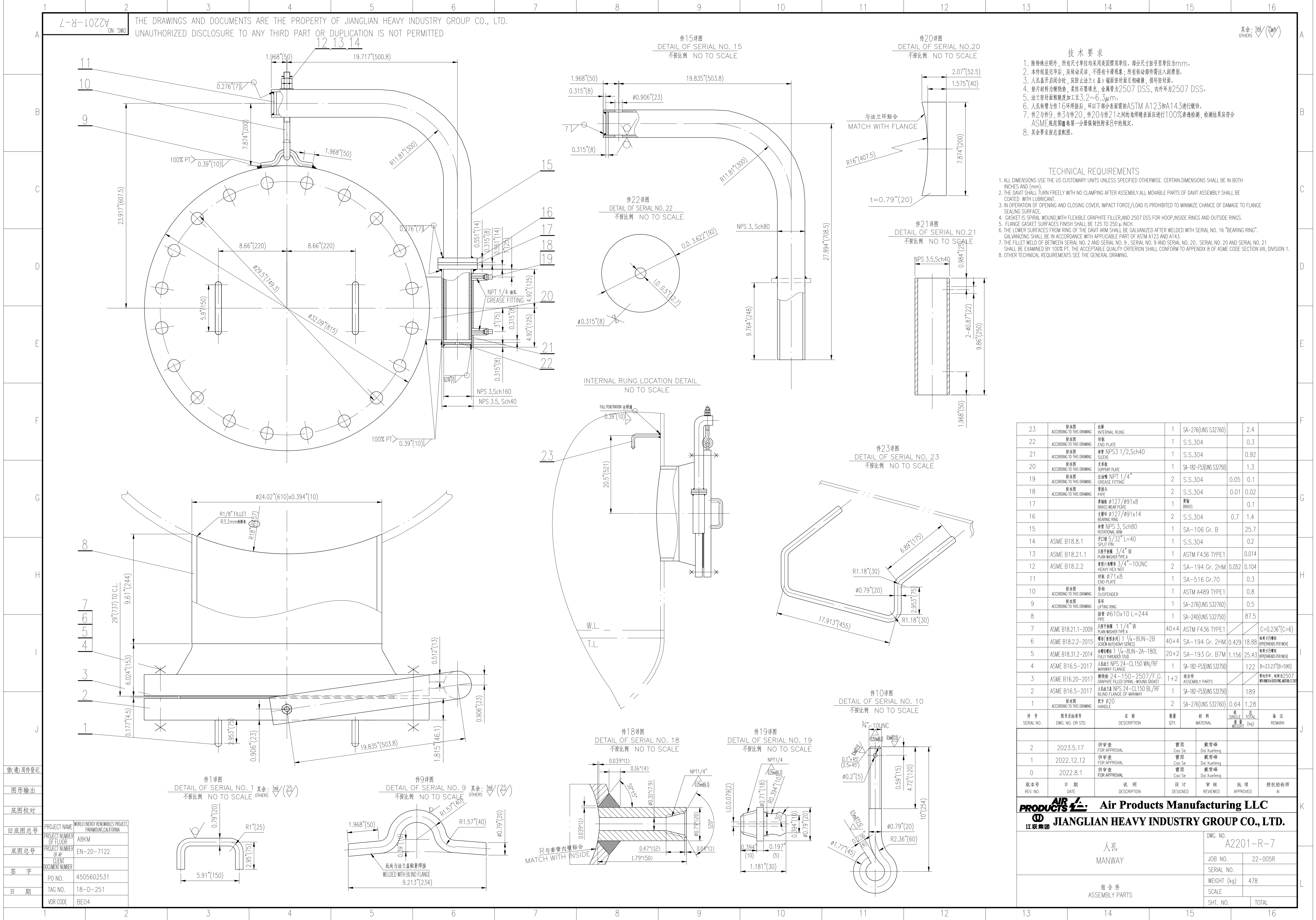
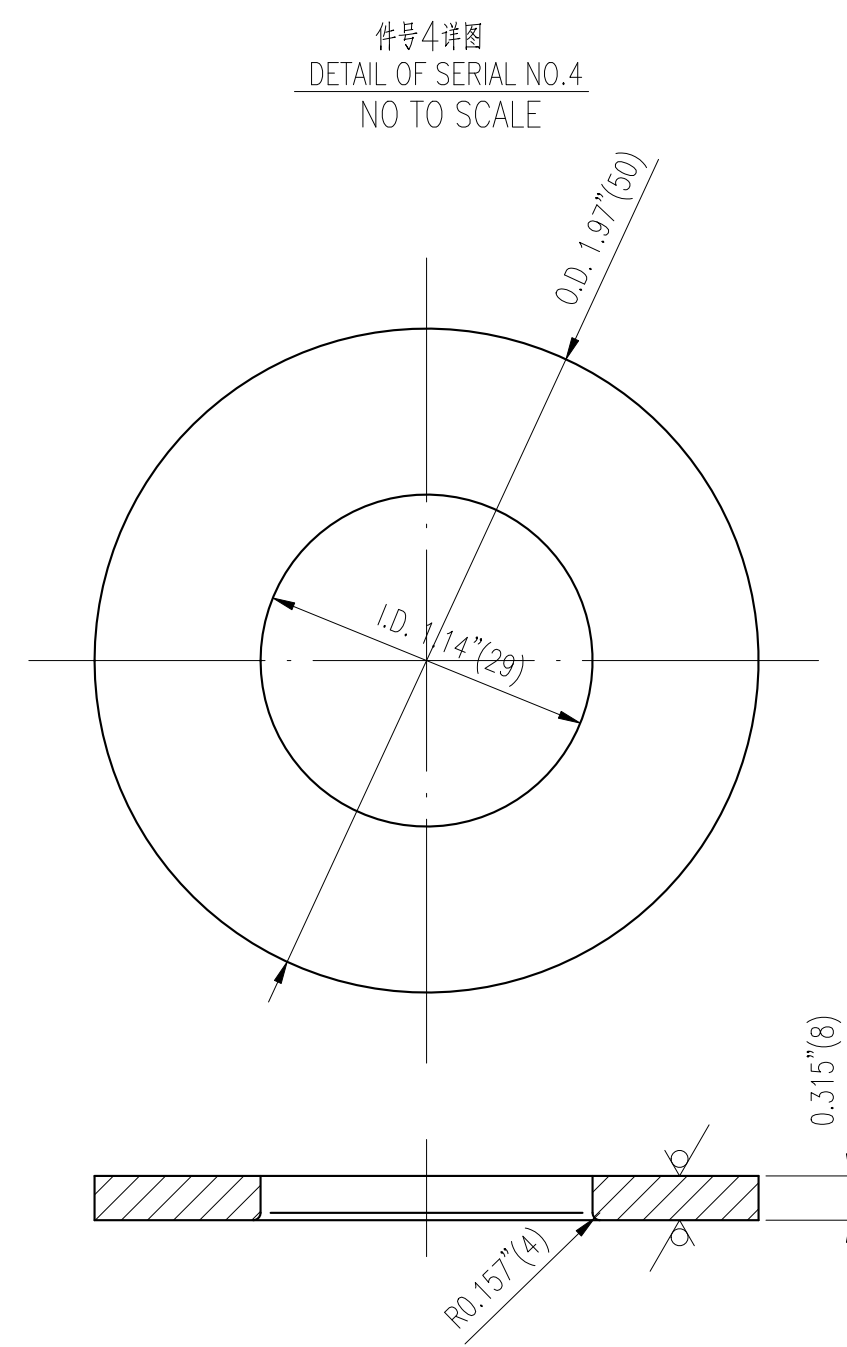
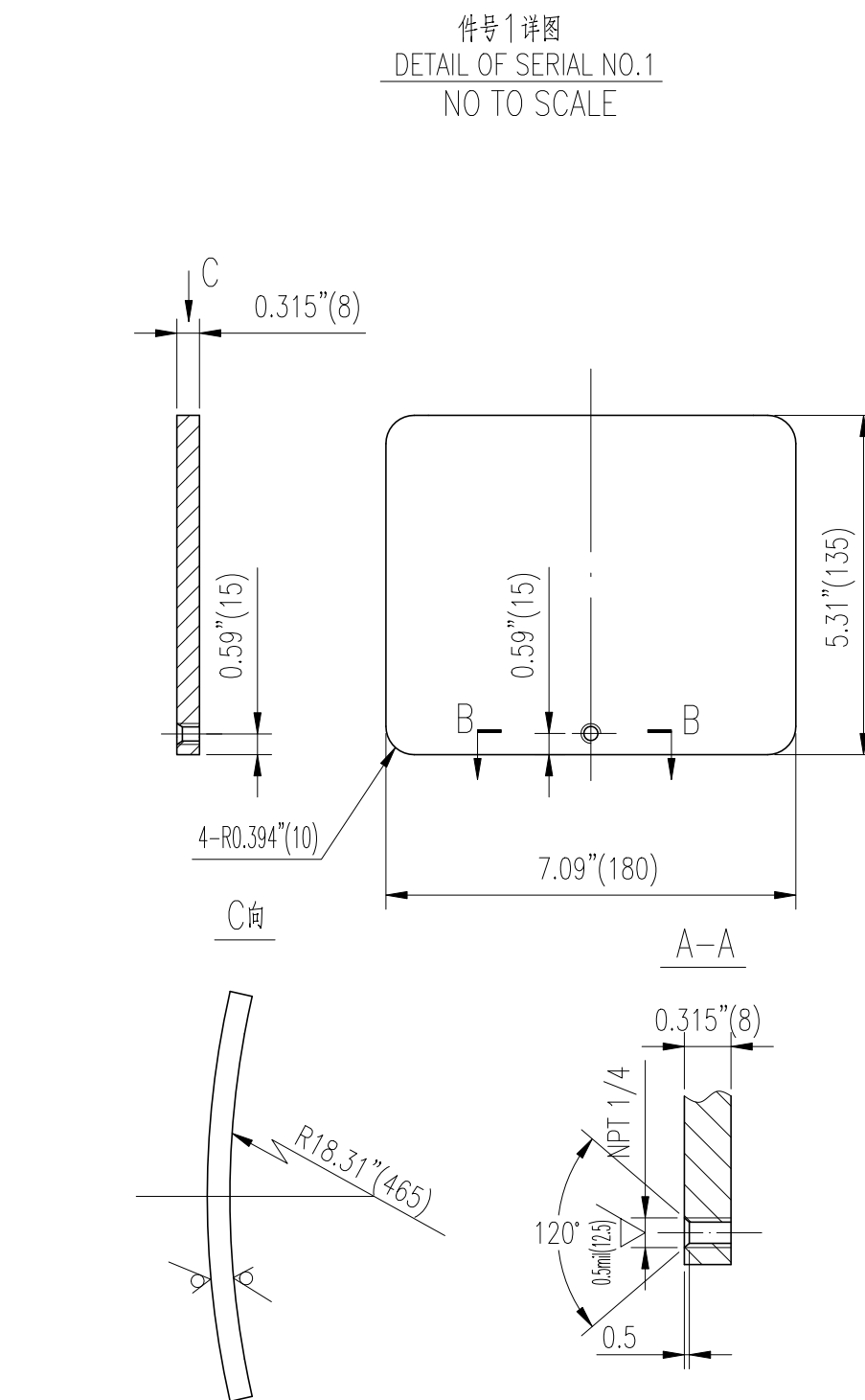
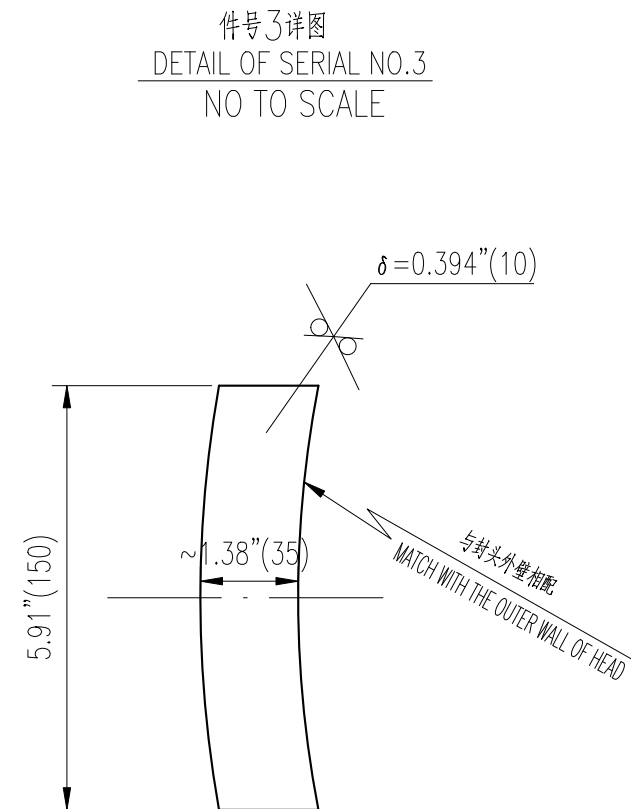
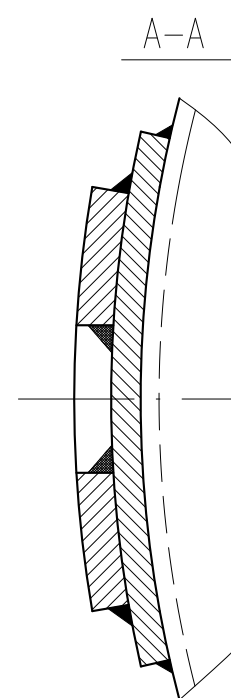
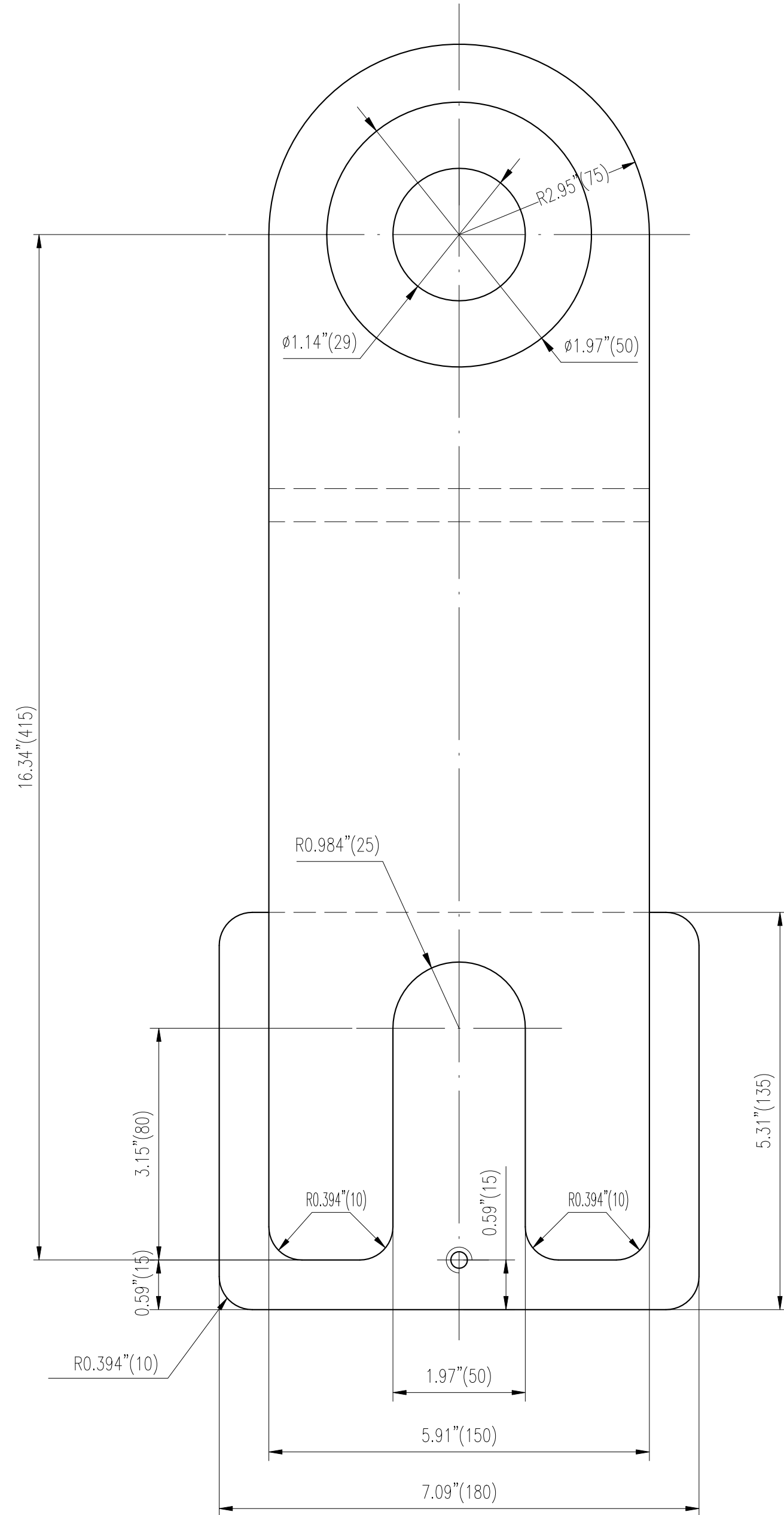






1. SA-240 (UNS S32750) 不锈钢板应符合ASME规范第Ⅱ卷A篇2021版SA-240的规定及NACE MR0103标准。
2. SA-516 Gr.70热轧钢板应符合ASME规范第Ⅱ卷A篇2021版SA-516的规定。
3. 连接处焊接接头应进行100%渗透检测，检测标准应符合ASME规范第Ⅴ卷第一部分强制性附录8中的规定。
4. 由NPT 1/4螺孔通入15psig(100kPa)的压缩空气，检查连接处焊接焊缝的质量，气焊处不得有渗漏现象。
5. 其余技术要求参见总装配图。

其余: $\frac{1\text{mil}}{\nabla}$ ($\frac{25\mu\text{m}}{\nabla}$)

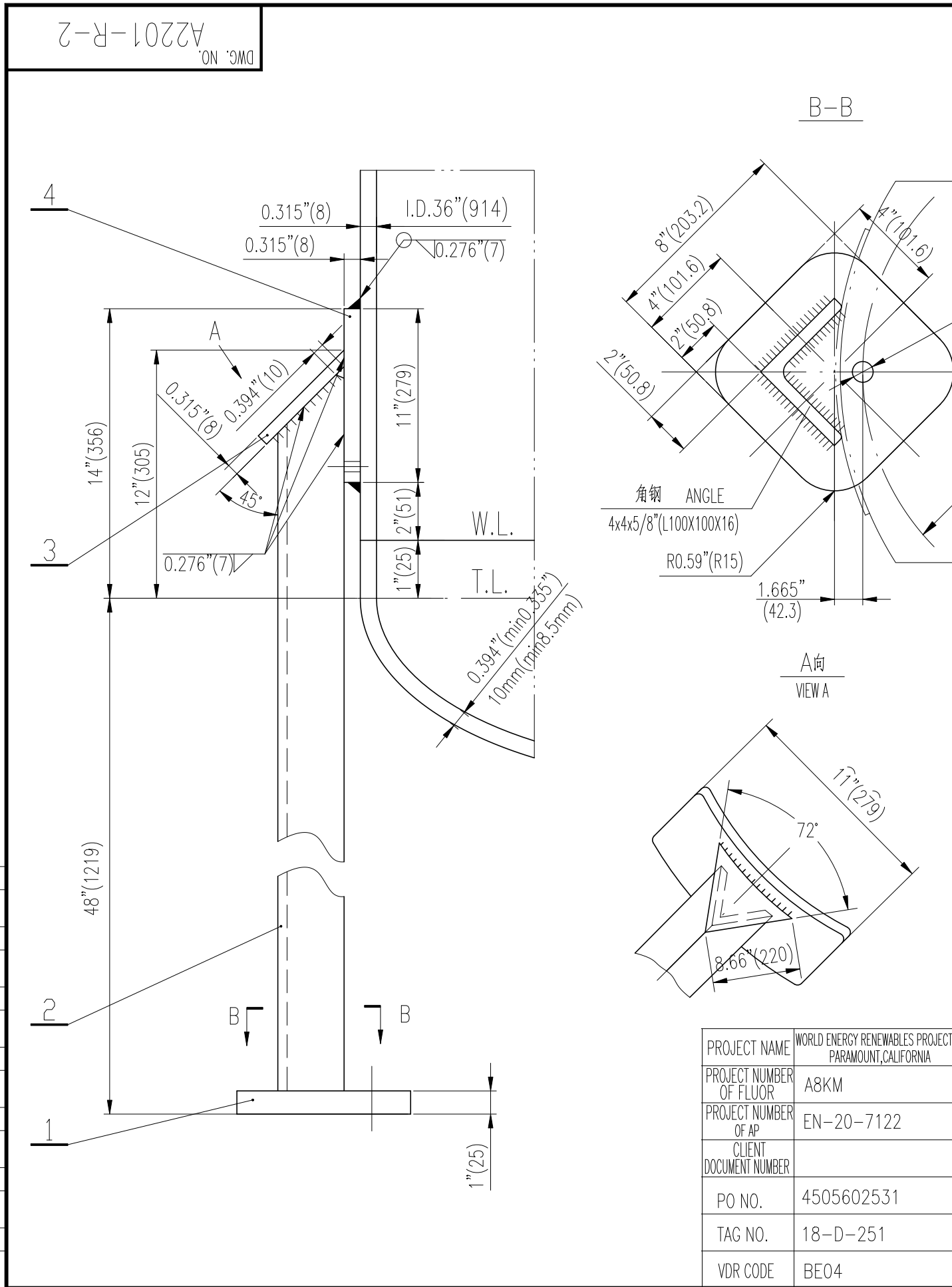
1. SA-240 (UNS 32160) PLATES USED FOR SHELLS SHALL CONFORM TO THE PROVISIONS ASME CODE PART A SECTION II, 2021 EDITION AND MEET MR0103 COMPLIANCE.
2. SA-516 Gr.70 HOT ROLLED PLATES FOR THE REINFORCING PAD SHALL CONFORM TO THE PROVISIONS ASME CODE SECTION II PART A, 2021 EDITION.
3. THE FILLET WELD SHALL BE EXAMINED BY 100% PT. THE ACCEPTABLE QUALITY CRITERION SHALL CONFORM TO APPENDIX B OF ASME CODE SECTION VIII, DIVISION 1.
4. PURGE 0.4-0.5MPa COMPRESSED AIR THROUGH M10 SCREW HOLE. CHECK THE QUALITY OF THE CONNECTING WELD OF REINFORCING PAD. THE FILLET WELD SHALL BE FREE OF LEAKAGE.
5. OTHER TECHNICAL REQUIREMENTS SEE THE GENERAL DRAWING.

件号2详图
DETAIL OF SERIAL NO.2
NO TO SCALE

AIR
PRODUCTS  **Air Products Manufacturing LLC**
 **江联集团** **JIANGLIAN HEAVY INDUSTRY GROUP CO., LTD.**

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技术要求

- 未注角焊缝的焊脚尺寸为两零件中较薄板的厚度。
- 角接头表面应进行100%渗透检测，检测结果应符合ASME规范第III卷第一分册强制性附录8中的规定。
- 其余技术要求见总装配图。

TECHNICAL REQUIREMENTS

- UNLESS SPECIFIED OTHERWISE, THE DIMENSION OF FILLET WELD LEG SHALL BE EQUAL TO THE THICKNESS OF THINNER PLATE.
- THE FILLET WELD SHALL BE EXAMINED BY 100% PT. THE ACCEPTABLE QUALITY CRITERION SHALL CONFORM TO APPENDIX B OF ASME CODE SECTION VIII, DIVISION 1.
- OTHER TECHNICAL REQUIREMENTS SEE THE GENERAL DRAWING.

件4详图
ITEM 4 DETAILS

1 1" HOLE FOR 3/4" ANCHOR BOLT
Ø29 孔配 3/4" 地脚螺栓

角钢 ANGLE
4x4x5/8" (L100X100X16)

δ=0.315" (8)

72°

8.60" (220)

4	数量	δ=8	1	SA-240(UNS S32750)	4.9	
3	数量	δ=8	1	SA-516 Gr. 70	2.0	
2	数量	角钢 4x4x5/8"	1	SA-36	34.9	L=1499mm
1	数量	底板 1203x203 δ=25	1	SA-516 Gr. 70	8.1	

件 号 SERIAL NO.	图号及标准号 DWG. NO. OR STD.	名 称 DESCRIPTION	数量 QTY.	材 料 MATERIAL	单 重 SINGLE WEIGHT (kg)	备 注 REMARK
2	2023.5.17	供审查 FOR APPROVAL		曹磊 Cao Se	戴雪峰 Dai Xuefeng	
1	2022.12.12	供审查 FOR APPROVAL		曹磊 Cao Se	戴雪峰 Dai Xuefeng	

版本号 REV. NO.	日 期 DATE	说 明 DESCRIPTION	设 计 DESIGNED	审 核 REVIEWED	批 准 APPROVED	授权检验师 AI

AIR PRODUCTS **Jianglian Heavy Industry Group Co., Ltd.**

支腿
LEG SUPPORT

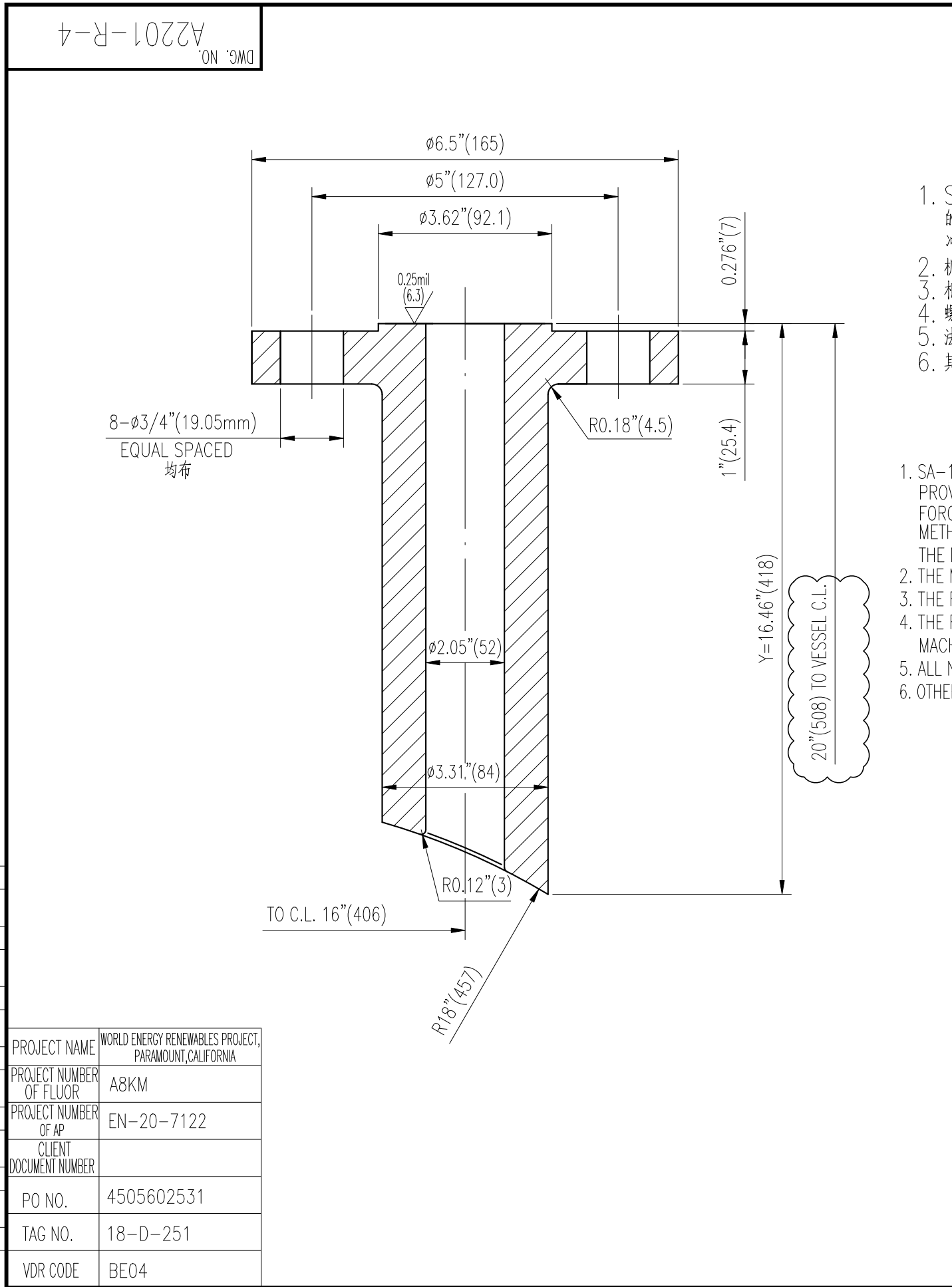
组 合 件
ASSEMBLY PARTS

PROJECT NAME	WORLD ENERGY RENEWABLES PROJECT, PARAMOUNT, CALIFORNIA
PROJECT NUMBER OF FLOOR	A8KM
PROJECT NUMBER OF AP	EN-20-7122
CLIENT DOCUMENT NUMBER	
PO NO.	4505602531
TAG NO.	18-D-251
VDR CODE	BE04

DWG. NO.	A2201-R-2
JOB NO.	22-005R
SERIAL NO.	
WEIGHT (kg)	50
SCALE	
SHT. NO.	TOTAL

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技术要求

- SA-182-F53 (UNS S32750) 固溶处理加淬火不修钢锻件应符合ASME规范第II卷A篇2021版SA-182的规定及NACE MR0103标准。锻件应按ASTM A923试验方法B和C进行试验，试验方法B的试验温度应不大于-40℃，冲击能量平均值应大于54J，侧向膨胀量值应不低于0.38mm。
- 机加工面不得有毛刺、划痕及其它缺陷。
- 相邻两螺栓孔中心间距允许偏差为±0.8mm。
- 螺栓中心圆直径和加工后密封面直径的同心度允许偏差为0.8mm。
- 法兰在安装时螺栓孔的位置应居中分布。
- 其余技术要求见总装配图且应符合ASME B16.5-2017中的要求。

TECHNICAL REQUIREMENTS

- SA-182-F53 (UNS S32750) SOLUTION TREAT AND QUENCH FORGINGS SHALL CONFORM TO THE PROVISIONS OF ASME CODE SECTION II PART A, 2021 EDITION, AND NACE MR0103 COMPLIANCE. FORGINGS SHALL BE TESTED ACCORDING TO ASTM A923 TEST METHODS B AND C. THE TEST TEMPERATURE OF TEST METHOD B SHALL NOT BE GREATER THAN -40 °C, AND THE AVERAGE IMPACT ENERGY SHALL BE GREATER THAN 54J. THE MEASURED TRANSVERSE EXPANSION VALUE SHALL BE >0.38mm.
- THE MACHINED SURFACE SHOULD BE SMOOTH, WITHOUT BURS, NICKS AND OTHER BUGS.
- THE REQUIRED TOLERANCE FOR THE CENTER-TO-CENTER OF ADJACENT BOLT HOLES SHALL BE ±0.8mm.
- THE REQUIRED TOLERANCES FOR CONCENTRICITY BETWEEN THE FLANGE BOLT CIRCLE DIAMETER AND MACHINED FACING DIAMETERS ARE 0.8mm.
- ALL NOZZLE BOLT HOLES TO STRADDLE PRINCIPLE VESSEL CENTERLINE.
- OTHER TECHNICAL REQUIREMENTS SEE THE GENERAL DRAWING AND SHOULD MEET WITH THE PROVISIONS OF ASME B16.5-2017.

法兰 NPS 2-CL600 LWN/Rf
FLANGE FOR NOZZLE A

2	2023.5.17	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		
1	2022.12.12	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		
0	2022.8.1	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		

版本号 REV. NO.	日 期 DATE	说 明 DESCRIPTION	设 计 DESIGNED	审 核 REVIEWED	批 准 APPROVED	授权检验师 AI

AIR PRODUCTS **Jianglian Heavy Industry Group Co., Ltd.**

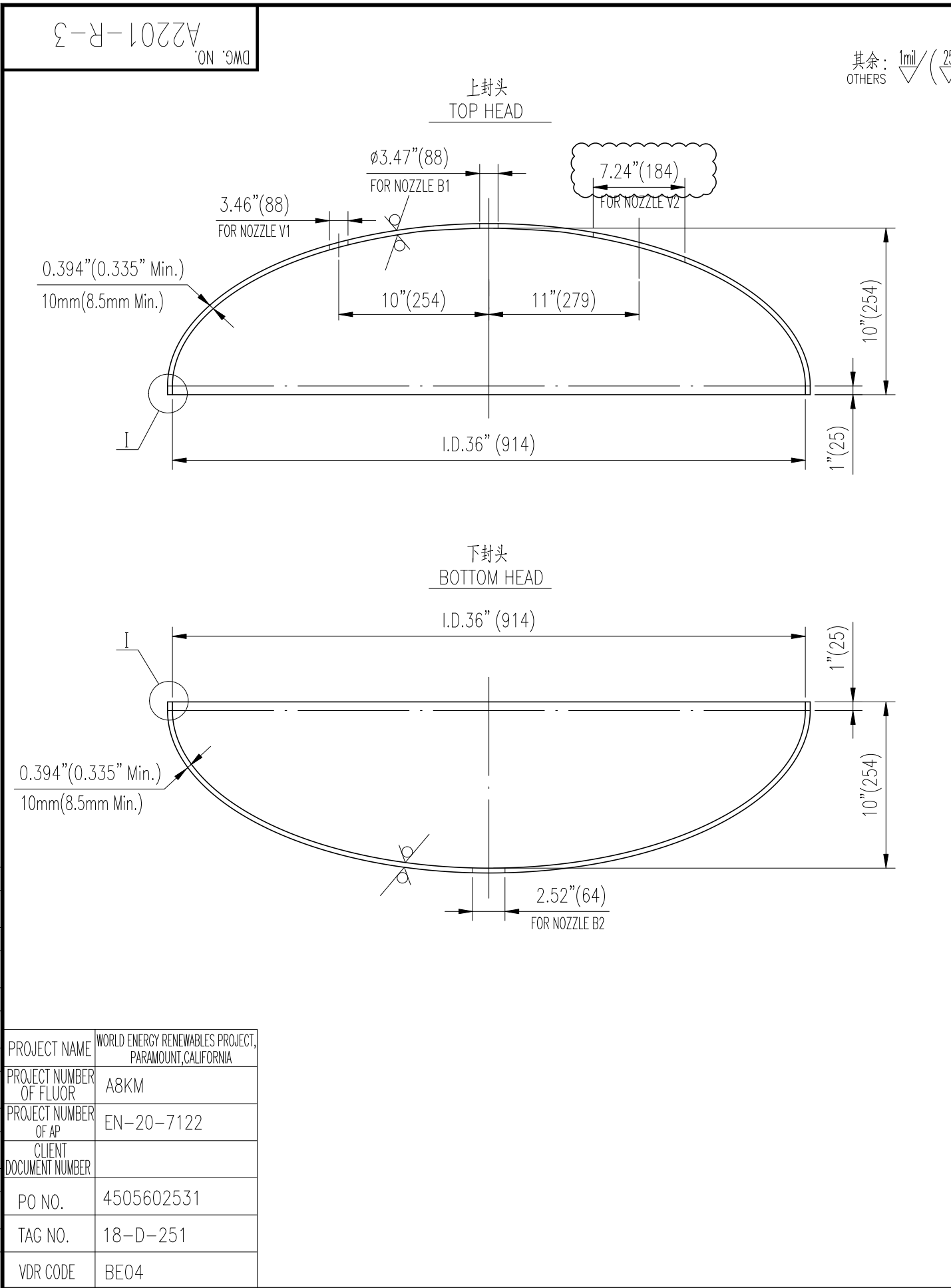
法兰 NPS 2-CL600 LWN/Rf
FLANGE FOR NOZZLE A

PROJECT NAME	WORLD ENERGY RENEWABLES PROJECT, PARAMOUNT, CALIFORNIA
PROJECT NUMBER OF FLOOR	A8KM
PROJECT NUMBER OF AP	EN-20-7122
CLIENT DOCUMENT NUMBER	
PO NO.	4505602531
TAG NO.	18-D-251
VDR CODE	BE04

DWG. NO.	A2201-R-4
JOB NO.	22-005R
SERIAL NO.	
WEIGHT (kg)	13.6
SCALE	
SHT. NO.	TOTAL

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技术要求

- 封头用SA-240 (UNS S32750) 固溶不修钢锻件应符合ASME规范第II卷A篇2021版SA-240的规定及NACE MR0103标准，钢板表面质量为1号。不修钢锻件按ASTM A923试验方法B和C进行试验，试验方法B的试验温度应不大于-40℃，冲击能量平均值应大于54J，且应说明侧向膨胀量值以供参考。
- 封头应整板下料冲压成形，不允许拼接，封头成形后应进行固溶处理。
- 封头保证成形最小厚度为8.5mm，保证内径Ø914。
- 开孔方位按管口方位图。

TECHNICAL REQUIREMENTS

- SA-240 (UNS S32750) PLATES USED FOR HEAD SHALL CONFORM TO THE PROVISIONS ASME CODE SECTION II PART A, 2021 EDITION AND NACE MR0103 COMPLIANCE. THE SURFACE QUALITY OF STEEL PLATE IS NO.1. THE STEEL PLATE SHALL BE TESTED ACCORDING TO ASTM A923 TEST METHODS B AND C. THE TEST TEMPERATURE OF TEST METHOD B SHALL NOT BE GREATER THAN -40 °C, AND THE AVERAGE IMPACT ENERGY SHALL BE GREATER THAN 54J. THE MEASURED TRANSVERSE EXPANSION VALUE SHALL BE STATED FOR REFERENCE.
- THE HEAD SHALL BE COLD FORMED BY ONE PIECE BLANK. NO SPLICING IS PERMITTED. THE COLD FORMED HEAD SHALL BE SUBJECT TO SOLUTION TREATMENT.
- MINIMUM THICKNESS OF 0.335", AND I.D. 36" SHALL BE ENSURED FOR THE HEAD AFTER FORMED.
- THE OPENING ORIENTATION IS ACCORDING TO THE NOZZLE ORIENTATION DRAWING.

接管(V1,V2,B1,B2)开孔敞口详图
DETAIL OF NOZZLE (V1,V2,B1,B2) GROOVE

不按比例 NOT TO SCALE

2	2023.5.17	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		
1	2022.12.12	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		
0	2022.8.1	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		

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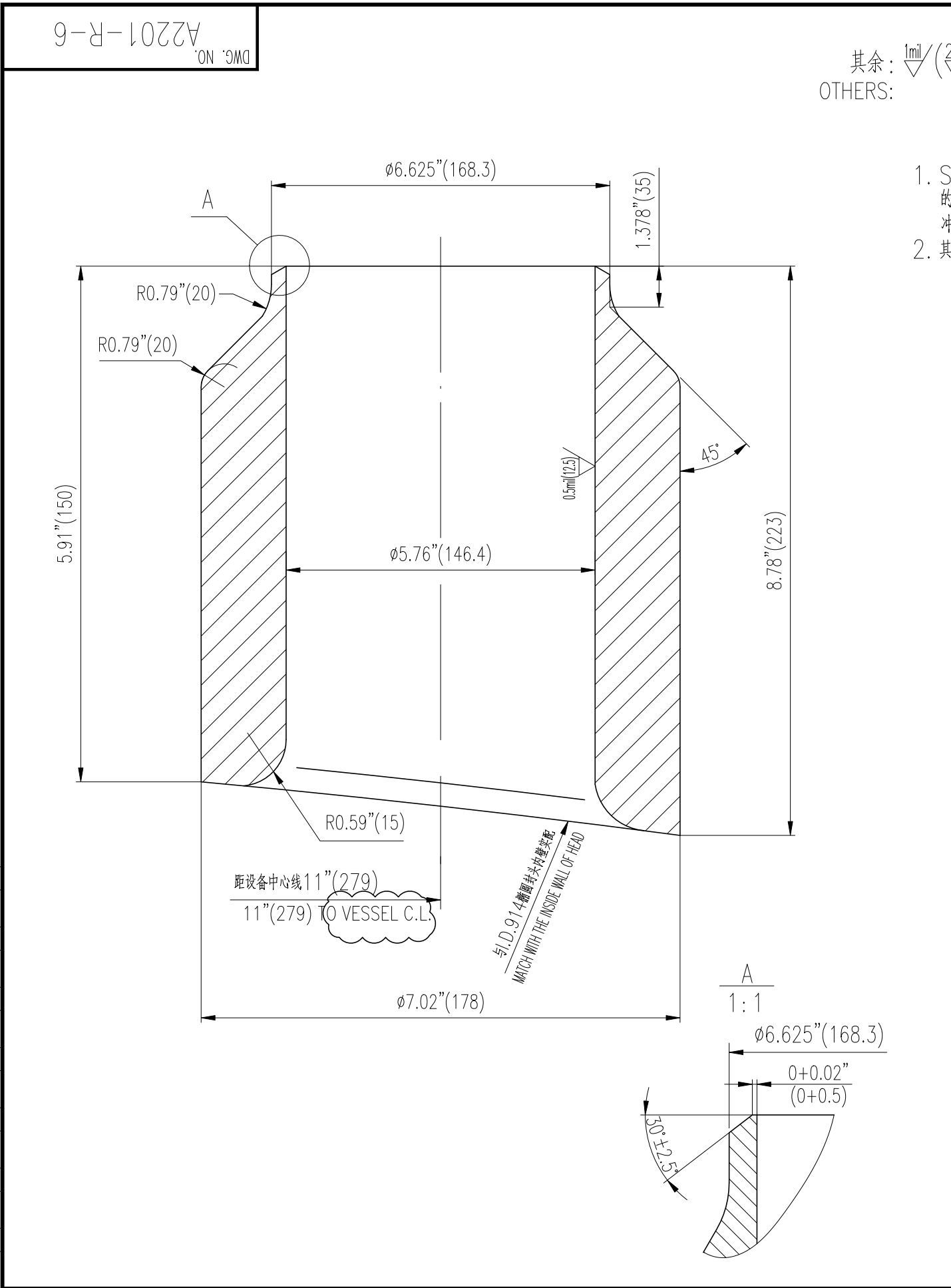
2:1 椭圆形封头
2:1 ELLIPSOIDAL HEAD

PROJECT NAME	WORLD ENERGY RENEWABLES PROJECT, PARAMOUNT, CALIFORNIA
PROJECT NUMBER OF FLOOR	A8KM
PROJECT NUMBER OF AP	EN-20-7122
CLIENT DOCUMENT NUMBER	
PO NO.	4505602531
TAG NO.	18-D-251
VDR CODE	BE04

DWG. NO.	A2201-R-3
JOB NO.	22-005R
SERIAL NO.	
WEIGHT (kg)	77(单个)
SCALE	
SHT. NO.	TOTAL

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技术要求

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- 其余技术要求见总装配图。

TECHNICAL REQUIREMENTS

- SA-182-F53 (UNS S32750) SOLUTION TREAT AND QUENCH FORGINGS SHALL CONFORM TO THE PROVISIONS OF ASME CODE SECTION II PART A, 2021 EDITION, AND NACE MR0103 COMPLIANCE. FORGINGS SHALL BE TESTED ACCORDING TO ASTM A923 TEST METHODS B AND C. THE TEST TEMPERATURE OF TEST METHOD B SHALL NOT BE GREATER THAN -40 °C, AND THE AVERAGE IMPACT ENERGY SHALL BE GREATER THAN 54J. THE MEASURED TRANSVERSE EXPANSION VALUE SHALL BE >0.38mm.
- OTHER TECHNICAL REQUIREMENTS SEE THE GENERAL DRAWING.

厚壁管 NPS 6
THICK-WALLED NOZZLE FOR NOZZLE V2

2	2023.5.17	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		
1	2022.12.12	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		
0	2022.8.1	供审查 FOR APPROVAL	曹磊 Cao Se	戴雪峰 Dai Xuefeng		

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AIR PRODUCTS **Jianglian Heavy Industry Group Co., Ltd.**

厚壁管 NPS 6
THICK-WALLED NOZZLE FOR NOZZLE V2

PROJECT NAME	WORLD ENERGY RENEWABLES PROJECT, PARAMOUNT, CALIFORNIA
PROJECT NUMBER OF FLOOR	A8KM
PROJECT NUMBER OF AP	EN-20-7122
CLIENT DOCUMENT NUMBER	
PO NO.	4505602531
TAG NO.	18-D-251
VDR CODE	BE04

DWG. NO.	A2201-R-6
JOB NO.	22-005R
SERIAL NO.	
WEIGHT (kg)	26.5
SCALE	
SHT. NO.	TOTAL

