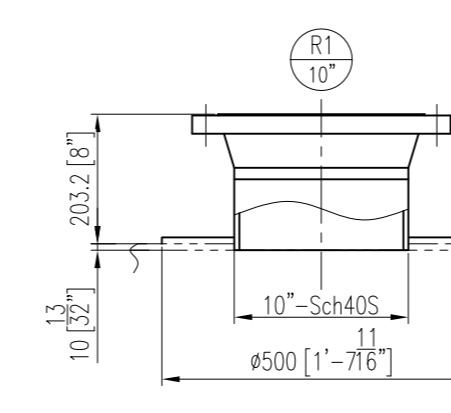
管口 D1 详图
DETAIL OF NOZZLE D1
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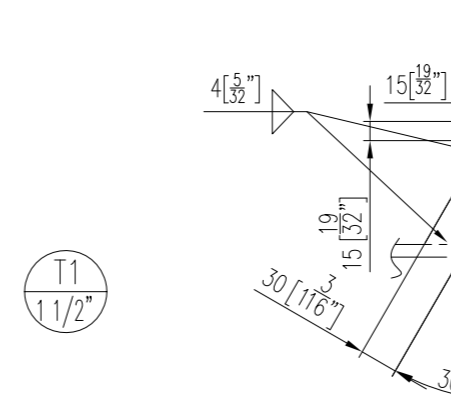
管口 P1 详图
DETAIL OF NOZZLE P1
1:4



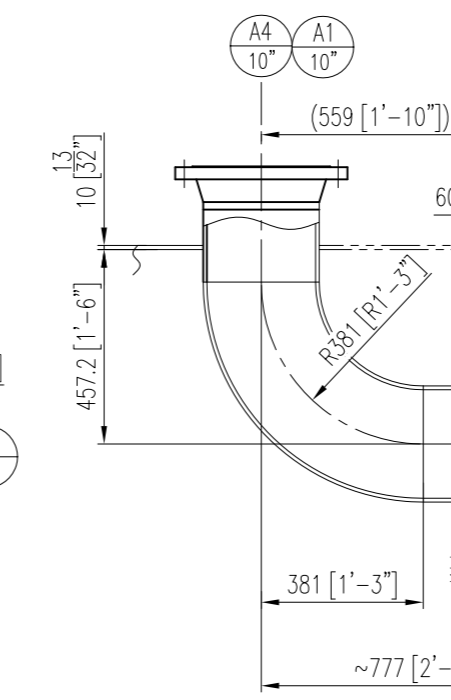
管口 R1 详图
DETAIL OF NOZZLE R1
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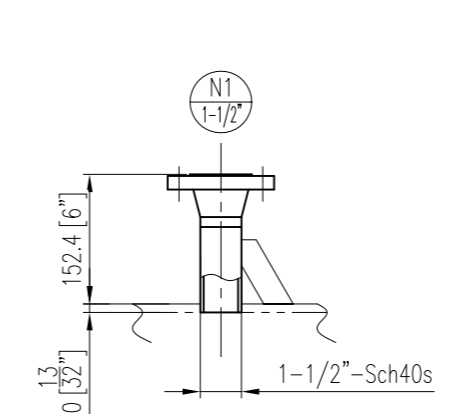
管口 N1, P1, T1, D1, V1 隔板详图
DETAIL OF NOZ. N1, P1, T1, D1, V1 RIB PLATE
不按比例 NO SCALE



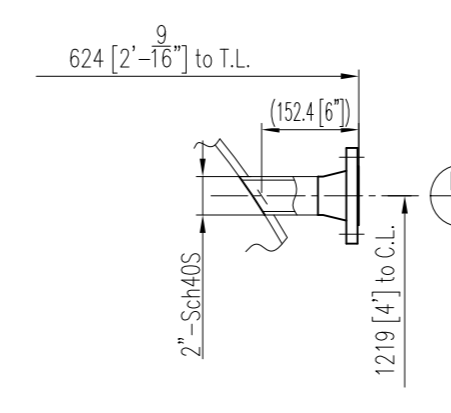
管口 A1, A4 详图
REINFORCEMENT PAD DETAIL OF NOZZLE A1, A4
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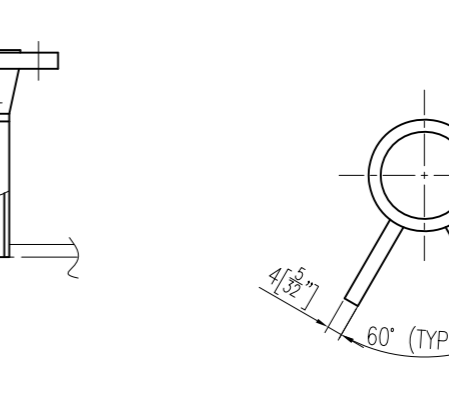
管口 N1 详图
DETAIL OF NOZZLE N1
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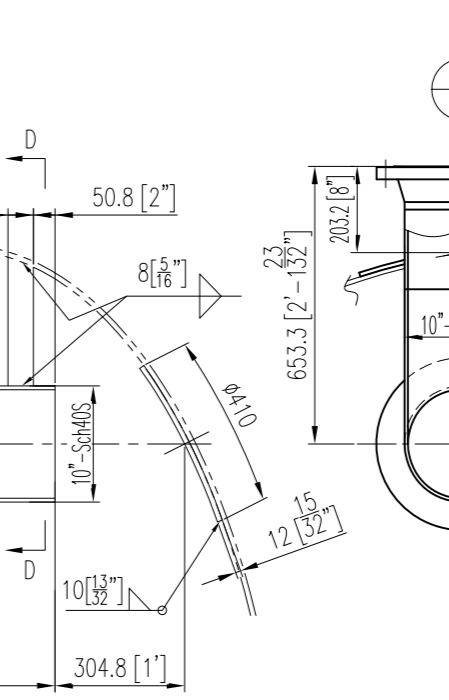
管口 L2 详图
DETAIL OF NOZZLE L2
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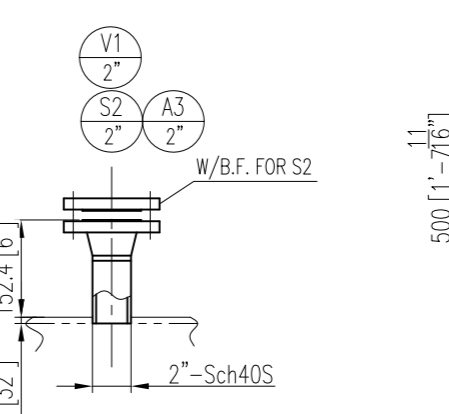
管口配两根筋板布置详图
ORIENTATION DETAIL OF 2 RIB PLATE FOR NOZZLE
不按比例 NO SCALE



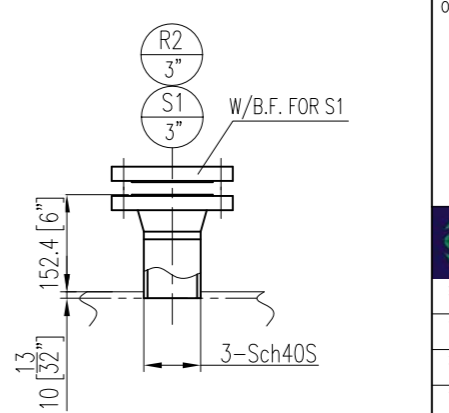
管口 A1, A4 详图
REINFORCEMENT PAD DETAIL OF NOZZLE A1, A4
1:12



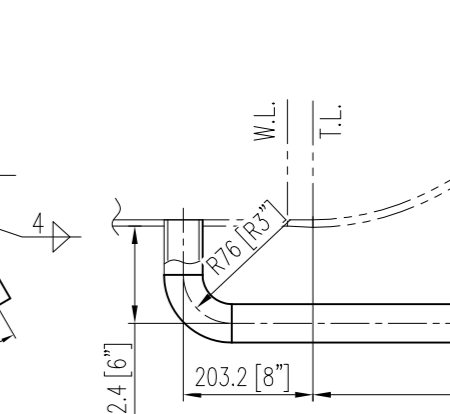
管口 A3, S1, V1 详图
DETAIL OF NOZZLE A3, S1, V1
1:8



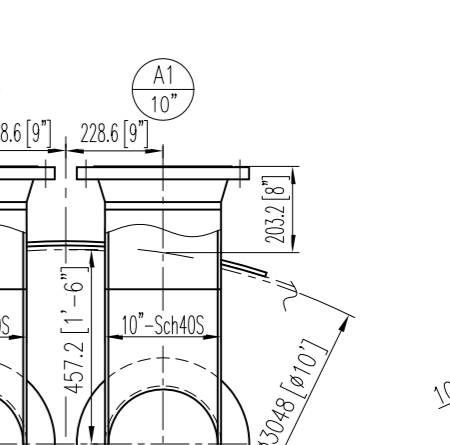
管口 R2, S1 详图
DETAIL OF NOZZLE R2, S1
1:8



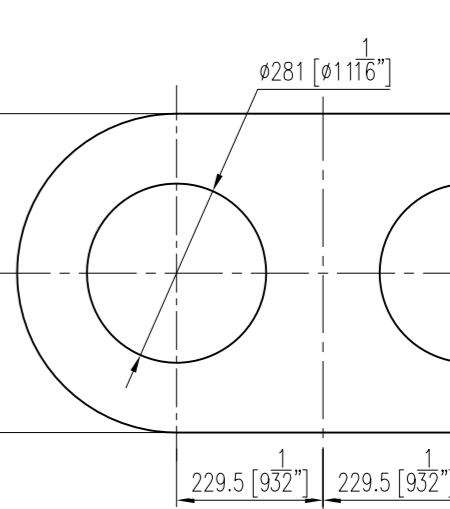
管口 L1 详图
DETAIL OF NOZZLE L1
1:8



D-D
1:8



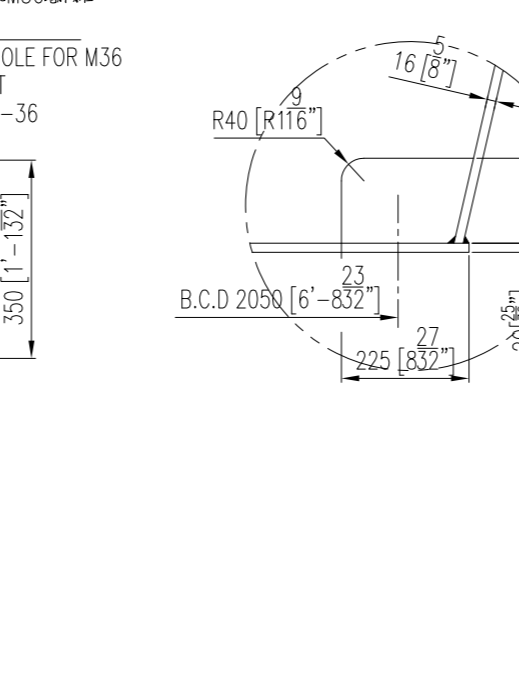
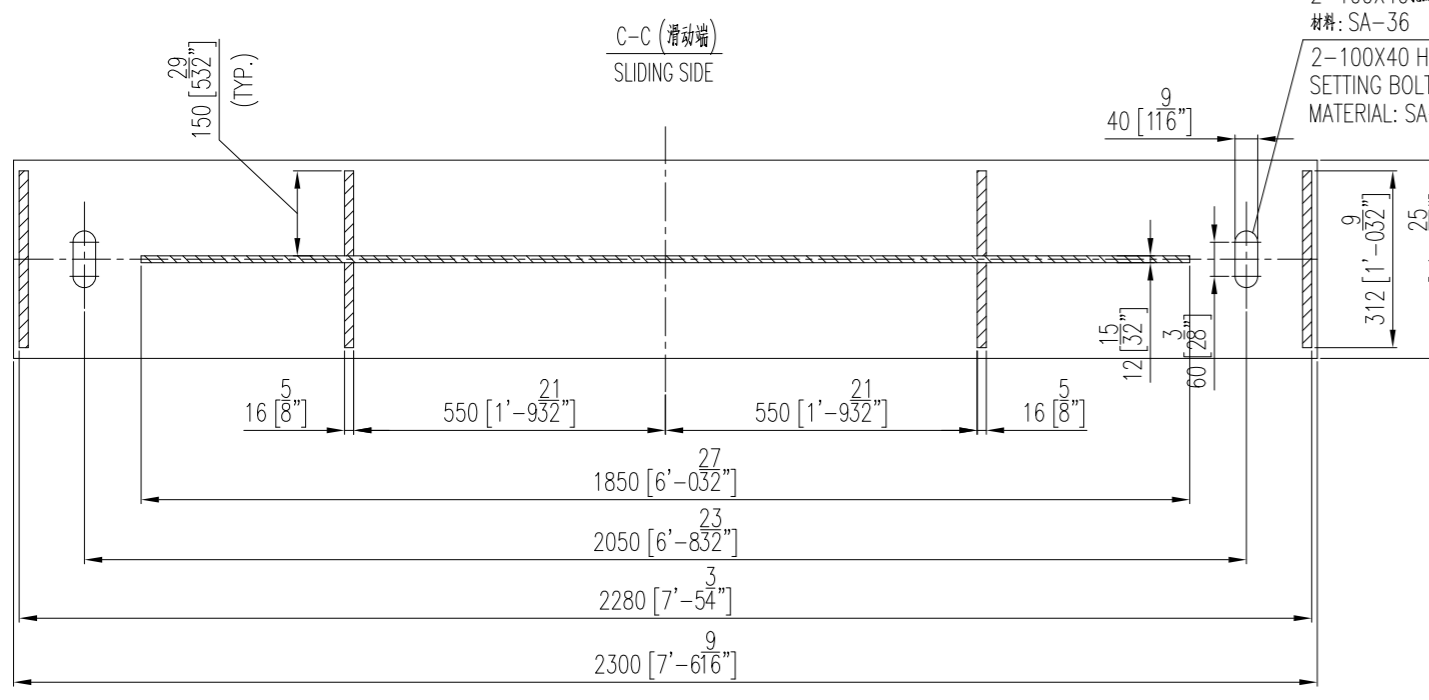
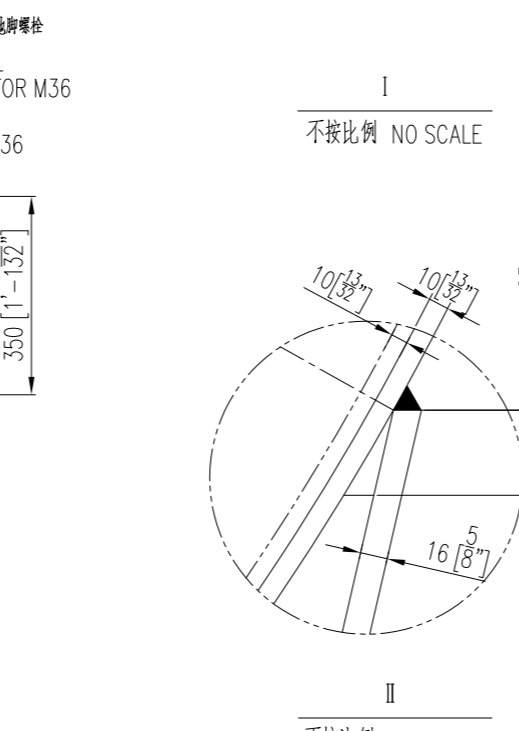
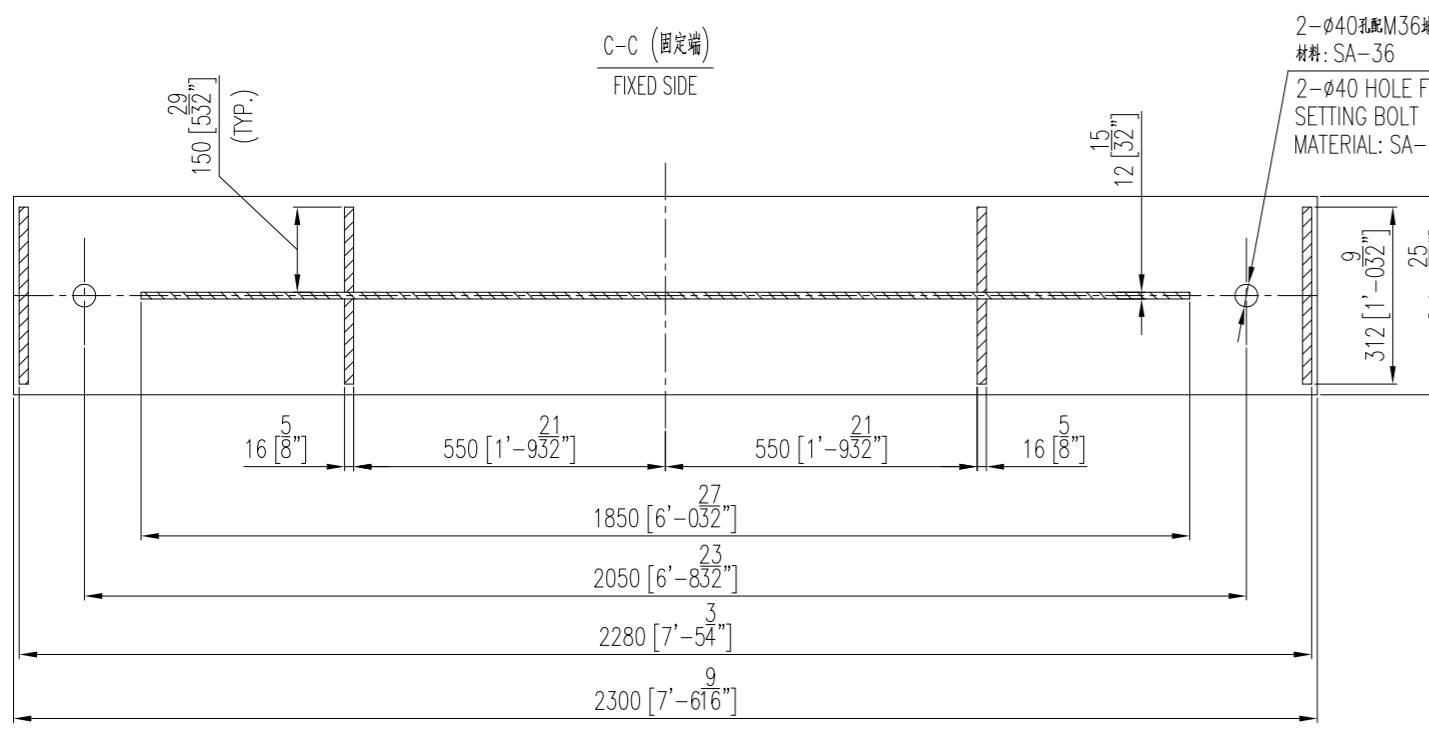
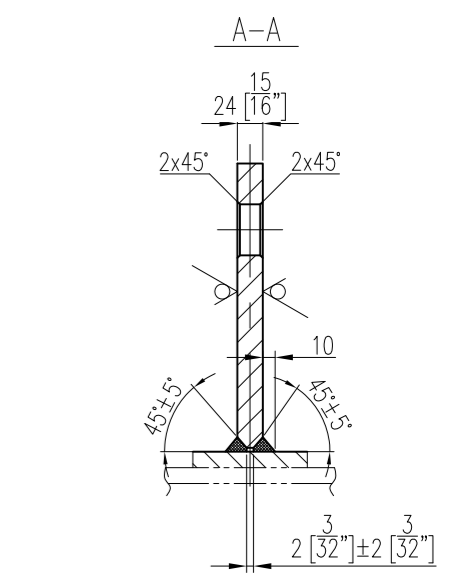
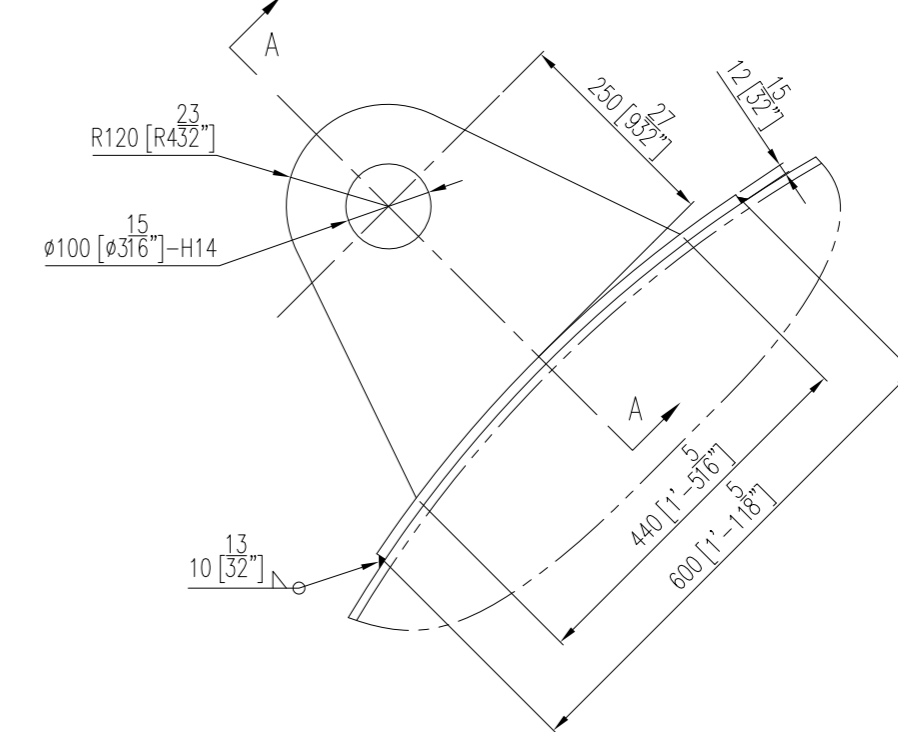
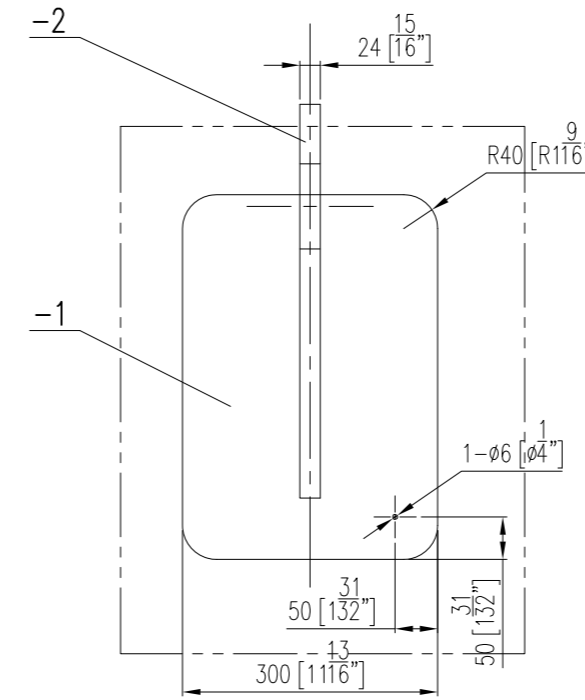
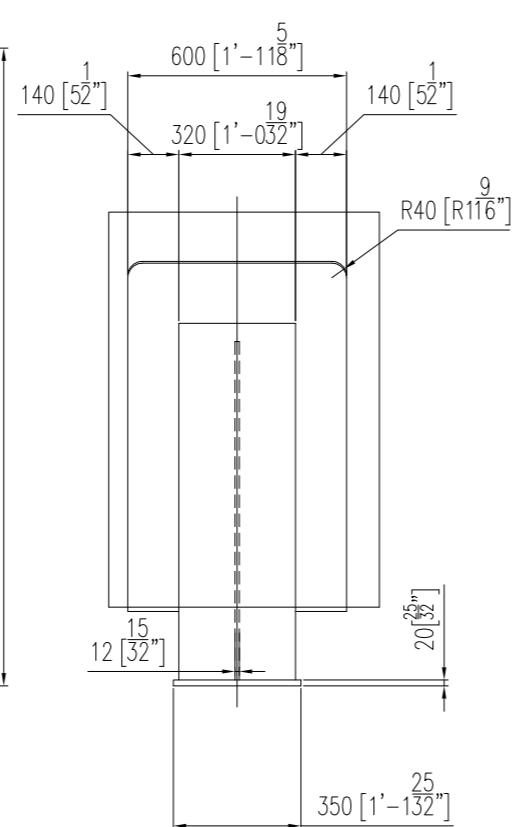
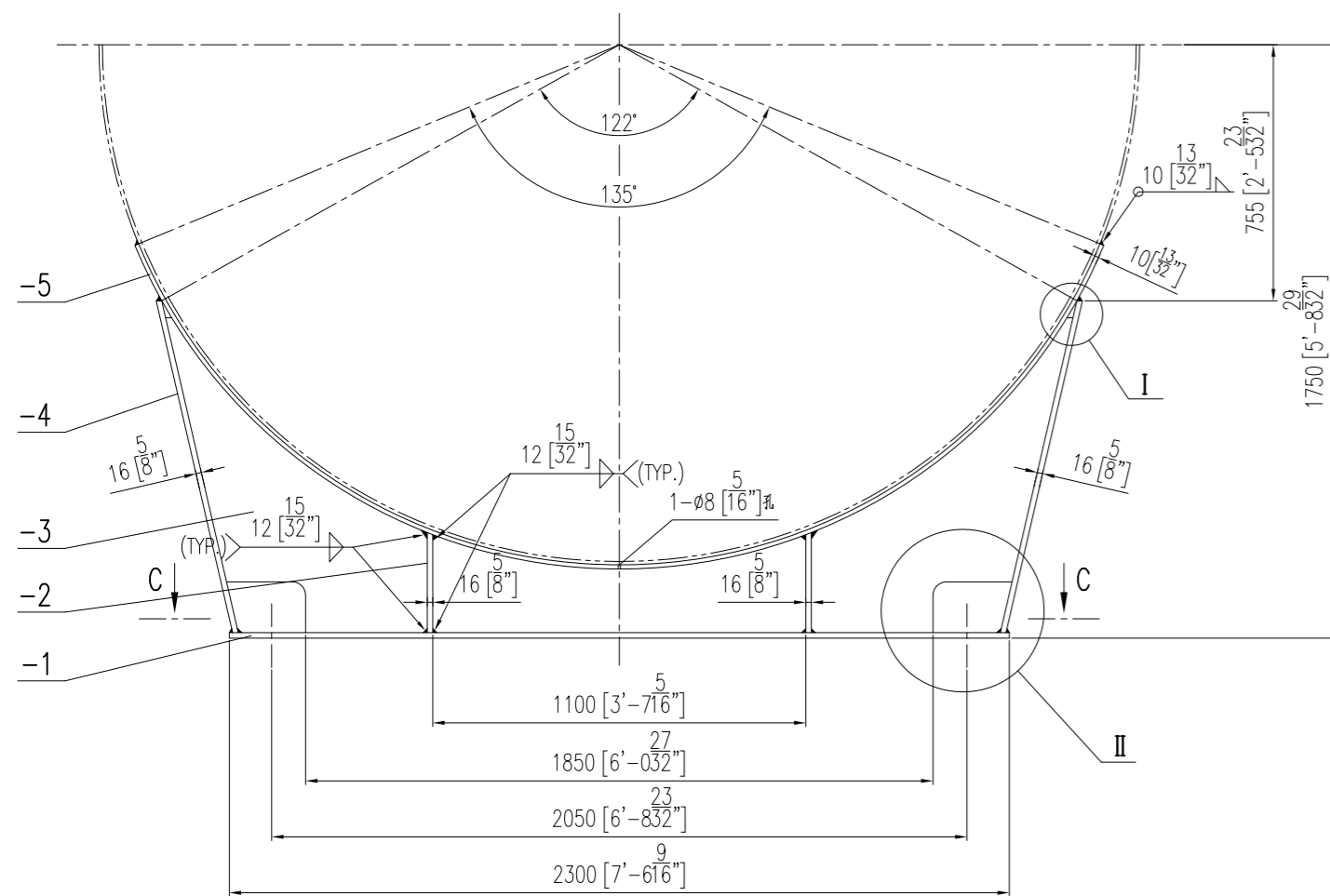
管口 A1, A4 补强圈详图
DETAIL OF NOZZLE A1, A4
1:8



REV	DATE	DESCRIPTION	DRAWN	CHK.	APPR.
04	2015-11-03	ISSUED FOR FABRICATION	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	2015-08-21	FOR APPROVAL	W.X.D	Y.W.T	F.Z
00	2015-05-15	FOR APPROVAL	W.X.D	Y.W.T	F.Z

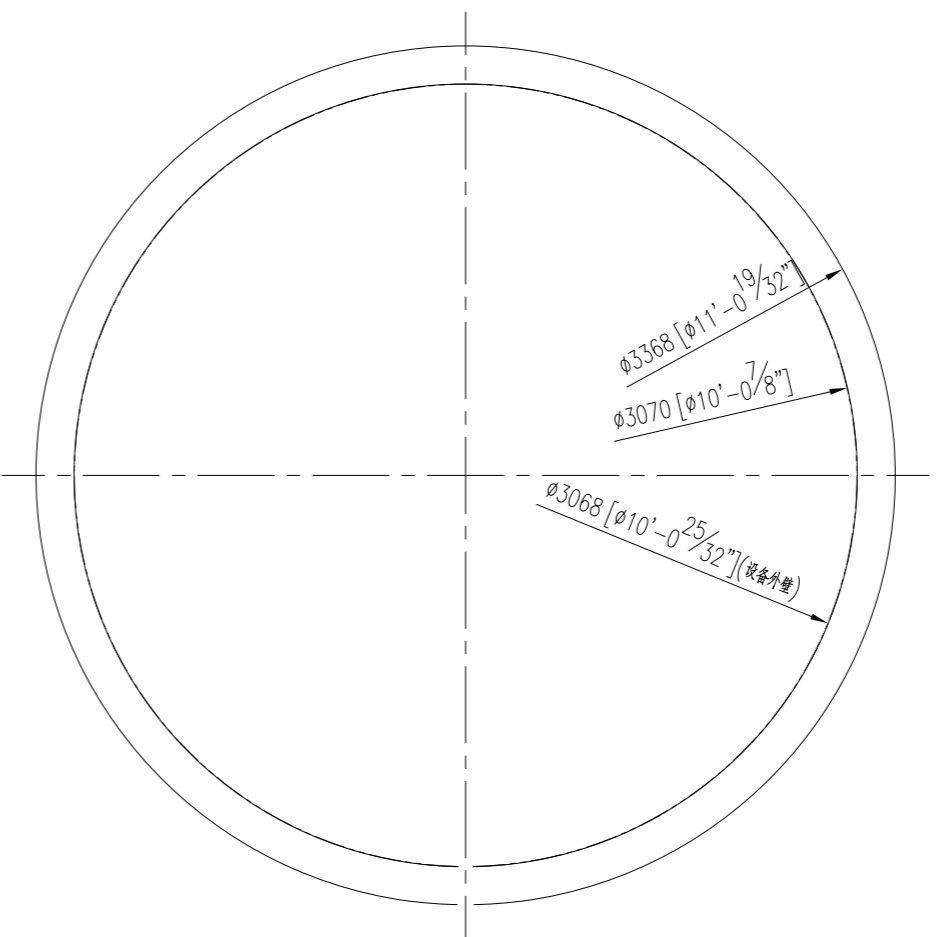
OWNER / DEVELOPER:

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	
设计 DESIGN	审核 CHECK	标准号 STANDARD	图号 DRAWING NO. BSA15-306-00(3/3)
Evonik Corporation Mobile, AL, USA		比例 SCALE	图3张 共7张 第3张
General arrangement for Emergency Relief System Knock-Out Tank		批准 APPROVED	图章 STAMP
图号 ITEM NO. V-9562	生产号 SERIAL NO. 15-A3179	设计 DESIGNER	审核 CHECKER

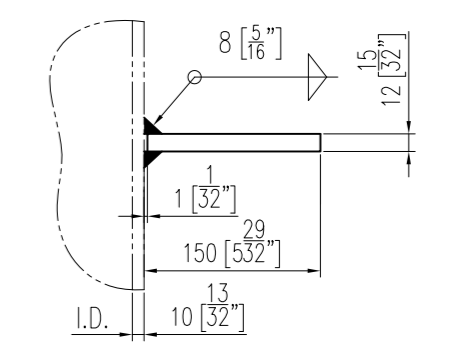


技术要求:
TECHNICAL REQUIREMENT:
1. 焊接采用电焊, 焊接规范按 WPS 的规定
WELDING OPERATION SHALL BE PER APPROVED WPS.
2. 除注明者外, 角焊缝的焊角高度按较薄板厚度
Except noted, the throat height of fillet weld equal to thickness of the thinner part.
3. 所有角焊缝按 ASME VIII-1 附录 8 中规定 100% P.T.
ALL CORNER WELDING LINE SHALL MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX 8) BE 100% P.T.
4. 其余要求见装配图。
OTHER TECHNICAL REQUIREMENTS SEE THE ASSEMBLY DRAWING.

件号	图号及标准号	名称	数量	材料	重量 (Kg)	所在图号	装配图号	备注
DRAWING NO. OR STANDARD NO.	TITLE	QUANT.	MATERIAL	WEIGHT	DWG. NO.	ASSM. DWG. NO.	REMARKS	
-2		盖板 24t	1	SA-283 C				
-1		盖板 12t	1	SA-240 316L				
2		设备垫板	4	104	BSA15-306-01	BSA15-306-00(1/3)		



加强圈焊接详细图
WELDING DETAIL OF STIFFENING RING
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
WELDING OPERATION SHALL BE PER APPROVED WPS.
2. 除注明者外, 角焊缝的焊角高度按较薄板厚度
Except noted, the throat height of fillet weld equal to thickness of the thinner part.
3. 所有角焊缝按 ASME VIII-1 附录 8 中规定 100% P.T.
ALL CORNER WELDING LINE SHALL MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX 8) BE 100% P.T.
4. 其余要求见装配图。
OTHER TECHNICAL REQUIREMENTS SEE THE ASSEMBLY DRAWING.

件号	名称	材料	数量	重量 (Kg)	所在图号	装配图号
DRAWING NO. OR STANDARD NO.	TITLE	MATERIAL	QUANT.	WEIGHT	DWG. NO.	ASSM. DWG. NO.
7	加强圈	SA-240 316L	2	616	BSA15-306-01	BSA15-306-00(1/3)

件号	名称	材料	数量	重量 (Kg)	所在图号	装配图号	
DRAWING NO. OR STANDARD NO.	TITLE	MATERIAL	QUANT.	WEIGHT	DWG. NO.	ASSM. DWG. NO.	
04	2015-11-03	ISSUED FOR FABRICATION			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	2015-08-21	FOR APPROVAL			W.X.D	Y.W.T	F.Z
00	2015-05-15	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: Mobile ACA Project

Evonik Corporation
Mobile, AL, USA

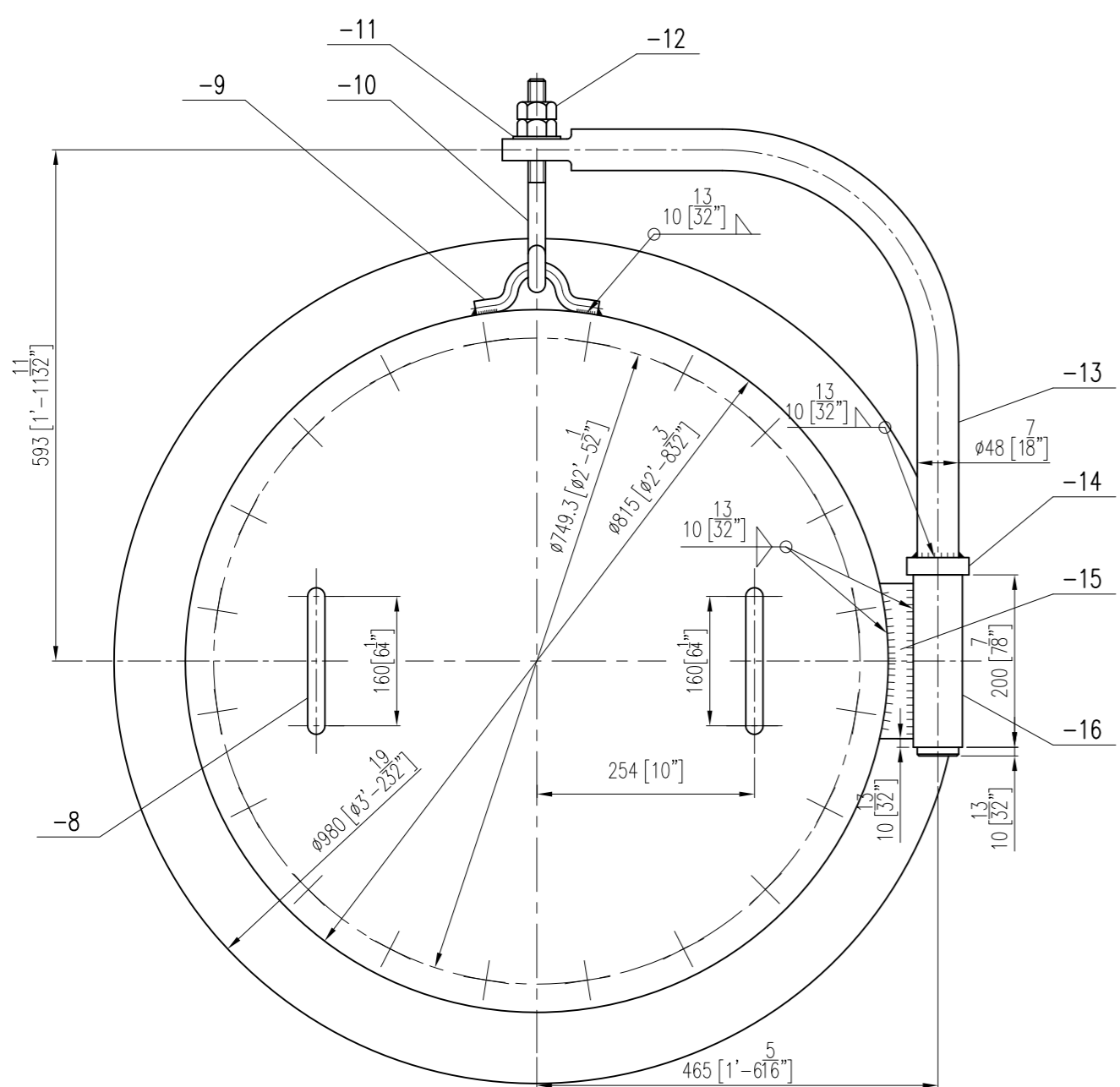
Details for
Emergency Relief System Knock-Out Tank

图号: 04
图号: BSA15-306-01
图号: BSA15-306-01
图号: 04
图号: 04

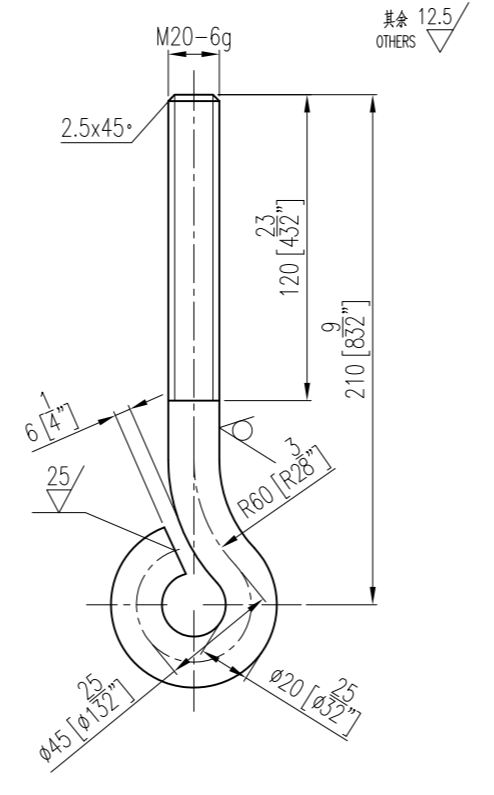
图号: V-9562
图号: 15-A3179

技术要求:
TECHNICAL REQUIREMENT:
1. 焊接采用电焊, 焊接规范按 WPS 的规定
WELDING OPERATION SHALL BE PER APPROVED WPS.
2. 除注明者外, 角焊缝的焊角高度按较薄板厚度
Except noted, the throat height of fillet weld equal to thickness of the thinner part.
3. 所有角焊缝按 ASME VIII-1 附录 8 中规定 100% P.T.
ALL CORNER WELDING LINE SHALL MEET THE REQUIREMENTS OF ASME VIII-1 (APPENDIX 8) BE 100% P.T.
4. 其余要求见装配图。
OTHER TECHNICAL REQUIREMENTS SEE THE ASSEMBLY DRAWING.

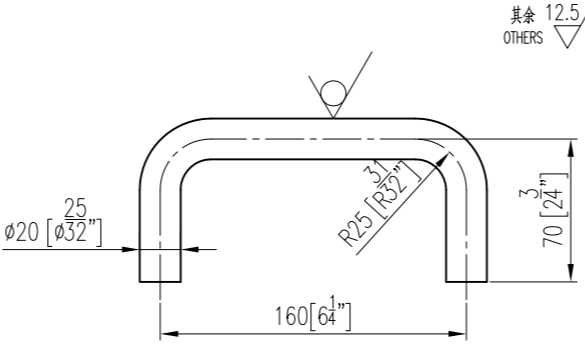
件号	图号及标准号	名称	数量	材料	重量 (Kg)	所在图号	装配图号	备注
DRAWING NO. OR STANDARD NO.	TITLE	QUANT.	MATERIAL	WEIGHT	DWG. NO.	ASSM. DWG. NO.	REMARKS	
-5		盖板 10t	1	SA-240 316L				
-4		盖板 16t	2	SA-283 C	39			
-3		盖板 12t	1	SA-283 C	40			
-2		盖板 16t	4	SA-283 C	5.5			
-1		盖板 2300X350X20t	1	SA-283 C	126			
5		鞍座	2	441	BSA15-306-01	BSA15-306-00(1/3)		



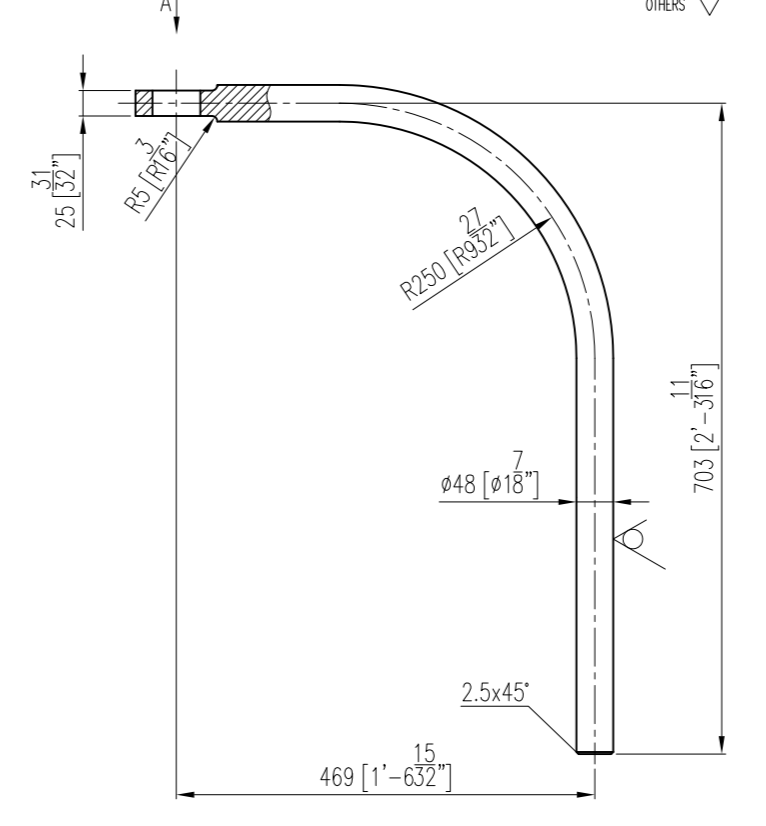
件-10 吊钩详图
DETAIL OF NO.-10
不按比例 NO SCALE



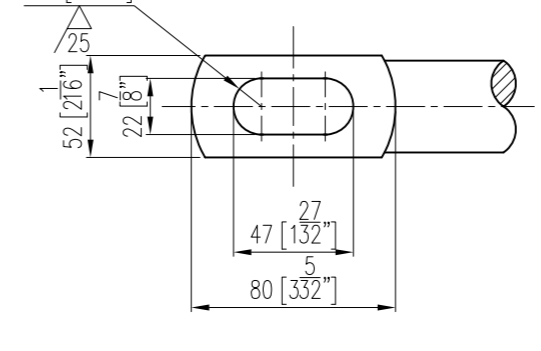
件-8 把手详图
DETAIL OF NO.-8
不按比例 NO SCALE



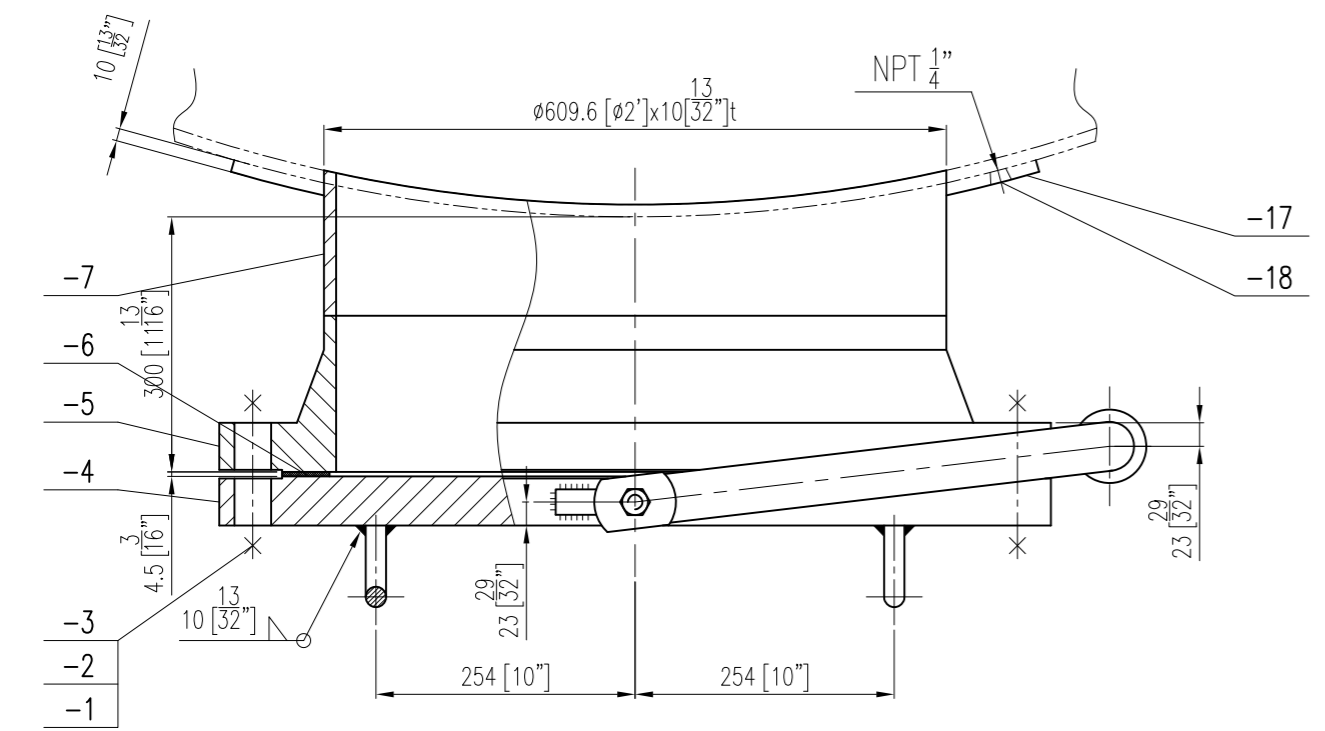
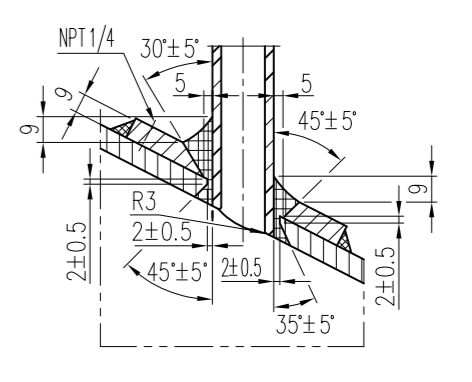
件-13 转臂接管详图
DETAIL OF NO.-13
不按比例 NO SCALE



件-15 支撑板详图
DETAIL OF NO.-15
不按比例 NO SCALE



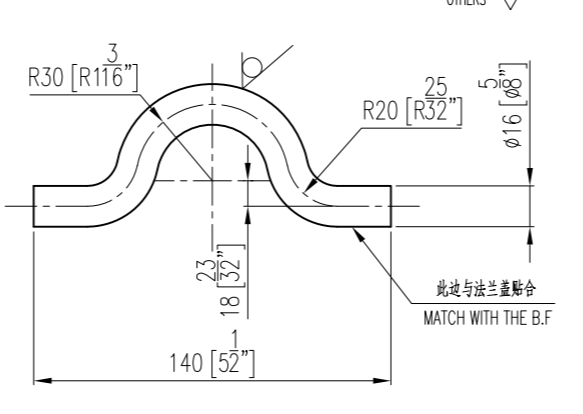
非径向D类焊接接头(管口M1带补强圈)
D BUTT WELD DETAIL (NOZZLE M1 WITH REINFORCEMENT PAD)
不按比例 NO SCALE



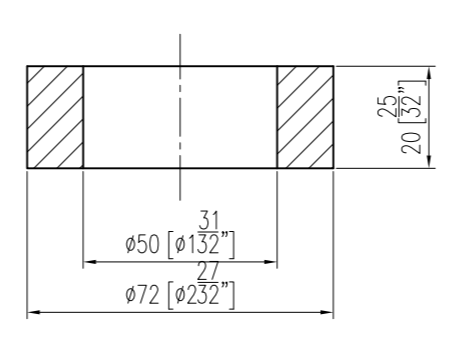
人孔M1详图
DETAIL OF MANHOLE M1

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. 其余按装配图中规定。
OTHER REQUIREMENTS SHALL BE INDICATED IN ASSEMBLY DRAWING.

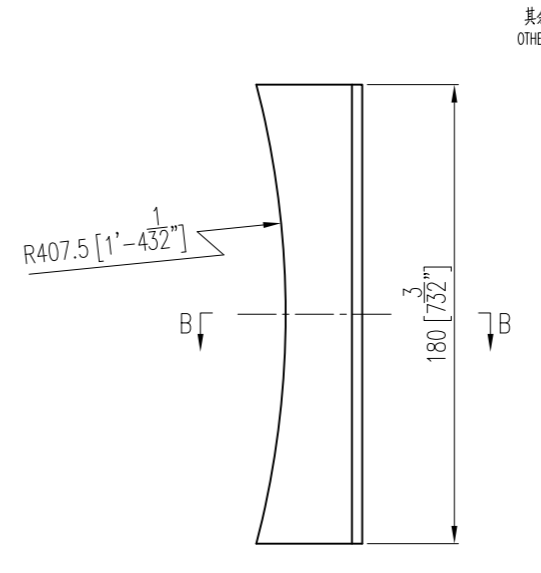
件-9 吊环详图
DETAIL OF NO.-9
不按比例 NO SCALE



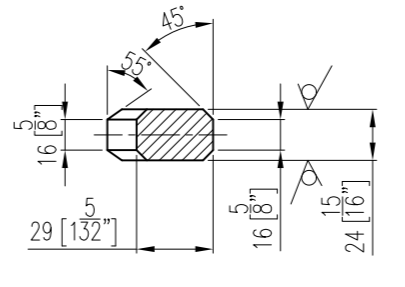
件-14 环详图
DETAIL OF NO.-14
不按比例 NO SCALE



件-15 支撑板详图
DETAIL OF NO.-15
不按比例 NO SCALE



B-B
不按比例 NO SCALE



序号	图号及标准号	名称	数量	材料	重量	备注
-18	ASME B16.11	六角头螺栓 NPT 1/4	1	SS304		
-17		补强圈	1	SA-240 316L	15.1	
-16		无缝钢管	1	SA-312 TP 304	0.92	
-15	BSA15-306-02	支撑板 t=24	1	SA-240 304	1.1	
-14	BSA15-306-02	平板	1	SA-240 304	0.4	
-13	BSA15-306-02	圆棒	1	SA-479 304	15.3	
-12	ASME B18.2.2	螺母	2	SS304	/	
-11		垫圈	1	SS304	/	
-10	BSA15-306-02	圆棒	1	SA-479 304	0.8	
-9	BSA15-306-02	圆棒	1	SA-479 304	0.3	
-8	BSA15-306-02	把手	2	SA-479 304	0.7	1.4
-7		筒壳	1	SA-240 316L	32.4	
-6	REFER TO ASME B16.20	密封垫	1+2	SEE TECHNICAL REQUIREMENTS	/	
-5	ASME B16.5-2009	法兰	1	SA-182 F316L	121.7	
-4	ASME B16.5-2009	法兰	1	SA-182 F316L	188.4	
-3		垫圈	40+4	SS304	0.03	1.2
-2	ASME B18.2.2	螺母	40+4	SA-194 2H	0.1	4
-1	ASME B18.2.1	螺栓	20+2	SA-193 B7	1.5	30

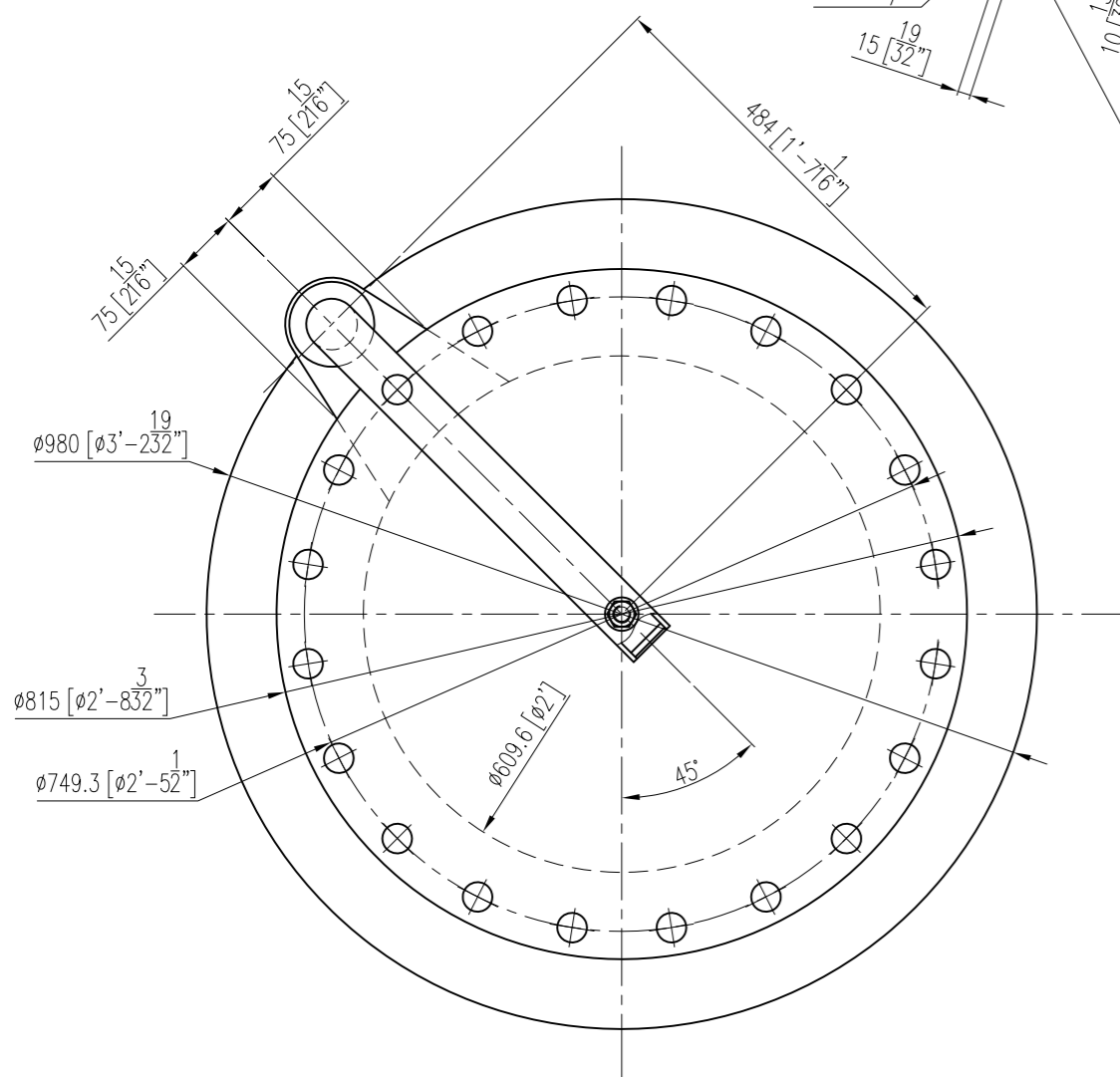
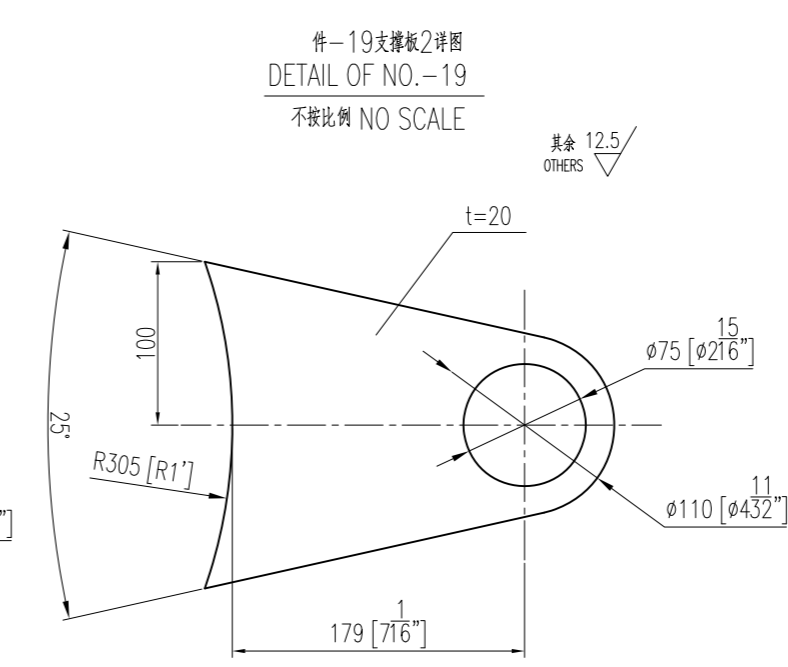
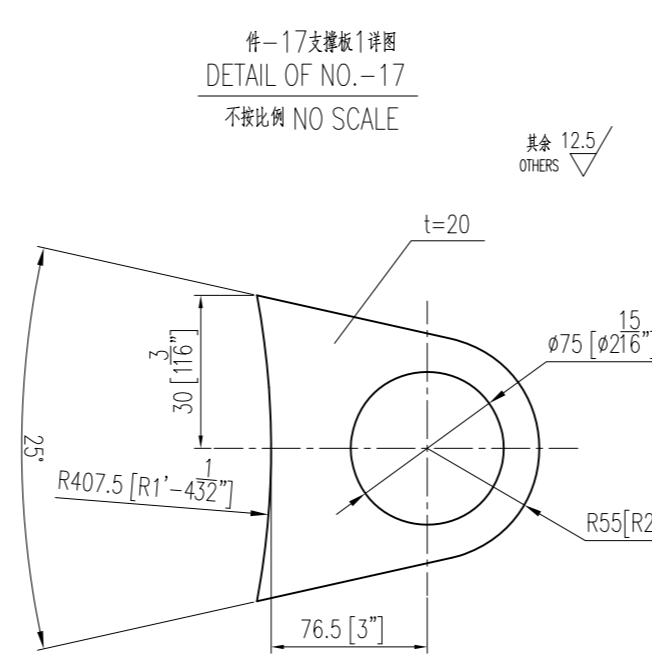
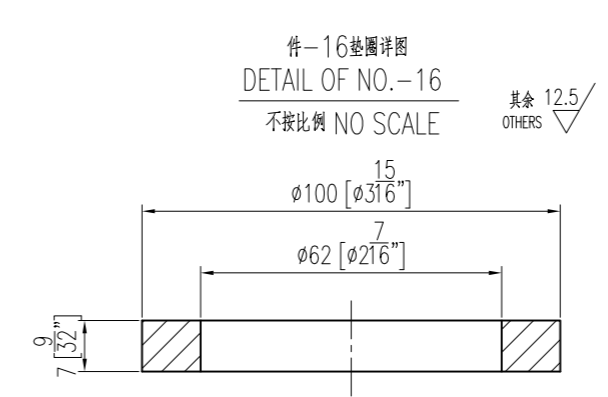
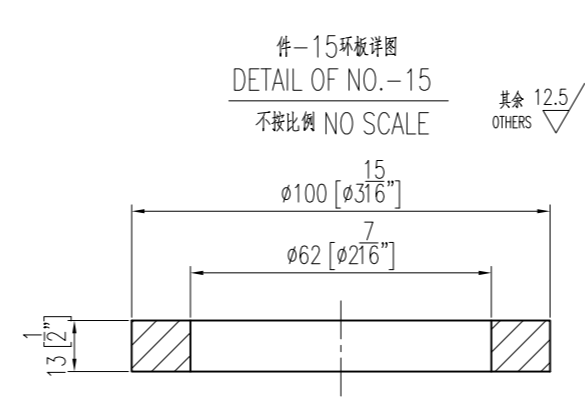
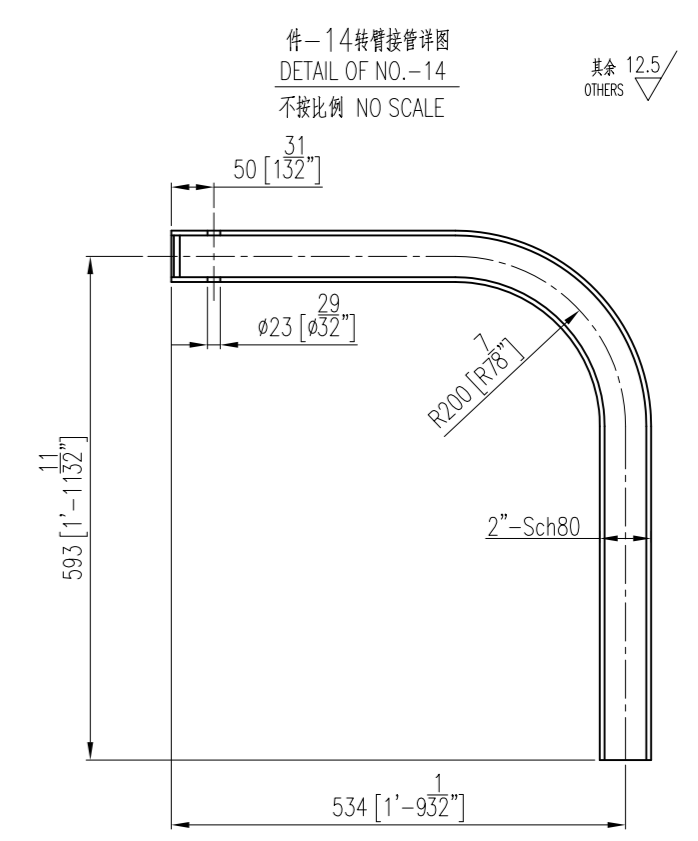
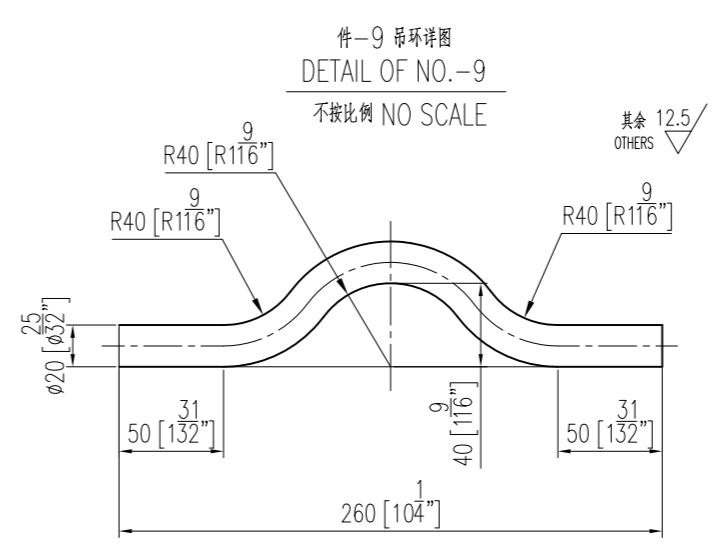
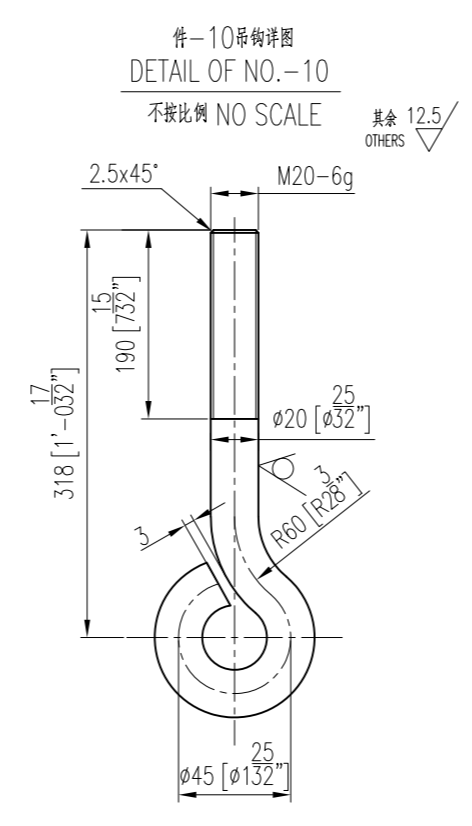
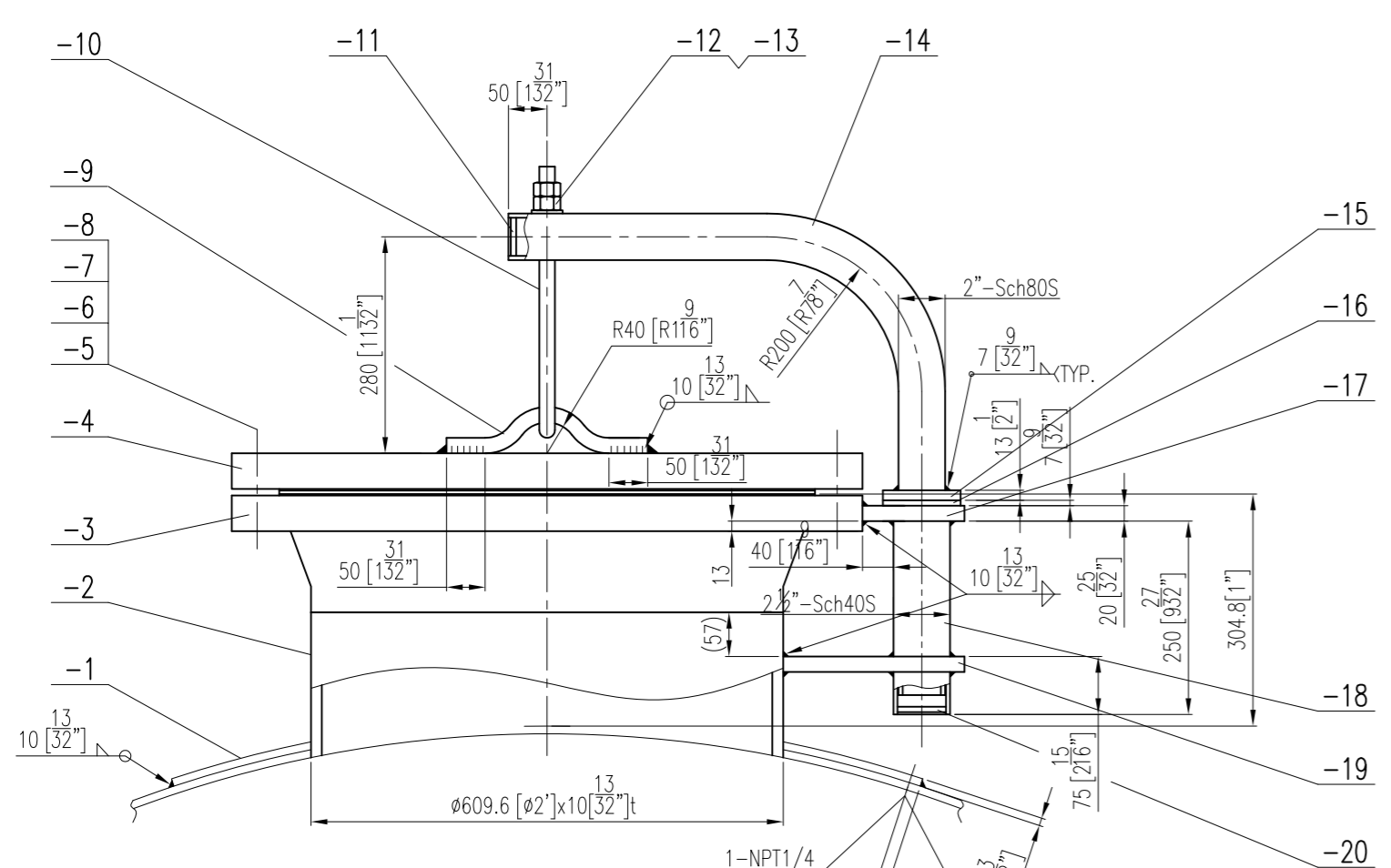
序号	图号及标准号	名称	数量	材料	重量	备注
M1	人孔 24"	人孔	1	413	BSA15-306-02	BSA15-306-00(1/3)

REV	DATE	DESCRIPTION	DRAWN	CHK	APPR
04	2015-11-03	ISSUED FOR FABRICATION			
03	2015-09-25	FOR APPROVAL			
02	2015-09-07	FOR APPROVAL			
01	2015-08-21	FOR APPROVAL			
00	2015-05-15	FOR APPROVAL			

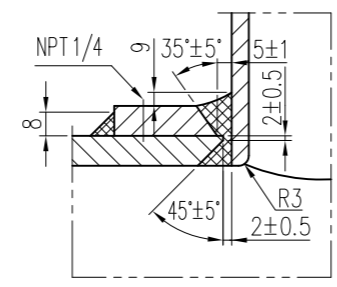
OWNER / DEVELOPER:

Evonik Corporation
Mobile, AL, USA

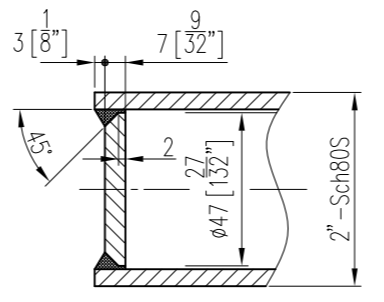
昆山贝色特材装备有限公司 Kunshan Bexceller Special Equipment Co., Ltd	项目名称: Mobile ACA Project
Evonik Corporation Mobile, AL, USA	图号: BSA15-306-02
Details for Emergency Relief System Knock-Out Tank	比例: 1:5
图号: V-9562	生产号: 15-A3179



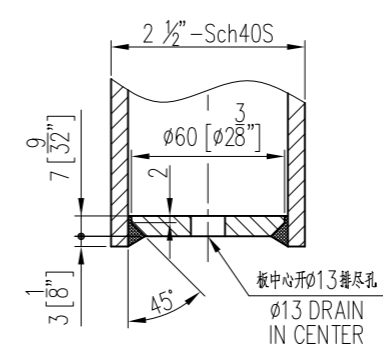
D 类焊接接头(管口M2带补强圈)
DETAIL OF D WELD(NOZZLE M2 WITH REINFORCEMENT PAD)
不按比例 NO SCALE



件-11封板(一)详图
DETAIL OF NO.-11
不按比例 NO SCALE



件-20封板(二)详图
DETAIL OF NO.-20
不按比例 NO SCALE



技术要求:
TECHNICAL REQUIREMENT:
1. 焊接接头型式及尺寸除图中注明外,其余按ASME VIII-1中规定,角焊缝接头的焊脚尺寸按接头的厚度,法兰的焊接按相应法兰标准中的规定。
THE WELDED JOINTS AND SIZE SHALL BE ASME VIII-1, FILLET WELDING ROOT AS PER THINNER THICKNESS, THE WELDING OF FLANGE SHALL BE ACCORDING TO THE RELATIVE FLANGE CODE.
2. 筒节对接焊缝进行100%PT检测,合格标准按ASME 第 VIII 卷, 附录 B; 筒节对接焊缝进行100%射线检测,合格标准按ASME 第 VIII 卷, UW-51。
MANHOLE SHELL WELDS SHALL BE 100% PT AS PER APP. B IN SECTION VIII OF ASME CODE. MANHOLE SHELL WELDS SHALL BE 100% RT AS PER UW-51 IN SECTION VIII OF ASME CODE.
3. 其余要求见装配图。
OTHER TECHNICAL REQUIREMENTS SEE THE ASSEMBLY DRAWING.

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 WEIGHT	备注 REMARKS
-21	ASME B16.11	六角头管塞 NPT 1/4 HEX HEAD PLUG	1	SS304		
-20	见本图(SEE THIS DWG.)	封板(一) ø60x7t SEAL PLATE	1	SA-240 304	0.2	
-19	见本图(SEE THIS DWG.)	大法兰2 t=20 SUPPORT PLATE 2	1	SA-240 304	2.6	
-18	ASME B36.10M	接管 2-1/2"-Sch40S	1	SA-312 TP304	2.2	L=250mm
-17	见本图(SEE THIS DWG.)	大法兰1 t=20 SUPPORT PLATE 1	1	SA-240 304	2.6	
-16	见本图(SEE THIS DWG.)	垫圈 ø100/ø62x7t PLATE	1	黄铜 BRASS	0.4	
-15	见本图(SEE THIS DWG.)	环板 ø100/ø62x13t RING PLATE	1	SA-240 304	0.6	
-14	ASME B36.10M	接管 2"-Sch80S	1	SA-312 TP304	8.4	
-13	ASME B18.12	垫圈 20 WASHER	1	SA-240 304	/	
-12	ASME B18.2.2	螺母 M20 NUTS	2	SA-194 Gr.8	/	
-11	见本图(SEE THIS DWG.)	封板(一) ø47x7t SEAL PLATE	1	SA-240 304	0.2	
-10	见本图(SEE THIS DWG.)	吊钩 FLYING HOOK	1	SA-479 304	1.2	
-9	见本图(SEE THIS DWG.)	吊环 FLYING RINGS	1	SA-479 304	0.8	
-8	ASME B16.20	垫圈 24"-150# SPECIAL WELDING GASKET	1+2	见技术要求 SEE TECHNICAL REQUIREMENTS	/	
-7		垫圈 WASHER	40+4	SS304	0.03	1.2
-6	ASME B18.2.2	螺母 1-1/4"-BUNC-2B NUTS	40+4	SA-194 2H 热浸镀锌 HOT DIP GALVANIZED	0.1	4
-5	ASME B18.2.1	全螺纹螺栓 1-1/4"-BUNC-2A L=200 TOTAL SCREW FLUD	20+2	SA-193 B7 热浸镀锌 HOT DIP GALVANIZED	1.5	30
-4	ASME B16.5-2009	法兰盖 BL 24"-150# RF BLIND FLANGE	1	SA-182 F316L	188	
-3	ASME B16.5-2009	法兰 WN 24"-150# RF S=10 FLANGE	1	SA-182 F316L	122	
-2		接管 ø609.6x10 L=187 PIPE	1	SA-240 316L	28.2	
-1		补强圈 ø980/ø618 t=10 REINFORCING PAD	1	SA-240 316L	65	
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 WEIGHT	备注 REMARKS
M2	大法兰 24" MANHOLE COMPONENT	组合件 COMPONENT	1	458 BSA15-306-03	BSA15-306-00(1/3)	
件号 NO.	名称 PART NAME	材料 MATERIAL	数量 QUANT.	重量 (Kg) WEIGHT	所在图号 DWG. NO.	装配图号 ASSM. DWG. NO.
04	2015-11-03	ISSUED FOR FABRICATION			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	2015-08-21	FOR APPROVAL			W.X.D	Y.W.T F.Z
00	2015-05-15	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

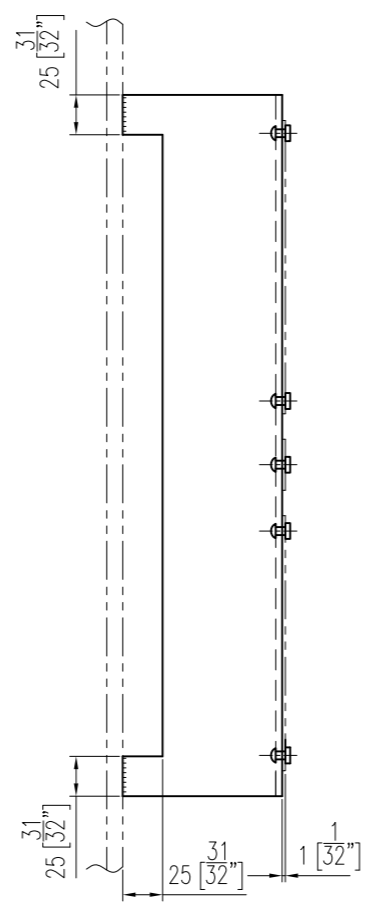
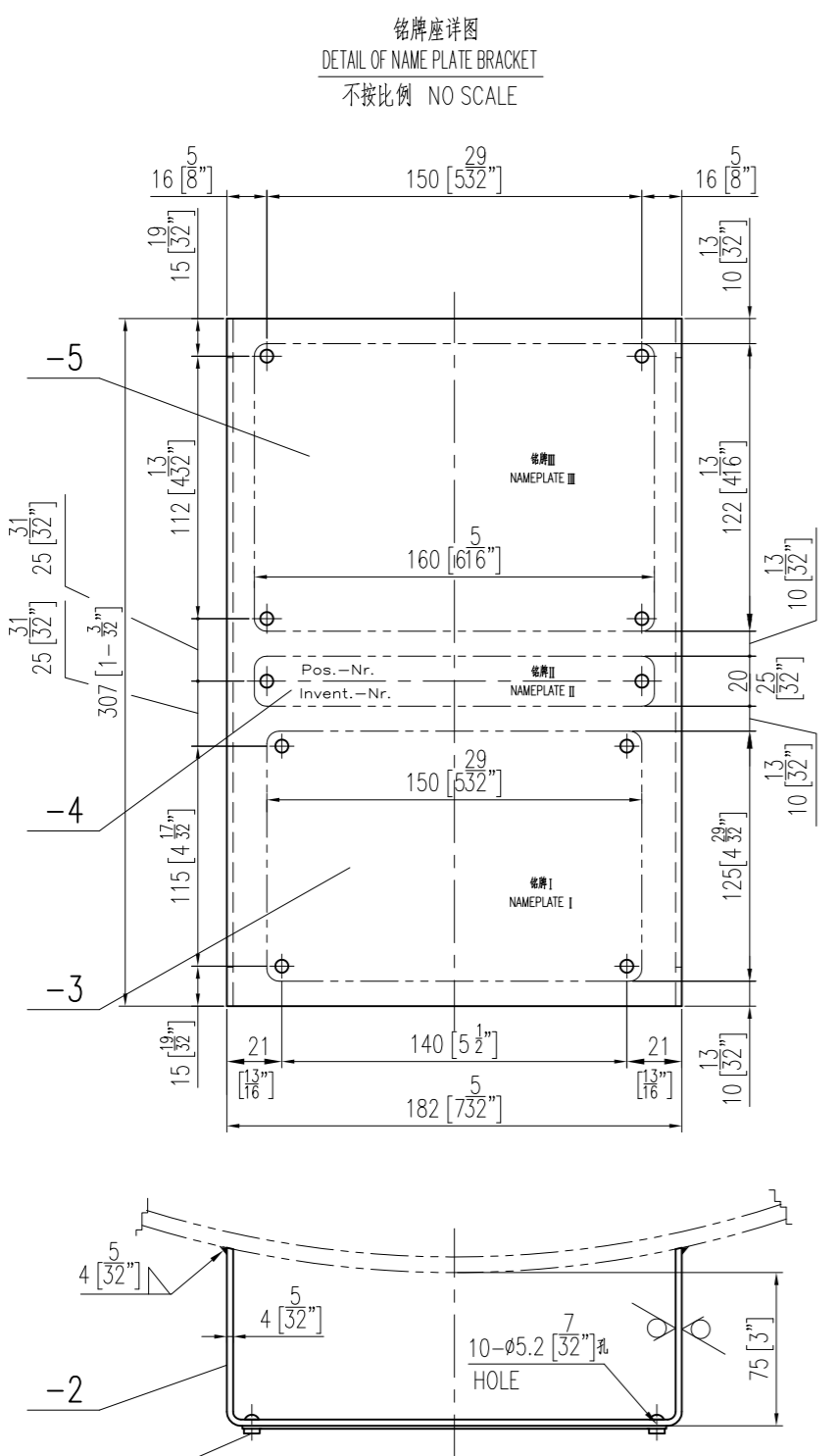
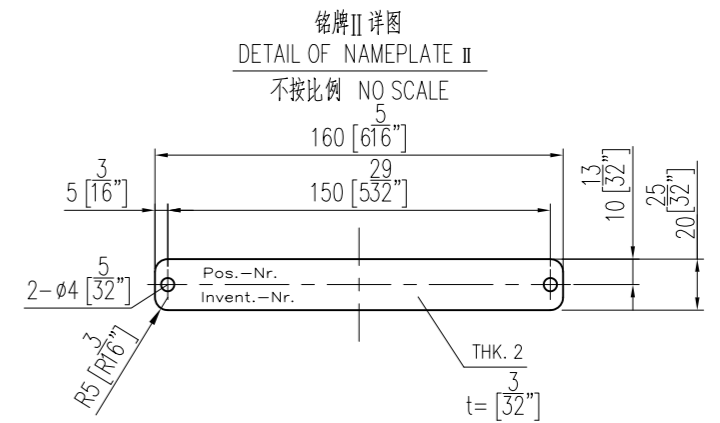
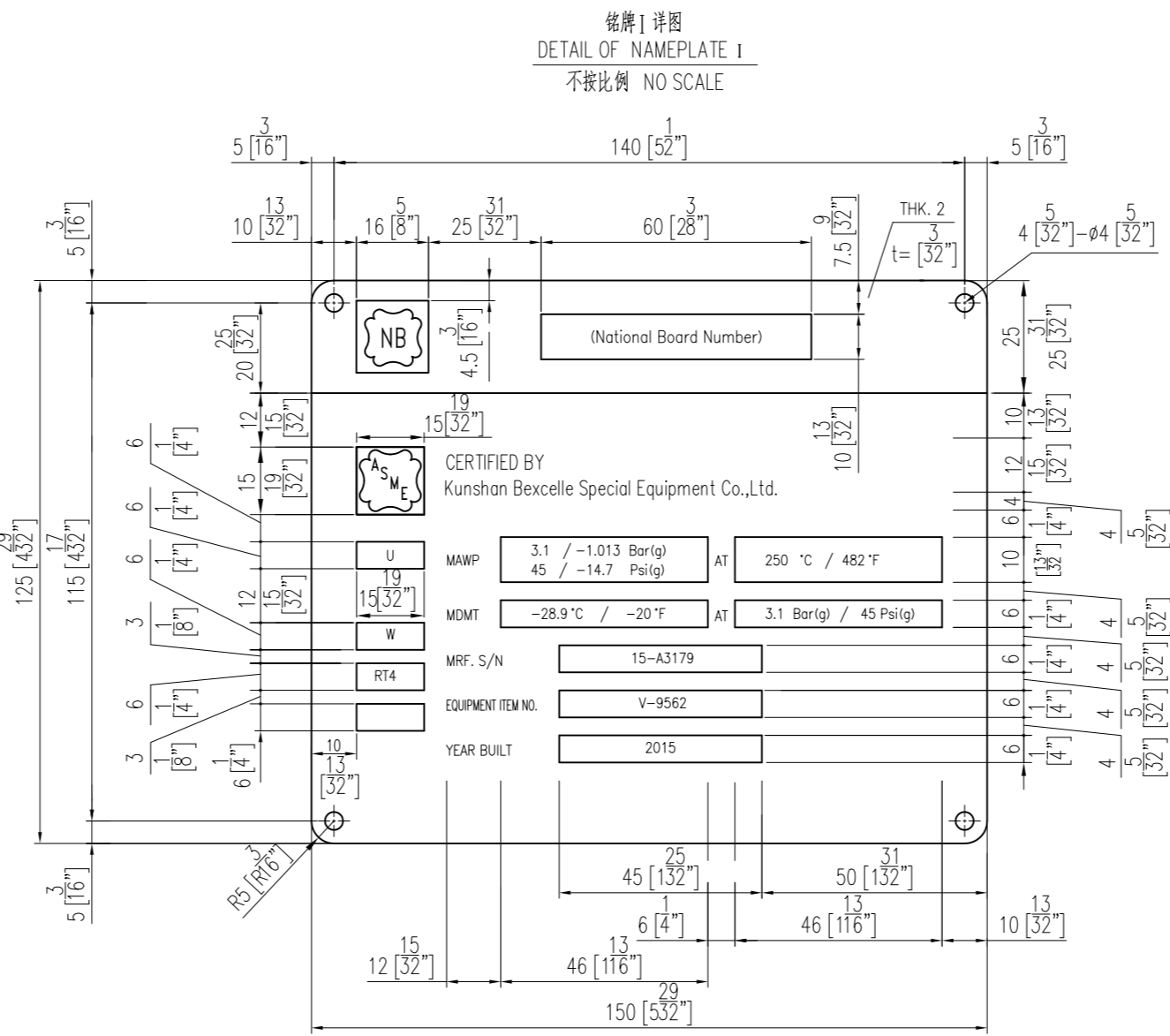
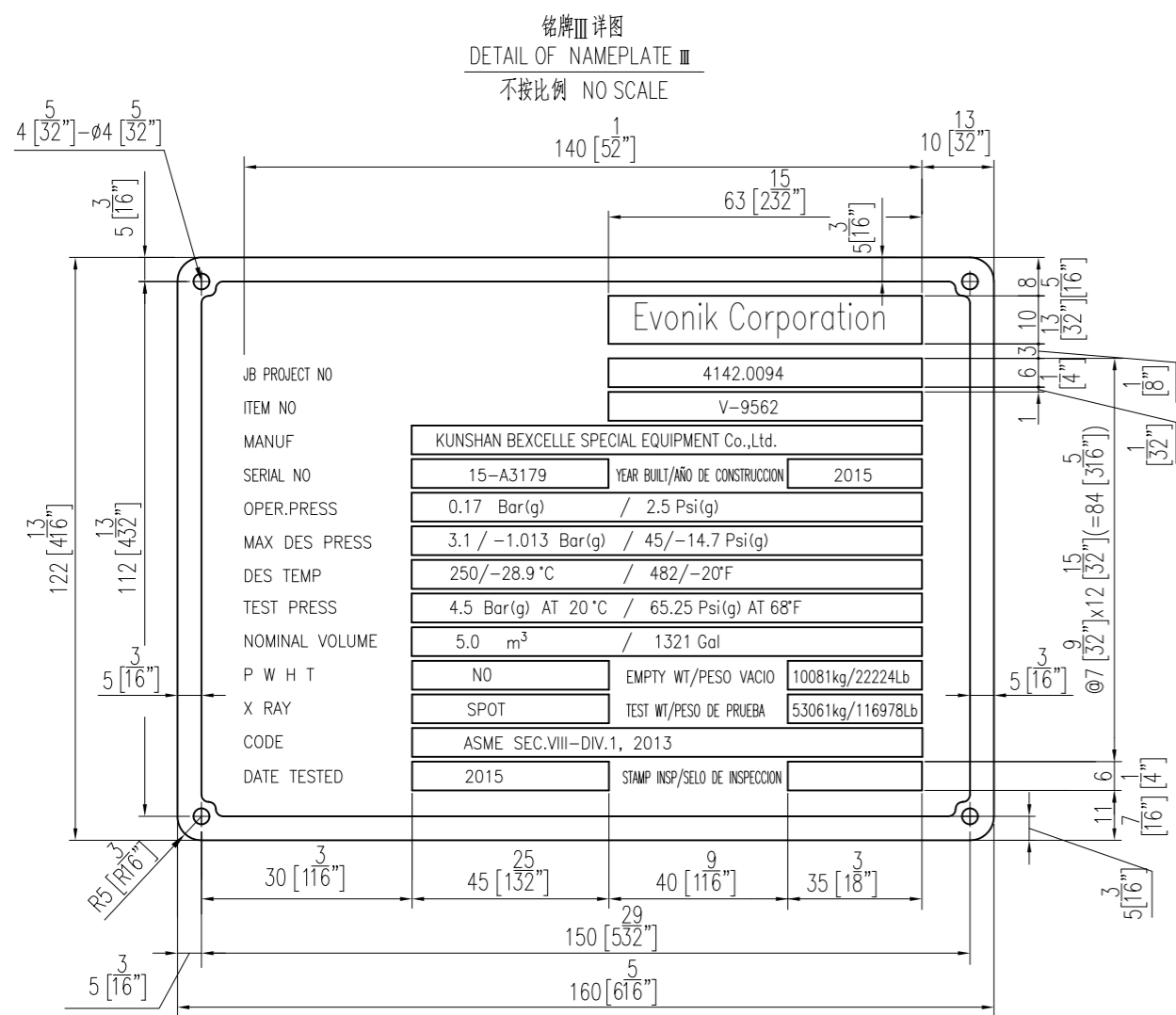
图号: 04
DWG. NO. BSA15-306-03

比例: 1:1
SCALE

标准号: V-9562
STANDARD

生产号: 15-A3179
SERIAL NO.

图章: 6 of 7
SIGNATURE



- 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, 不得有缺角和模糊, 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I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 I 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	数量	重量	所在图号	数量	重量	备注
-5		铭牌II δ=2 NAMEPLATE II	1	SA-240 304	0.5							
-4		铭牌II δ=2 NAMEPLATE II	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	/							

OWNER / DEVELOPER:

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Kunshan Bexcelle Special Equipment Co.,Ltd

项目名称: Mobile ACA Project

Evonik Corporation
Mobile, AL, USA

Details for
Emergency Relief System Knock-Out Tank

图号: 04
图号: BSA15-306-04
图号: BSA15-306-04
图号: 04
图号: 04

图号: V-9562
图号: 15-A3179