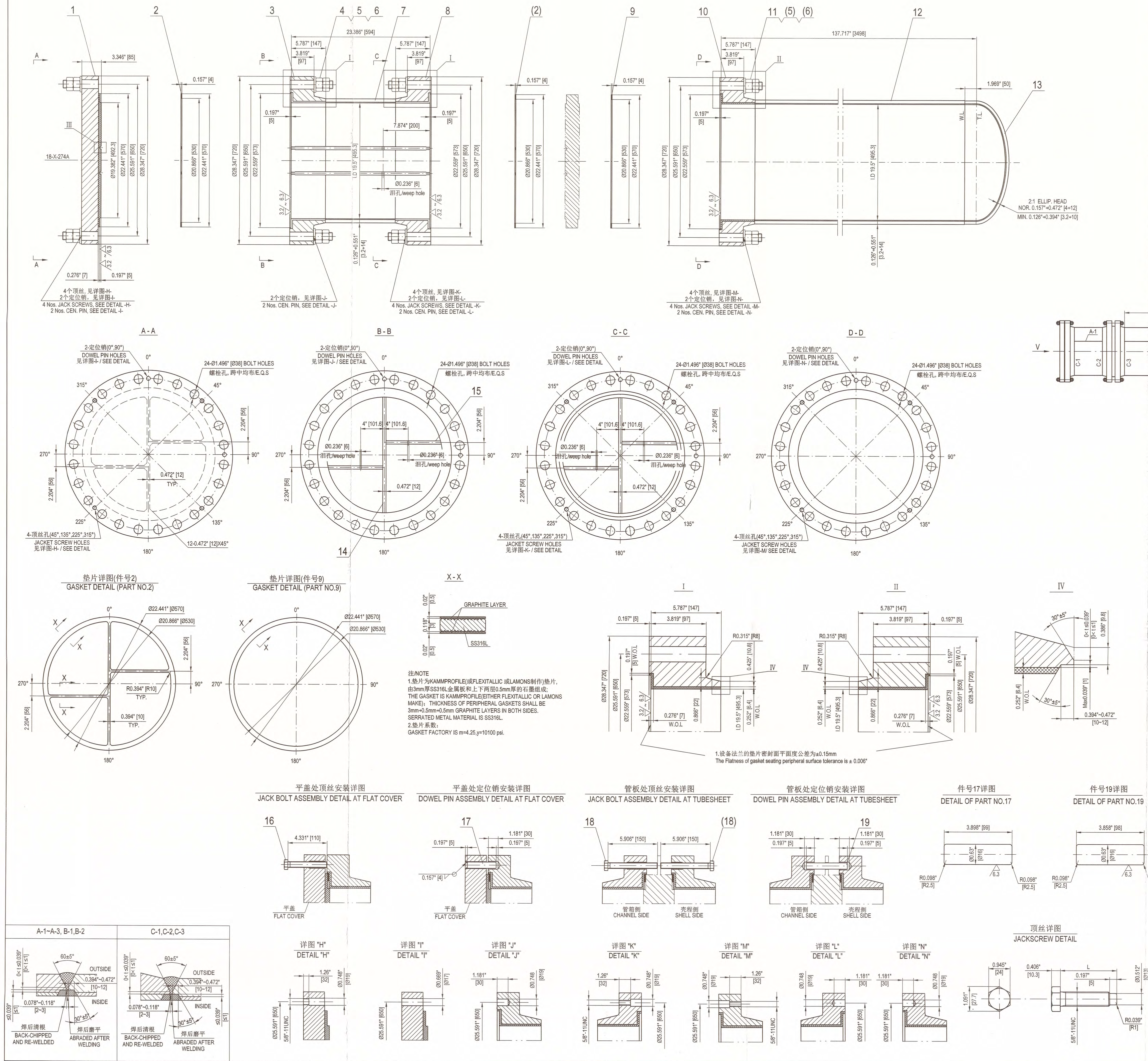




分程隔板焊接详图
DETAIL WELDING OF PASS PARTITION

As Built

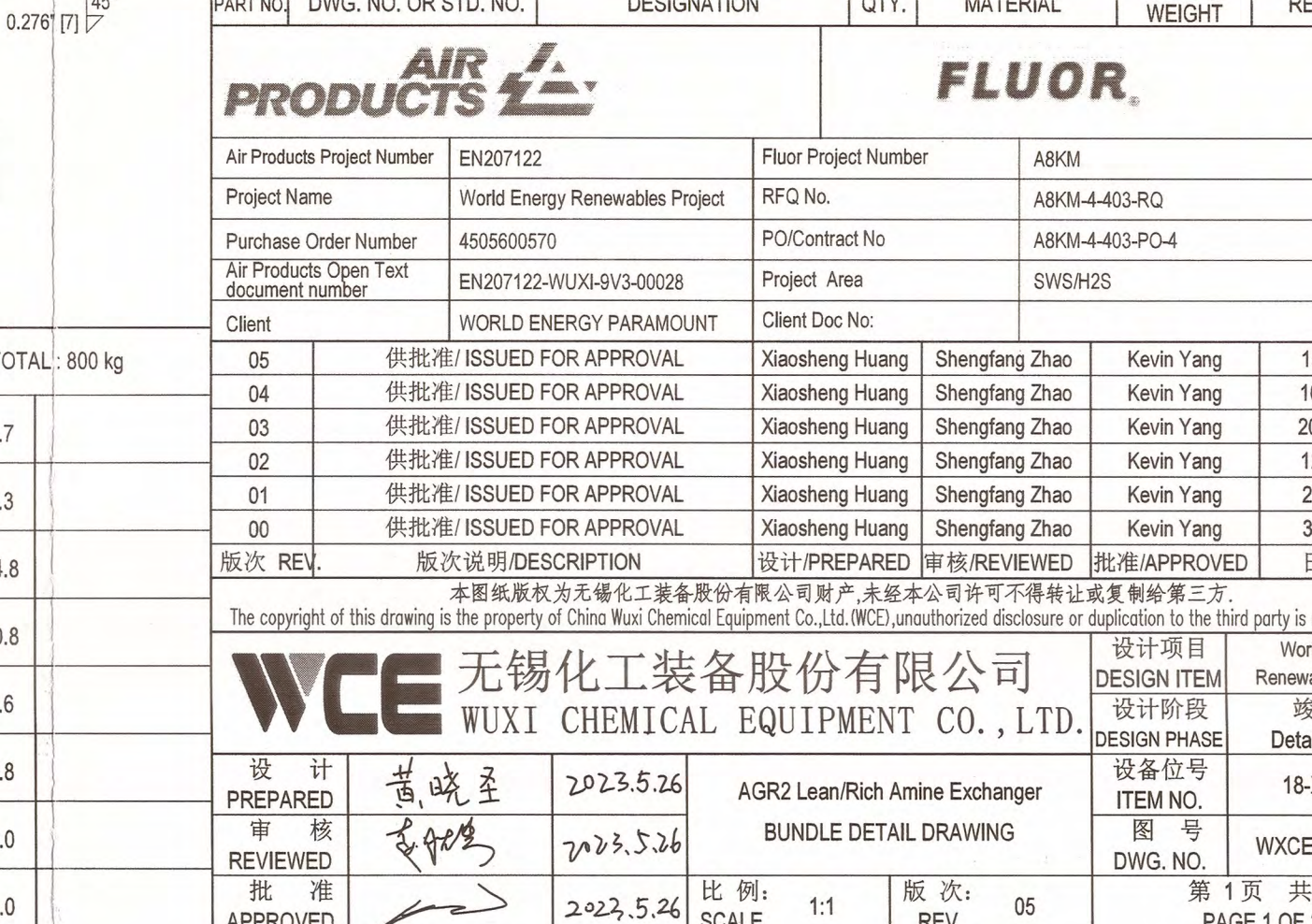
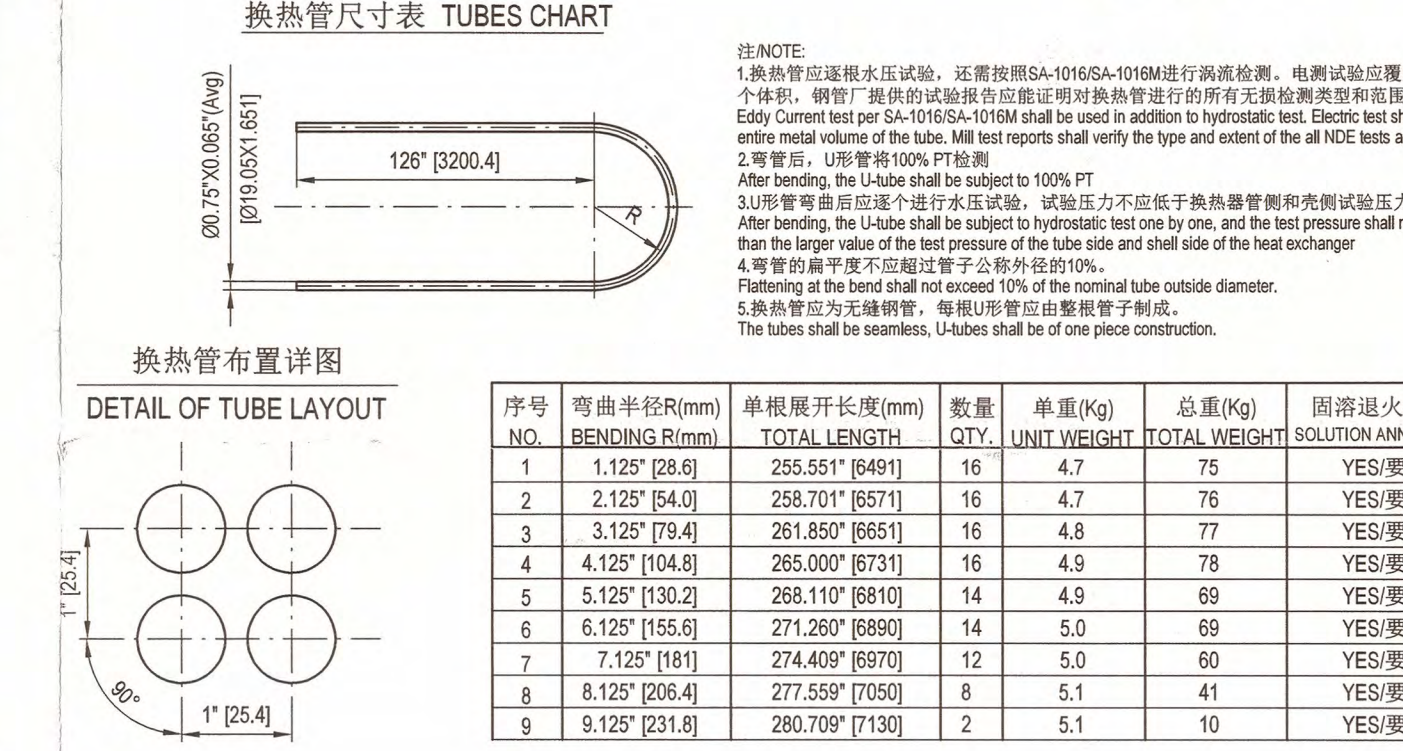
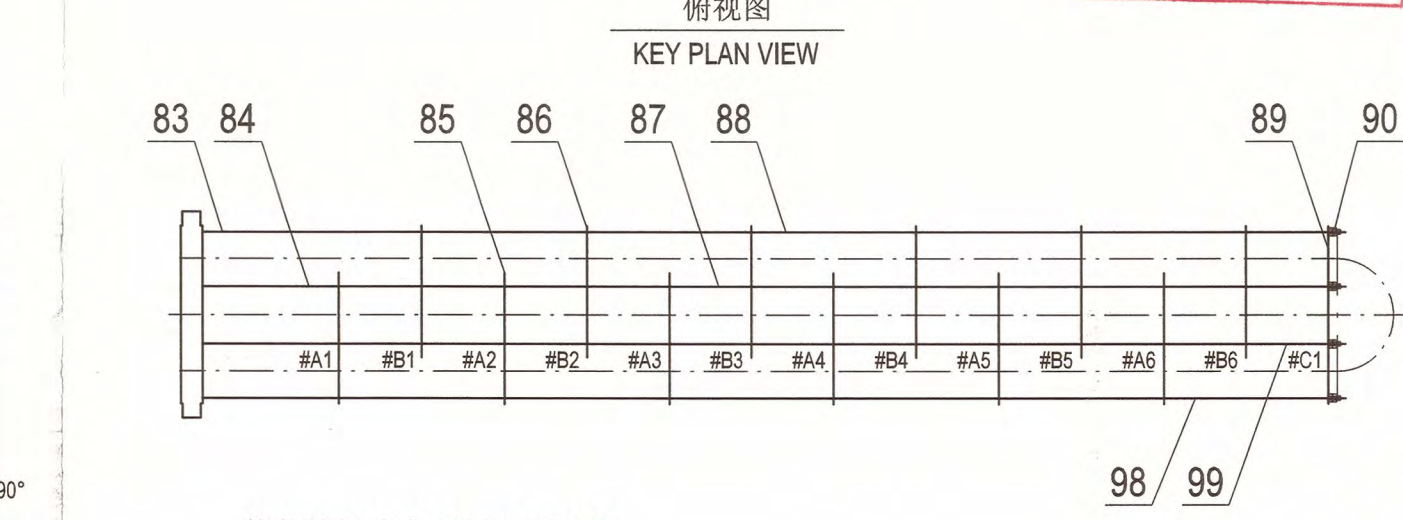
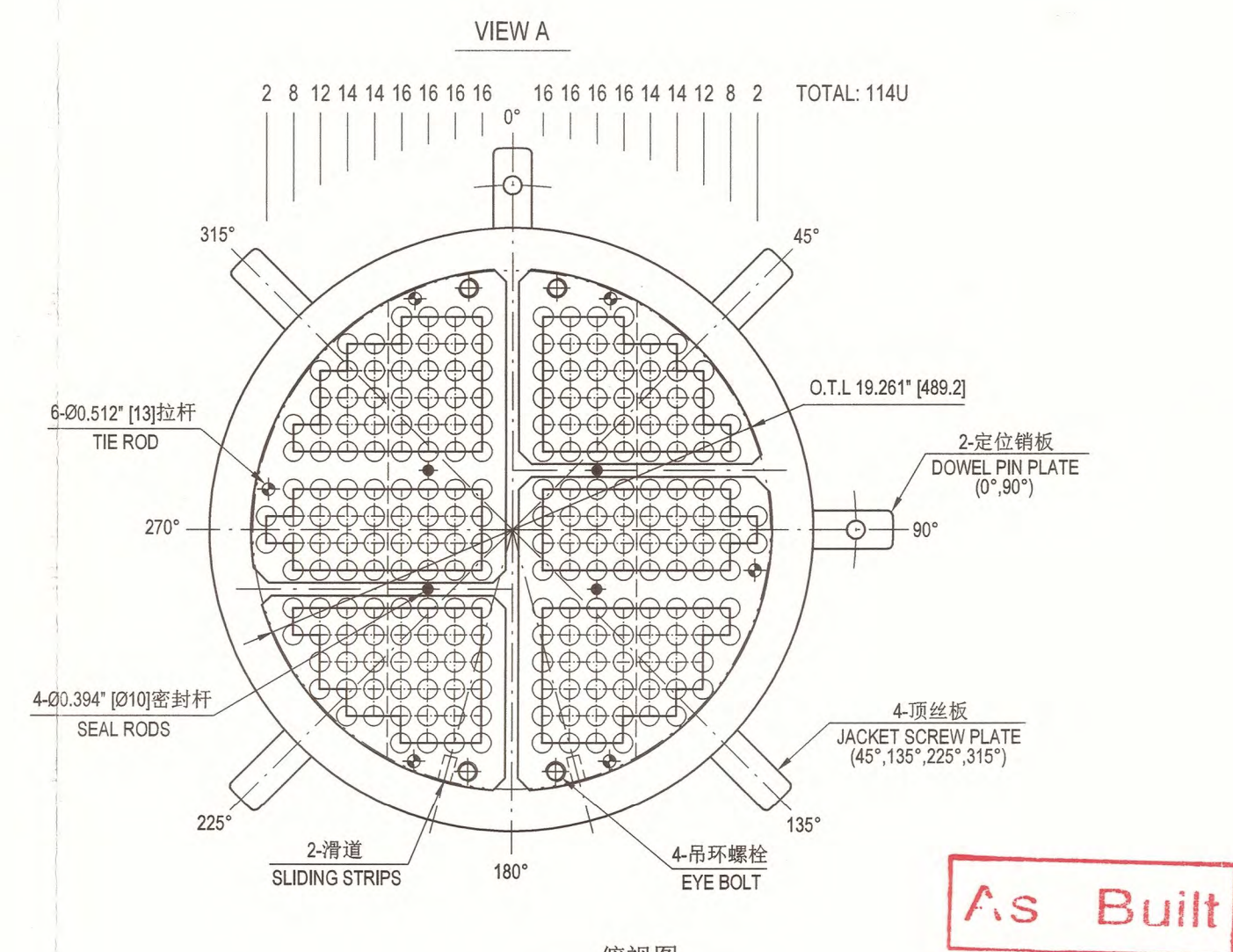
焊缝布置图
WELD SEAM PLAN

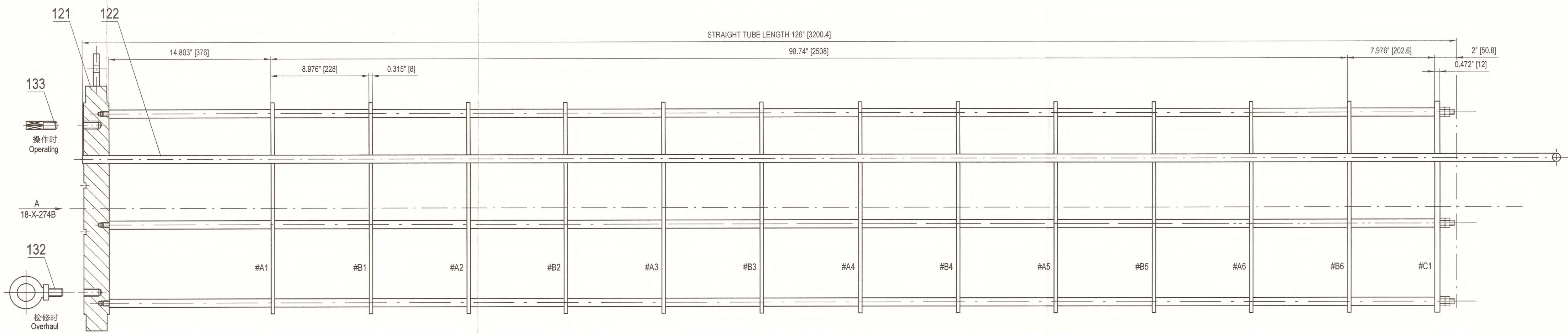
VIEW V

TOTAL : 1770 kg					
19	定位销 DOWEL PIN	2	SA-479 304	0.2	0.4
18	顶丝 5/8"-11UNC L=150 JACKSCREW	8	SA-479 304	0.4	3.2
17	定位销 DOWEL PIN	2	SA-479 304	0.2	0.4
16	顶丝 5/8"-11UNC L=110 JACKSCREW	4	SA-479 304	0.3	1.2
15	分程隔板 t=12 PASS PARTITION	2	SA-240 316L	15.6	31.2
14	分程隔板 t=12 PASS PARTITION	1	SA-240 316L		32.6
13	2:1 椭圆封头 1D495.3X(12+4) 2:1 ELLIPTICAL HEAD	1	SA-516 Gr.70N + CLAD SA-240 316L	45.0	After forming: 10+3.2
12	壳体 ID495.3X(14+3.2) L=3301 SHELL	1	SA-516 Gr.70N + CLAD SA-240 316L		632
11	ASME B18.2.1-2012 (R2021) 全螺纹螺栓 1 3/8"-8UN-2A L=440 FULL THREADED STUD BOLTS	24+3	SA-193 Gr.B7M	3.3	79.2
10	壳程法兰 SHELL FLANGE	1	SA-266 Gr.2N + SS316L OVERLAY		163
9	壳程法兰垫片 SHELL FLANGE GASKET	1+2	见注 1/See note 1		/
8	管箱法兰 CHANNEL FLANGE	1	SA-266 Gr.2N SS316L OVERLAY		163
7	管箱筒体 ID495.3X(14+3.2) L=300 CHANNEL SHELL	1	SA-516 Gr.70N + CLAD SA-240 316L		57.5
6	ASME PCC-1-2019 APPENDIX M 硬面圈垫圈 1 3/8" HARDENED O-RING WASHER	96+12	TYPE 1	/	/
5	ASME B18.2.2-2022 重型六角螺母 1 3/8"-8UN-2B HEX HEAVY NUTS	192+24	SA-194 Gr.2HM	0.3	57.6
4	ASME B18.2.1-2012 (R2021) 全螺纹螺栓 1 3/8"-8UN-2A L=370 FULL THREADED STUD BOLTS	24+3	SA-193 Gr.B7M	2.8	67.2
3	管箱法兰 CHANNEL FLANGE	1	SA-266 Gr.2N SS316L OVERLAY		163
2	管程法兰垫片 CHANNEL FLANGE GASKET	2+4	见注 1/See note 1		/
1	平盖 FLAT COVER	1	SA-266 Gr.2N SS316L OVERLAY		272

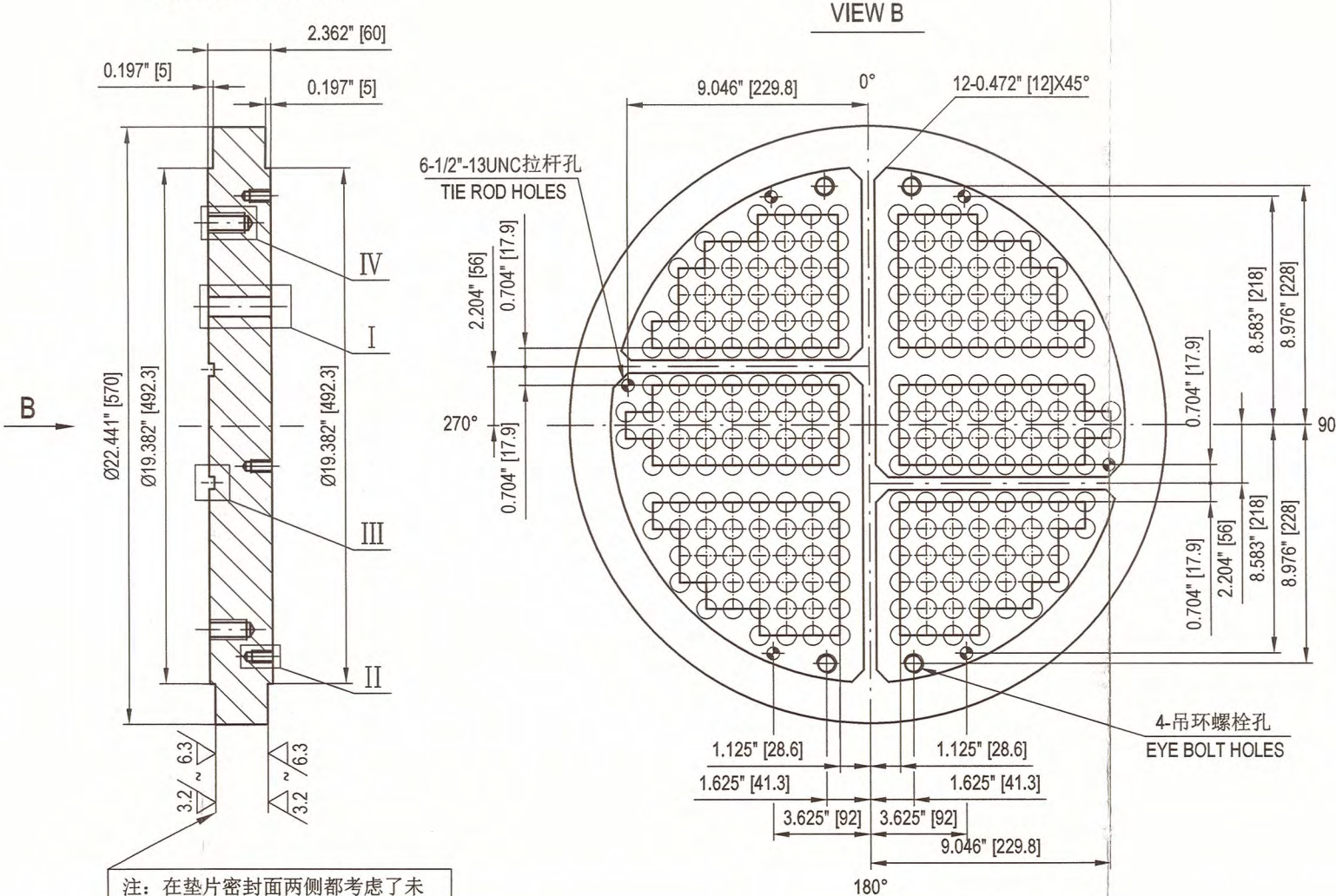
件号	图号或标准号	名称	数量	材料	单件重量(kg)	总重量(kg)	备注
PART NO.	DWG. NO. OR STD. NO.	DESIGNATION	QTY.	MATERIAL	WEIGHT	TOTAL WEIGHT	REMARKS
AIR PRODUCTS		FLUOR					
Air Products Project Number		EN207122	Fluor Project Number		ABKM		
Project Name		World Energy Renewables Project	RFQ No.		ABKM-4-403-RQ		
Purchase Order Number		4505600570	PO/Contract No		ABKM-4-403-PO-4		
Air Products Open Text document number		EN207122-WUXI-9V3-00028	Project Area		SWS/H2S		
Client		WORLD ENERGY PARAMOUNT	Client Doc No:				
05	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	15-Feb-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	20-OCT-22		
02	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	12-Aug-22		
01	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	20-Jun-22		
00	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	30-Apr-22		
版次		版次说明/DESCRIPTION	设计/DESIGNED	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 设计阶段 DESIGN PHASE 设备位号 ITEM NO. 图号 DWG. NO.			
设计 PREPARED	黄晓生	2023.5.26	AGR2 Lean/Rich Amine Exchanger		World Energy Renewables Project		
审核 REVIEWED	李红	2023.5.26	SHELL DETAIL DRAWING		竣工图 Detail Design		
批准 APPROVED		2023.5.26	比例 SCALE	1:1	版次 REV.	05	第 1 页 共 2 页 PAGE 1 OF 2





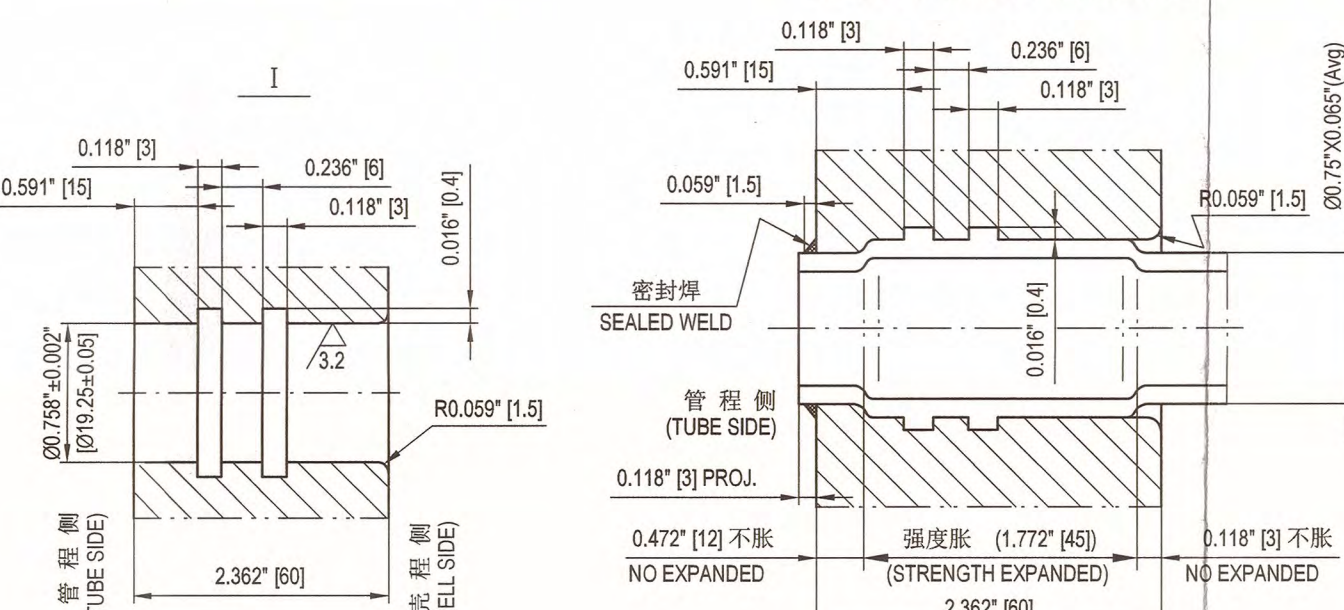


管板详图
TUBESHEET DETAIL

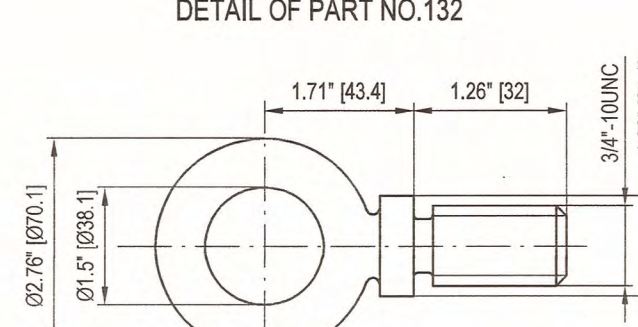


注：在垫片密封面两侧都考虑了未来0.126\"/>

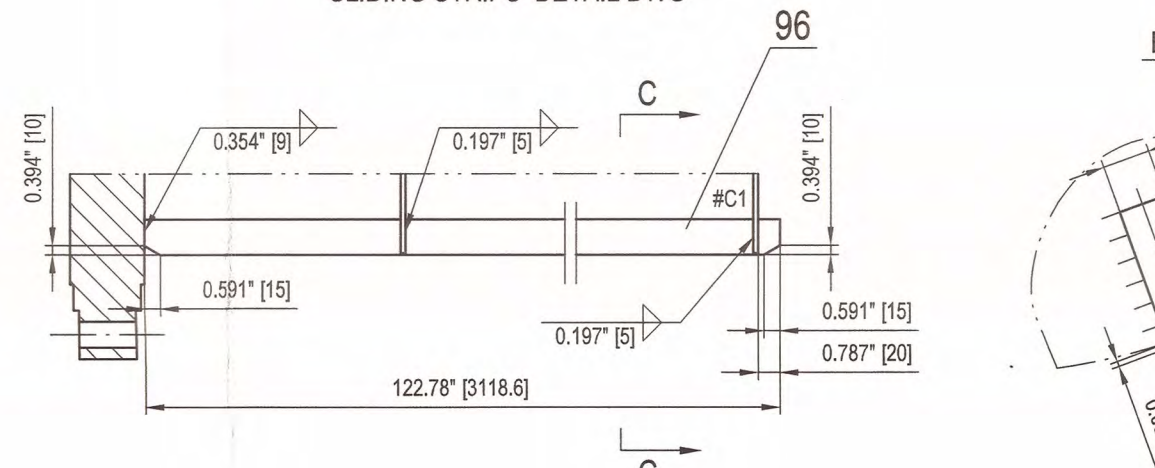
换热管与管板连接详图
DETAIL OF TUBES TO TUBESHEET



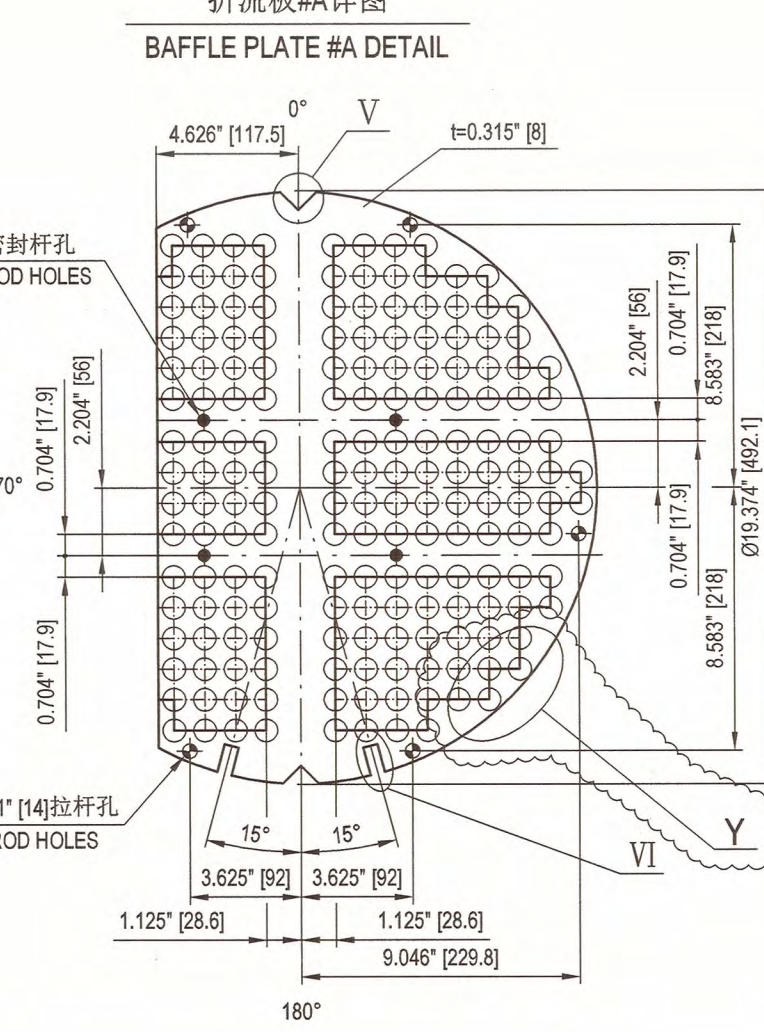
件号132详图
DETAIL OF PART NO.132



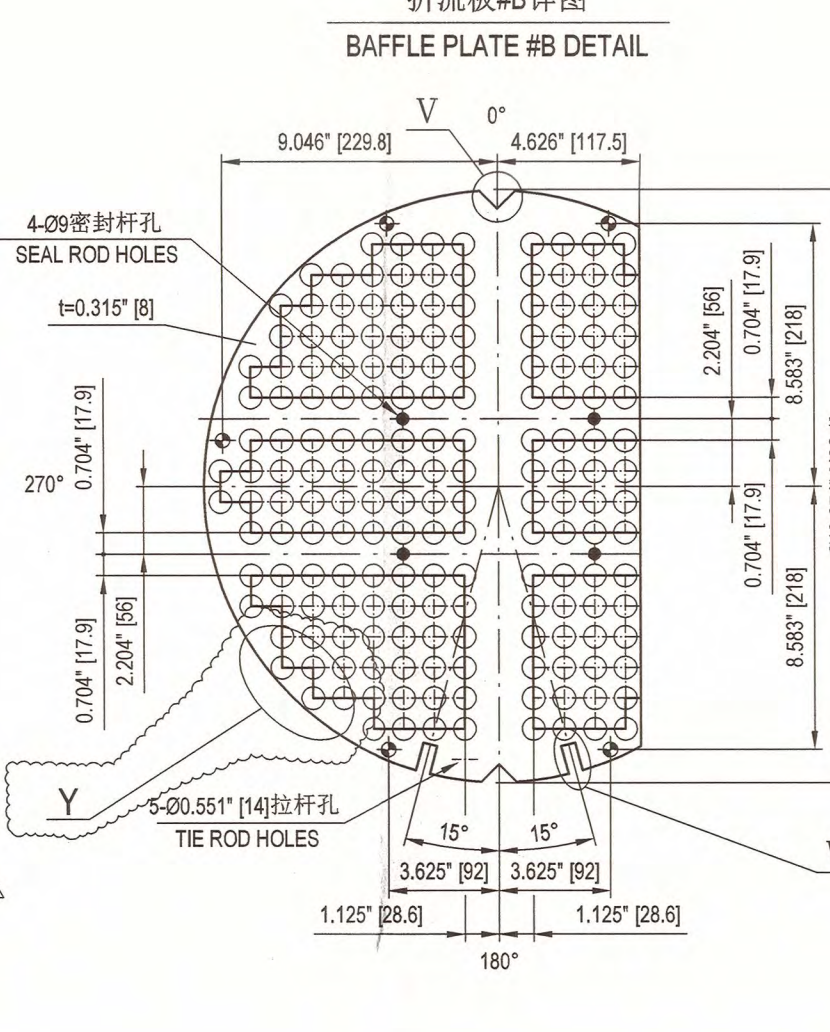
滑道详图
SLIDING STRIPS DETAIL DWG



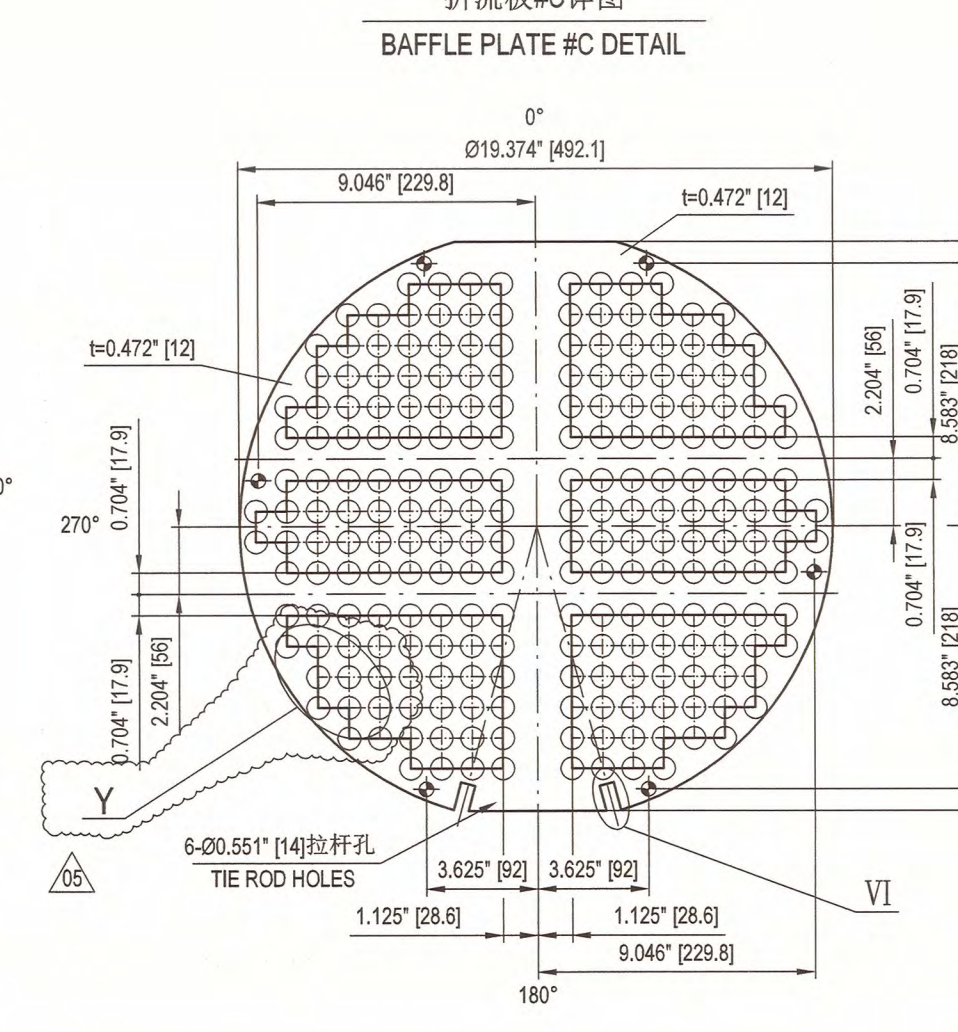
折流板#A详图
BAFFLE PLATE #A DETAIL



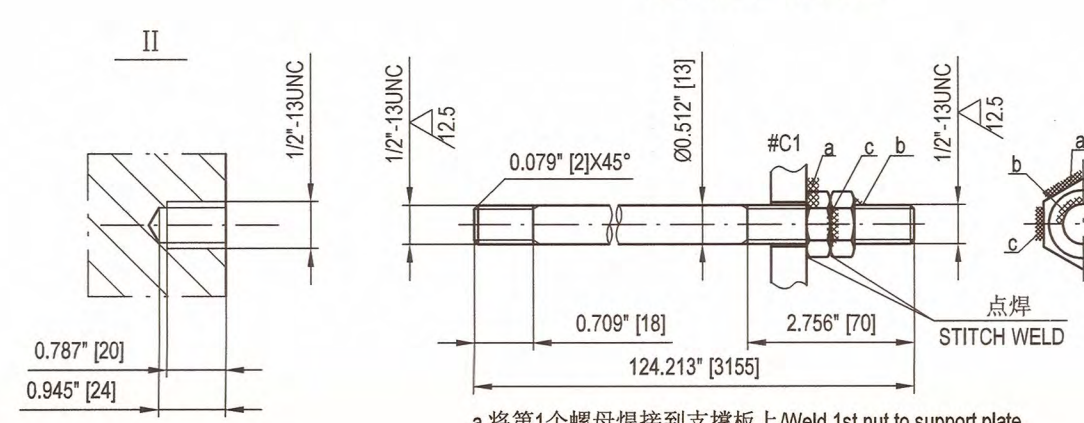
折流板#B详图
BAFFLE PLATE #B DETAIL



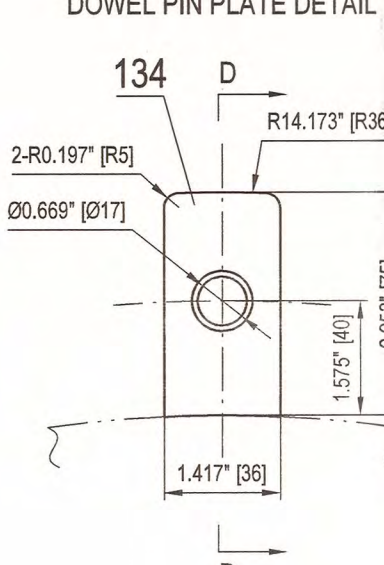
折流板#C详图
BAFFLE PLATE #C DETAIL



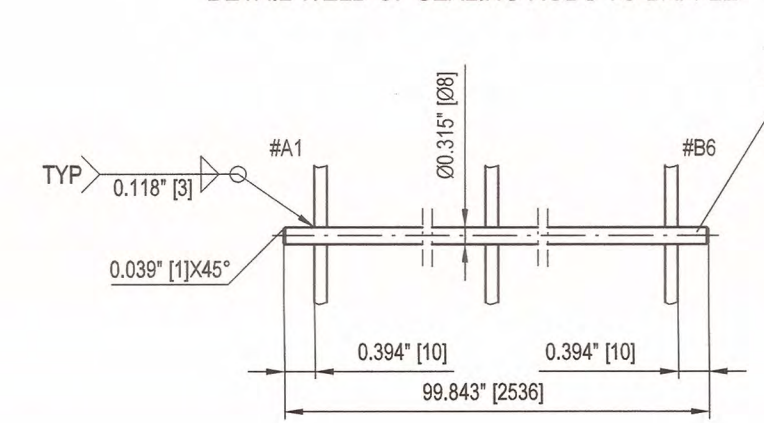
拉杆详图
DETAIL OF TIE ROD



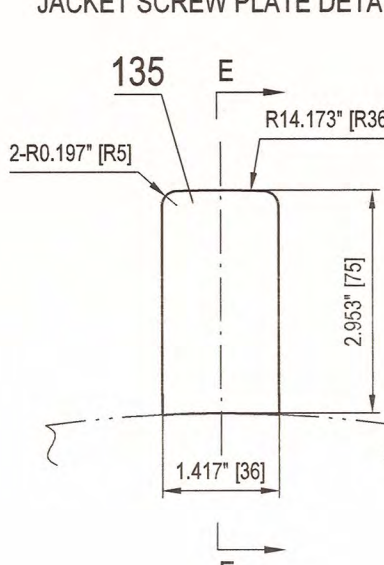
定位销板详图
DOWEL PIN PLATE DETAIL



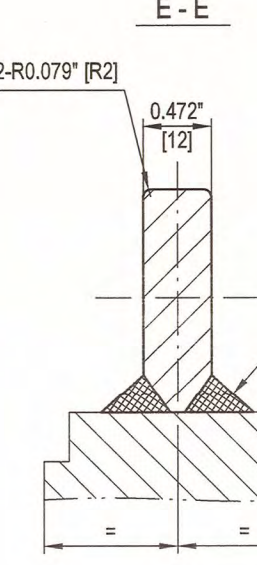
密封杆焊接详图
DETAIL WELD OF SEALING RODS TO BAFFLE



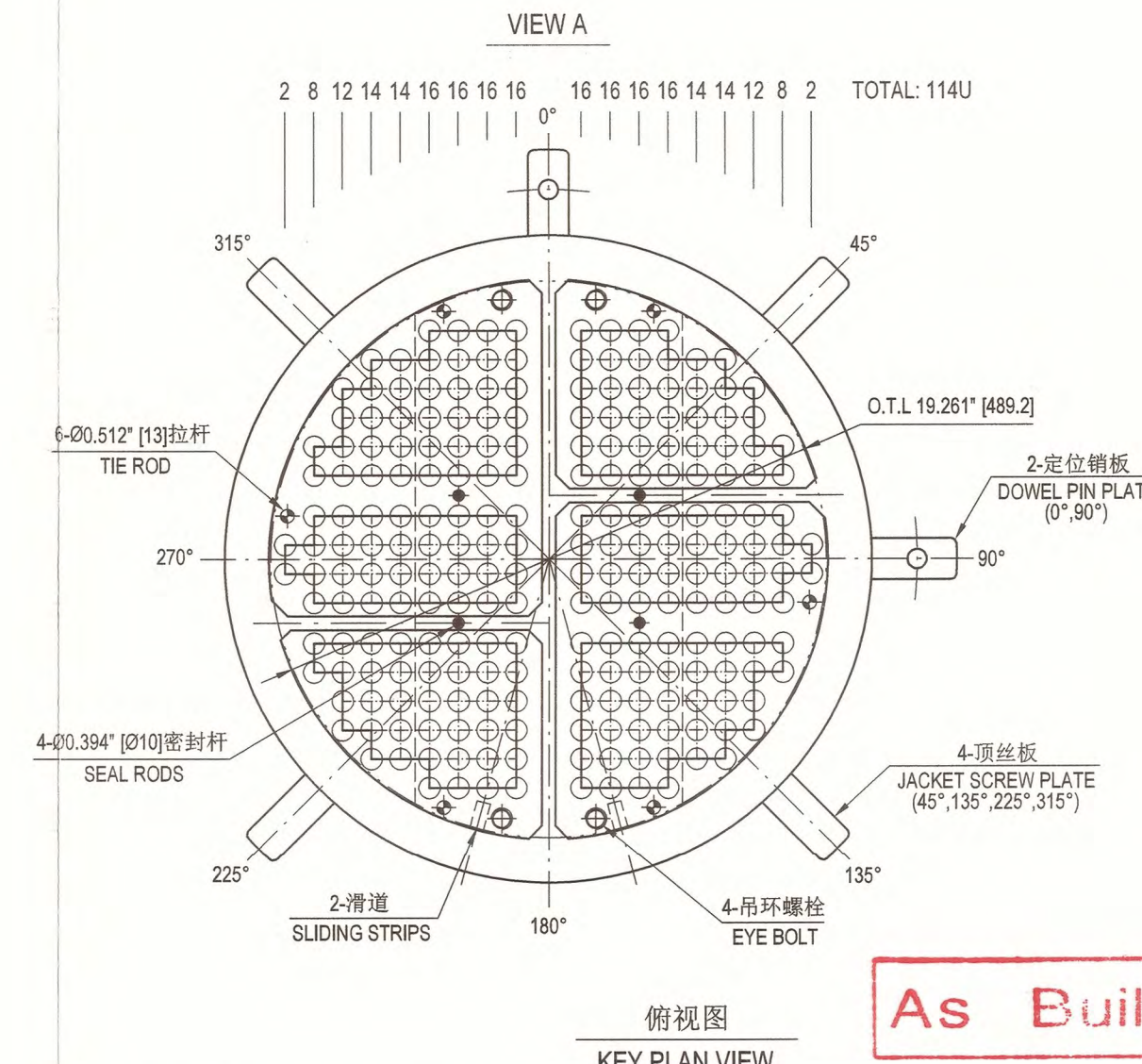
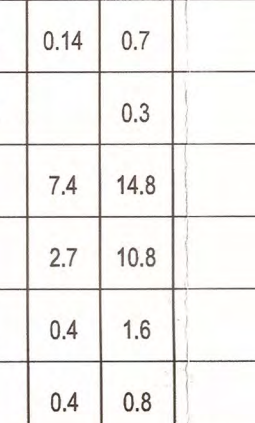
顶丝板详图
JACKET SCREW PLATE DETAIL



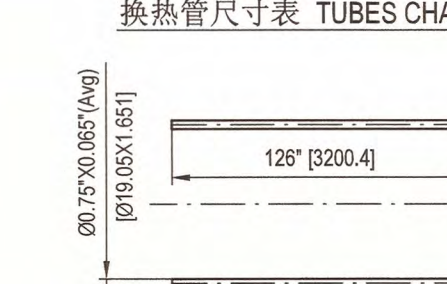
顶丝板详图
JACKET SCREW PLATE DETAIL



滑道详图
SLIDING STRIPS DETAIL DWG



换热管尺寸表 TUBES CHART

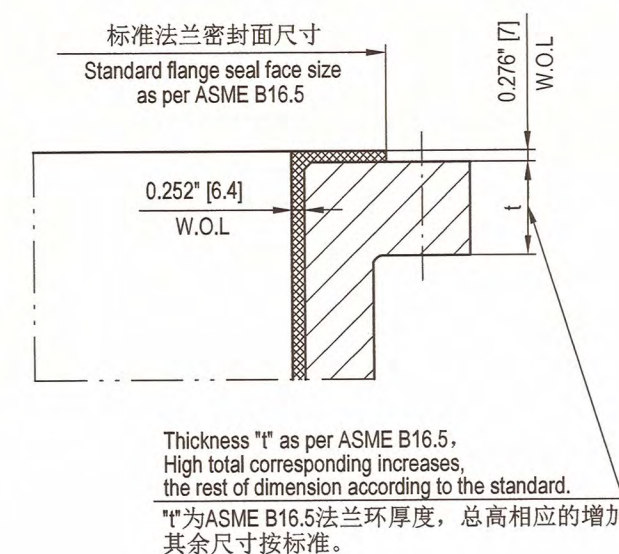
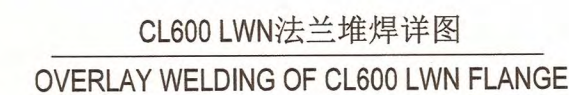
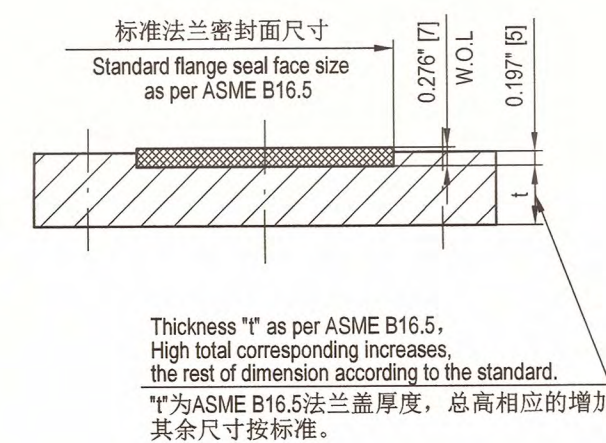
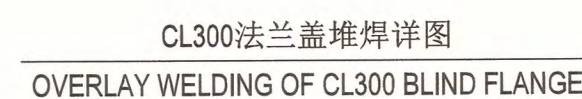
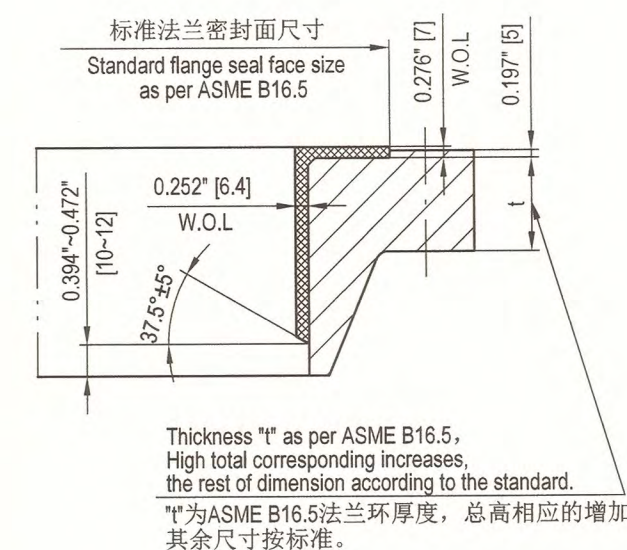
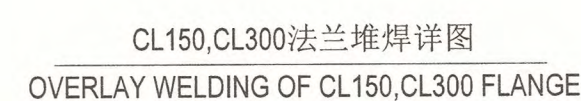
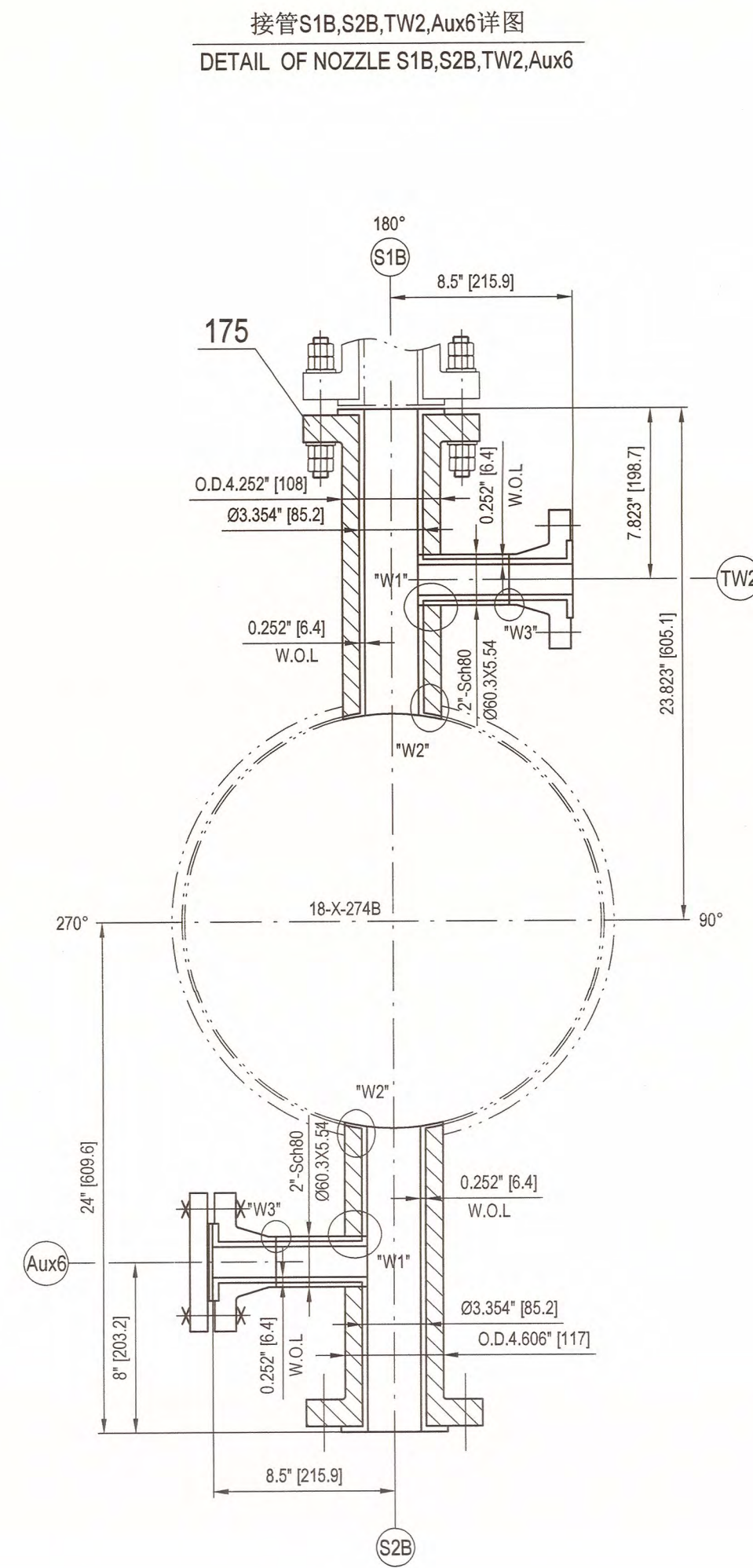
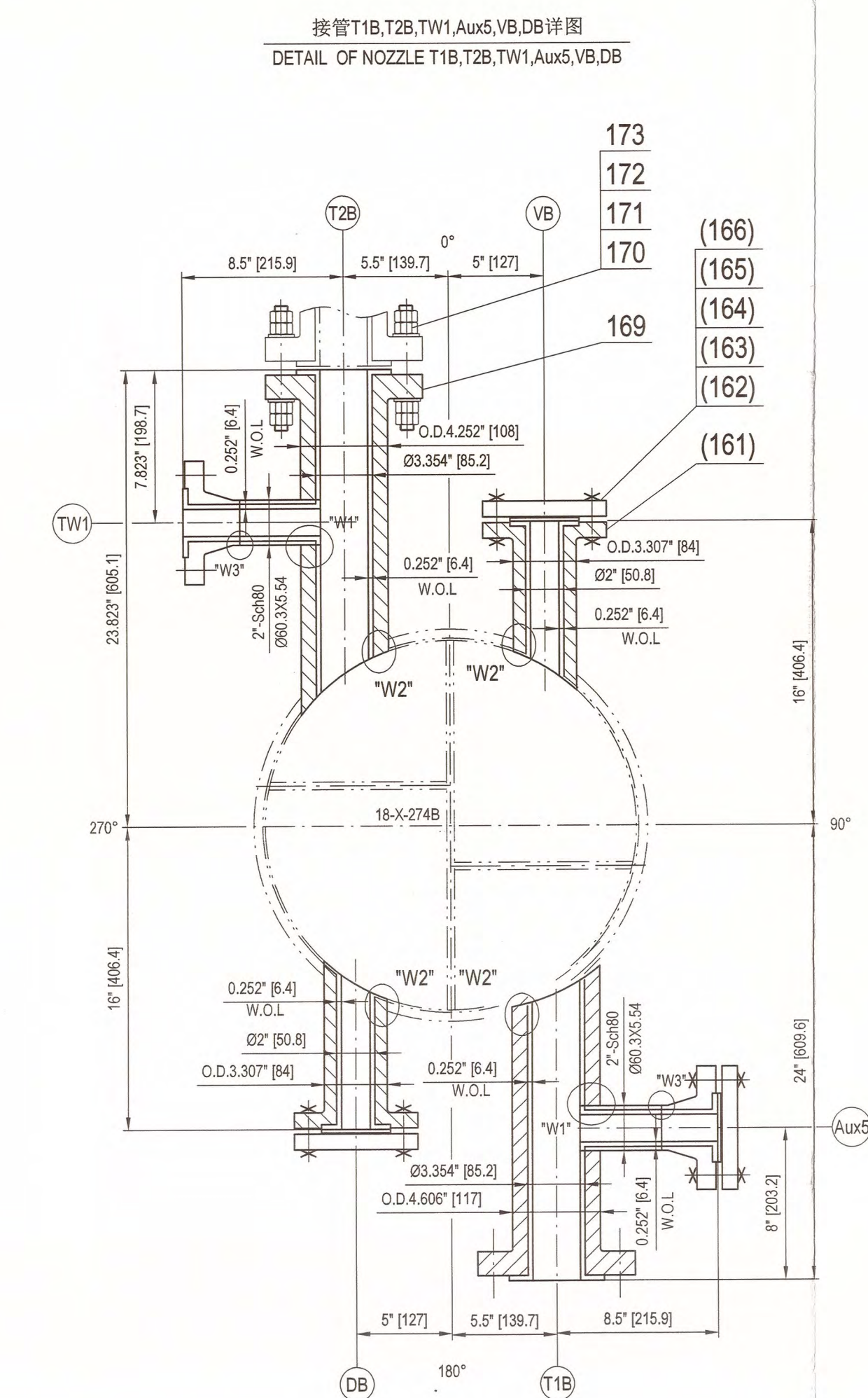
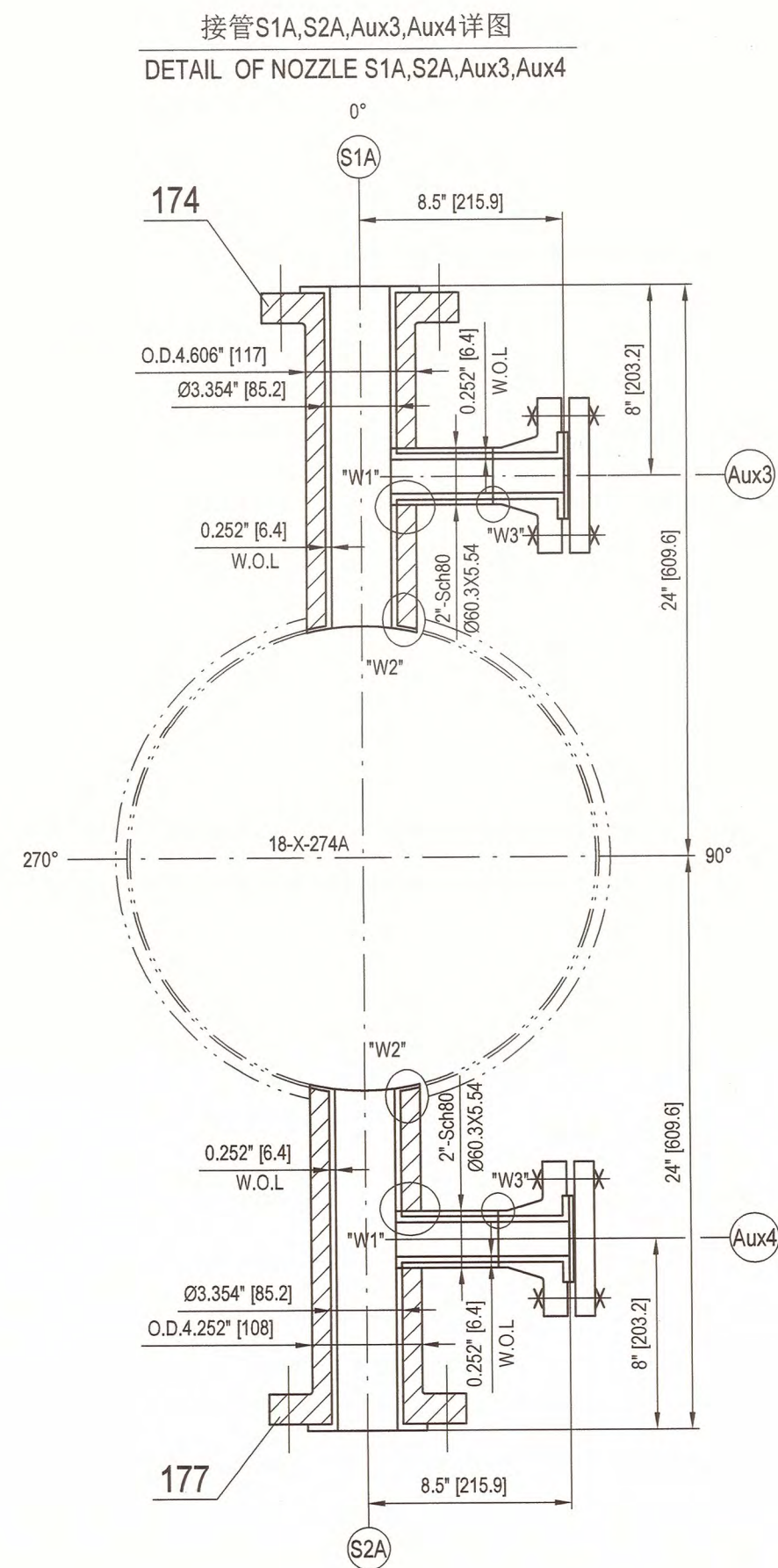
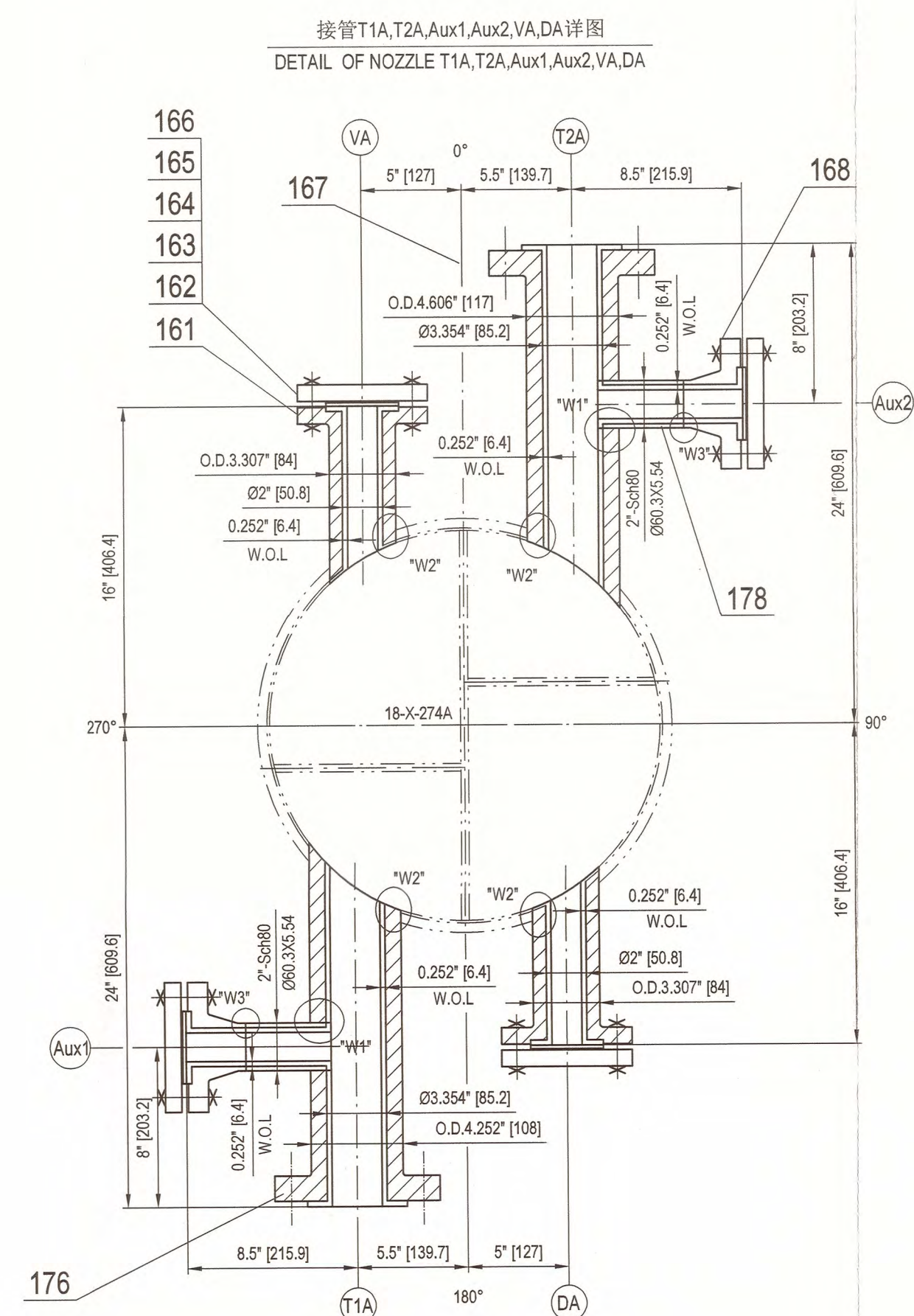


注：1. 换热管应逐根水压试验，还需按照SA-450/SA-450M进行涡流检测，电测试验应覆盖换热管整个
2. 管帽后，U形管应进行100% PT检测
3. U形管弯后应逐根进行水压试验，试验压力不应低于换热管侧和壳侧试验压力的较大值
4. 管帽的扁平度不应超过管子公称外径的10%
5. 换热管应为无缝管，每根U形管应由整根管子制成。
The tubes shall be seamless, U-tubes shall be of one piece construction.

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 ANNEALING
1	1.125\"	255.551\"	16	4.7	75	YES/要
2	1.125\"	258.701\"	16	4.7	76	YES/要
3	3.125\"	261.850\"	16	4.8	77	YES/要
4	4.125\"	265.000\"	16	4.9	78	YES/要
5	5.125\"	268.110\"	14	4.9	69	YES/要
6	6.125\"	271.260\"	14	5.0	69	YES/要
7	7.125\"	274.409\"	12	5.0	60	YES/要
8	8.125\"	277.559\"	8	5.1	41	YES/要
9	9.125\"	280.709\"	2	5.1	10	YES/要

131	ASME B18.2.2-2022	六角螺母 1/2\"-13UNC-2B TIE RODS	12	SA-194 Gr.B8MA	0.05	0.8	
130		拉杆 Ø13 L=3180 SUPPORT BAFFLE #C	6	SS316L	3.4	20.4	
129		支撑板#C t=12 BAFFLE #B	1	SA-240 316L		11.6	
128		定距管 Ø19.05X1.651 L=448 SPACERS	10	SA-213 TP316L	0.32	3.2	
127		定距管 Ø19.05X1.651 L=220 BAFFLE #B	44	SA-213 TP316L	0.16	7.0	
126		折流板#B t=8 BAFFLE #B	6	SA-240 316L	6.2	37.2	
125		折流板#A t=8 BAFFLE #A	6	SA-240 316L	6.2	37.2	
124		定距管 Ø19.05X1.651 L=376 SPACERS	5	SA-213 TP316L	0.27	1.4	
123		定距管 Ø19.05X1.651 L=604 TUBES	1	SA-213 TP316L		0.4	
122		换热管 Ø19.05X1.651 (Avg) TUBES	114U	SA-213 TP316L		555	(SEALMESS)
121		管板 TUBESHEET	1	SA-182 F316L		90.4	

件号 PART NO.	图号或标准号 DWG. NO. OR STD. NO.	名称 DESIGNATION	数量 QTY.	材料 MATERIAL	单重(Kg) WEIGHT	备注 REMARKS
AIR PRODUCTS						
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-SV3-00028			Project Area: SWS/H2S			
Client: WORLD ENERGY PARAMOUNT			Client Doc No:			
05	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	15-Feb-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	20-OCT-22	
02	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	12-Aug-22	
01	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	20-Jun-22	
00	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	30-Apr-22	
版次 REV: 设计/DESIGN			审核/REVIEWED		批准/APPROVED	
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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/DESIGN			设计阶段 DESIGN PHASE		竣工图 Detail Design	
设计 PREPARED	曹晓至	2023.5.26	AGR2 Lean/Rich Amine Exchanger		设备位号 ITEM NO.	18-X-274B
审核 REVIEWED	曹晓至	2023.5.26	BUNDLE DETAIL DRAWING		图号 DWG. NO.	WXCE8705-02-2
批准 APPROVED	曹晓至	2023.5.26	比例 SCALE	1:1	第 2 页 共 2 页 PAGE 2 OF 2	



"W2" 焊缝详图 DETAIL OF "W2" WELD	"W3" 焊缝详图 DETAIL OF "W3" WELD

As Built

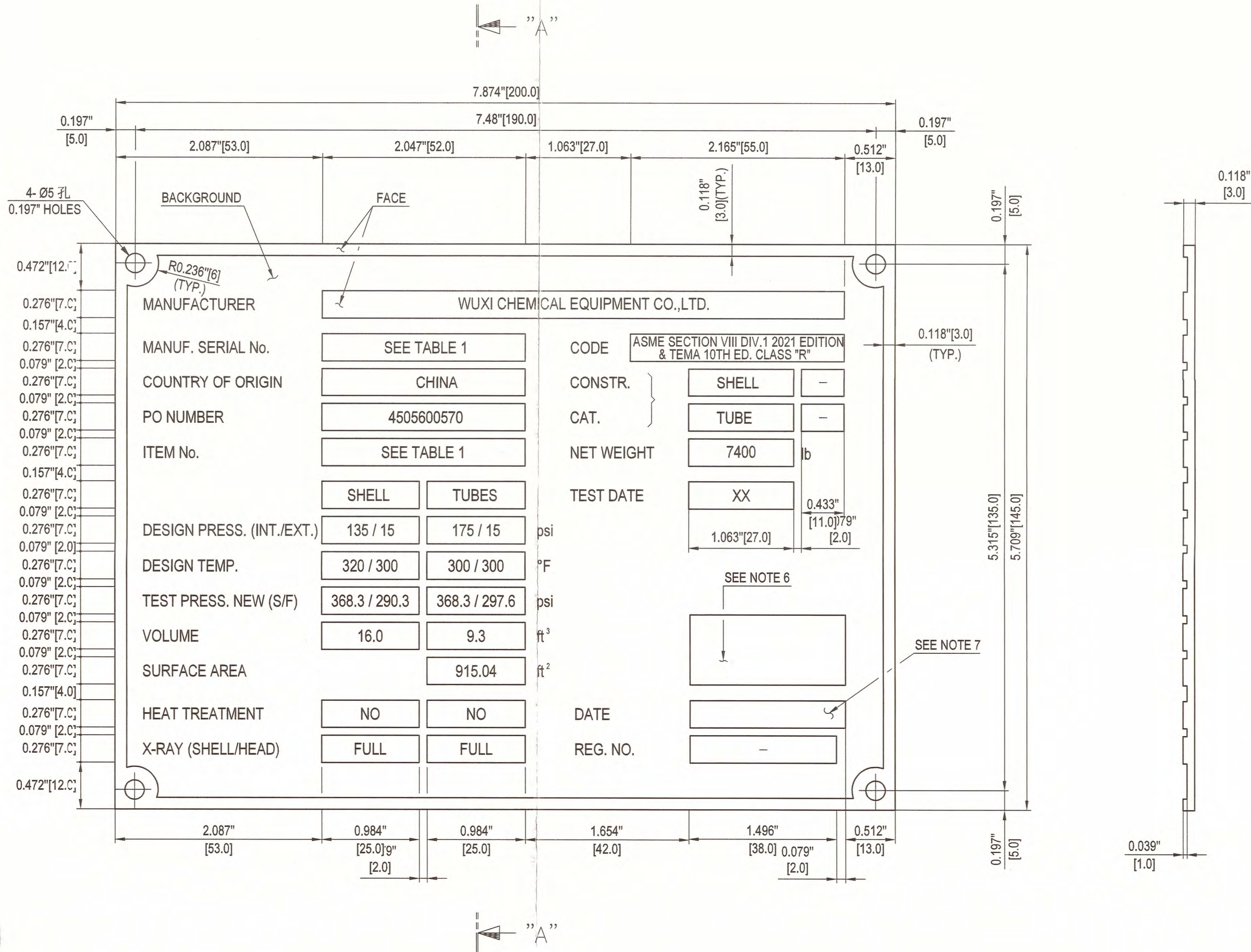
注:NOTE

1. 4.5mm厚316L缠绕垫，填充带为柔性石墨，内环为SS316L，外环为SS316L；垫片供应商应为Flexitallic styles CGI 或 Lamons styles WRI, WRI-LC, ≤DN600的Class 150#缠绕垫为低应力，
4.5 mm thk. 316L Spiral Wound, Graphite Filled, SS316L inner and SS316L outer ring;
The gasket manufacturers shall be Flexitallic styles CGI or Lamons styles WRI, WRI-LC. Spiral Wound gaskets shall be low-stress type for Class 150# gaskets in DN600 and smaller

						TOTAL : 320 kg	
178		接管 Ø60.3X(5.4+6.4) NOZZLE	8	SA-266 Gr.2N + +SS316L WOL	1.6	10.8	Aux1~Aux6 TW1,TW2
177	参照/REFER ASME B16.5-2017	法兰 LWN 3"-150# RF B=85.2 FLANGE (堆焊前/B.F.W.O)	1	SA-105N + SS316L WOL	19.6	S2A	
176	参照/REFER ASME B16.5-2017	法兰 LWN 3"-150# RF B=85.2 FLANGE (堆焊前/B.F.W.O)	1	SA-105N + SS316L WOL	21.0	T1A	
175	参照/REFER ASME B16.5-2017	法兰 LWN 3"-150# RF B=85.2 FLANGE (堆焊前/B.F.W.O)	1	SA-105N + SS316L WOL	19.4	S1B	
174	参照/REFER ASME B16.5-2017	法兰 LWN 3"-150# RF B=85.2 FLANGE (堆焊前/B.F.W.O)	2	SA-105N + SS316L WOL	19.6	39.2	S1A,S2B
173	ASME PCC-1-2019 APPENDIX M	硬质垫圈 5/8" HARDENED WASHER	1644	TYPE 1	/	/	T2B,S1B
172	ASME B18.2.2-2022	六角重型螺母 5/8"-11UNC-2B HEAVY HEX NUTS	32+8	SA-194 Gr.2HMM	0.05	3.2	T2B,S1B
171	ASME B18.2.1-2012 (R2021)	全螺纹螺栓 5/8"-11UNC-2A L=169 FULL THREADED STUD BOLTS	8+2	SA-193 Gr.B7M	0.5	8.0	T2B,S1B
170	ASME B16.20-2017	缠绕垫 3"-150# RF SPIRAL WOUND GASKET	2+4	见注 1 SEE NOTE: 1	/	/	T2B,S1B
169	参照/REFER ASME B16.5-2017	法兰 LWN 3"-150# RF B=85.2 FLANGE (堆焊前/B.F.W.O)	1	SA-105N + SS316L WOL	20.8	T2B	
168	参照/REFER ASME B16.5-2017	法兰 WN 2"-300# RF Sch80 FLANGE (堆焊前/B.F.W.O)	8	SA-105N + SS316L WOL	3.5	28.0	Aux1~Aux6 TW1,TW2
167	参照/REFER ASME B16.5-2017	法兰 LWN 3"-150# RF B=85.2 FLANGE (堆焊前/B.F.W.O)	2	SA-105N + SS316L WOL	21.0	42.0	T2A,T1B
166	ASME PCC-1-2019 APPENDIX M	硬质垫圈 5/8" HARDENED WASHER	160+16	TYPE 1	/	/	VA,DA,Aux1~Aux VB,DB,Aux5,Aux6
165	ASME B18.2.2-2022	六角重型螺母 5/8"-11UNC-2B HEAVY HEX NUTS	320+32	SA-194 Gr.2HMM	0.01	3.2	VA,DA,Aux1~Aux VB,DB,Aux5,Aux6
164	ASME B18.2.1-2012 (R2021)	全螺纹螺栓 5/8"-11UNC-2A L=169 FULL THREADED STUD BOLTS	80+8	SA-193 Gr.B7M	0.2	16.0	VA,DA,Aux1~Aux VB,DB,Aux5,Aux6
163	ASME B16.20-2017	缠绕垫 2"-300# RF SPIRAL WOUND GASKET	10+20	见注 1 SEE NOTE: 1	/	/	VA,DA,Aux1~Aux VB,DB,Aux5,Aux6
162	参照/REFER ASME B16.5-2017	法兰 盖 BL 2"-300# RF BLIND FLANGE	10	SA-105N + SS316L WOL	3.2	32.0	VA,DA,Aux1~Aux VB,DB,Aux5,Aux6
161	参照/REFER ASME B16.5-2017	法兰 LWN 2"-300# RF B=50.8 FLANGE (堆焊前/B.F.W.O)	4	SA-105N + SS316L WOL	8.7	34.8	VA,DA,VB,DB
Part No.	图号或标准号	名 称	数量	材 料	单件重量(kg)	TOTAL WEIGHT	备 注
件号	DWG. NO. OR STD. NO.	DESIGNATION	QTY.	MATERIAL	WEIGHT	REMARKS	

AIR PRODUCTS		FLUOR.										
Air Products Project Number		EN2071122		Fluor Project Number		A8KM						
Project Name		World Energy Renewables Project		RFQ No.		A8KM4-403-RQ						
Purchase Order Number		4050600570		PO/Contract No		A8KM4-003-PO-4						
Air Products Open Text document Number		EN207112-WUXI-SV3-00026		Project Area		SWS/H2S						
Client		WORLD ENERGY PARAMOUNT		Client Doc No:								
05	供批注//ISSUED FOR APPROVAL	Xiaosheng Huang		Shengfang Zhao		Kevin Yang		15-Feb-23				
04	供批注//ISSUED FOR APPROVAL	Xiaosheng Huang		Shengfang Zhao		Kevin Yang		10-JAN-23				
03	供批注//ISSUED FOR APPROVAL	Xiaosheng Huang		Shengfang Zhao		Kevin Yang		20-OCT-22				
02	供批注//ISSUED FOR APPROVAL	Xiaosheng Huang		Shengfang Zhao		Kevin Yang		12-Aug-22				
01	供批注//ISSUED FOR APPROVAL	Xiaosheng Huang		Shengfang Zhao		Kevin Yang		20-Jun-22				
00	供批注//ISSUED FOR APPROVAL	Xiaosheng Huang		Shengfang Zhao		Kevin Yang		30-Apr-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 Detail Design		
设计 PREPARED	黄晓至		2023.5.26		AGR2 Lean/Rich Amine Exchanger NOZZLE DETAIL DRAWING				设备位号 ITEM NO.		18-X-274/B	
审核 REVIEWED	李响		2023.5.26						图号 DWG. NO.		WXCE8705-03	
批准 APPROVED			2023.5.26		比例: 1:1 SCALE		版次: 05 REV.		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, 背影凸起, 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:

- 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:

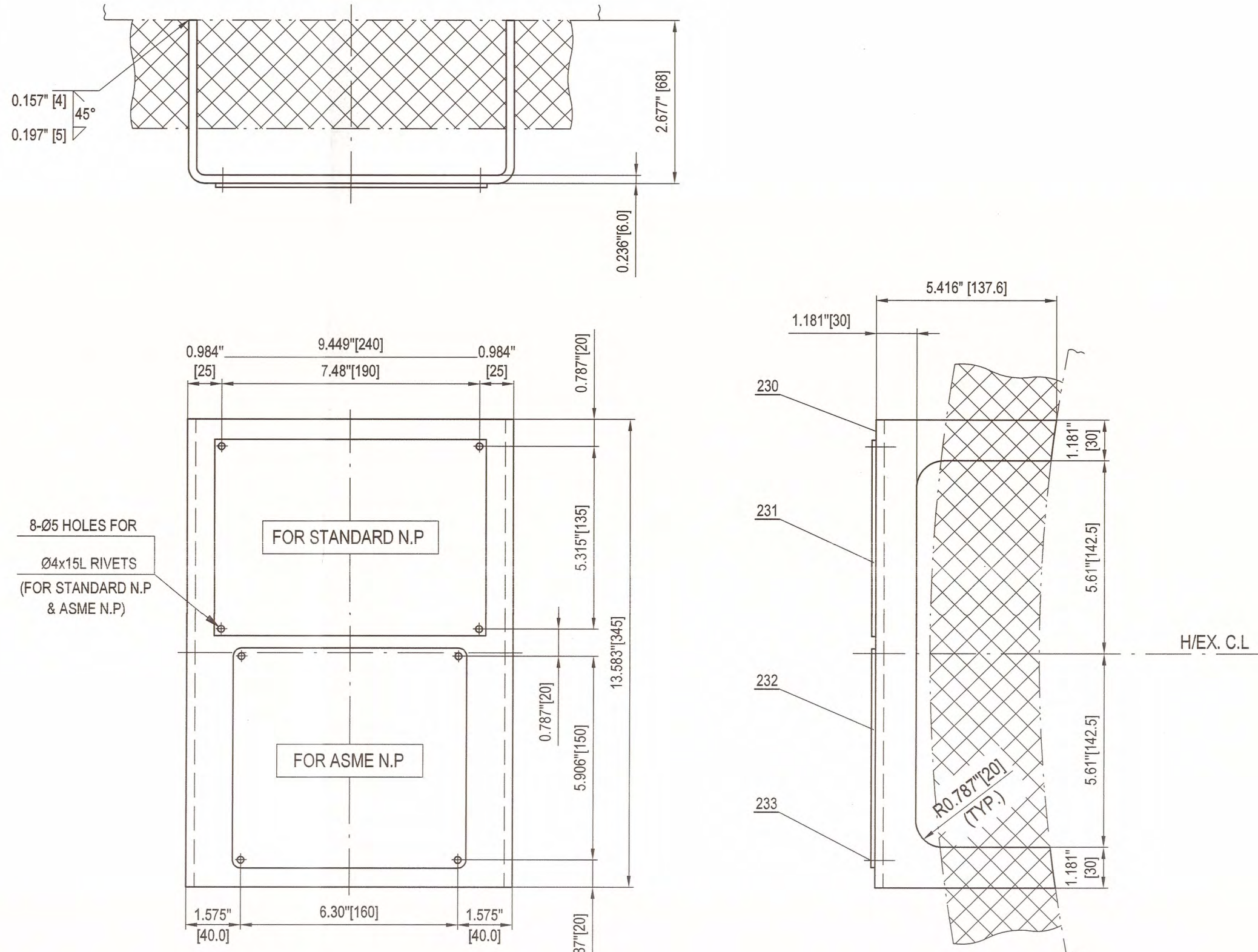
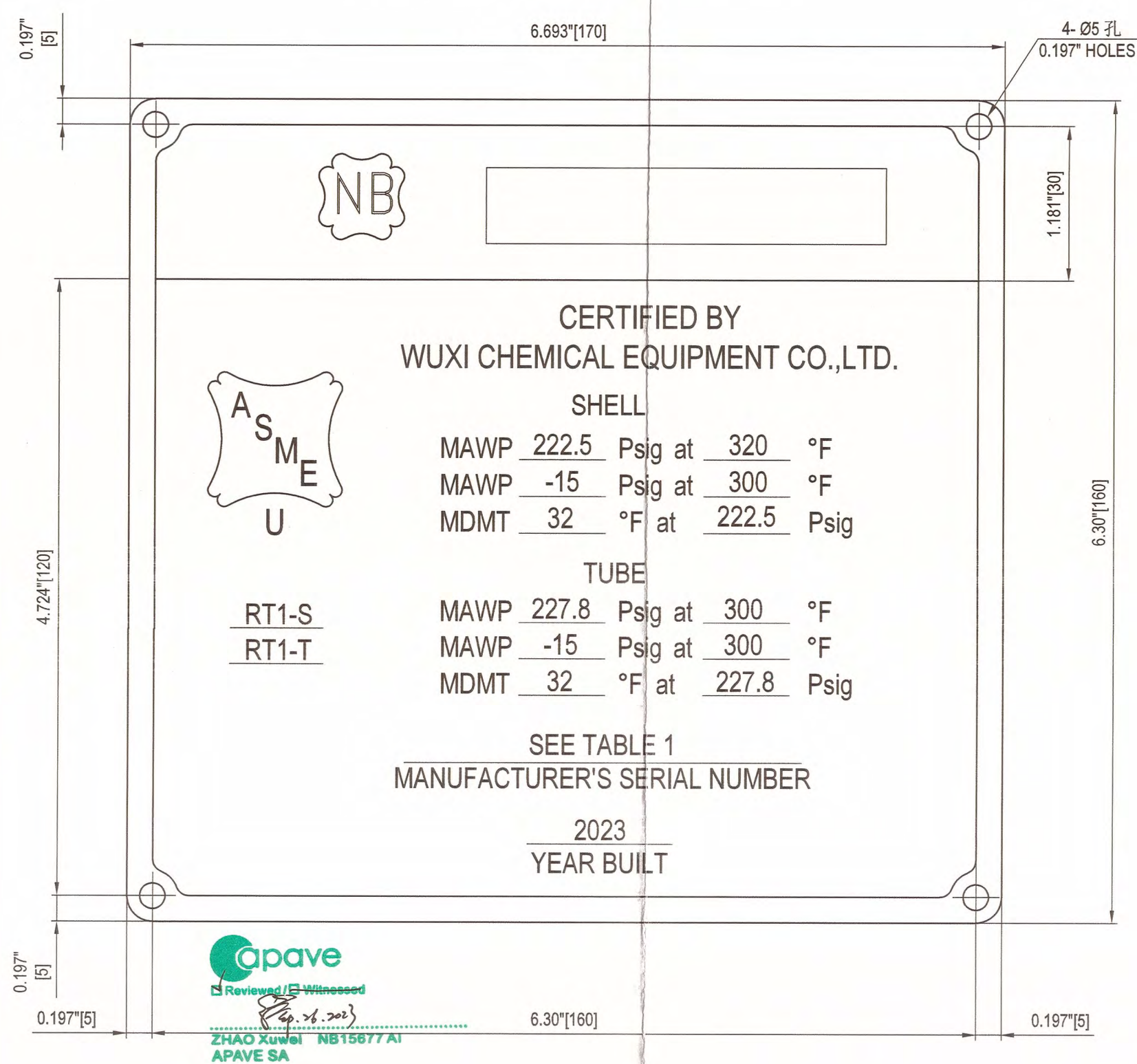
- SPACE FOR AUTHORITY APPROVAL STAMP.
- DATE OF AUTHORITY APPROVAL. (EXAMPLE: 01 MAR 2019)
- TEST DATE MEANS DATE OF PRESSURE TEST.
- REG. NO.:REGISTRATION NUMBER.

表 1 / TABLE 1

设备位号 ITEM NO.	18-X-274A	18-X-274B
制令号 MANUF. SERIAL No.	WHA22-015-1-1	WHA22-015-1-2

SECTION "A"-"A"

ASME铭牌详图
DETAIL OF ASME NAME PLATE



As Built

Engineer in Responsible Charge
Signature: 曹晓至
(Name)

233	铆钉 Ø4x14 RIVET	16	SS304	/	/	
232	ASME铭牌 t=3 ASME NAMEPLATE	2	SS304	0.4	0.8	
231	标准铭牌 t=3 STANDARD NAMEPLATE	2	SS304	0.7	1.4	
230	支架 t=6 BRACKET	2	SA-516 Gr.70N	3.9	7.8	
件号 PART NO.	图号或标准号 DWG. OR STD. NO.	名 称 DESCRIPTION	数量 QTY.	材 料 MATERIAL	单件EACH 重量 Wt. (kg)	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-9V3-00028	Project Area		SWS/H2S	
Client		WORLD ENERGY PARAMOUNT	Client Doc No:			
05	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	15-Feb-23	
04	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	10-JAN-23	
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00	供批准/ISSUED FOR APPROVAL	Xiaosheng Huang	Shengfang Zhao	Kevin Yang	30-Apr-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		
			设计阶段 DESIGN PHASE	竣工图 Detail Design		
设 计 PREPARED	曹晓至	2023.5.26	AGR2 Lean/Rich Amine Exchanger		设备位号 ITEM NO.	18-X-274A/B
审 核 REVIEWED	曹晓至	2023.5.26	NAMEPLATE DETAIL DRAWING		图 号 DWG. NO.	WXCE8705-05
批 准 APPROVED	曹晓至	2023.5.26	比 例: SCALE	1:1	版 次: REV.	05
					第 1 页 共 1 页 PAGE 1 OF 1	