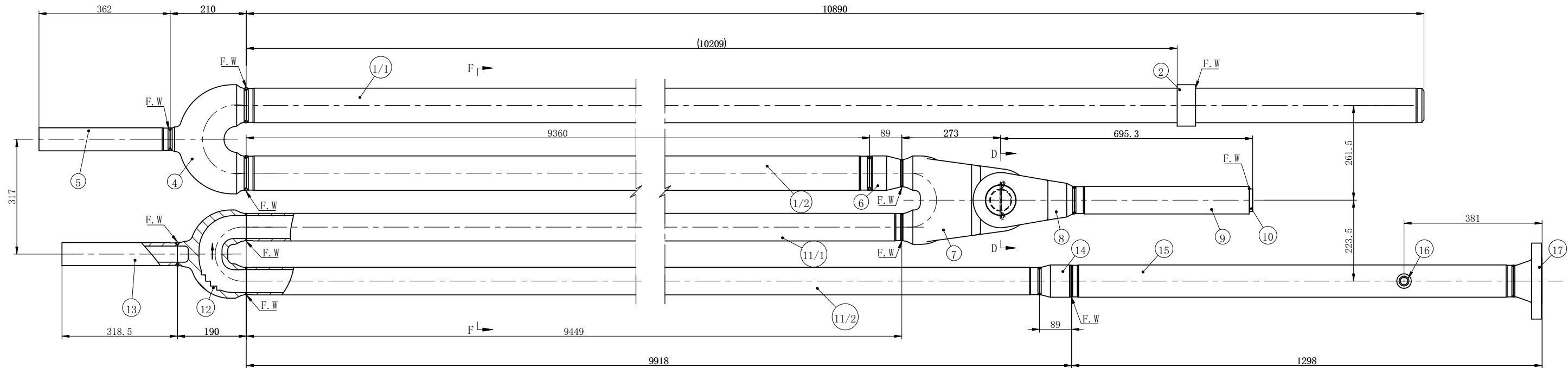
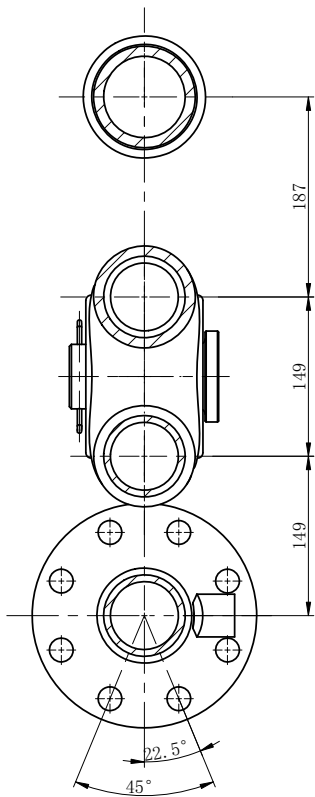


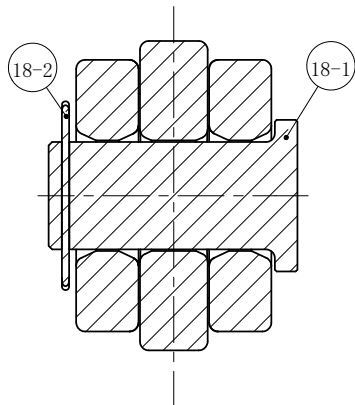
Project No. 22215 (NH25-35MIC)		
	Material Data Sheet NH25-35MIC	Doc. No: NH25-35MIC Rev.: 00
Alloy: NH25-35MIC (W.N.1.4852-G-X40NiCrNb35 25) Service: Tube and Static casting		
1. Chemical Analysis As Shown (%)		
Element	Mini-Max	Remarks
C	0.4-0.55	
Mn	10×%S - 1.50	
Si	1.50-2.00	
S	≤0.03	
P	≤0.03	
Cr	24.0-27.0	
Ni	34.0-37.0	
Nb	0.80-1.20	
Cu	≤0.25	
Mo	≤0.50	
Ti	Add	
Pb	≤100ppm	
Sn	≤100ppm	
As	≤100ppm	
V	≤0.10	
Zr	Add	
Zn	≤100ppm	
Al	≤0.05	
W	≤0.30	
2. Mechanical Property at Room Temperature Tensile strength : ≥450 MPa Yield strength (Rp 0,2): ≥ 240 MPa Elongation (5d): ≥8% for tube, ≥6% for static casting		
<div style="text-align: right;"> Edited: 陆丛丛 Lu Congcong Checked: 李峻 Li Jun Approved: 魏丽娟 Wei Lijuan </div>		
1 / 1		



F-F
1 : 5



D-D
1 : 3



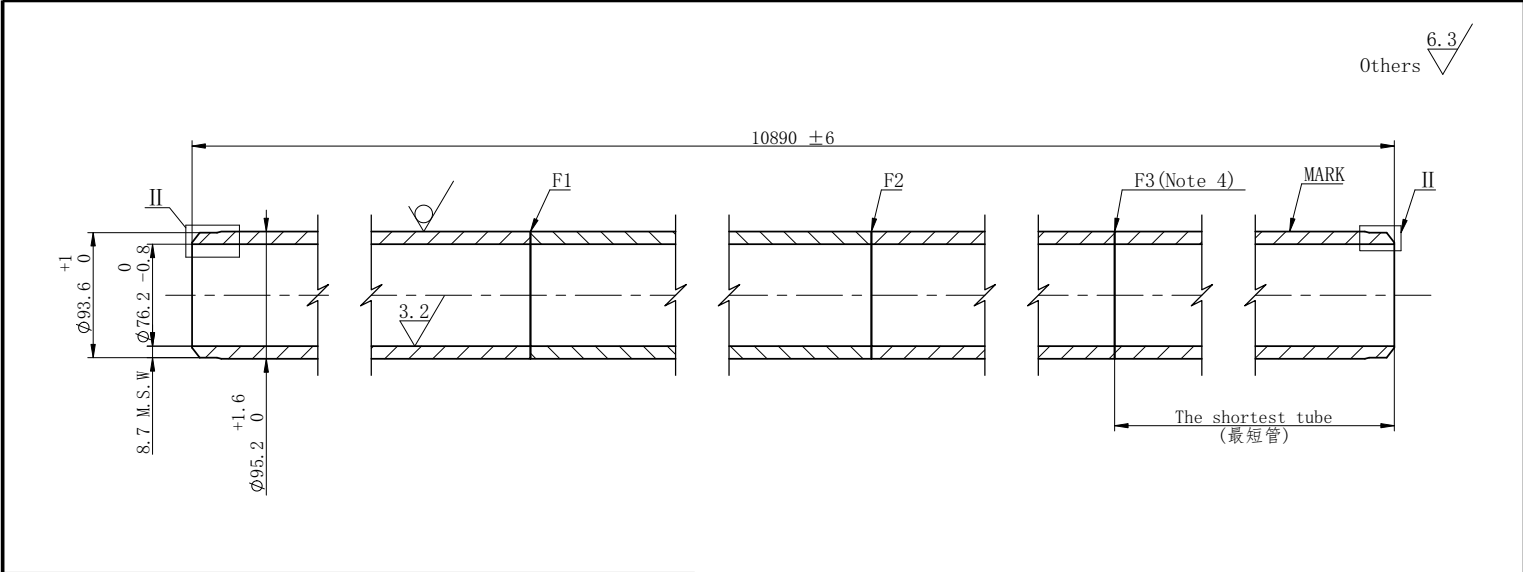
Note: 1.F.W=Field weld
2.The label of furnace number shall be reserved for each pipe segment during delivery.
注 : 1.F.W代表现场焊接
2.发货时每根管段保留炉号标识

18-2	0107B	Specify Pin 指定销	1	ASTM B166 N06601	0.0	0.0	
18-1	0107A	Pin 销轴	1	NH25-35MIC	3.5	3.5	
17	0106A	Flange 法兰	1	ASTM A182 F321	7.2	7.2	
16	0106B	Half coupling 半管接头	1	ASTM A182 F321	0.2	0.2	
15	0102A	Tube 6 管6	1	NH25-35MIC	13.9	13.9	
14	0105B	Reducer 2 减径管 2	1	NH25-35MIC	1.6	1.6	
13	0102C	Tube 8 管8	1	NH25-35MIC	4.0	4.0	
12	0103B	180° Return bend 3 180° 弯头 3	1	NH25-35MIC	11.1	11.1	
11/2	0101D	Tube 4 管4	1	NH25-35MIC	109.5	109.5	
11/1	0101C	Tube 3 管3	1	NH25-35MIC	105.3	105.3	
10	0107C	Tap 阀门	1	NH25-35MIC	0.6	0.6	
9	0102D	Tube 9 管9	1	NH25-35MIC	5.3	5.3	
8	0104B	Tube support 管支撑	1	NH25-35MIC	15.9	15.9	
7	0104A	180° Return bend 2 180° 弯头 2	1	NH25-35MIC	19.3	19.3	
6	0105A	Reducer 1 减径管 1	1	NH25-35MIC	2.0	2.0	
5	0102B	Tube 7 管7	1	NH25-35MIC	4.6	4.6	
4	0103A	180° Return bend 1 180° 弯头 1	1	NH25-35MIC	19.3	19.3	
2	0102E	Tube 5 管5	1	NH25-35MIC	1.0	1.0	
1/2	0101B	Tube 2 管2	1	NH25-35MIC	191.3	191.3	
1/1	0101A	Tube 1 管1	1	NH25-35MIC	222.7	222.7	
件号 Item NO.	图号或标准号 DRW. NO. /SD. NO.	名称 Description	数量	材料 MATERIAL	重量 U'W (Kg)	总重 T'W (Kg)	备注

一套转化管装配 的材料清单
Bill of material for 1 set Reformer tube assembly

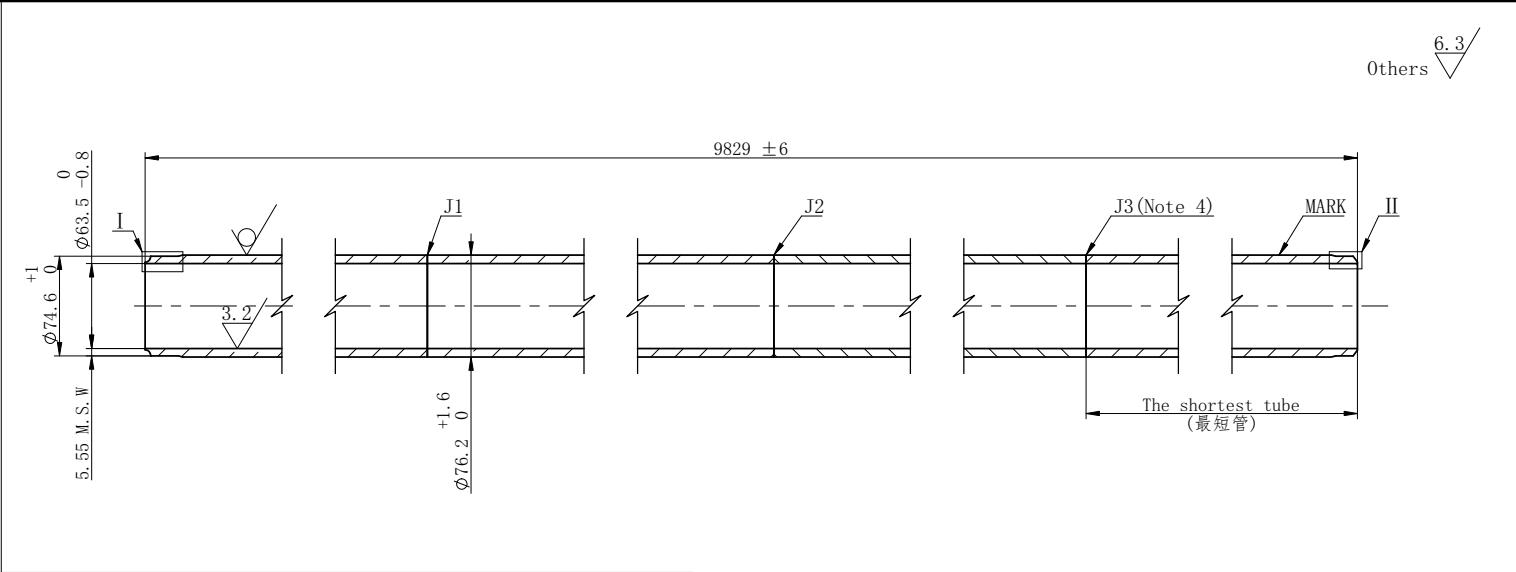
Total order Qty 订货数量	32	重量 U'W (Kg)	738.4	总重 T'W (Kg)	23628.8
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								Reformer tube assembly 转化管装配图	
						Client 客户	Termoenergo inzenjering	工程号 PROJECT. NO.	22215
R00	2022. 7. 28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan	P. 0 NO. 订单号	1/7/22 NPA	图号 DRW. NO.	00
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准	客户图号 Client Dwg. No.	RT01 00 00 00 Rev. 0	件号 ITEM. NO.	

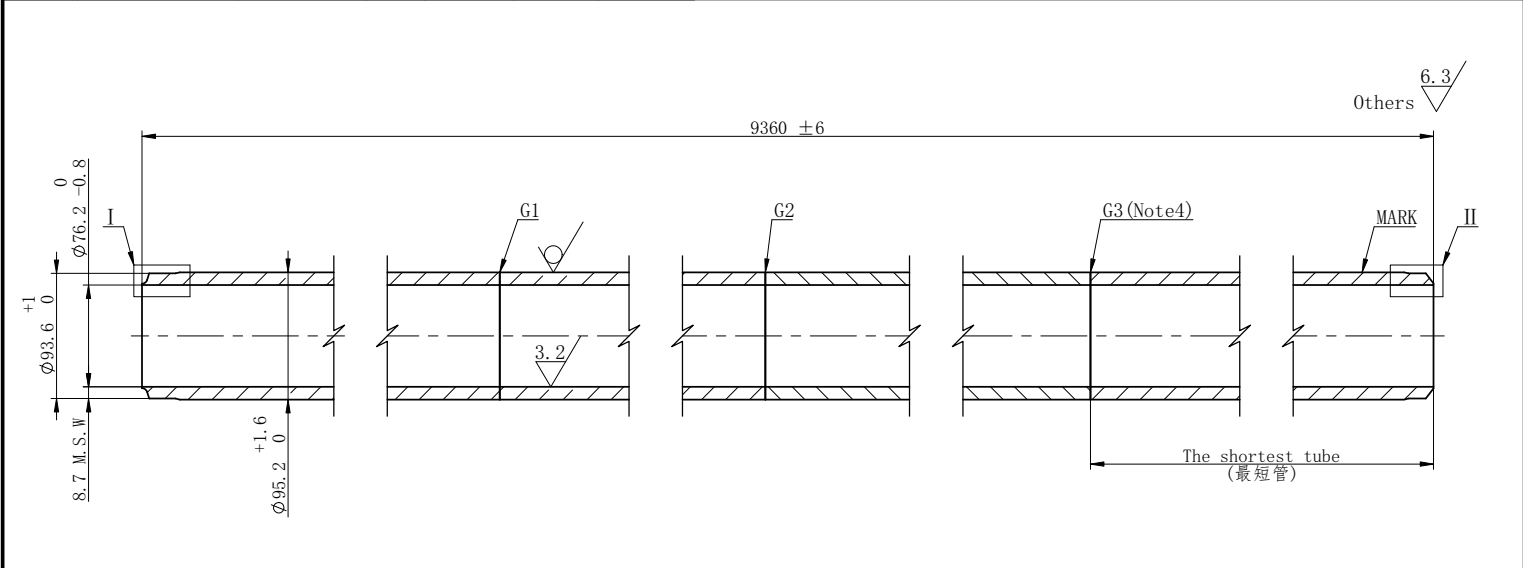


1/1	Tube 1 管1	NH25-35MIC	32	222. 7	0101A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

Mark: NPA-Project No.-Item No.-Series No. (Marked with ink jet printing.)
标识: NPA-工程号-件号-顺序号(喷码标识)。



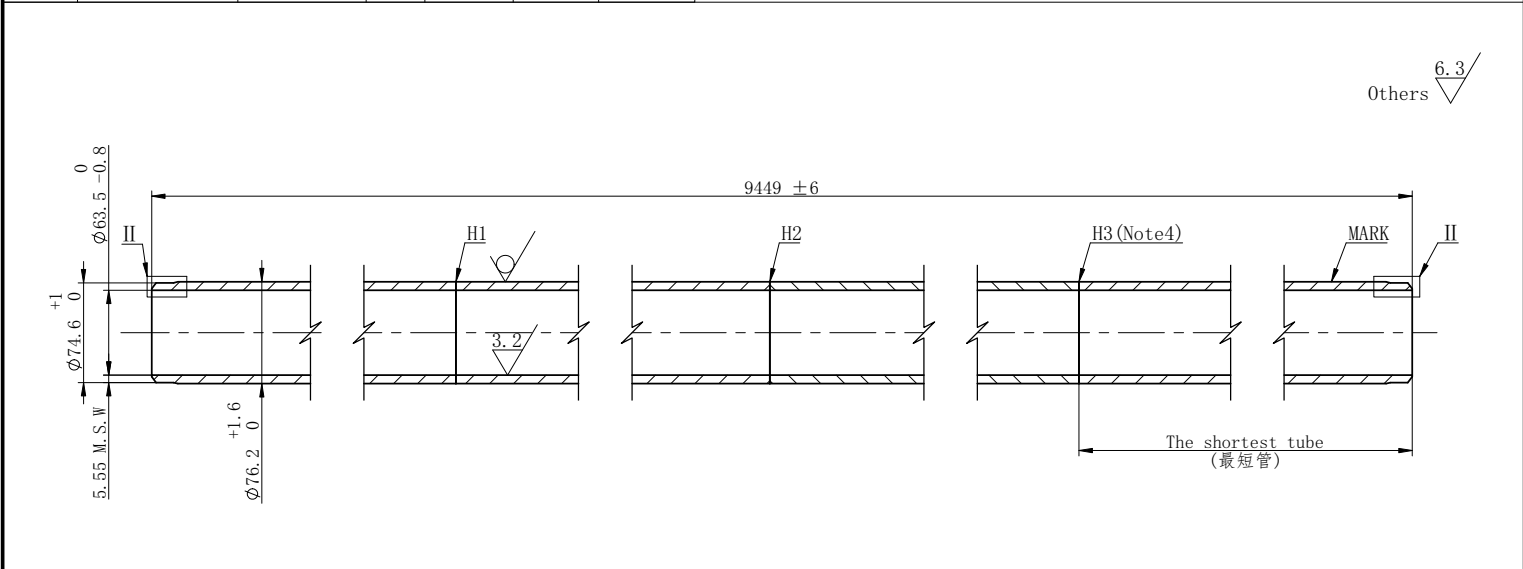
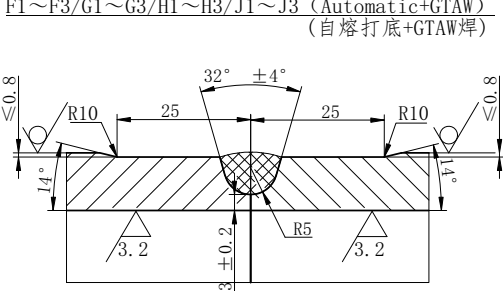
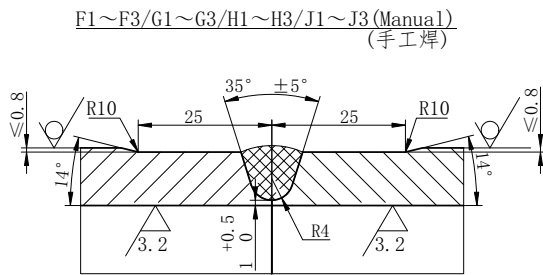
11/2	Tube 4 管4	NH25-35MIC	32	109. 5	0101D	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



1/2	Tube 2 管2	NH25-35MIC	32	191. 3	0101B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

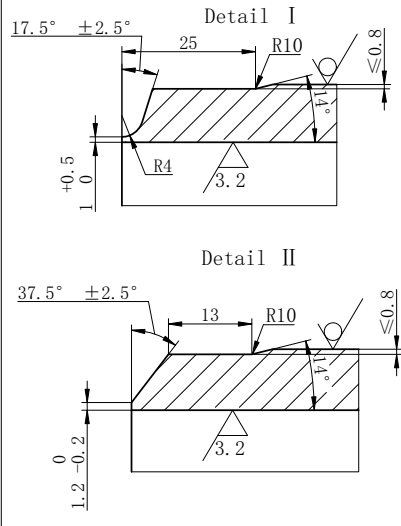
- General notes
- Fabrication and inspection should be in accordance with technical document and ASTM A608.
 - M.S.W=Minimum sound wall.
 - NDE requirements refer to ITP .
 - The number of tube sections \leq 4,the shortest tube should be > 1.2m.
The number of welding joints is tube sections number -1.
 - The outside of completed welds is smooth with a minimum reinforcement of 1.0mm and a maximum of 3.0mm(min. angle of repose between parent metal and weld metal 150°).
The inner welding root should be grinded until it is flush with the inner hole.
 - Tube bow max.6mm for any 3m,max.10mm overall.
 - Machining tolerances unless otherwise:
ISO 2768-1 m ;ISO 2768-2 K
 - Mark:
Process identification: Project No.-Item No.-Heat No. (Marked with marking pen.)

- 技术要求
- 制造和检验应符合技术文件和ASTM A608。
 - M. S. W表示最小密实层厚度。
 - 无损检测按ITP执行。
 - 管段数 \leq 4，最短管大于1. 2m。
焊缝接头数为管段数-1。
 - 焊缝外部光滑，加强高为1. 0mm-3. 0mm
(母材与熔覆金属之间的最小角为150°)。
内焊根应打磨至与内径平齐。
 - 管段或组焊长管直线度公差，任意3m内为不超过6mm，全长不超过10mm。
 - 机加工未注公差：
ISO 2768-1 m级;ISO 2768-2 K级
 - 标识：
过程标识：工程号-件号-炉号(手写标识)。

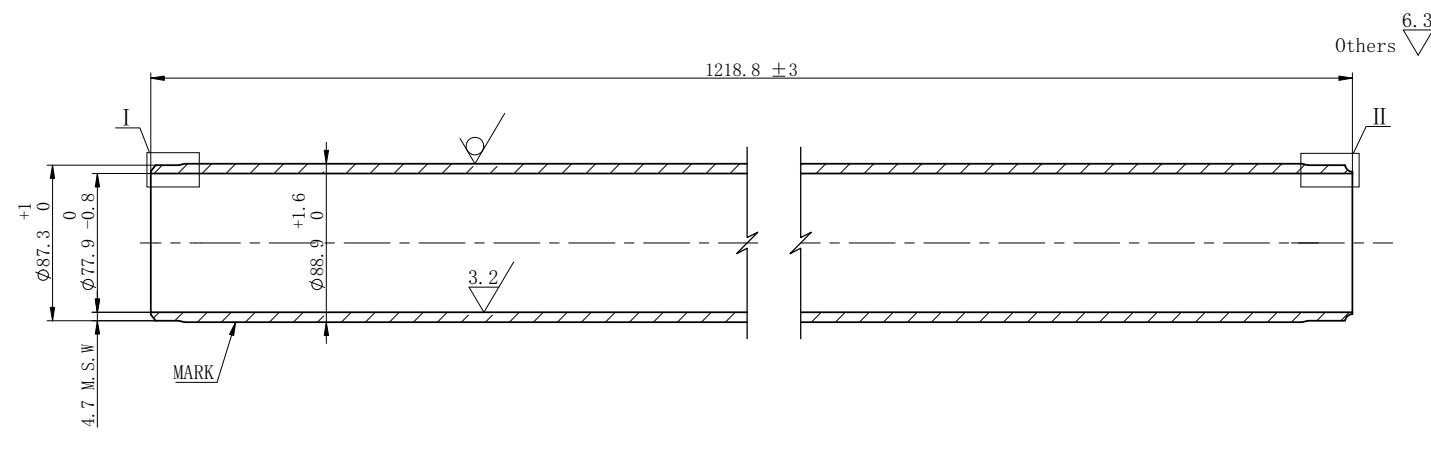
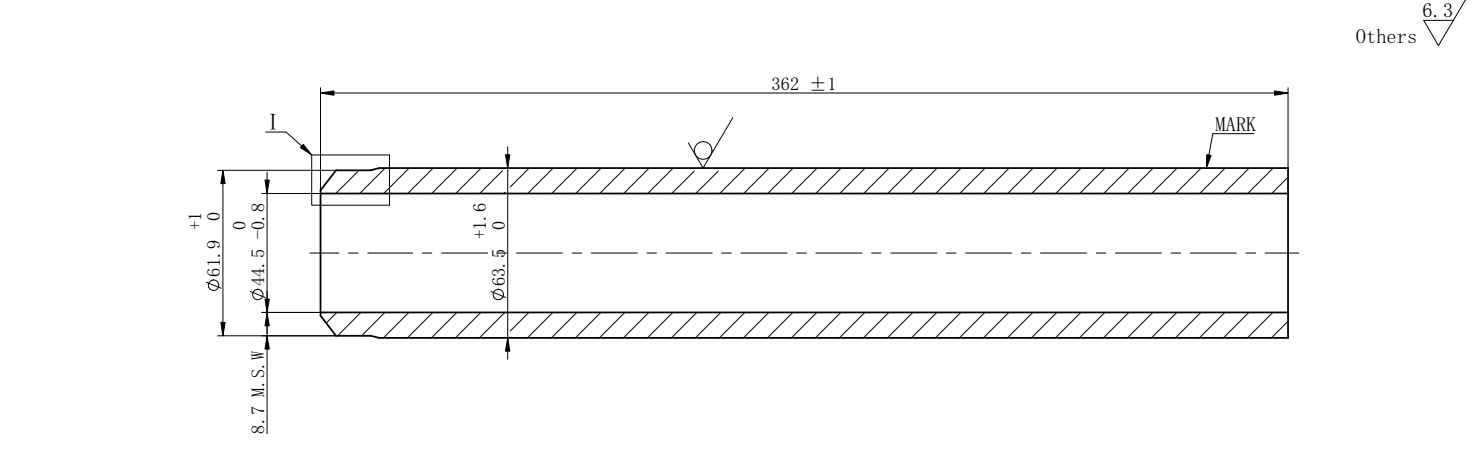
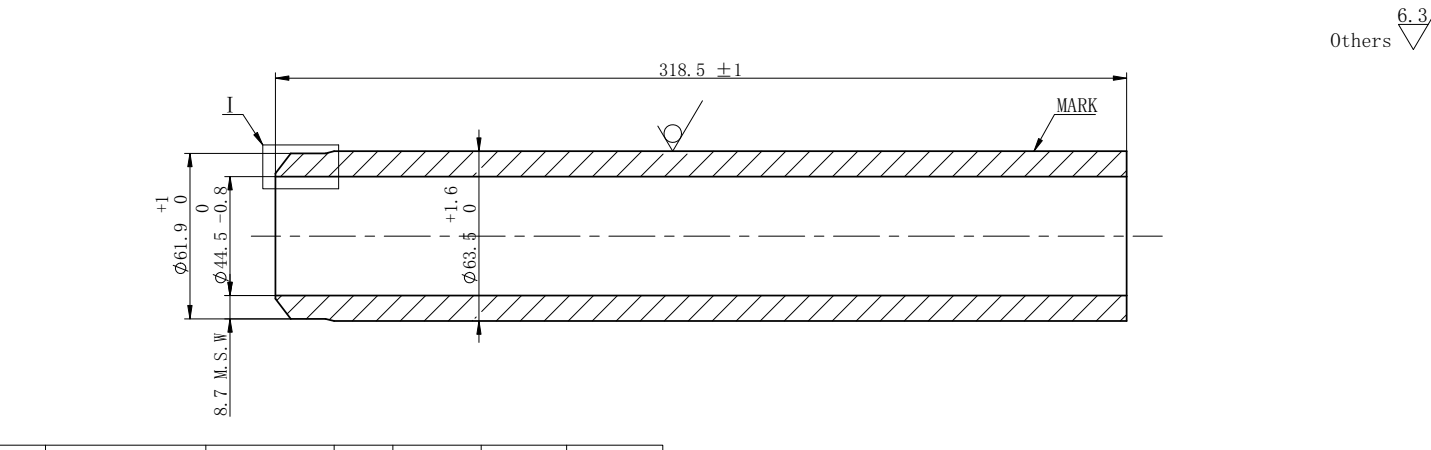
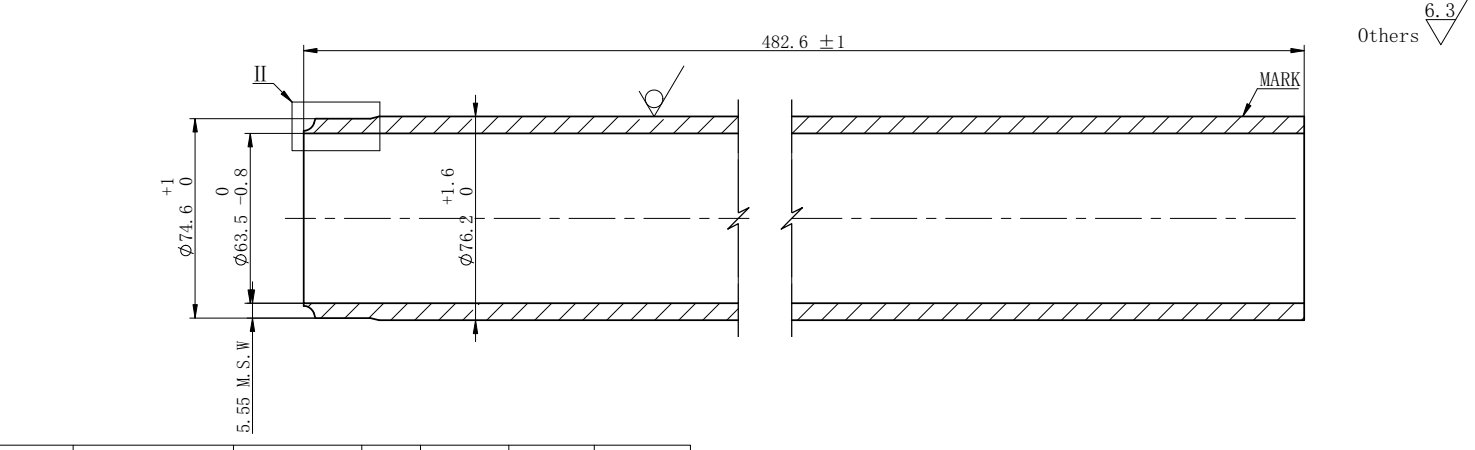
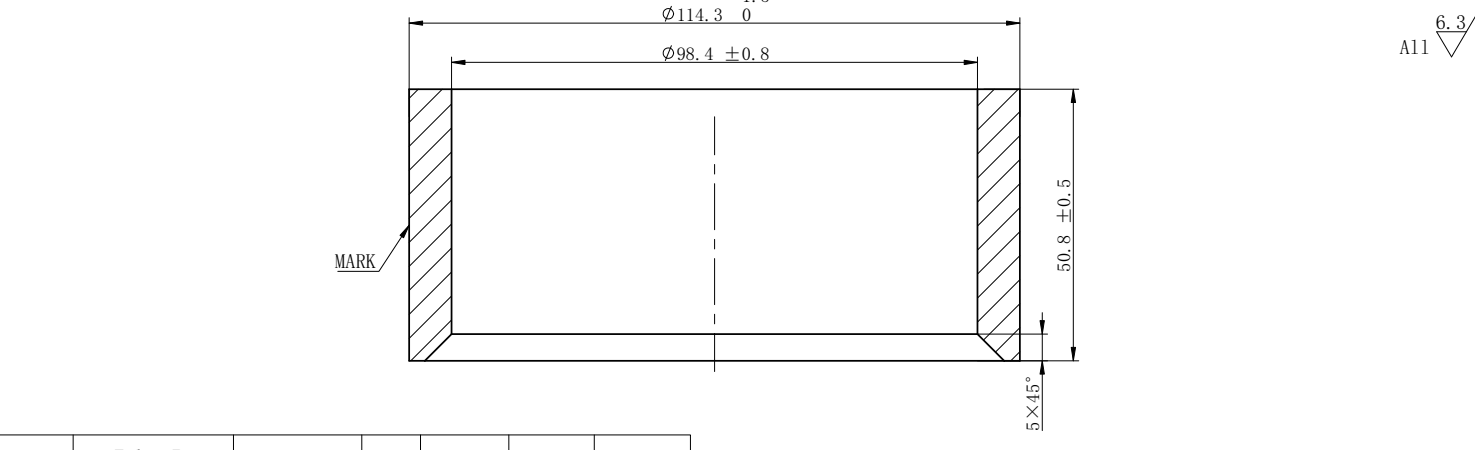


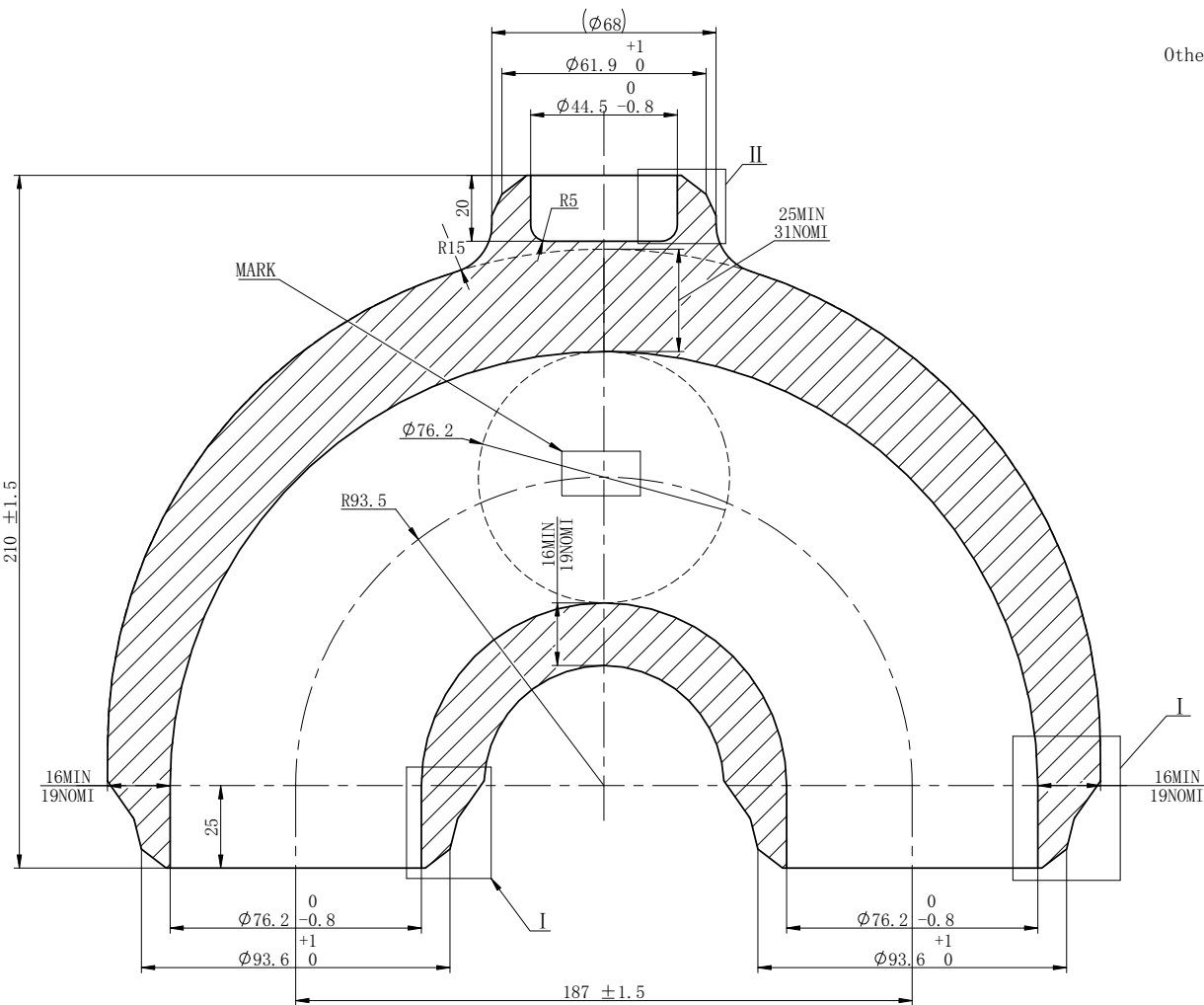
11/1	Tube 3 管3	NH25-35MIC	32	105. 3	0101C	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

Mark: NPA-Project No. -Item No.-Series No. (Marked with ink jet printing.)
标识: NPA-工程号-件号-顺序号(喷码标识)。

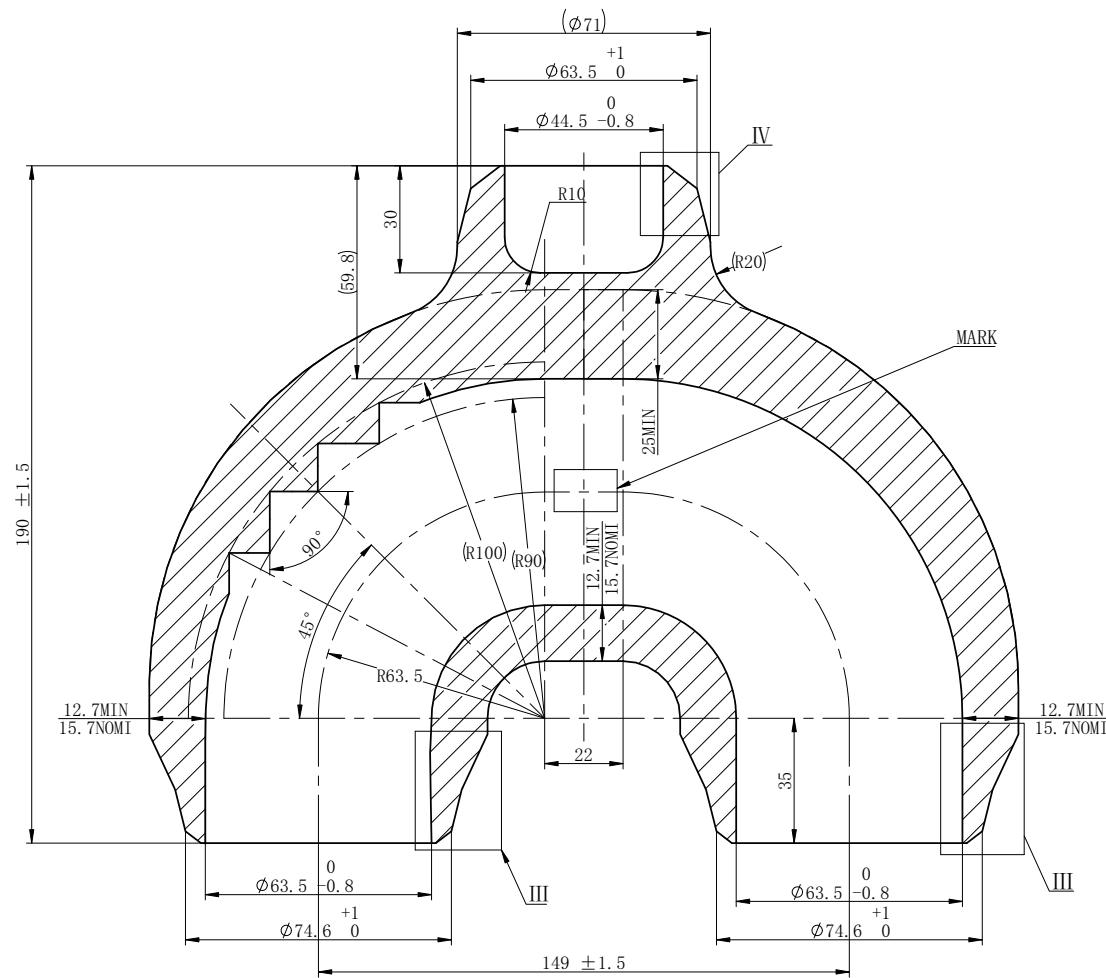


R00	2022. 7. 28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准
			Part drawing 1 零件图 1		
Client 客户		Termoenergo inzenjering	工程号 PROJECT. NO.	22215	
P. 0 NO. 订单号		1/7/22 NPA	图号 DRW. NO.	0101	
客户图号 Client Dwg. No.		RT01 00 00 00 Rev. 0	件号 ITEM. NO.		

													
15	Tube 6 管6	NH25-35MIC	32	13.9	0102A		5	Tube 7 管7	NH25-35MIC	32	4.6	0102B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK	件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK
							Mark: NPA-Project No.-Item No.-Heat No.-Series No. (Marked with ink jet printing.) 标识: NPA-工程号-件号-炉号-顺序号(喷码标识)。						
													
13	Tube 8 管8	NH25-35MIC	32	4.0	0102C		9	Tube 9 管9	NH25-35MIC	32	5.3	0102D	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK	件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK
Mark: NPA-Project No.-Item No. -Heat No.-Series No. (Marked with ink jet printing.) 标识: NPA-工程号-件号-炉号-顺序号(喷码标识)。													
<p>技术要求</p> <p>1. 制造和检验应符合技术文件和ASTM A608。</p> <p>2. M. S. W表示最小密实层厚度。</p> <p>3. 无损检测按ITP执行。</p> <p>4. 管段直线度公差，任意1m内为不超过2mm。</p> <p>5. 机加工未注公差： ISO 2768-1 m级;ISO 2768-2 K级</p> <p>6. 标识： 过程标识: 工程号-件号-炉号(手写标识)。</p>													
<p>General notes</p> <p>1. Fabrication and inspection should be in accordance with technical document and ASTM A608.</p> <p>2. M.S.W=Minimum sound wall.</p> <p>3. NDE requirements refer to ITP .</p> <p>4. Tube bow max.2mm for any 1m.</p> <p>5. Machining tolerances unless otherwise: ISO 2768-1 m ;ISO 2768-2 K</p> <p>6. Mark: Process identification: Project No.-Item No.-Heat No. (Marked with marking pen.)</p>							2	Tube 5 管5	NH25-35MIC	32	1.0	0102E	
							件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK
							Mark: NPA-Project No.-Item No.-Heat No.-Series No. (by laser marking) 标识: NPA-工程号-件号-炉号-顺序号(激光打标)。						
							Part drawing 2 零件图 2						
							Client 客户	Termoenergo inzenjering		工程号 PROJECT. NO.	22215		
R00	2022. 7. 28	First issue for approval 首次发布待批准		陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan	P. 0 NO. 订单号	1/7/22 NPA		图号 DRW. NO.	0102		
Rev. 版次	Date 日期	Description 描述		Drawn By 制图	Check By 检查	Approve By 批准	客户图号 Client Dwg. No.	RT01 00 00 00 Rev.0		件号 ITEM. NO.			



4	180° Return bend 1 180° 弯头 1	NH25-35MIC	32	19.3	0103A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



12	180° Return bend 3 180° 弯头 3	NH25-35MIC	32	11.1	0103B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

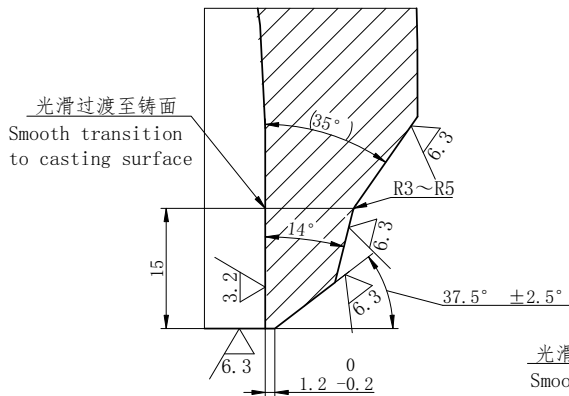
General notes

- The manufacturing and inspection shall conform to technical document and ASTM A351.
- NDE requirement refer to ITP.
- Machining tolerances unless otherwise: ISO 2768-1 m, ISO 2768-2 K.
Casting tolerances as per ISO 8062-DCTG 10.
- Mark: Project No.-Item No.-Heat No.-Series No.(by low stress stamp)
NPA-Material.(by casting)
- Allow to keep the process pouring gate platform, height ≤5mm

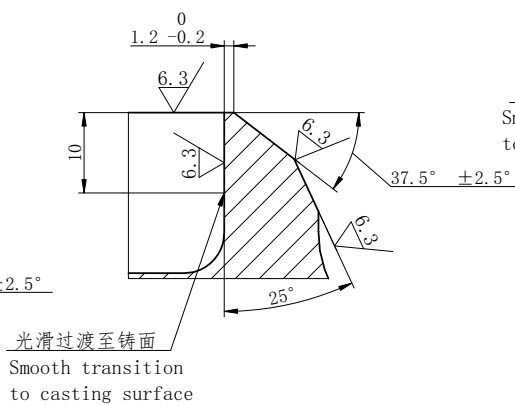
技术要求

- 制造、检验应符合技术文件和ASTM A351的要求。
- 无损检测按ITP执行。
- 未注加工公差按ISO 2768-1 m级;ISO 2768-2 K级;
未注铸造公差按ISO 8062-DCTG 10级。
- 标识: 工程号-件号-炉号-顺序号(低应力钢印) NPA-材质(铸字)
- 允许保留工艺浇口平台, 高度≤5mm

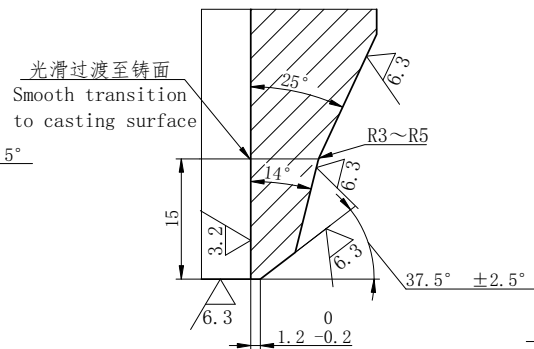
Detail I



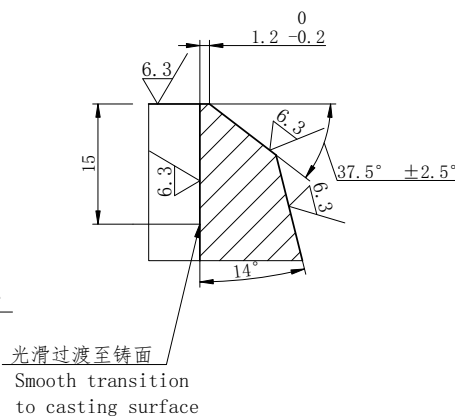
Detail II



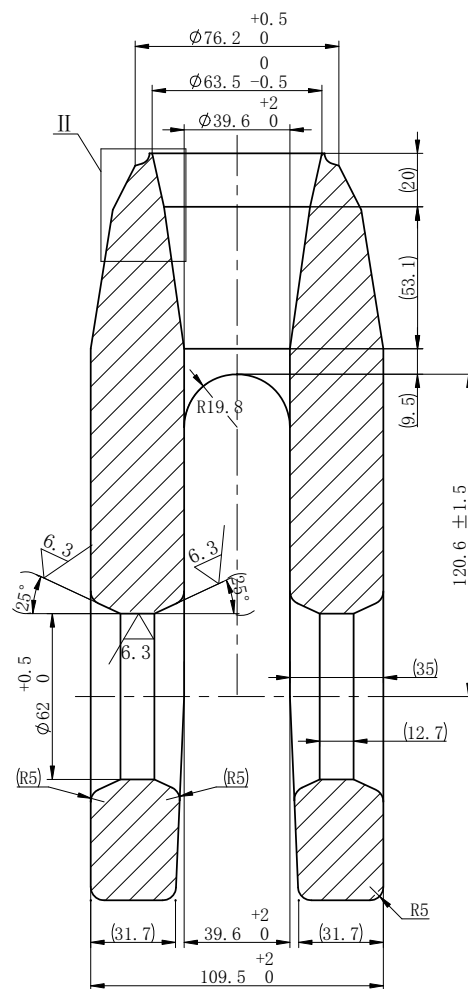
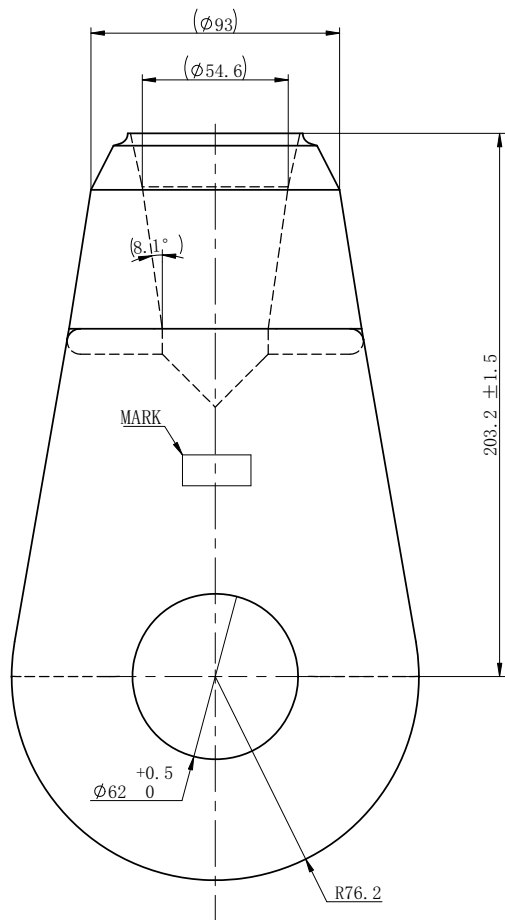
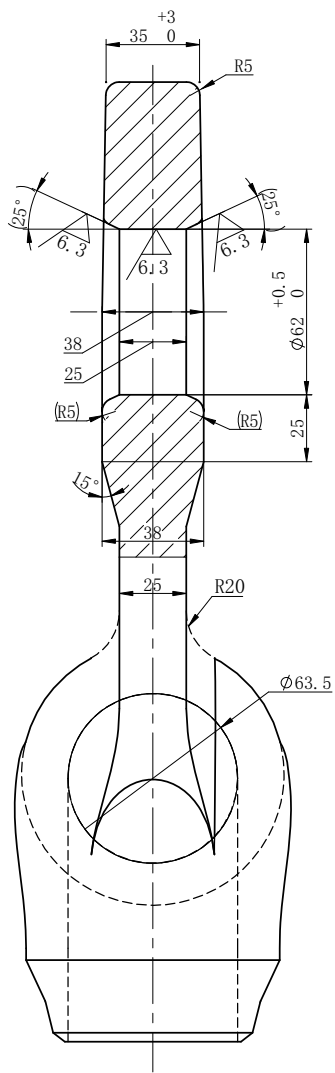
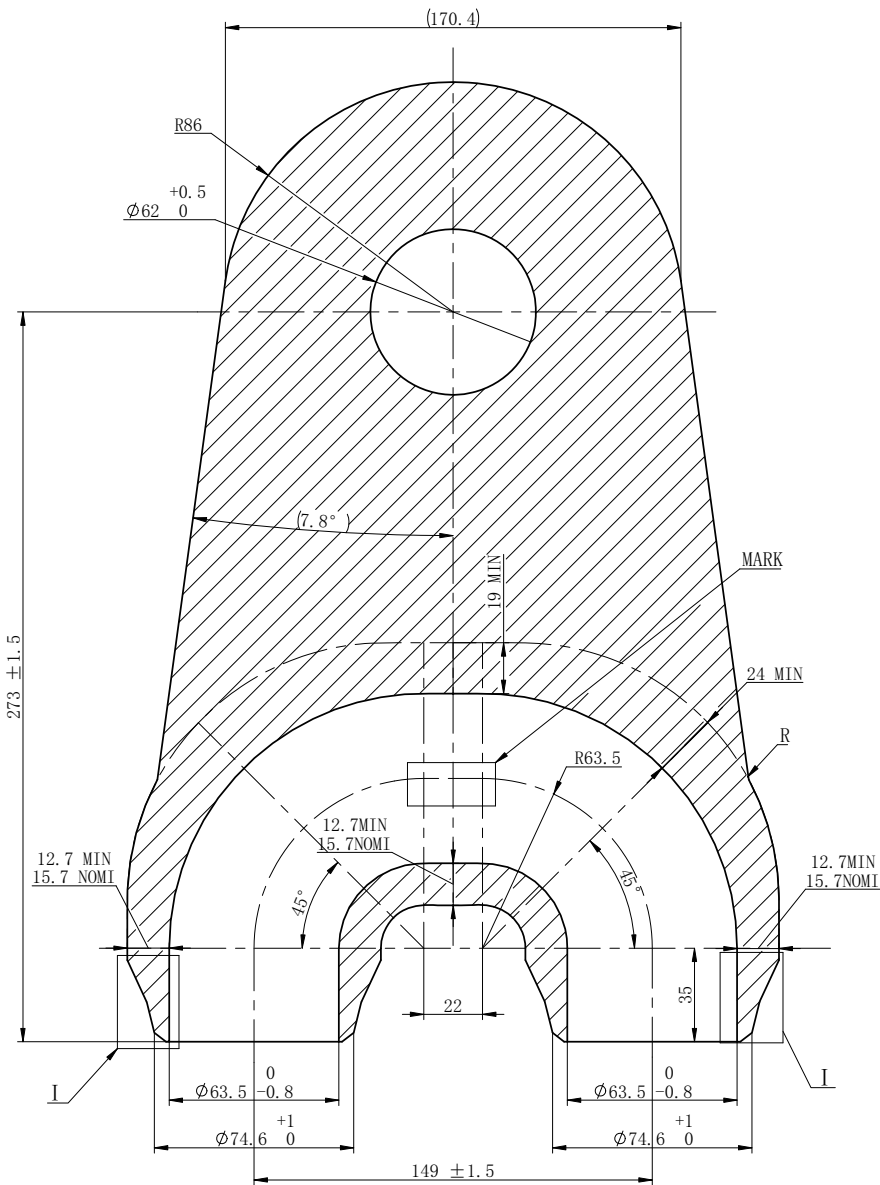
Detail III



Detail IV



								Part drawing 3 零件图 3	
						Client 客户	Termoenergo inzenjering	工程号 PROJECT. NO.	22215
R00	2022.7.28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan	P.O NO. 订单号	1/7/22 NPA	图号 DRW. NO.	0103
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准	客户图号 Client Dwg. No.	RT01 00 00 00 Rev.0	件号 ITEM. NO.	



7	180° Return bend 2 180° 弯头 2	NH25-35MIC	32	19.3	0104A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

8	Tube support 管支撑	NH25-35MIC	32	15.9	0104B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

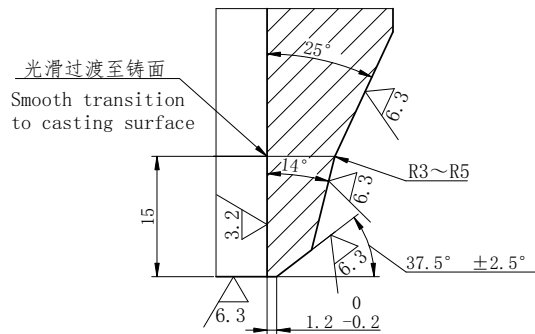
General notes

- The manufacturing and inspection shall conform to technical document and ASTM A351.
- NDE requirement refer to ITP.
- Machining tolerances unless otherwise: ISO 2768-1 m, ISO 2768-2 K.
Casting tolerances as per ISO 8062-DCTG 10.
- Mark: Project No.-Item No.-Heat No.-Series No.(by low stress stamp)
NPA-Material.(by casting)
- Allow to keep the process pouring gate platform, height ≤5mm

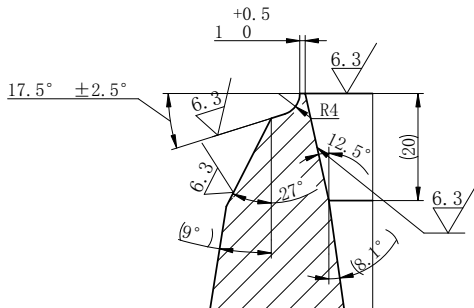
技术要求

- 制造、检验应符合技术文件和ASTM A351的要求。
- 无损检测按ITP执行。
- 未注加工公差按ISO 2768-1 m级;ISO 2768-2 K级;
未注铸造公差按ISO 8062-DCTG 10级。
- 标识: 工程号-件号-炉号-顺序号(低应力钢印) NPA-材质(铸字)
- 允许保留工艺浇口平台, 高度≤5mm

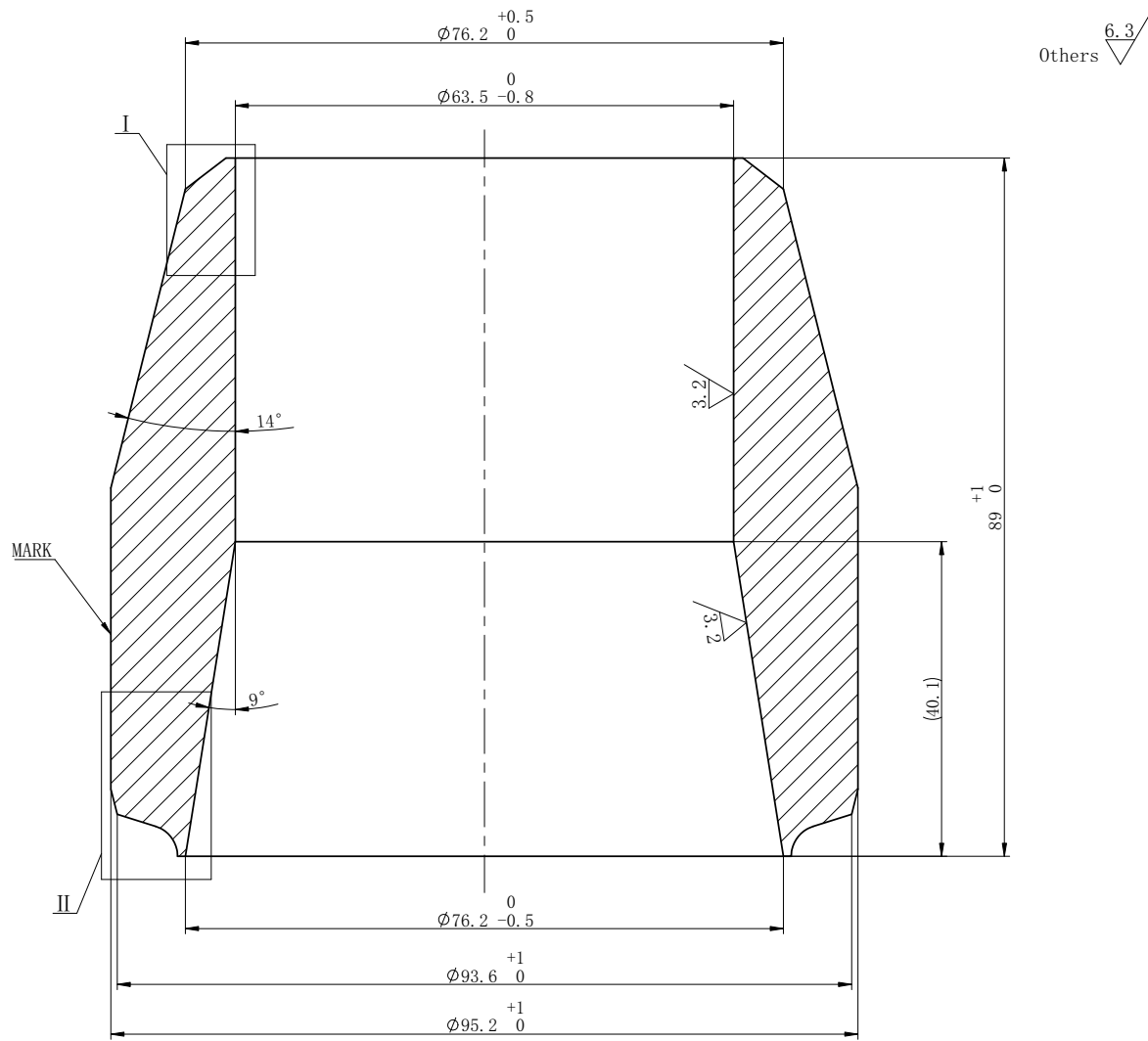
Detail I



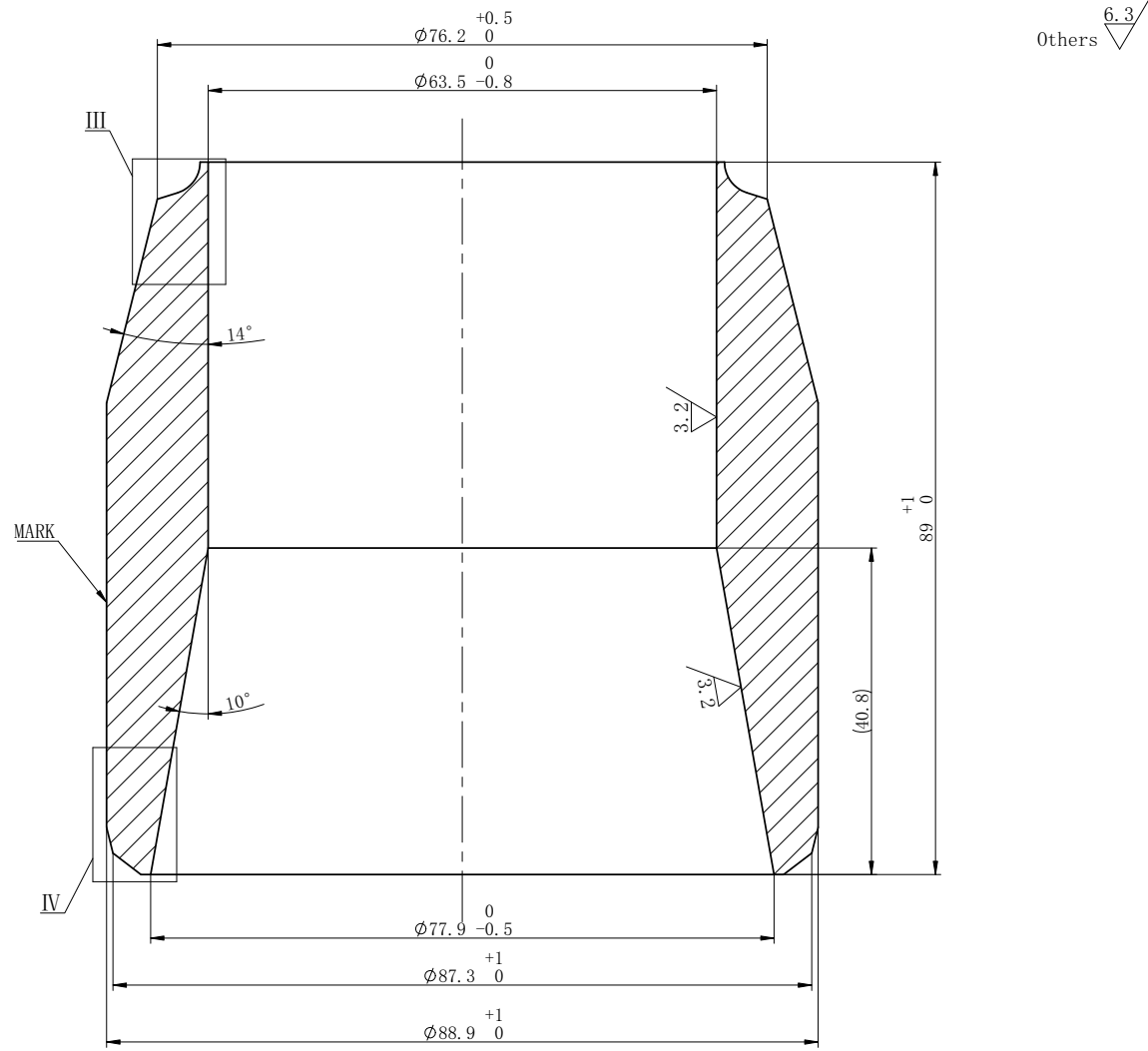
Detail II



R00	2022. 7. 28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准
			Part drawing 4 零件图 4		
Client 客户		Termoenergo inzenjering	工程号 PROJECT. NO.	22215	
P. O NO. 订单号		1/7/22 NPA	图号 DRW. NO.	0104	
客户图号 Client Dwg. No.		RT01 00 00 00 Rev. 0	件号 ITEM. NO.		



6	Reducer 1 减径管 1	NH25-35MIC	32	2.0	0105A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



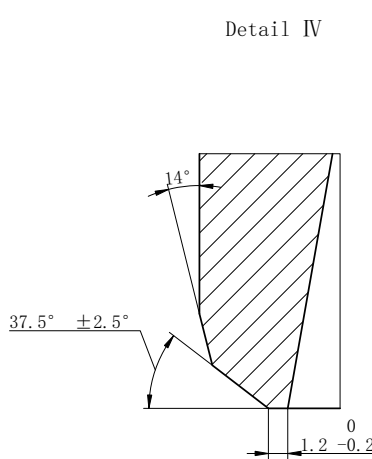
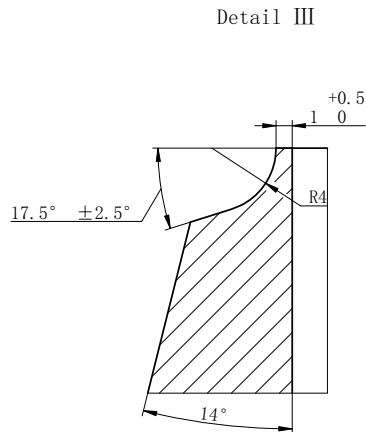
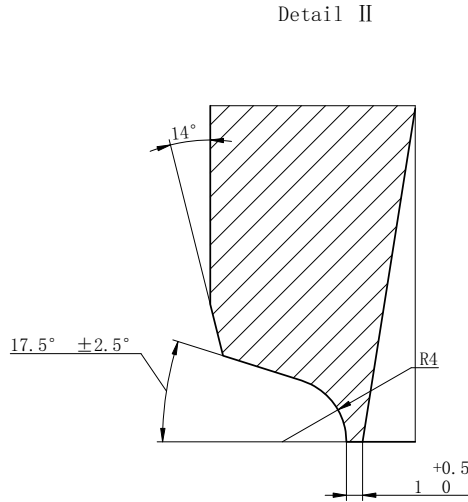
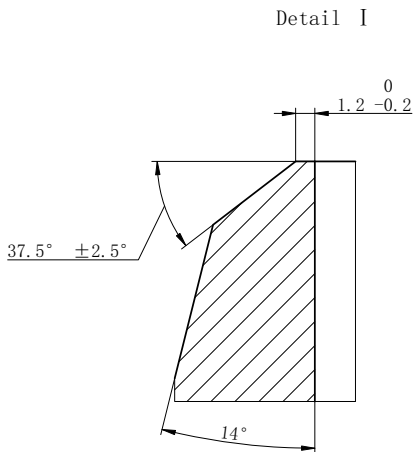
14	Reducer 2 减径管 2	NH25-35MIC	32	1.6	0105B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

Notes

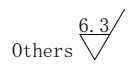
- Fabrication and inspection should be in accordance with technical document and ASTM A608.
- NDE requirements refer to ITP .
- Machining tolerances unless otherwise:
ISO 2768-1 m ;ISO 2768-2 K
- Mark:
NPA-Project No.-Item No.-Heat No. Series No. (by laser marking)

技术要求

- 制造和检验应符合技术文件和ASTM A608。
- 无损检测按ITP执行。
- 机加工未注公差：
ISO 2768-1 m级;ISO 2768-2 K级
- 标识：
NPA-工程号-件号-炉号-顺序号(激光打标)。



								Part drawing 5 零件图 5	
						Client 客户	Termoenergo inzenjering	工程号 PROJECT. NO.	22215
R00	2022.7.28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan	P.0 NO. 订单号	1/7/22 NPA	图号 DRW. NO.	0105
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准	客户图号 Client Dwg. No.	RT01 00 00 00 Rev.0	件号 ITEM. NO.	



技术要求

1. 制造、检验应符合ASTM A182和ASME B16.5的要求。
2. 无损检测按ITP执行。
3. 未注加工公差按ISO 2768-1 M级;ISO 2768-2 K级;
4. 标识: NPA-工程号-件号-材料-3" 300# WN RF-顺序号(激光打标)

17	Flange 法兰	ASTM A182 F321	32	7.2	0106A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

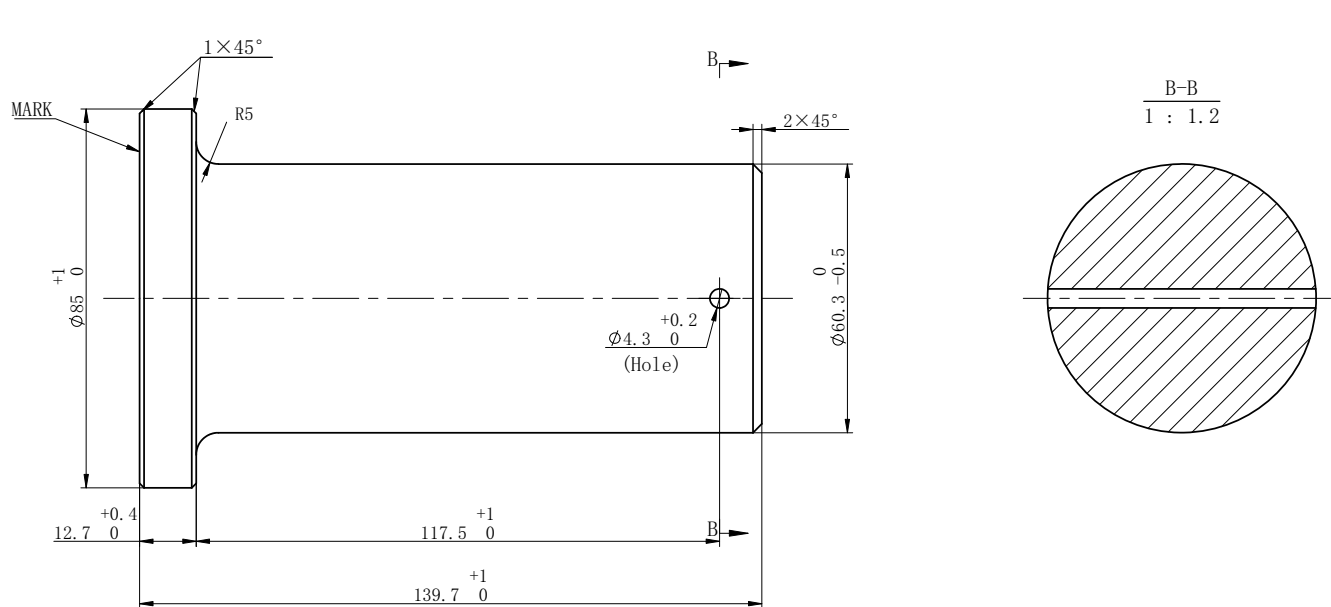


技术要求

1. 制造、检验应符合技术文件和ASTM A182的要求。
2. 无损检测按ITP执行。
3. 未注加工公差按ISO 2768-1 m级;ISO 2768-2 K级;
4. 标识: NPA-工程号-件号-材料-顺序号 (激光打标)

16	Half coupling 半管接头	ASTM A182 F321	32	0.2	0106B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

R00	2022. 7. 28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准
			Part drawing 6 零件图 6		
Client 客户	Termoenergo inzenjering		工程号 PROJECT. NO.	22215	
P. O NO. 订单号	1/7/22 NPA		图号 DRW. NO.	0106	
客户图号 Client Dwg. No.	RT01 00 00 00 Rev. 0		件号 ITEM. NO.		



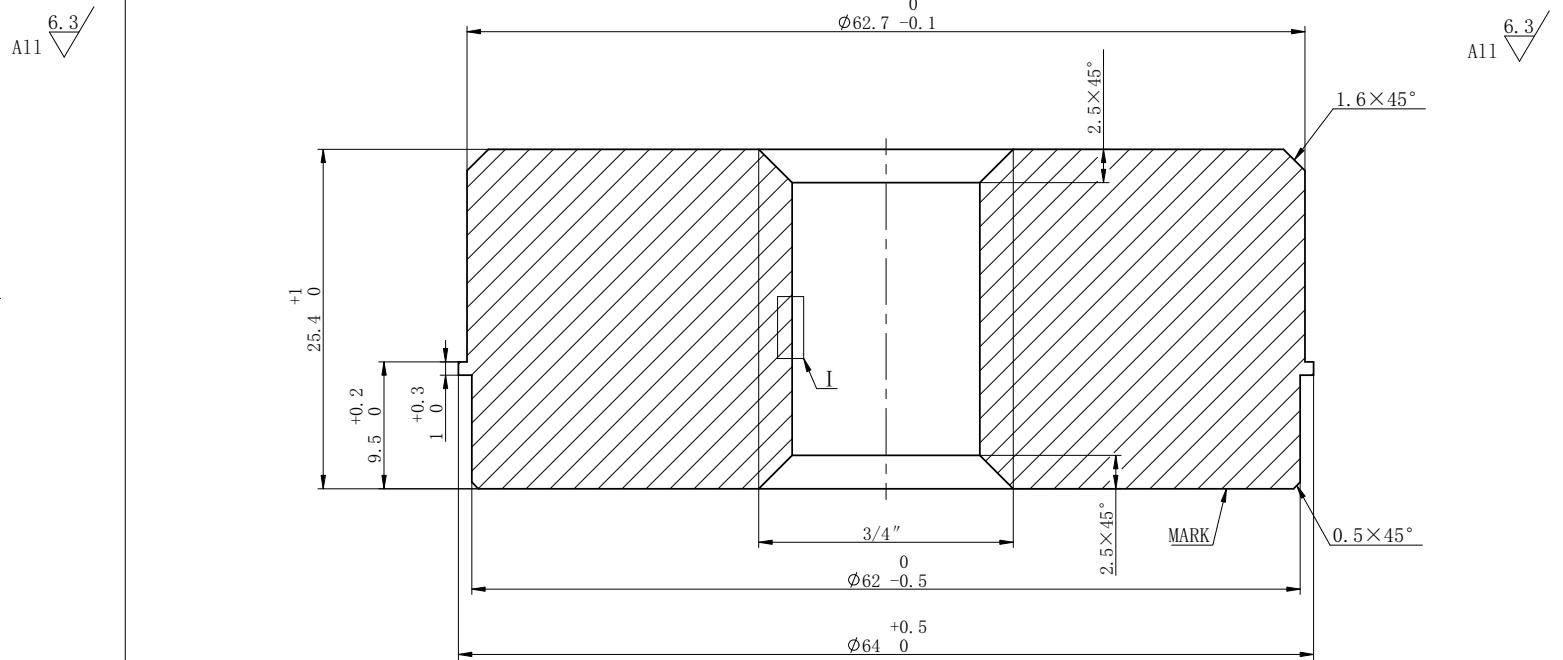
General notes

- 1.The manufacturing and inspection shall conform to technical document and ASTM A351.
- 2.NDE requirement refer to ITP.
- 3.Machining tolerances unless otherwise: ISO 2768-1 m, ISO 2768-2 K. Casting tolerances as per ISO 8062-DCTG 10.
- 4.Mark: NPA-Project No.-Item No.-Heat No.-Series No.(by laser marking)

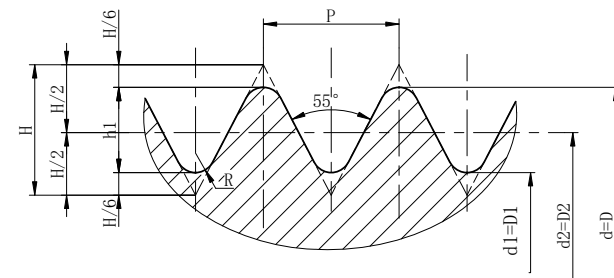
技术要求

1. 制造、检验应符合技术文件和ASTM A351的要求。
2. 无损检测按ITP执行。
3. 未注加工公差按ISO 2768-1 m级;ISO 2768-2 K级;
未注铸造公差按ISO 8062-DCTG 10级。
4. 标识: NPA-工程号-件号-炉号-顺序号(激光打标)

18-1	Pin 销轴	NH25-35MIC	32	3.5	0107A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



Detail I



3/4"	19.051	2.540	17.424	15.798	1.627	0.349	10
NOMINAL SIZE	Basic Major Diameter, d=D	Thread Pitch, P	Basic Pitch Diameter, d2=D2	Basic Diameter Internal, d1=D1	Height of Thread, h1	Radius, r	Threads/ in, z

技术要求

1. 制造、检验应符合技术文件和ASTM A351的要求。
2. 无损检测按ITP执行。
3. 未注加工公差按ISO 2768-1 m级;ISO 2768-2 K级;
未注铸造公差按ISO 8062-DCTG 10级。
4. 标识: NPA-工程号-件号-炉号-顺序号(激光打标)

General notes

- 1.The manufacturing and inspection shall conform to technical document and ASTM A351.
- 2.NDE requirement refer to ITP.
- 3.Machining tolerances unless otherwise: ISO 2768-1 m, ISO 2768-2 K.
Casting tolerances as per ISO 8062-DCTG 10.
- 4.Mark: NPA-Project No.-Item No.-Heat No.-Series No.(by laser marking)

10	Tap 阀门	NH25-35MIC	32	0.6	0107C	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

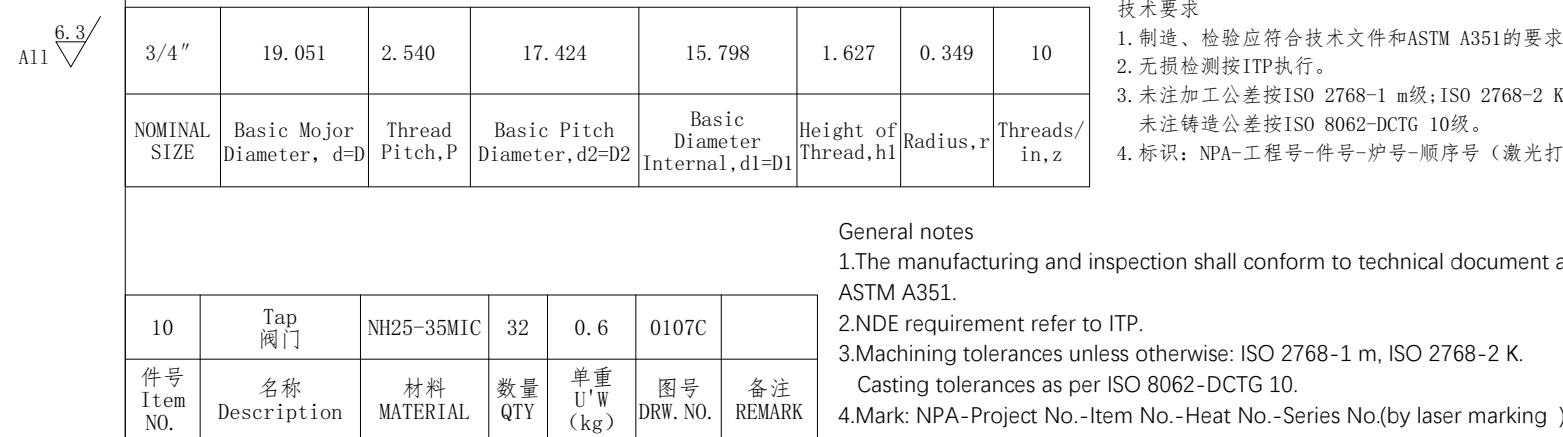
General notes

- 1.The manufacturing and inspection shall conform to technical document and ASTM B166.
- 2.NDE requirement refer to ITP.
- 3.Machining tolerances unless otherwise: ISO 2768-1 m, ISO 2768-2 K.
- 4.Mark: NPA-Project No.-Item No.-Series No.

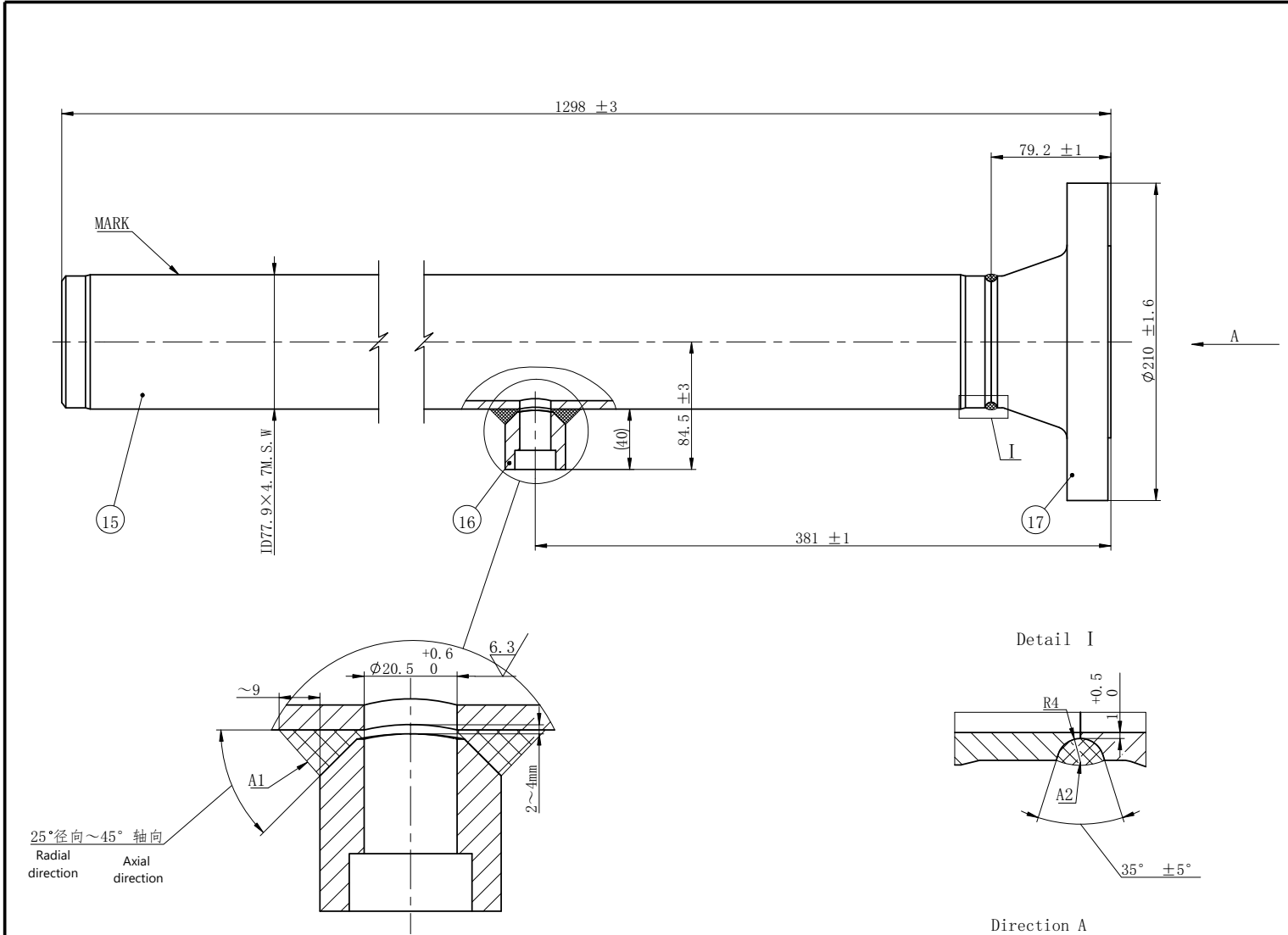
技术要求

1. 制造、检验应符合技术文件和ASTM B166的要求。
2. 无损检测按ITP执行。
3. 未注加工公差按ISO 2768-1 m级;ISO 2768-2 K级。
4. 标识: NPA-工程号-件号-顺序号

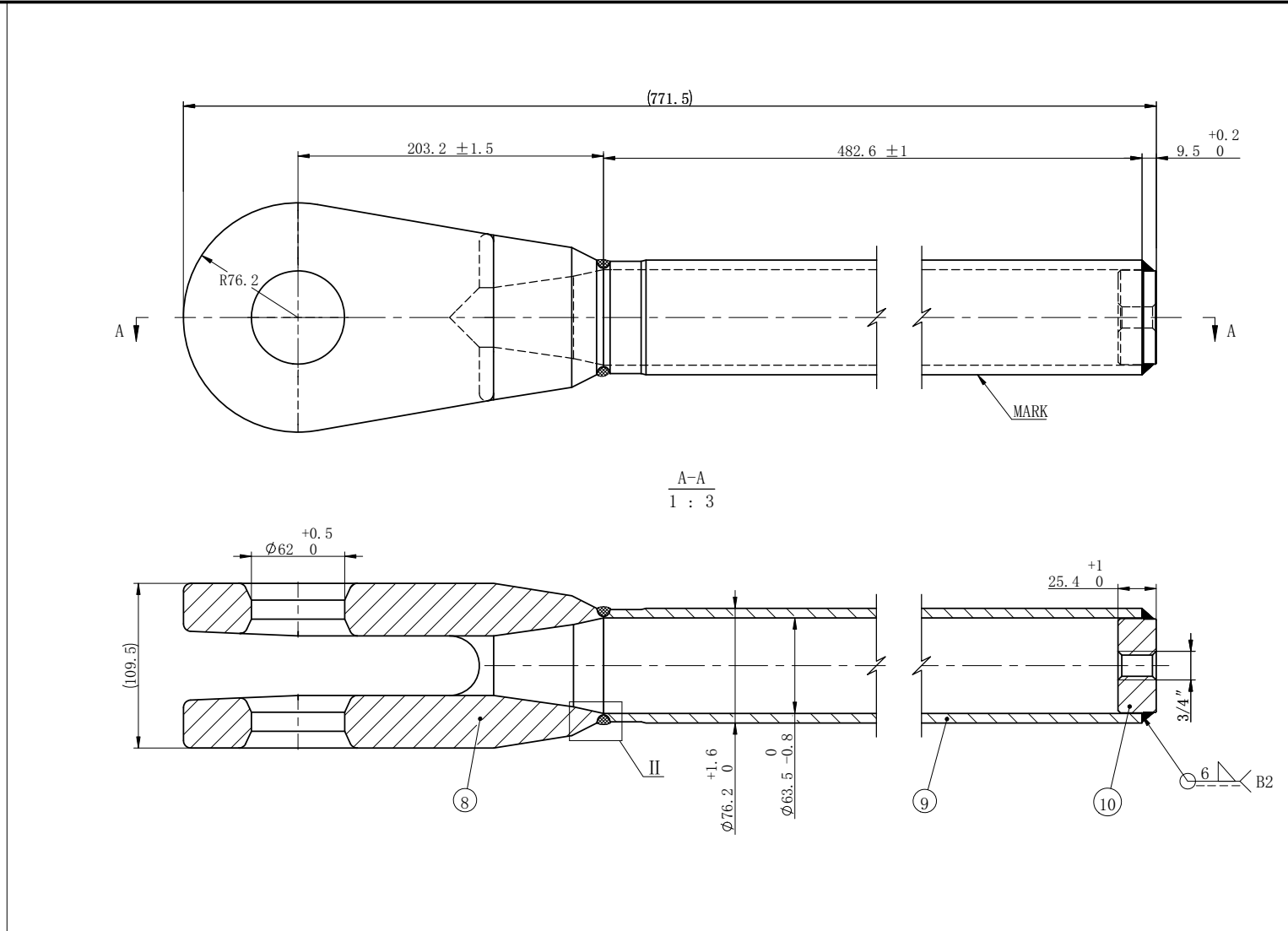
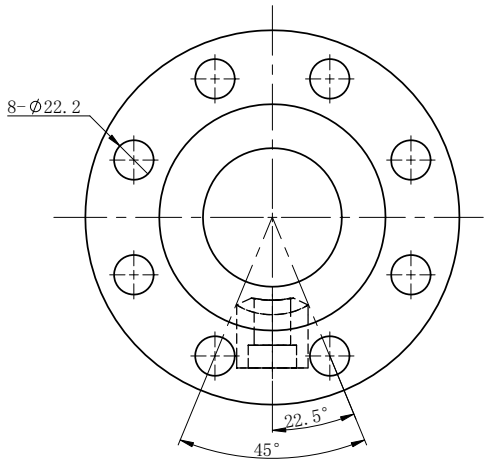
18-2	Specify pin 指定销	ASTM B166 N06601	32	0.0	0107B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



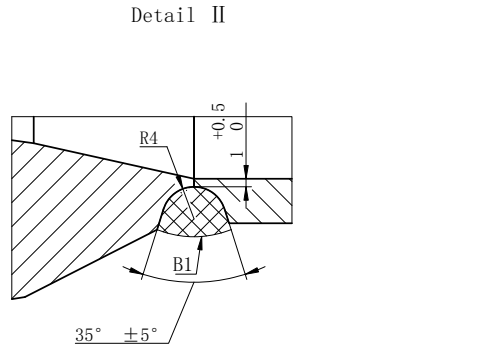
R00	2022. 7. 28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准
			Part drawing 7 零件图 7		
Client 客户	Termoenergo inzenjering		工程号 PROJECT. NO.	22215	
P. O NO. 订单号	1/7/22 NPA		图号 DRW. NO.	0107	
客户图号 Client Dwg. No.	RT01 00 00 00 Rev. 0		件号 ITEM. NO.		



17	Flange 法兰	ASTM A182 F321	1	7.2	0106A	
16	Half coupling 半管接头	ASTM A182 F321	1	0.2	0106B	
15	Tube 6 管6	NH25-35MIC	1	13.9	0102A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号或标准号 DRW. NO. /SD. NO.	备注 REMARK
A	Flange component 法兰组件	Assembly 组合件	32	21.3	01A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



10	Tap 阀门	NH25-35MIC	1	0.6	0107C	
9	Tube 9 管9	NH25-35MIC	1	5.3	0102D	
8	Tube support 管支撑	NH25-35MIC	1	15.9	0104B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号或标准号 DRW. NO. /SD. NO.	备注 REMARK
B	Tube support component 管支撑组件	Assembly 组合件	32	22	01B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



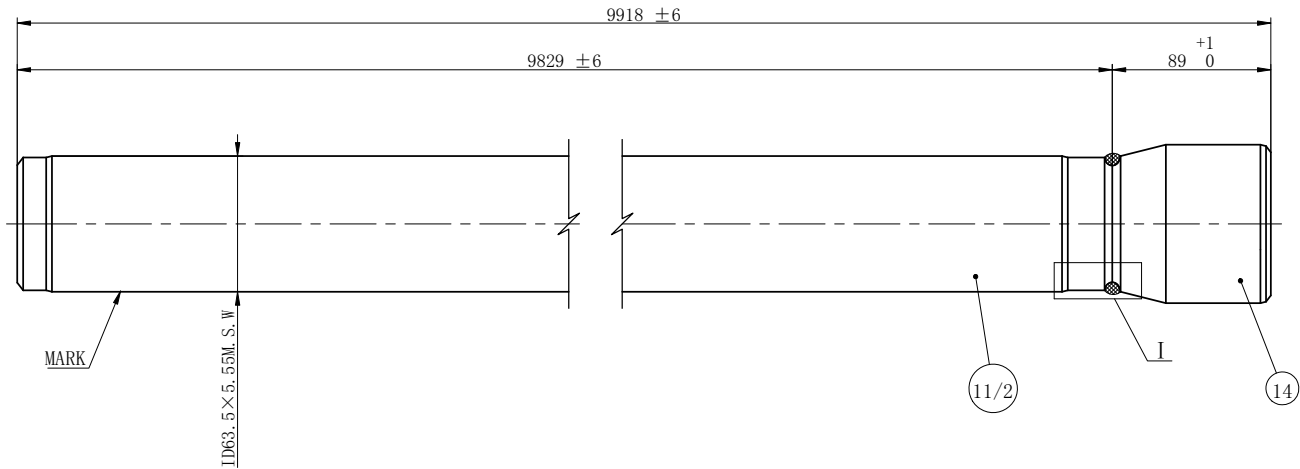
General notes

- 1.The manufacturing and inspection shall conform to technical document ,
For dimensions not individually toleranced refer to ISO 13920 B(JB/T5000.3-2007 B).
- 2.NDE requirement refer to ITP.
3. The outside of completed welds is smooth with a minimum reinforcement of 1.0mm and a maximum of 3.0mm(min. angle of repose between parent metal and weld metal 150°).
The inner welding root should be grinded until it is flush with the inner hole.
If there is no grinding condition, the inner surface should not sag,
and the maximum convex height should be ≤1.5mm.
- 4.Mark:NPA-Project No.-Item No.-Series No.(By using Ink jet printing)

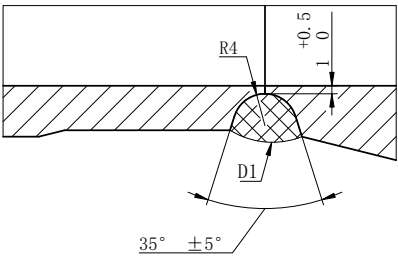
技术要求

- 1、制造、检验应符合技术文件,未注公差按 ISO 13920 B级 (JB/T5000.3-2007 B级)。
- 2、无损检测按ITP执行。
3. 焊缝外部光滑, 加强高为1.0mm-3.0mm (母材与熔覆金属之间的最小角为150°)。
内焊根打磨至与内径平齐。若无打磨条件, 内表面不得凹陷, 最大凸起高度≤1.5mm。
- 4、标记: NPA-工程号-件号-顺序号 (喷码)

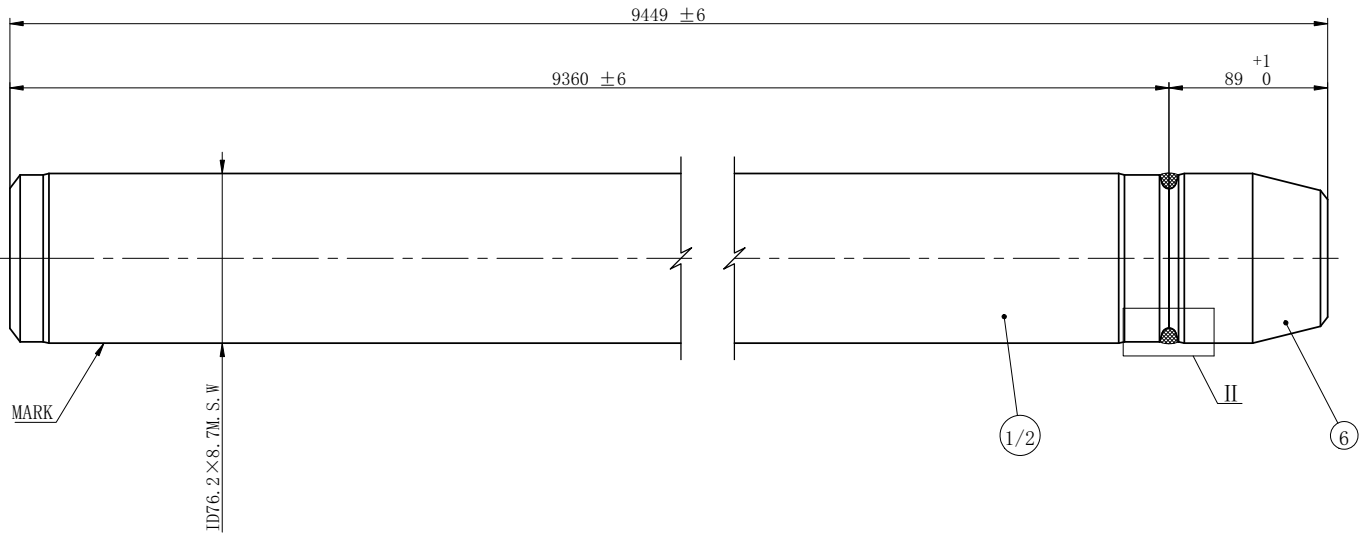
R00	2022. 7. 28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准
			Component drawing 1 部件图 1		
Client 客户		Termoenergo inzenjering	工程号 PROJECT. NO.	22215	
P. 0 NO. 订单号		1/7/22 NPA	图号 DRW. NO.	01	
客户图号 Client Dwg. No.		RT01 00 00 00 Rev. 0	件号 ITEM. NO.		



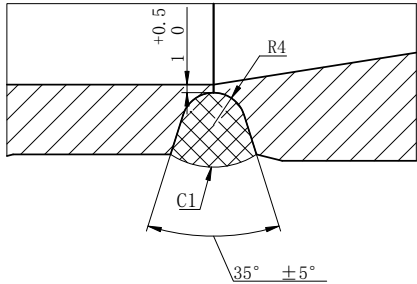
Detail I



14	Reducer 2 减径管 2	NH25-35MIC	1	1. 6	0105B	
11/2	Tube 4 管4	NH25-35MIC	1	109. 5	0101D	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号或标准号 DRW. NO. /SD. NO.	备注 REMARK
C	Reducer component 1 减径管组件 1	Assembly 组合件	32	111	02A	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK



Detail II



6	Reducer 1 减径管 1	NH25-35MIC	1	2. 0	0105A	
1/2	Tube 2 管2	NH25-35MIC	1	191. 3	0101B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号或标准号 DRW. NO. /SD. NO.	备注 REMARK
D	Reducer component 2 减径管组件 2	Assembly 组合件	32	193. 3	02B	
件号 Item NO.	名称 Description	材料 MATERIAL	数量 QTY	单重 U'W (kg)	图号 DRW. NO.	备注 REMARK

General notes

- The manufacturing and inspection shall conform to technical document ,
For dimensions not individually toleranced refer to ISO 13920 B(JB/T5000.3-2007 B).
- NDE requirement refer to ITP.
- The outside of completed welds is smooth with a minimum reinforcement of 1.0mm and a maximum of 3.0mm(min. angle of repose between parent metal and weld metal 150°).
The inner welding root should be grinded until it is flush with the inner hole.
If there is no grinding condition, the inner surface should not sag,
and the maximum convex height should be ≤1.5mm.
- Mark:NPA-Project No.-Item No.-Series No.(By using Ink jet printing)

技术要求

- 制造、检验应符合技术文件,未注公差按 ISO 13920 B级 (JB/T5000.3-2007 B级)。
- 无损检测按ITP执行。
- 焊缝外部光滑,加强高为1.0mm-3.0mm (母材与熔覆金属之间的最小角为150°)。
内焊根打磨至与内径平齐。若无打磨条件,内表面不得凹陷,最大凸起高度≤1.5mm。
- 标记: NPA-工程号-件号-顺序号 (喷码)

R00	2022. 7. 28	First issue for approval 首次发布待批准	陆丛丛 Lu Congcong	李峻 Li Jun	魏丽娟 Wei Lijuan
Rev. 版次	Date 日期	Description 描述	Drawn By 制图	Check By 检查	Approve By 批准
			Component drawing 2 部件图 2		
Client 客户		Termoenergo inzenjering	工程号 PROJECT. NO.	22215	
P. O NO. 订单号		1/7/22 NPA	图号 DRW. NO.	02	
客户图号 Client Dwg. No.		RT01 00 00 00 Rev. 0	件号 ITEM. NO.		