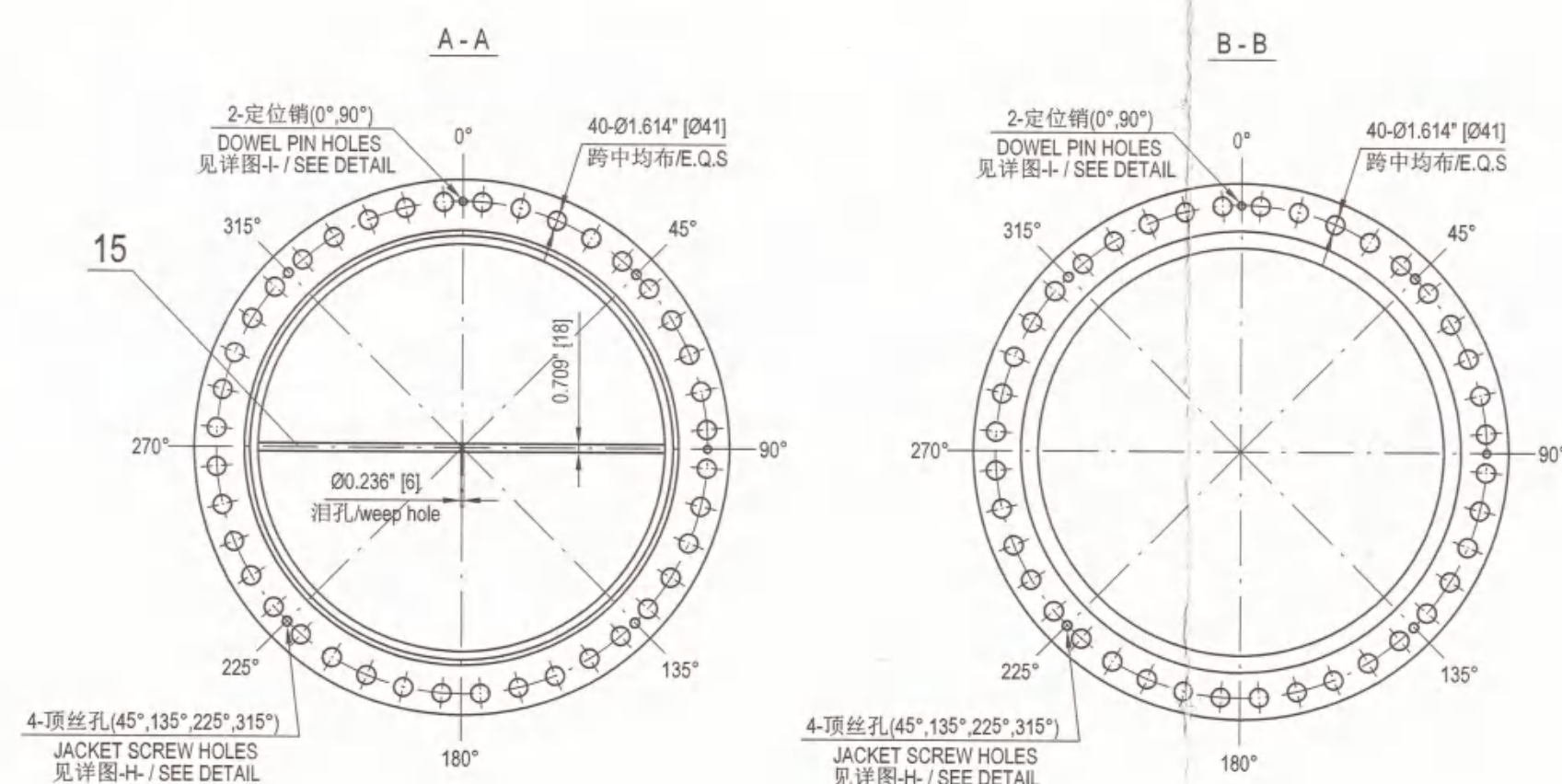
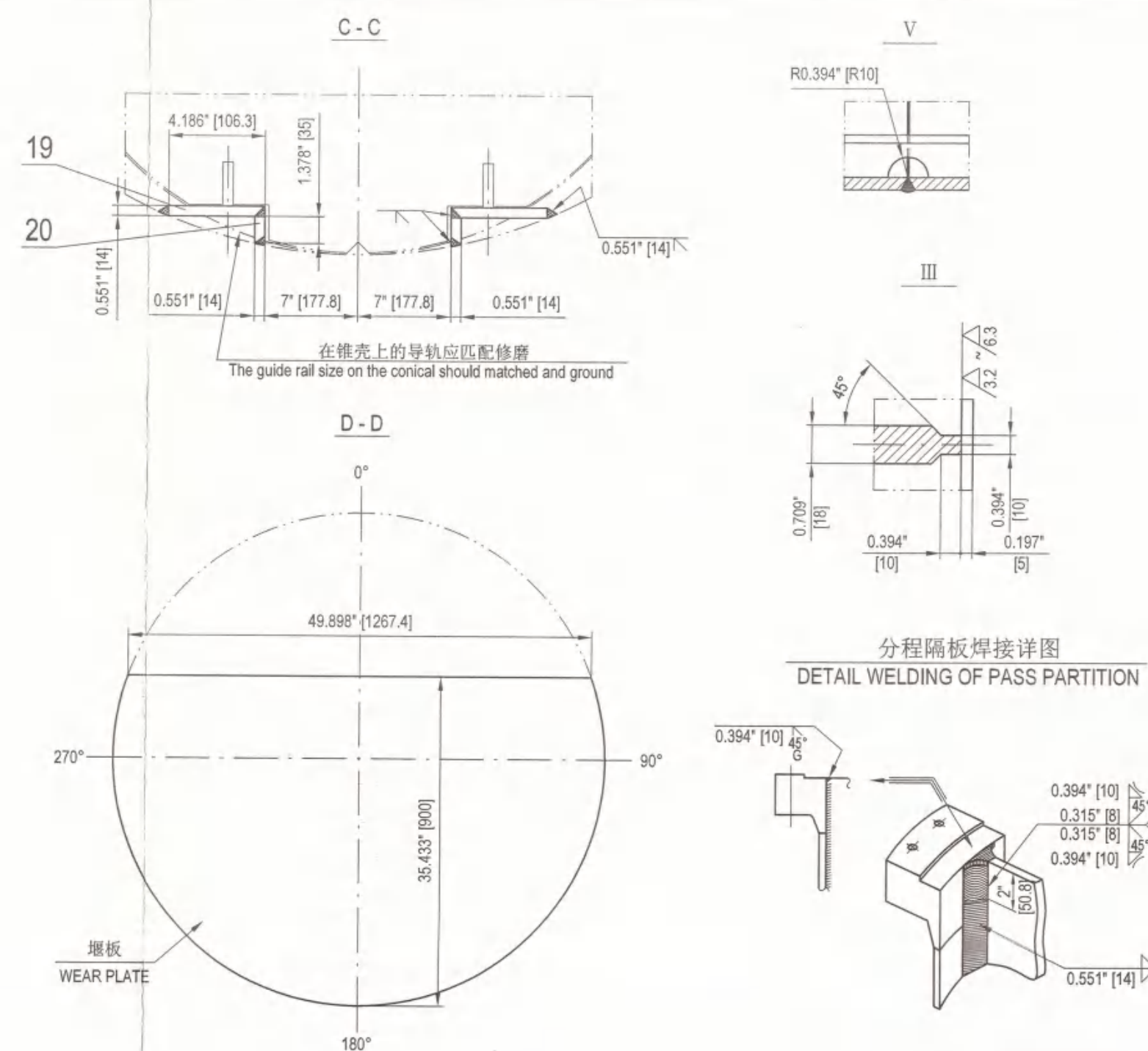
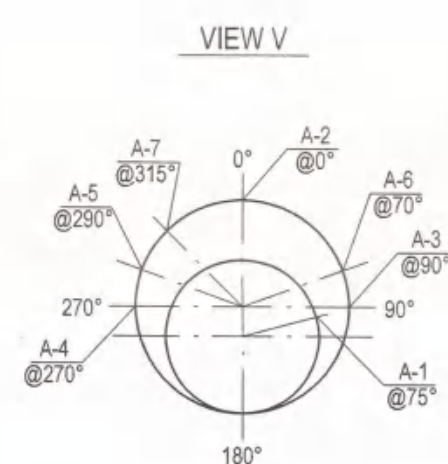
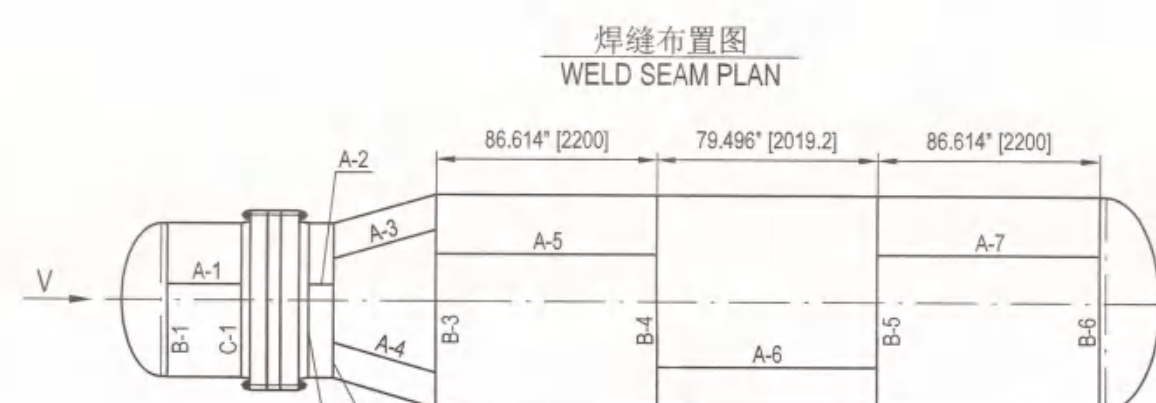
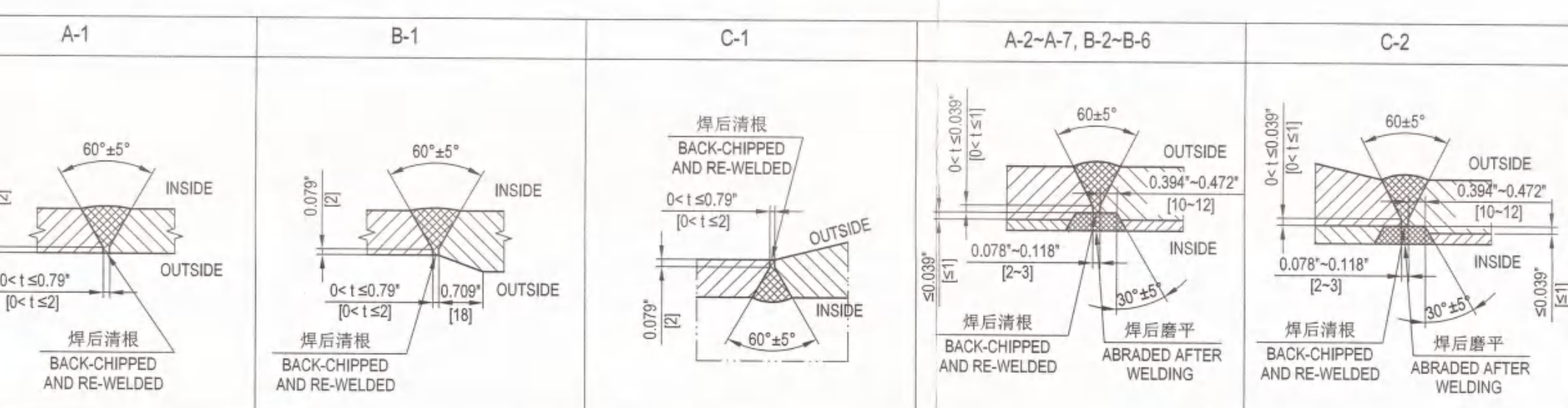
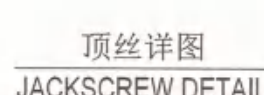
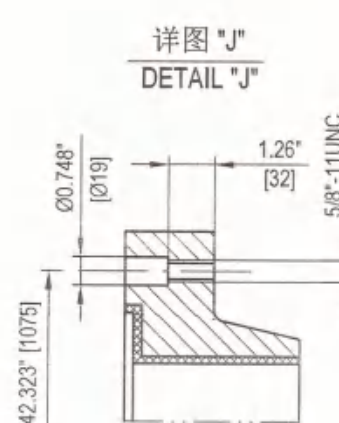
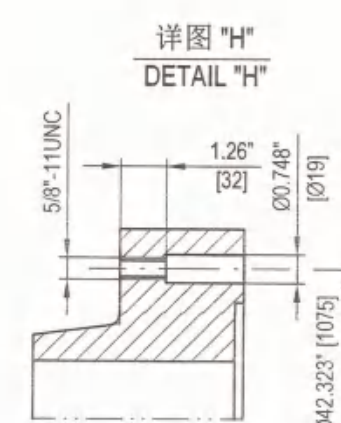
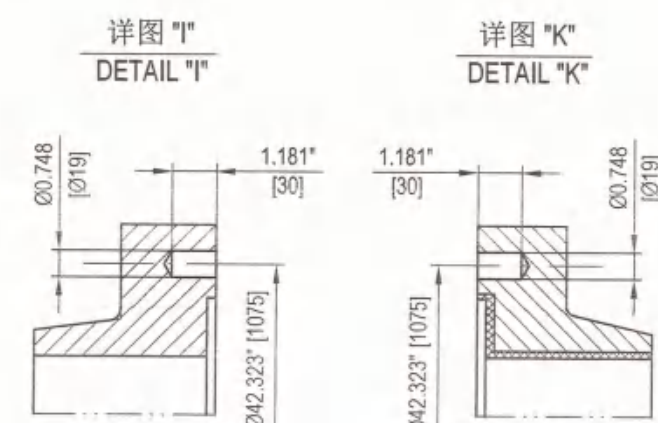
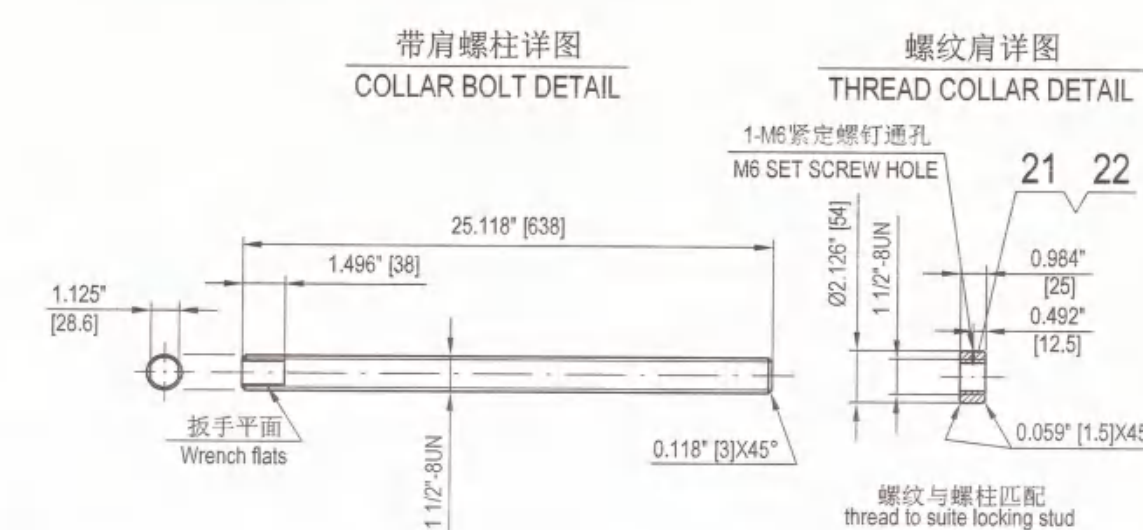
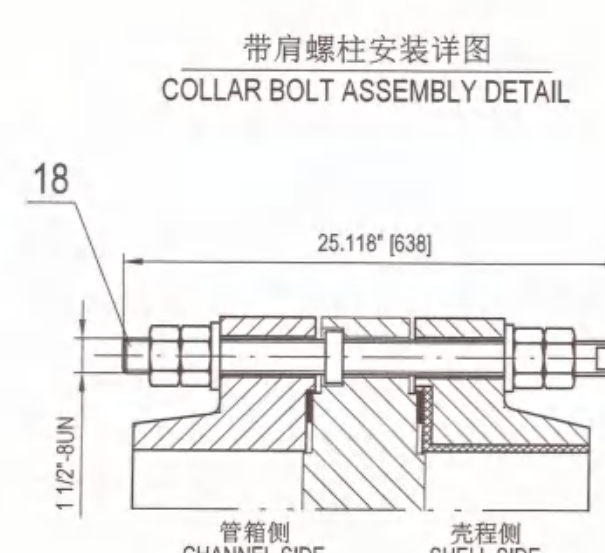
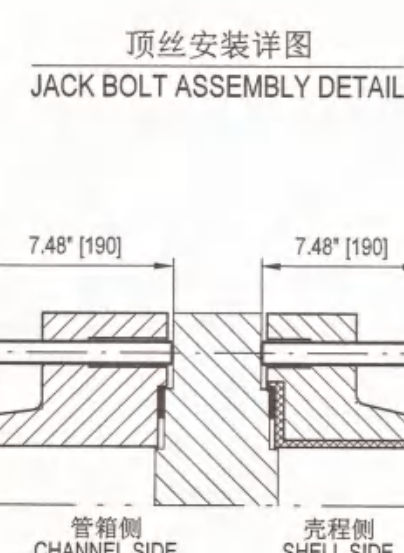
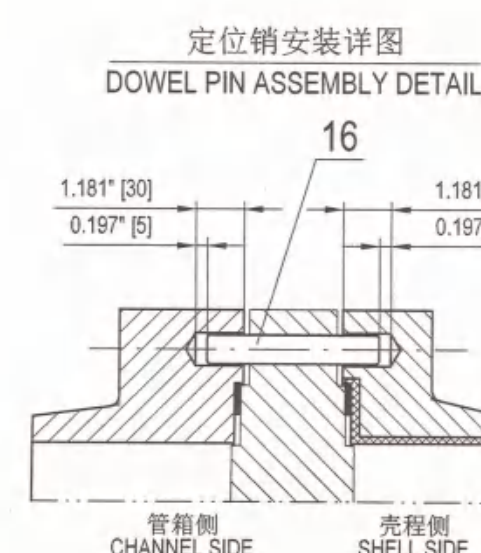
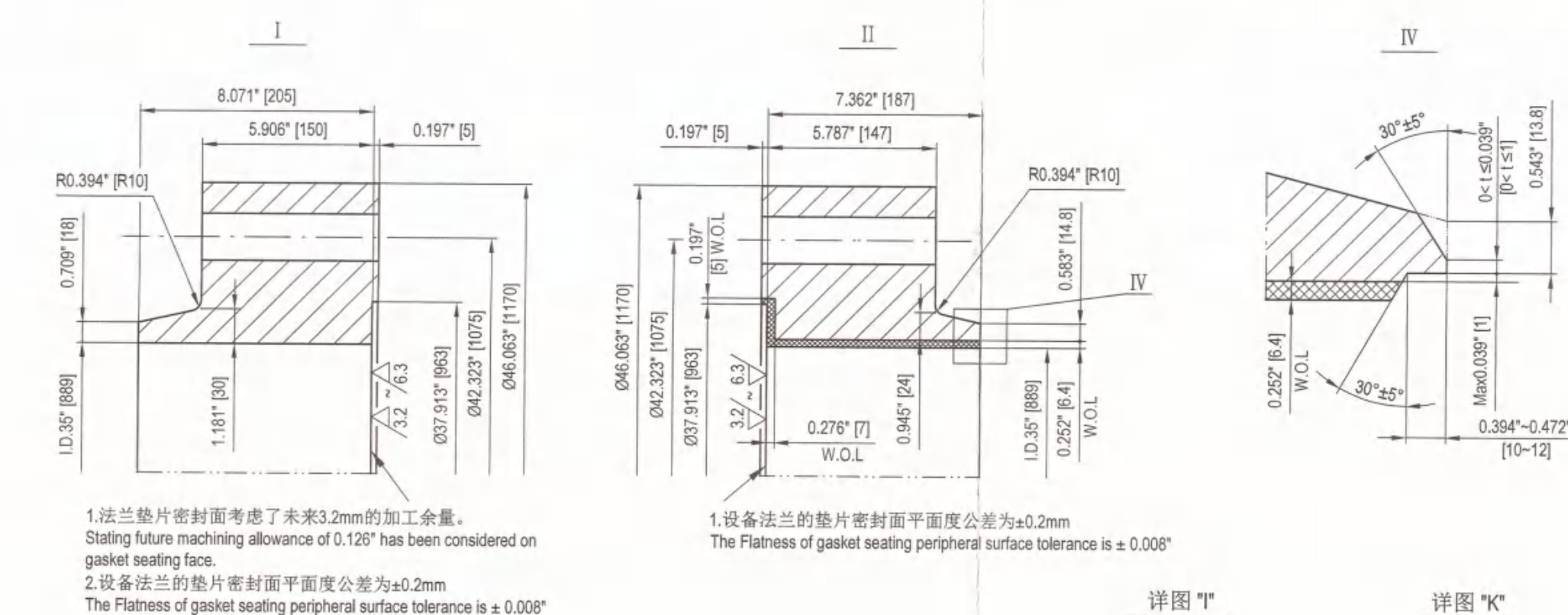


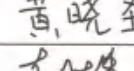
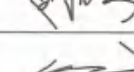
注/NOTE

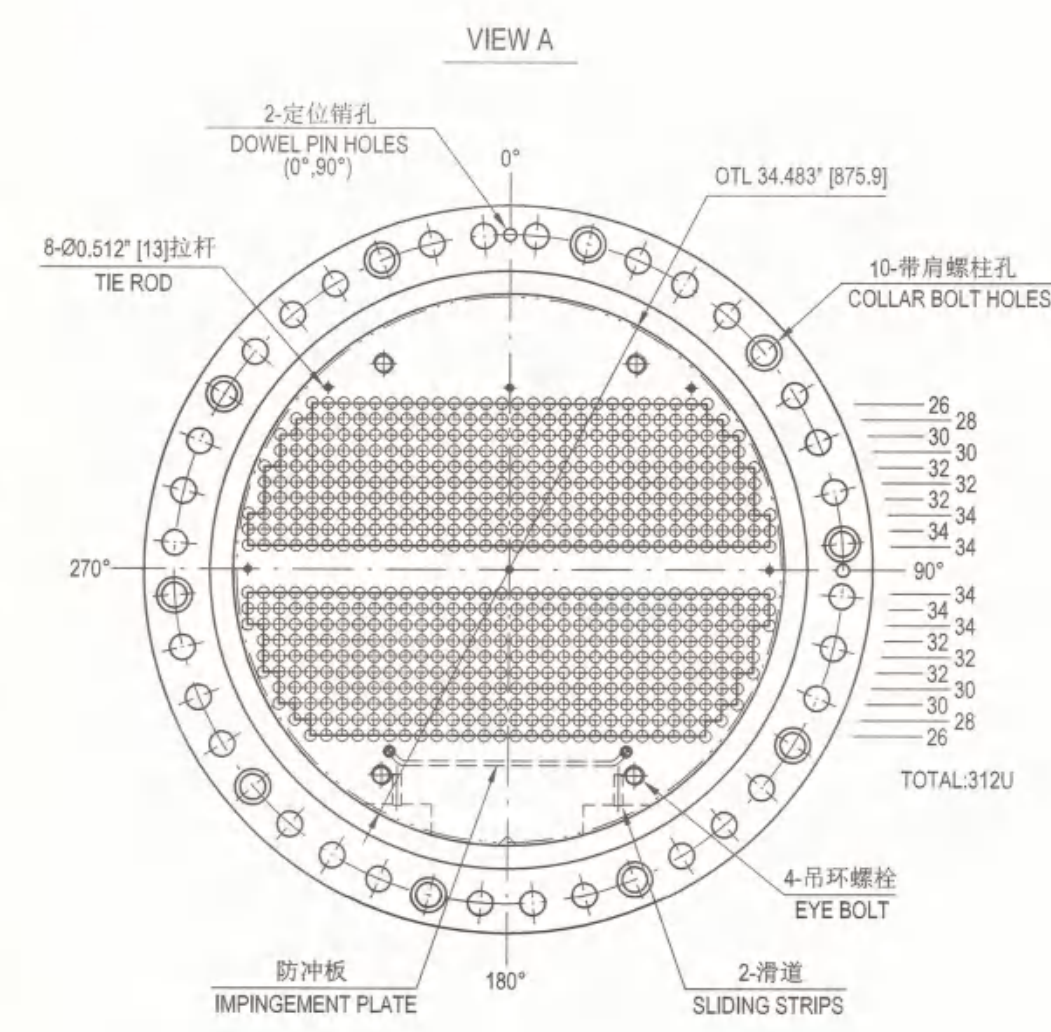
1. 垫片为KAMMPROFILE(或FLEXITALLIC 或LAMONS制作)垫片, 由3mm厚SS316L金属板 and 上下两层0.5mm厚的石墨组成; THE GASKET IS KAMMPROFILE(EITHER FLEXITALLIC OR LAMONS MAKE); THICKNESS OF PERIPHERAL GASKETS SHALL BE 3mm+0.5mm+0.5mm GRAPHITE LAYERS IN BOTH SIDES. SERRATED METAL MATERIAL IS SS316L.

2. 垫片系数: GASKET FACTORY IS $m=4.25, v=10100 \text{ psi}$.



							TOTAL : 6670 kg	
22	ISO 7434	紧定螺钉 M5 L=9 SET SCREW	10+2	22H	/	/		
21		螺纹肩 THREAD COLLAR	10+2	SA-194 Gr.2HM	0.1	1.0		
20		导轨 35X14X5920 GUIDE RAIL	2	SA-240 316L	33.6	67.2		
19		导轨 106.3X14X5920 GUIDE RAIL	2	SA-240 316L	77.9	156		
18		带肩螺栓 COLLAR BOLT	10+2	SA-193 Gr.B7M	5.2	52.0		
17		顶丝 5/8"-11UNC L=190 JACKSCREW	8	SA-479 304	0.3	1.2		
16		定位销 DOWEL PIN	2	SA-479 304	0.3	0.6		
15		分程隔板 t=18 PASS PARTITION	1	SA-516 Gr.70N		134		
14		堰板 t=14 WEIR PLATE	1	SA-240 316L		110		
13		2:1 椭圆封头 ID.1346.2X(12+4) 2:1 ELLIPTICAL HEAD	1	SA-516 Gr.70N + CLAD SA-240 316L		274	After forming: 10+2	
12		壳体 ID.1346.2X(14+3.2) L=6419.2 SHELL	1	SA-516 Gr.70N + CLAD SA-240 316L		3713		
11		锥壳 t=18+3.2 CONICAL	1	SA-516 Gr.70N + CLAD SA-240 316L		491		
10		壳体 ID.889X(18+3.2) L=150 SHELL	1	SA-516 Gr.70N + CLAD SA-240 316L		71.4		
9		壳程法兰 SHELL FLANGE	1	SA-266 Gr.2N + SS316L OVERLAY		499		
8		壳程法兰垫片 SHELL FLANGE GASKET	1+2	见注 1/See note 1	/			
7		管程法兰垫片 CHANNEL FLANGE GASKET	1+2	见注 1/See note 1	/			
6		管箱法兰 CHANNEL FLANGE	1	SA-266 Gr.2N		516		
5	ASME PCC-1- 2019 APPENDIX M	硬质圆垫圈 1 1/2" HARDENED CIRCLE WASHER	80+10	TYPE 4	/	/		
4	ASME B16.2.2-2022	重型六角螺母 1 1/2"-8UN-2B HEX HEAVY NUTS	160+20	SA-194 Gr.4HM	0.4	32.0		
3	ASME B16.2.1-2012 (R2021)	全螺纹螺栓 1 1/2"-8UN-2A L=800 FULL THREADED STUD BOLTS	30+3	SA-193 Gr.B7M	5.0	200		
2		管箱筒体 ID.889X18 L=634 CHANNEL SHELL	1	SA-516 Gr.70N		255.3		
1		2:1 椭圆封头 ID.889X12(10) 2:1 ELLIPTICAL HEAD	1	SA-516 Gr.70N		94.0		
件 号	图号或标准号	名 称	数 量	材 料	重 量(kg)	准 则	备 注	
PART NO.	DWG. NO. OR STD. NO.	DESIGNATION	QTY.	MATERIAL	WEIGHT(kg)	STANDARD	REMARKS	

											
Air Products Project Number	EN207122	Fluor Project Number	ABKM								
Project Name	World Energy Renewables Project	RFO No.	ABKM-4-403-RQ								
Purchase Order Number	4505600570	PO/Contract No	ABKM-4-403-PO-4								
Air Products Open Text document number	EN207122-WUX-9V3-00069	Project Area	SWHSZHS								
Client	WORLD ENERGY PARAMOUNT	Client Doc No:									
05	竣工图/AS-BUILT	Xiaosheng Huang	Shengfang Zhao Kevin Yang 15-APR-23								
04	供批准备/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao Kevin Yang 10-JAN-23								
03	供批准备/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao Kevin Yang 18-OCT-22								
02	供批准备/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao Kevin Yang 11-Aug-22								
01	供批准备/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao Kevin Yang 14-Jun-22								
00	供批准备/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao Kevin Yang 24-Mar-22								
版次REV.	版次说明/DESCRIPTION	设计/PREPARED	审核/REVIEWED 批准/APPROVED 日期/DATE								
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 无锡化工装备股份有限公司 WUXI CHEMICAL EQUIPMENT CO., LTD.		<table><tr><td>设计项目 DESIGN ITEM</td><td>World Energy Renewables Project</td></tr><tr><td>设计阶段 DESIGN PHASE</td><td>竣工图 AS BUILT</td></tr><tr><td>设计编号 ITEM NO.</td><td>18-X-270</td></tr><tr><td>图号 DWG. NO.</td><td>WXCE6703-01</td></tr></table>		设计项目 DESIGN ITEM	World Energy Renewables Project	设计阶段 DESIGN PHASE	竣工图 AS BUILT	设计编号 ITEM NO.	18-X-270	图号 DWG. NO.	WXCE6703-01
设计项目 DESIGN ITEM	World Energy Renewables Project										
设计阶段 DESIGN PHASE	竣工图 AS BUILT										
设计编号 ITEM NO.	18-X-270										
图号 DWG. NO.	WXCE6703-01										
设计 PREPARED	曹晓至	2023.4.15	AGR1 Amine Regen Reboiler SHELL DETAIL DRAWING								
审核 REVIEWED		2023.4.13									
批准 APPROVED		2023.4.15									
比例: SCALE		1:1	版次: REV.								
			05								
		第 1 页 共 1 页 PAGE 1 OF 1									



序号 NO.	弯曲半径(R(mm) BENDING R(mm)	单根展开长度(mm) TOTAL LENGTH	数量 QTY.	单重(Kg) UNIT WEIGHT	总重(Kg) TOTAL WEIGHT	固溶退火处理 SOLUTION ANNEAL
1	1.5 [36.1]	488.74 [12414]	34	8.9	304	YES/要
2	1.5 [36.1]	481.68 [12194]	34	9.1	306	YES/要
3	3.5 [88.9]	455.0 [11573]	34	9.0	302	YES/要
4	4.5 [114.3]	498.15 [12453]	32	9.1	295	YES/要
5	5.5 [138.7]	501.29 [12733]	32	9.2	293	YES/要
6	6.5 [165.1]	504.44 [12813]	32	9.2	295	YES/要
7	7.5 [190.5]	507.59 [12893]	30	9.3	278	YES/要
8	8.5 [215.9]	510.70 [12972]	30	9.3	280	YES/要
9	9.5 [241.3]	513.85 [13052]	28	9.4	263	YES/要
10	10.5 [266.7]	517.00 [13132]	26	9.5	246	YES/要

注意:

T型管应遵守以下试验方法：在符合AS-789SA-TSM、ASD和电偶电流测试时应按照AS-1016ESA-1016M。电阻式热流计测试应在符合AS-789SA-TSM、ASD和电偶电流测试时按照AS-1016ESA-1016M进行校准验证。

电测法测试必须使用热电偶套管一个，将所有的热电偶按规范安装并能对热电偶管运行的所有无检测类型和范围

2号管子，中压管ASD 100%PT测试

A) 当热端 U-tube 应该被水冷却到 100 °F

B) 3号U型管管后应进入水压试验站，该压力不应低于热交换器管和侧壳试验压力的较大值

A) 当热端 U-tube 应该遵守以下试验方法：在符合ASD和电偶电流测试时，水和蒸汽测试不应该比最大的设计值的热应力测试的管子侧壳和侧壳上的热交换器

C) 管嘴的壁厚不应该超过平均公称尺寸的10%。

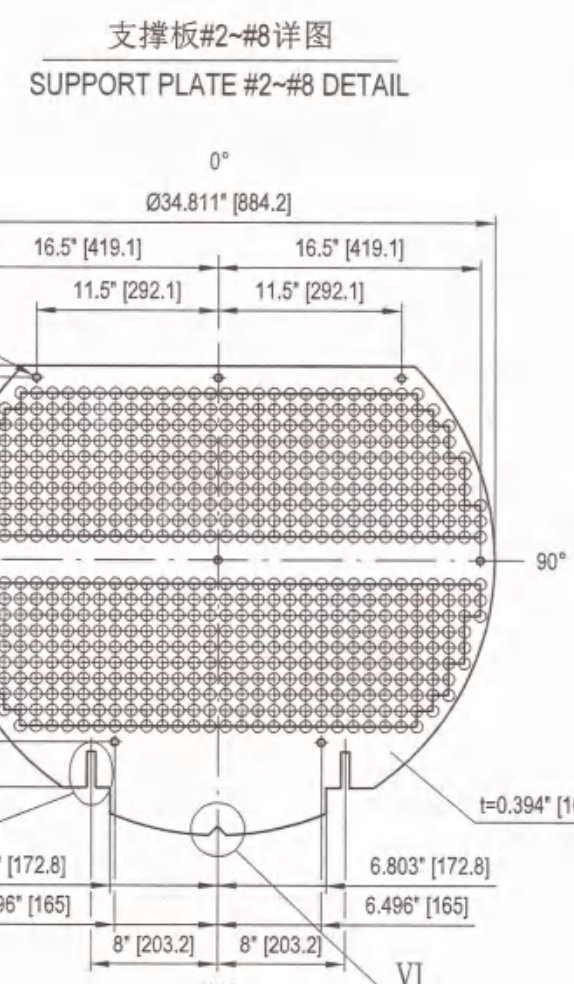
F) Flattening at the bend shall not exceed 10% of the nominal tube outside diameter.

G) 热处理工艺为退火处理，每根U型管都应经过退火处理。

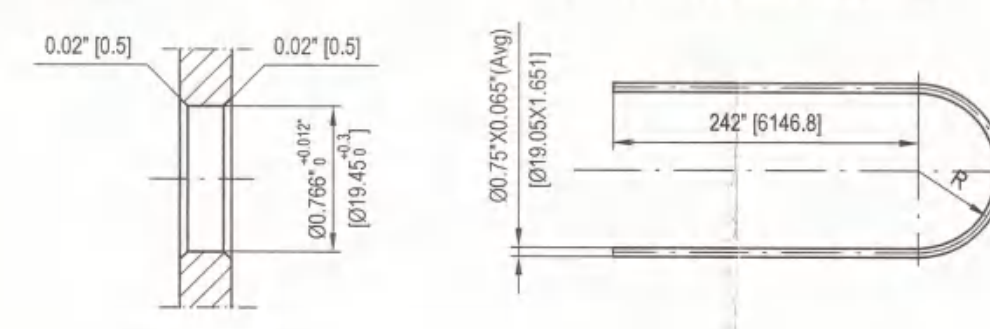
H) The tubes shall be seamless; U-tubes shall be of one piece construction.

I) U型管焊口其尺寸应符合150mm长接管段进行圆筒退火热处理。热处理应用电力夹方法，程序如下：

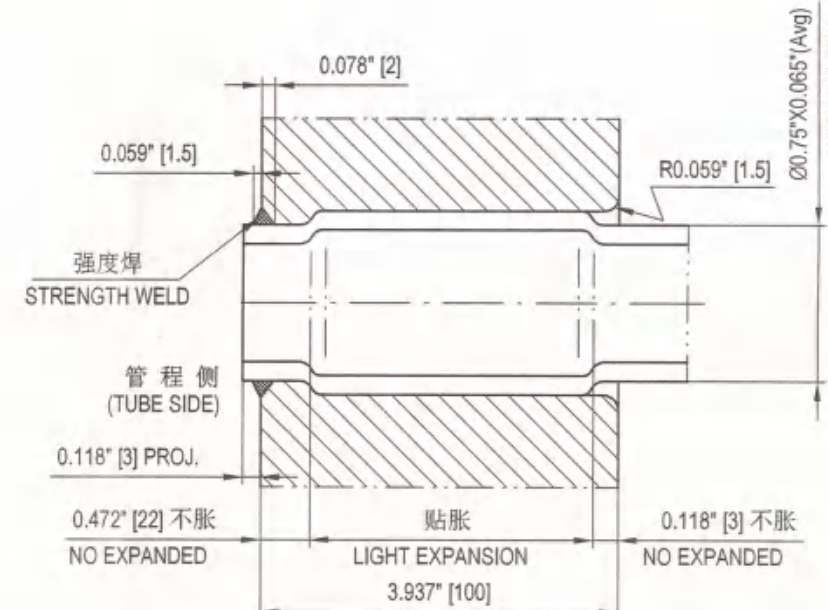
Tube u-tends shall receive post weld solution annealing heat treatment. Heat treatment shall use electric clamp methods, and the procedure shall be submitted to Buyer for approval. Furnace heat treatments are not allowed



换热管尺寸表 TUBES CHAR



防冲板详图



防冲板详图

IMPINGEMENT PLATE DETAIL

50

45°

0.591 [15]

0.394 [10]

2 [50.8]

14.89 [378.2]

切成2瓣
CUT INTO 2 DISC

R12.992 [333.0]

0.276 [7]

0.276 [7]

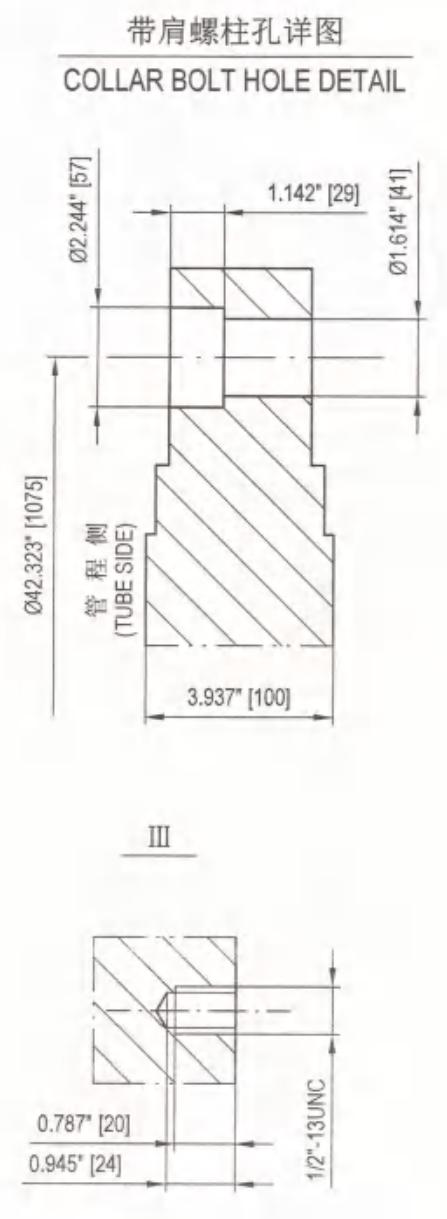
0.162 [4.1]

0.394 [10]

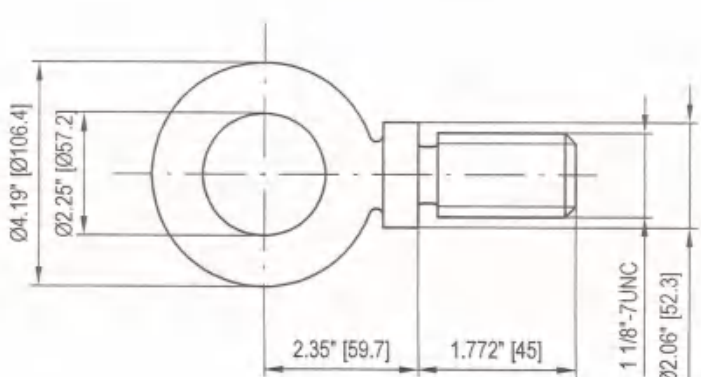
14.89 [378.2]

定位销孔详图

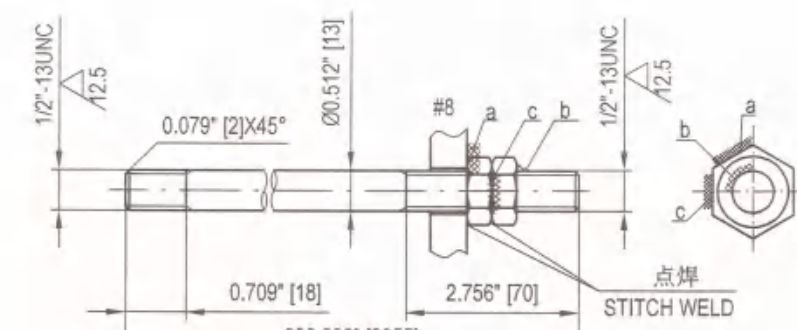
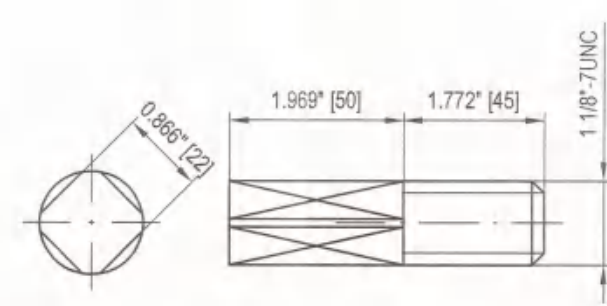
DOWEL PIN HOLE DETAIL



件号49详图
DETAIL OF PART NO.49



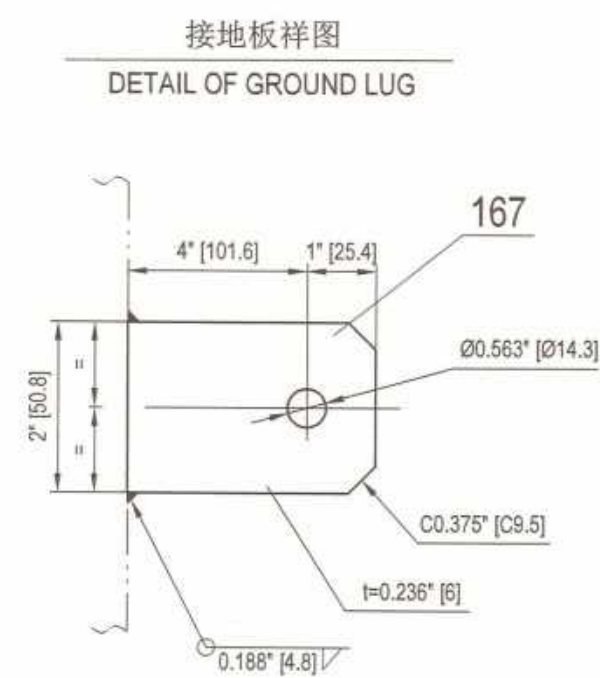
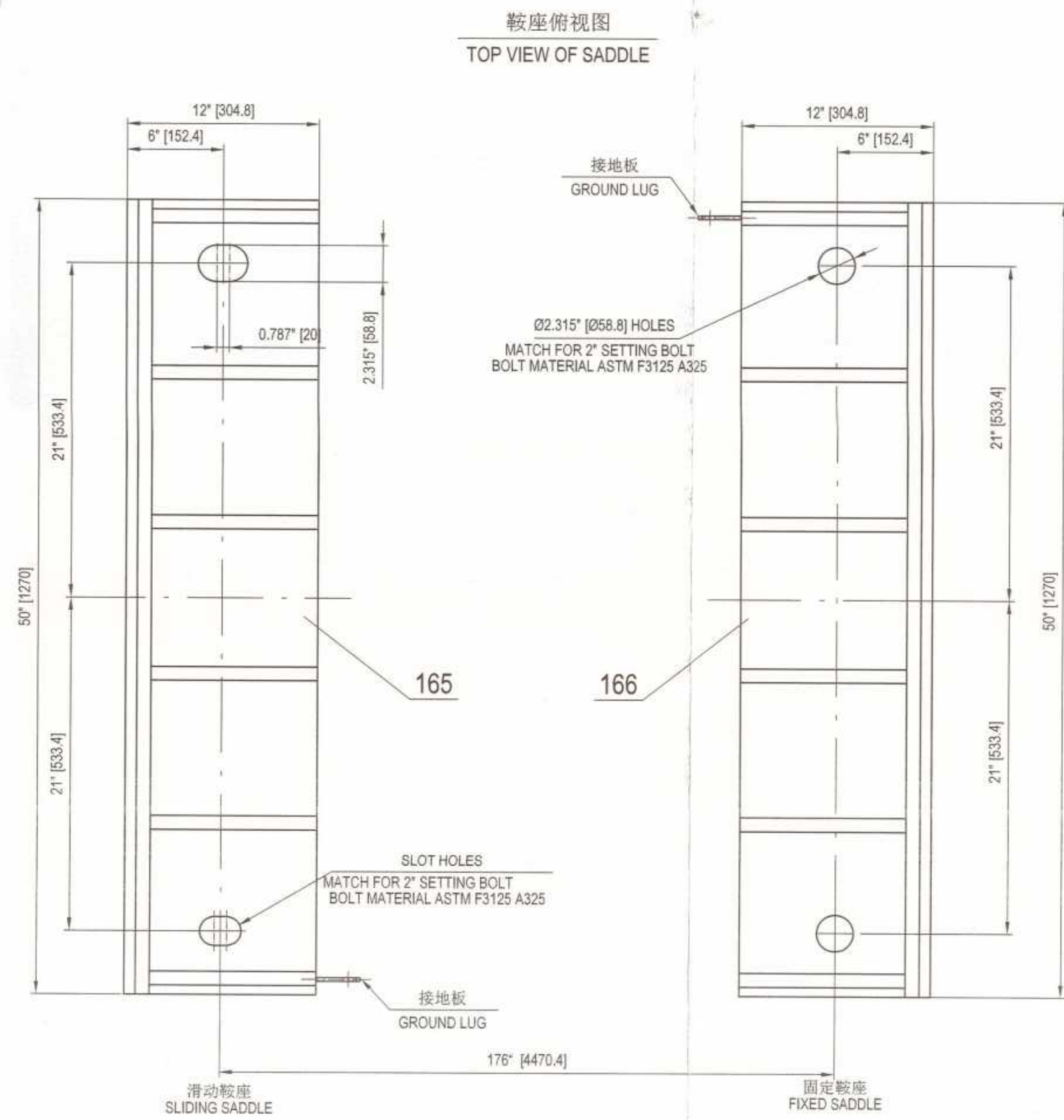
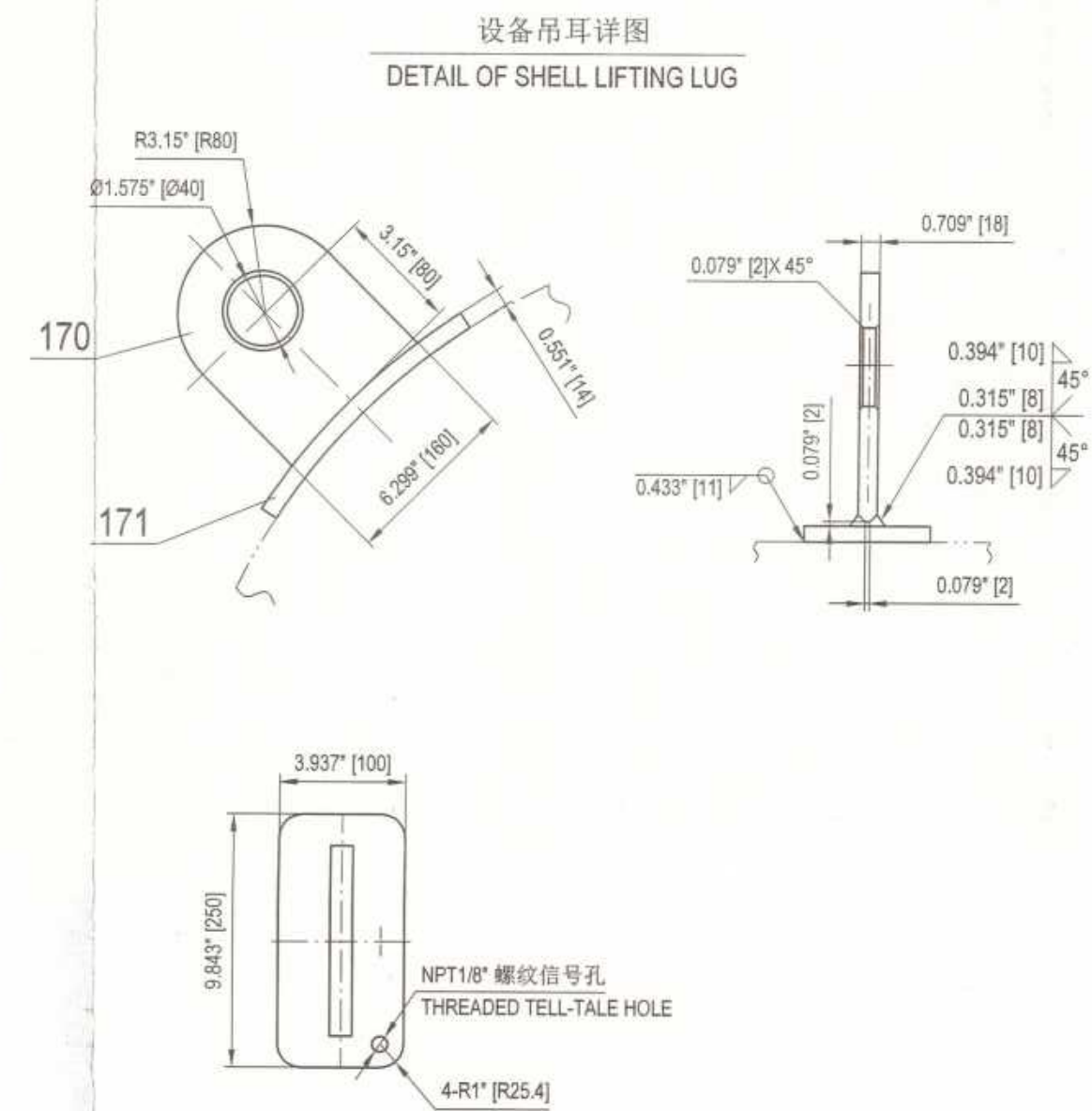
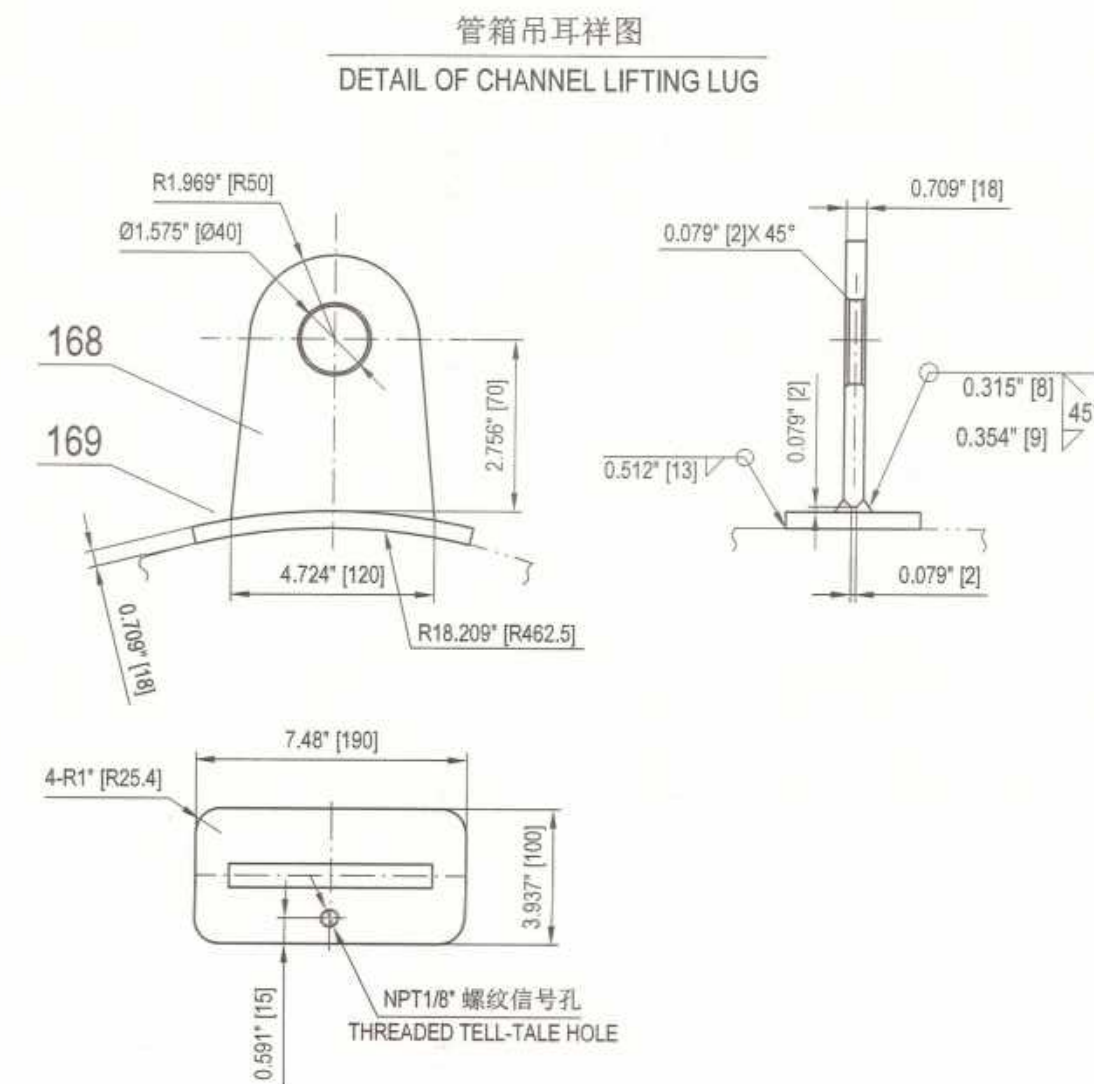
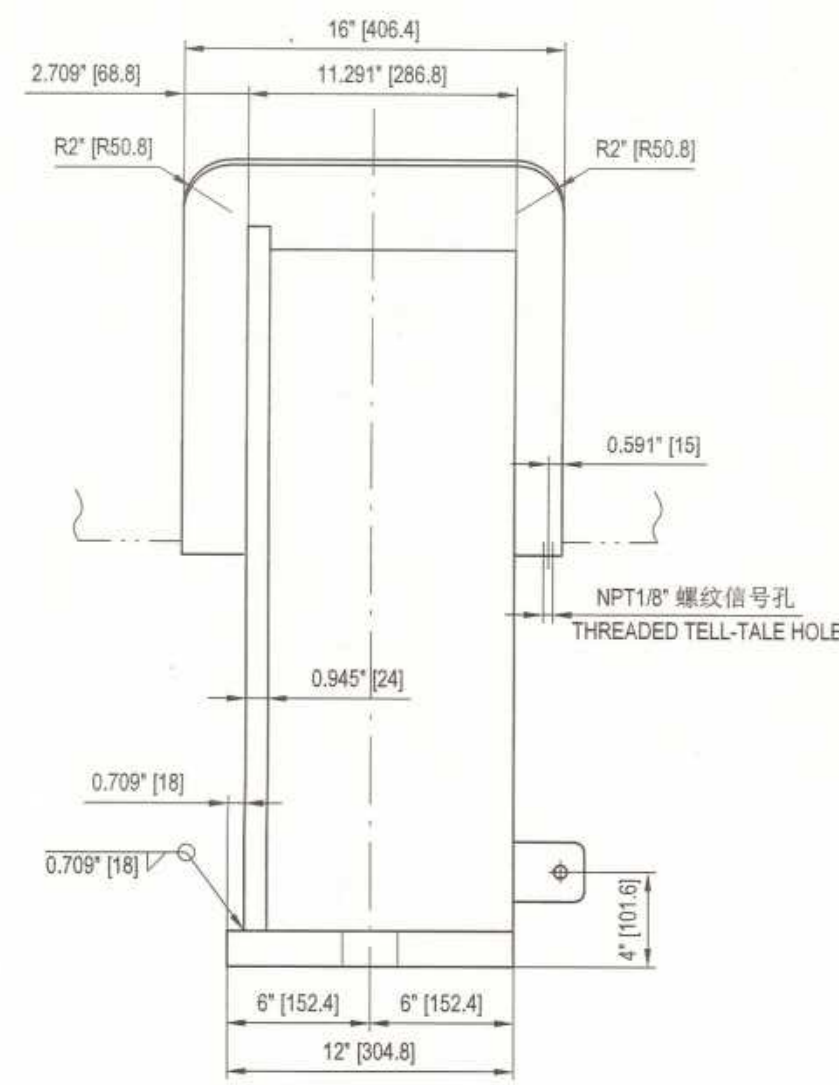
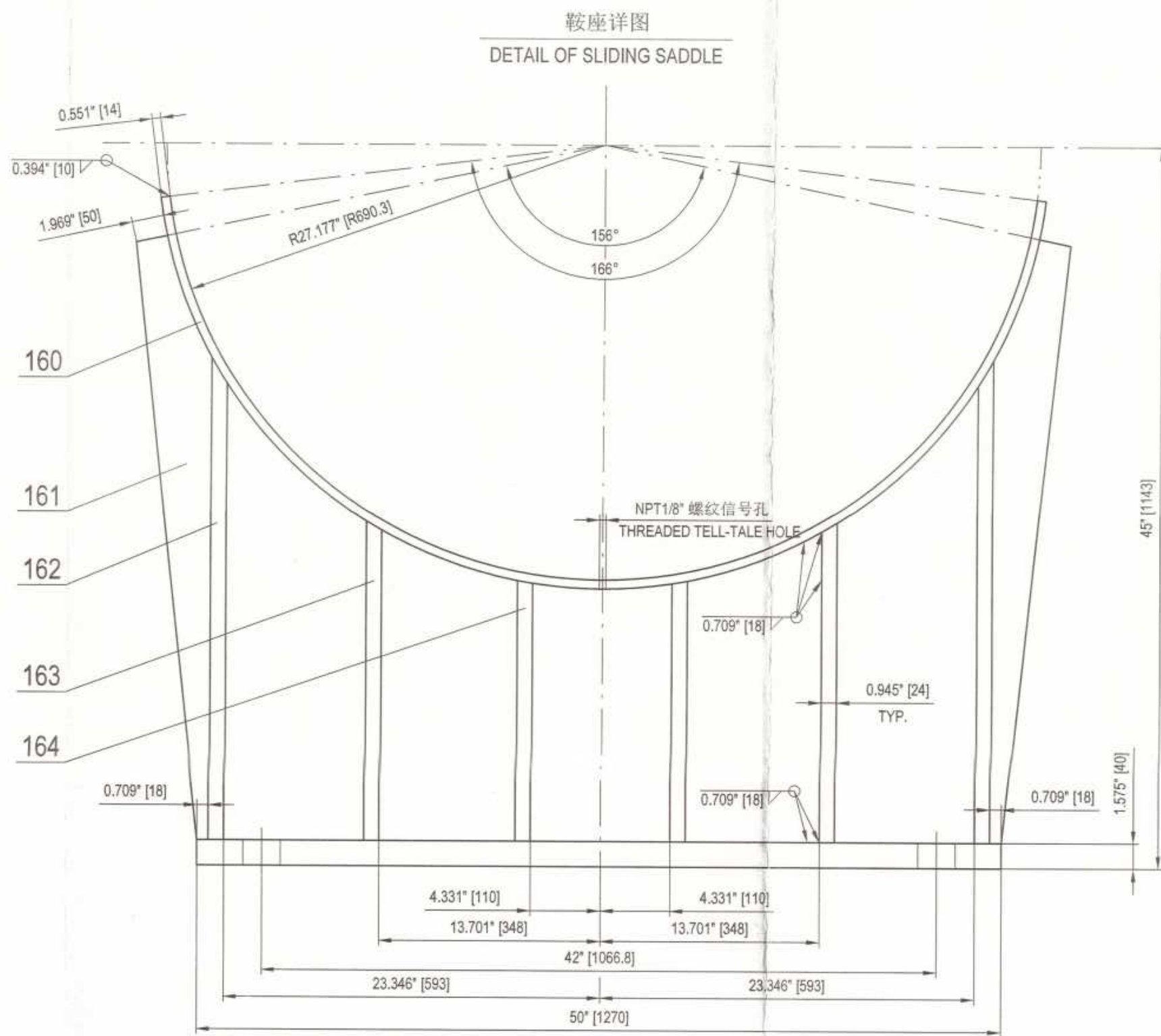
拉杆详图
DETAIL OF TIE ROD



- 将第1个螺母焊接到支撑板上/Weld 1st nut to support plate
- 将第2个螺母焊接到拉杆上/Weld 2nd nuts to tie rod
- 将两个螺母焊接在一起/Weld both nuts together

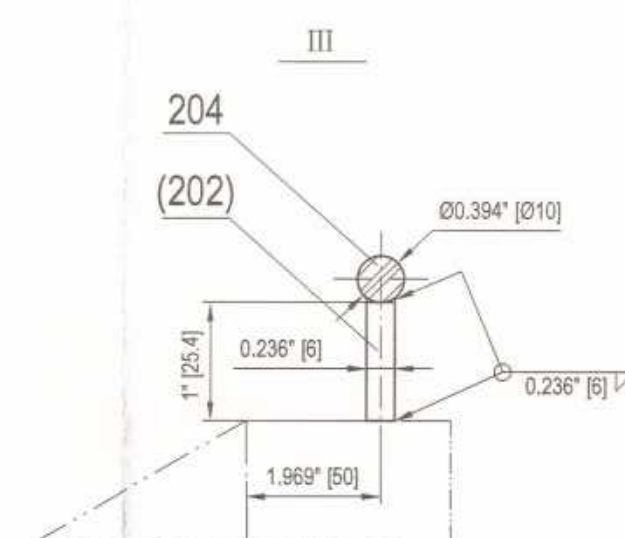
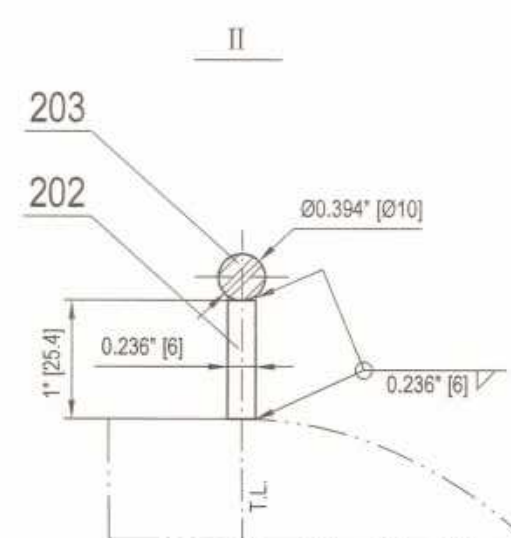
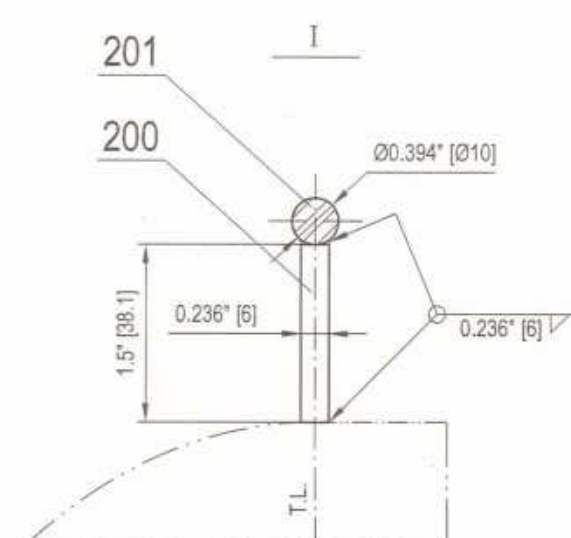
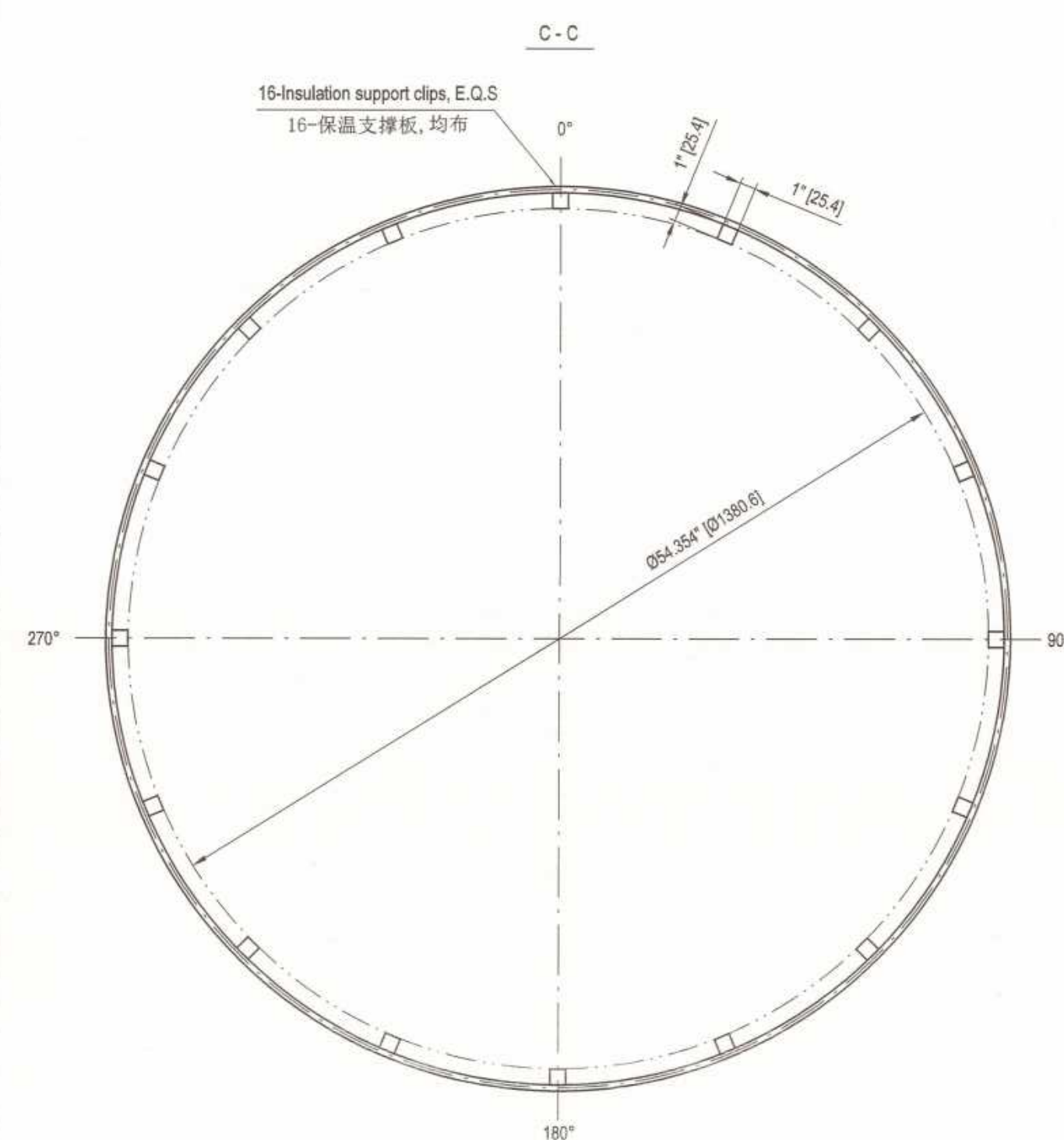
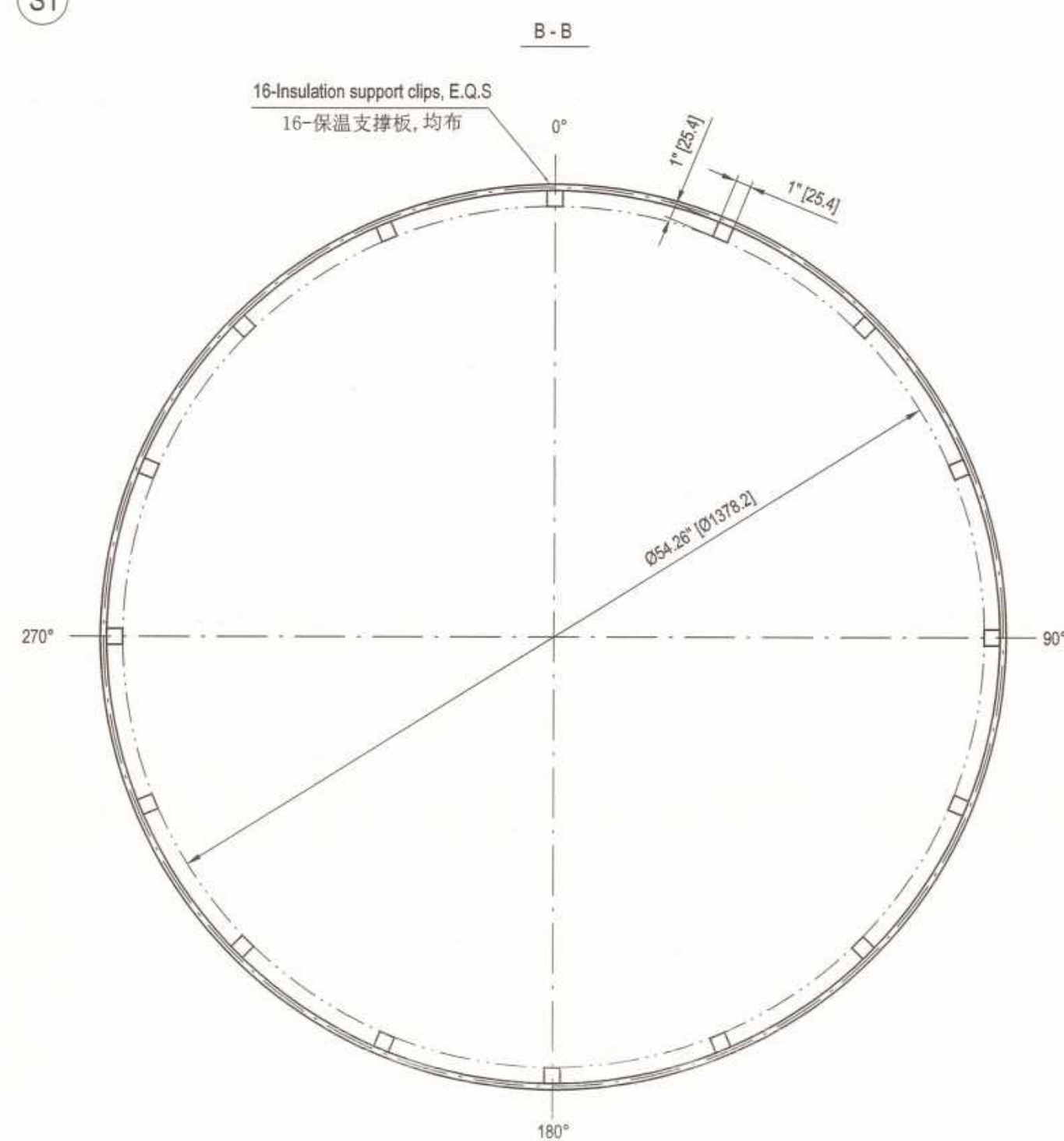
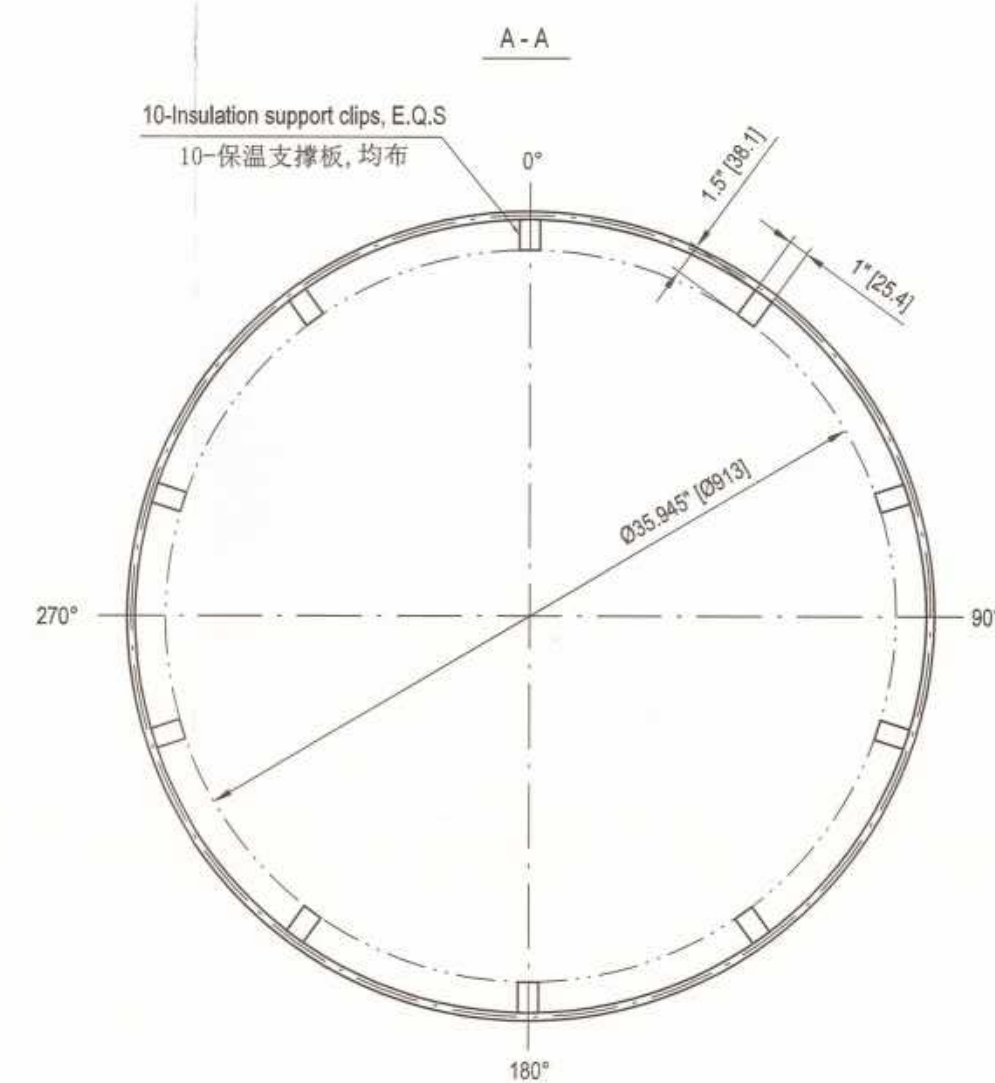
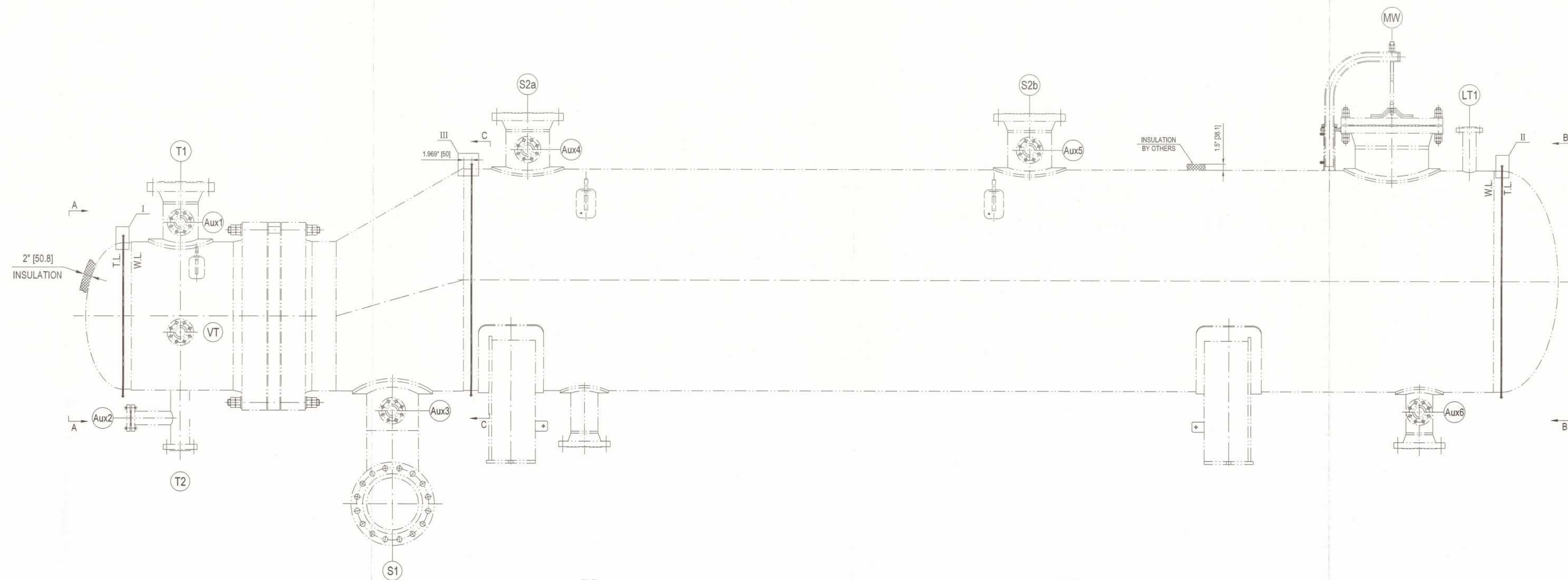
TOTAL : 3910 kg						
51	滑道 t=14 SLIDING STRIPS	2	SA-240 316L	33.3	66.6	
50	防冲挡板 t=10 IMPINGEMENT PLATE	1	SA-240 316L		8.7	
49	螺塞 PLUGS	4	SA-182 F60	0.5	2.0	
48	CROSBY S-279 吊环螺栓 1 1/8"-7UNC L=45 EYE BOLT	4	SA-182 F60	1.0	4.0	
47	ASME B18.2.2-2022 六角螺母 1/2"-13UNC-2B HEX NUT	16	SA-194 Gr.B8MA	0.05	0.8	
46	拉杆 Ø13 L=6055 TIE RODS	8	SS316L	6.4	51.2	
45	定距管 Ø19.05X1.651 L=749.8 SPACERS	56	SA-213 TP316L	0.54	30.2	
44	支撑板#2-#8 t=10 SUPPORT BAFFLE	7	SA-240 316L	34.2	239	
43	支撑板#1 t=10 SUPPORT BAFFLE	1	SA-240 316L		32.0	
42	定距管 Ø19.05X1.651 L=674.3 SPACERS	8	SA-213 TP316L	0.48	3.8	
41	换热管 Ø19X1.651 (Avg) TUBES	312U	SA-789 S32205	2865		(SEALMESS)
40	管板 TUBESHEET	1	SA-182 F60		606	
件 号	图号或标准号	名 称	数 量	材 料	单 重(kg)	备 注
PART NO.	DWG. NO. OR STD. NO.	DESIGNATION	QTY.	MATERIAL	WEIGHT	REMARKS

			
Air Products Project Number	EN207122	Fluor Project Number	A8KM
Project Name	World Energy Renewables Project	RFQ No.	A8KM44-403-RQ
Purchase Order Number	45005600570	PO/Contract No	A8KM44-403-PC-4
Air Products Open Text document number	EN207122-WUJH-9V3-00069	Project Area	SWSH2S
Client	WORLD ENERGY PARAMOUNT	Client Doc No:	
05	竣工图 AS-BUILT	Xiaosheng Huang	Shengfang Zhao
04	供批准 / ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao
03	供批准 / ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao
02	供批准 / ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao
01	供批准 / ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao
00	供批准 / ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao
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		批准/APPROVED	日期/DATE
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无锡化工装备股份有限公司 WUXI CHEMICAL EQUIPMENT CO., LTD.		设计项目 设计阶段 施工图 AS BUILT	
设计 PREPARED	黄晓生 2023.4.15	设备位号 ITEM NO. 18-X-270	
审核 REVIEWED	李强 2023.4.15	图号 DWG. NO. WXC6703-02	
批准 APPROVED	2023.4.15	比例: SCALE 1:1	版次: REV. 05
		第 1 页 共 1 页 Page 1 OF 1	



							TOTAL : 850 kg	
171		垫板 t=14 WEAR PLATE	4	SA-516 Gr.70N	2.8	11.2		
170		吊耳板 t=18 LUG	4	SA-516 Gr.70N	2.2	8.8		
169		垫板 t=18 WEAR PLATE	2	SA-516 Gr.70N	1.0	2.0		
168		吊耳板 t=18 LUG	2	SA-516 Gr.70N	1.3	2.6		
167		接地板 t=6 GROUND LUG	2	SA-240 304	0.2	0.4		
166		底板 t=40 BASE PLATE	1	SA-516 Gr.70N		97.6		
165		底板 t=40 BASE PLATE	1	SA-516 Gr.70N		97.6		
164		筋板 t=24 RIB PLATE	4	SA-516 Gr.70N	16.1	64.4		
163		筋板 t=24 RIB PLATE	4	SA-516 Gr.70N	19.9	79.6		
162		筋板 t=24 RIB PLATE	4	SA-516 Gr.70N	29.8	119		
161		腹板 t=24 WEB PLATE	2	SA-516 Gr.70N	108	216		
160		垫板 t=14 WEAR PLATE	2	SA-516 Gr.70N	70.9	142		
件号	图号或标准号	名称	数量	材料	单重(kg)	总重(kg)	备注	
PART NO.	DWG. NO. OR STD. NO.	DESIGNATION	QTY.	MATERIAL	WEIGHT	WEIGHT	REMARKS	

AIR PRODUCTS		AS		FLUOR			
Air Products Project Number		EN207122		Fluor Project Number			
Project Name		World Energy Renewables Project		RFQ No.			
Purchase Order Number		4505600570		PO/Contract No			
Air Products Open Text document number		EN207122-WUXI-SV3-00069		Project Area			
Client		WORLD ENERGY PARAMOUNT		Client Doc No:			
05	竣工图/AS-BUILT		Xiaosheng Huang	Shengfang Zhao	Kevin Yang	15-APR-23	
04	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang	Shengfang Zhao	Kevin Yang	10-JAN-23	
03	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang	Shengfang Zhao	Kevin Yang	18-OCT-22	
02	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang	Shengfang Zhao	Kevin Yang	11-Aug-22	
01	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang	Shengfang Zhao	Kevin Yang	14-Jun-22	
00	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang	Shengfang Zhao	Kevin Yang	24-Mar-22	
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WCE		无锡化工装备股份有限公司 WUXI CHEMICAL EQUIPMENT CO.,LTD.				设计项目 DESIGN ITEM World Energy Renewables Project 竣工图 AS BUILT 设备位号 ITEM NO. 图号 DWG. NO. WXCE6703-05	
设计 PREPARED	曹晓至	2023.4.15	AGR1 Amine Regen Reboiler				
审核 REVIEWED	李锐	2023.4.15	SADDLE AND LIFTING LUG DETAIL DRAWING				
批准 APPROVED	李锐	2023.4.15	比例: SCALE	1:1	版次: REV.	05	第 1 页 共 1 页 PAGE 1 OF 1



As Built

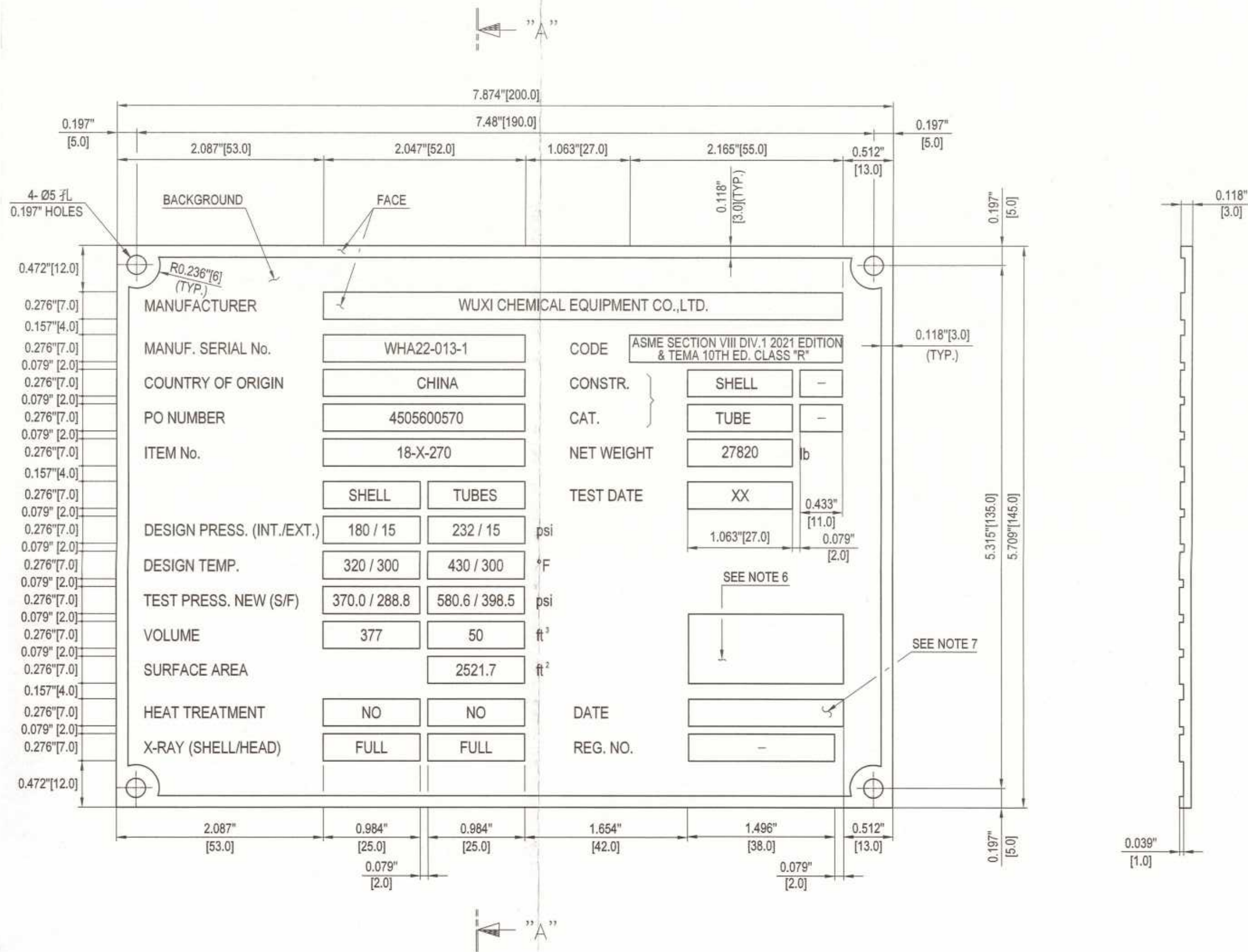
204	保温支撑环 Ø10 INSULATION SUPPORT RING	1	SA-36		2.8	
203	保温支撑环 Ø10 INSULATION SUPPORT RING	1	SA-36		2.8	
202	保温支撑板 t=6 INSULATION SUPPORT CLIP	32	SA-516 Gr.70N	0.03	1.0	
201	保温支撑环 Ø10 INSULATION SUPPORT RING	1	SA-36		1.9	
200	保温支撑板 t=6 INSULATION SUPPORT CLIP	10	SA-516 Gr.70N	0.04	0.4	
件 号 PART NO.	图号或标准号 DWG. NO. OR STD. NO.	名 称 DESIGNATION	数 量 QTY.	材 料 MATERIAL	重量(kg) WEIGHT	备 注 REMARKS

AIR PRODUCTS			FLUOR		
Air Products Project Number		EN207122	Fluor Project Number		ABKM
Project Name		World Energy Renewables Project	RFQ No.		ABKM-4-403-RQ
Purchase Order Number		4505600570	PO/Contract No		ABKM-4-403-PO-4
Air Products Open Text document number		EN207122-WUXI-SV3-00063	Project Area		SWS/H2S
Client		WORLD ENERGY PARAMOUNT	Client Doc No:		
03	竣工图/AS-BUILT	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	15-APR-23
02	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	10-JAN-23
01	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	18-OCT-22
00	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	11-Aug-22
版次 REV.	版次说明/DESCRIPTION	设计/PREPARED	审核/REVIEWED	批准/APPROVED	日期/DATE

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WCE 无锡化工装备股份有限公司 WUXI CHEMICAL EQUIPMENT CO., LTD.			设计项目 DESIGN ITEM World Energy Renewables Project 设计阶段 DESIGN PHASE 竣工图 AS BUILT		
设计 PREPARED	黄晓至	2023.4.15	AGR1 Amine Regen Reboiler		
审核 REVIEWED	张明	2023.4.15	INSULATION SUPPORT DETAIL DRAWING		
批准 APPROVED	张明	2023.4.15	比例 SCALE 1:1	版次 REV. 03	设备位号 ITEM NO. 18-X-270
			图号 DWG. NO. WXCE26-078	第 1 页 共 1 页 PAGE 1 OF 1	

标准铭牌详图
DETAIL OF STANDARD NAME PLATE



- 注:
- 除非另有说明, 否则所有尺寸均为毫米。
 - 完成后: 铭牌表面抛光处理包括采用铸印字, 背景凸起, 并涂上黑色油漆。
 - 日期: 抛光表面要插入的日期(英文)。标志可用蚀刻或模压方法标在铭牌上, 标志字符高度不小于0.157"[4mm], 字符深度不少于0.004"[0.1mm]。
 - 铭牌位置见设备装配图。
 - 水压试验后由AI和质量控制检验员一起进行钢印。

*1: NB *2: [Symbol]

- 批准钢印空间。
- 批准日期。(示例: 2019年3月1日)
- 试验日期指压力试验日期。
- REG. NO.: 注册号。

NOTES

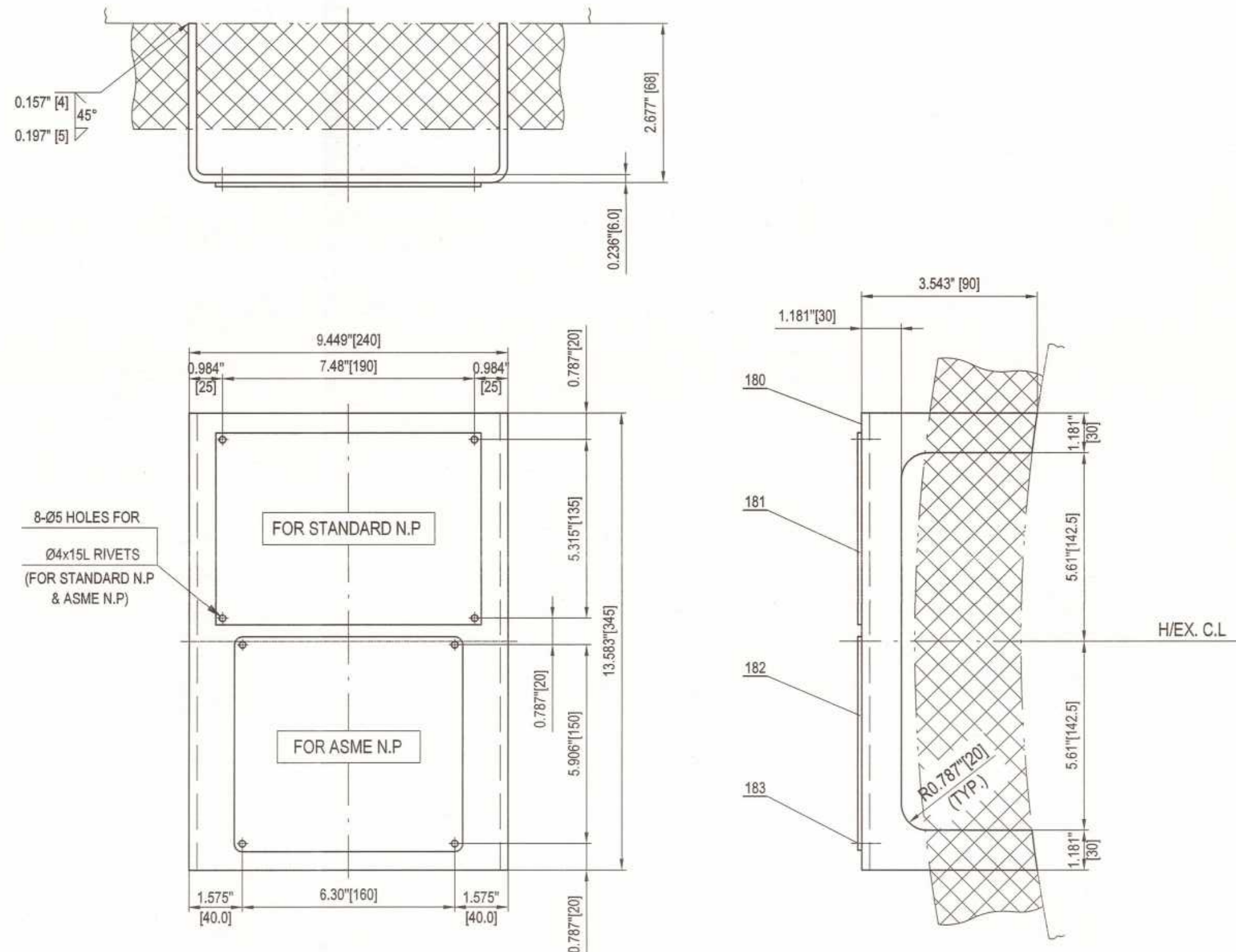
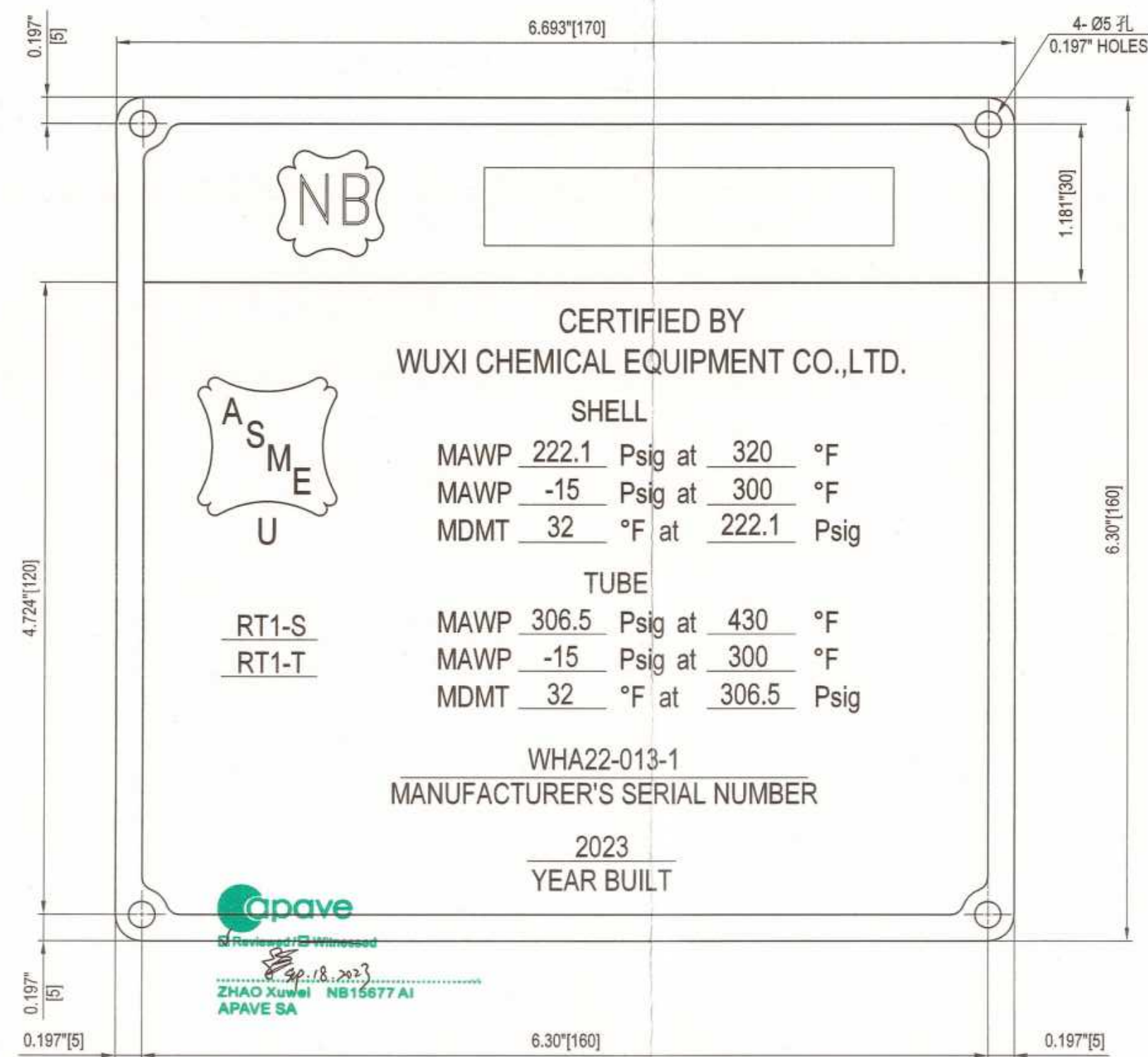
- ALL DIMENSIONS ARE MILLIMETERS UNLESS OTHERWISE NOTED.
- FINISH: "FACE" MACHINED AND POLISHED INCLUDING CAST LETTERING. BACKGROUND KNURLED AND PAINTED BLACK.
- DATE: DATE ON POLISHED SURFACE IS TO BE INSERTED (IN THE ENGLISH LANGUAGE) BY MEANS OF ENGRAVING OR HARD STAMPING AND MUST BE CLEARLY LEGIBLE. THE HEIGHT OF THE LETTERING SHOULD BE APPROX. 0.157"[4mm]. THE DEPTH OF THE LETTERING SHOULD BE APPROX. 0.004"[0.1mm].
- FOR NAME PLATE LOCATION, SEE ASSY DWG. OF EQUIPMENT
- STAMPING SHALL BE MADE BY Q.C INSPECTOR AFTER HYDROSTATIC TEST WITH CONCURRENCE OF A.I

*1: NB *2: [Symbol]

- SPACE FOR AUTHORITY APPROVAL STAMP.
- DATE OF AUTHORITY APPROVAL. (EXAMPLE: 01 MAR 2019)
- TEST DATE MEANS DATE OF PRESSURE TEST.
- REG. NO.: REGISTRATION NUMBER.

SECTION "A"- "A"

ASME铭牌详图
DETAIL OF ASME NAME PLATE



As Built									
183		铆钉 Ø4X14 RIVET	8	SS304		/			
182		ASME铭牌 t=3 ASME NAMEPLATE	1	SS304		0.4			
181		标准铭牌 t=3 STANDARD NAMEPLATE	1	SS304		0.7			
180		支架 t=6 BRACKET	1	SA-516 Gr.70N		3.9			
件号 PART NO.	图号或标准号 DWG. OR STD. NO.	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	每件EACH 重量 WT. (kg)	总计SUM	备注 REMARK		
AIR PRODUCTS			FLUOR.						
Air Products Project Number			EN207122		Fluor Project Number		A8KM		
Project Name			World Energy Renewables Project		RFQ No.		A8KM-4-403-RQ		
Purchase Order Number			4505600570		PO/Contract No		A8KM-4-403-PO-4		
Air Products Open Text document number			EN207122-WUXI-SV3-00069		Project Area		SW/S/H2S		
Client			WORLD ENERGY PARAMOUNT		Client Doc No:				
05	竣工图/AS-BUILT		Xiaosheng Huang		Shengfang Zhao		Kevin Yang		15-APR-23
04	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang		Shengfang Zhao		Kevin Yang		10-JAN-23
03	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang		Shengfang Zhao		Kevin Yang		18-OCT-22
02	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang		Shengfang Zhao		Kevin Yang		11-Aug-22
01	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang		Shengfang Zhao		Kevin Yang		14-Jun-22
00	供批准/ISSUED FOR APPROVAL		Xiaosheng Huang		Shengfang Zhao		Kevin Yang		24-Mar-22
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设计项目 DESIGN ITEM		World Energy Renewables Project		设计阶段 DESIGN PHASE		竣工图 AS BUILT		设备位号 ITEM NO.	
图号 DWG. NO.		WXCE8703-06		图号 DWG. NO.		WXCE8703-06		18-X-270	
设计 PREPARED	黄晓至	2023.4.15	AGR1 Amine Regen Reboiler		版次: 05		第 1 页 共 1 页		
审核 REVIEWED	李俊	2023.4.15	NAMEPLATE DETAIL DRAWING		REV.		PAGE 1 OF 1		
批准 APPROVED		2023.4.15	比例 SCALE 1:1		REV.		第 1 页 共 1 页		