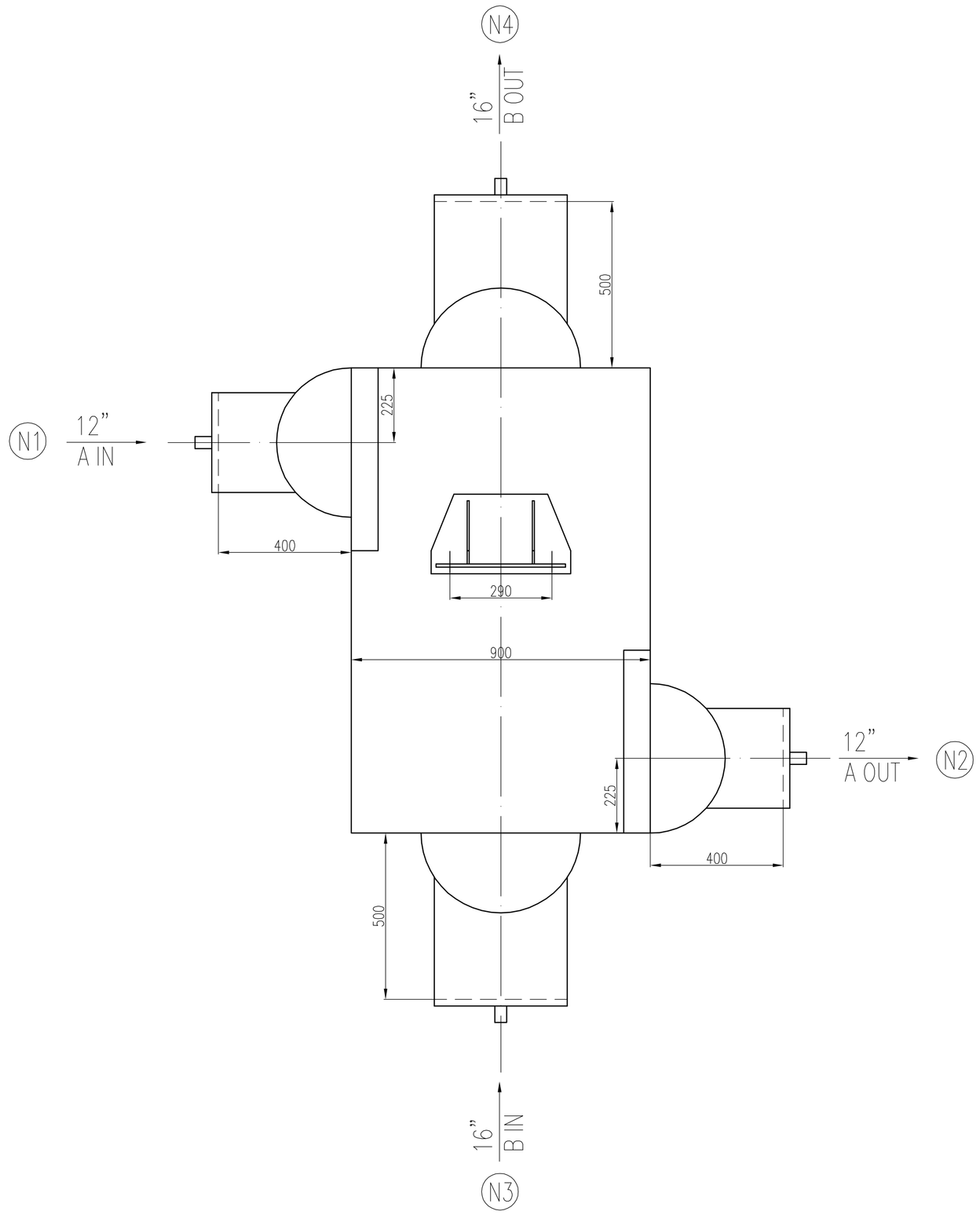


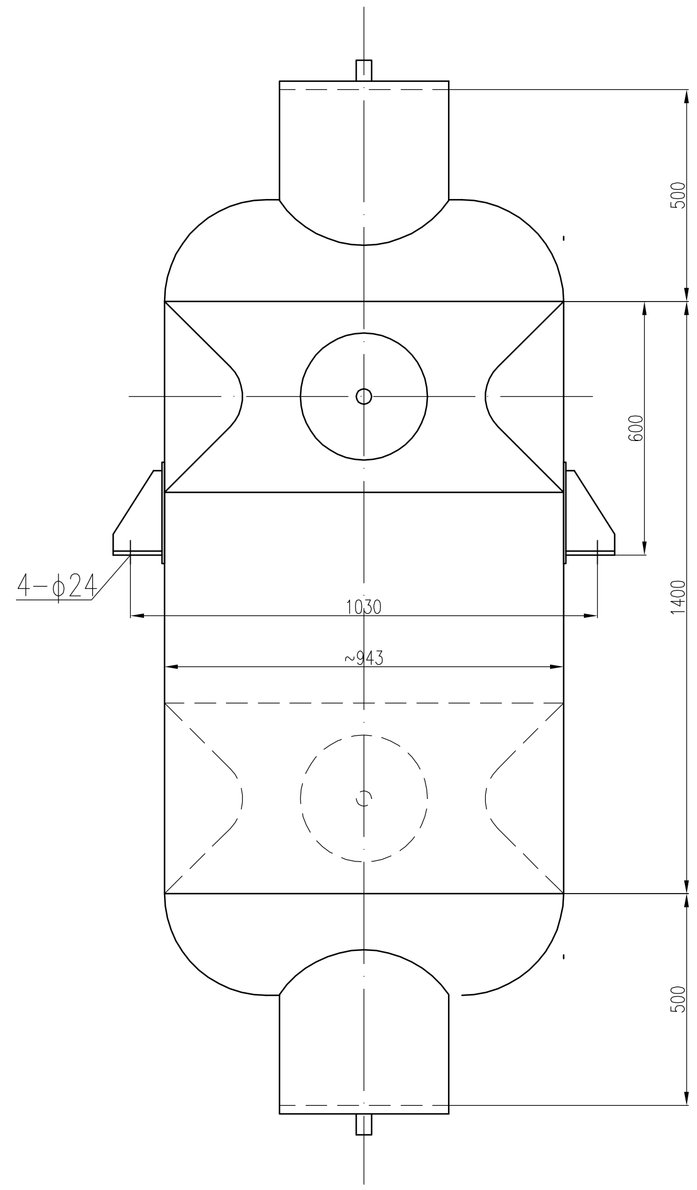


表 1 技术特性 TABLE.1 TECHNICAL DATA

流股	STREAM	A	B
介质	FLUID	FEED GAS	LEAN GAS
介质特性	MEDIA FEATURES	NO LETHAL	NO LETHAL
设计温度	DESIGN TEMPERATURE, °C	−30 ~ +65	−70 ~ +65
设计压力	DESIGN PRESSURE,(Mpa)	6.6	1.9
最高工作压力	MAX WORKING PRESSURE,(Mpa)	4.82	1.21
最高允许工作压力	MAX ALLOWABLE WORKING PRESSURE,(Mpa)	6.6	1.9
通道数	NO. OF PASSAGE	57	58
传热面积	HEAT TRANSTER AREA,SQ.m	295	303
通道容积	CAPACITY,m³	0.455	0.556
最小设计金属温度	MDMT, °C	-140	-140
腐蚀裕度	CORROSION ALLOWABLE	0	0

表 2 接管表 TABLE.2 NOZZLE LIST

管口符号 SYMBLE	DN	管口尺寸 NOZZLE END PREPARATION	接管材料 NOZZLE MATERIAL	封头内半径 厚度 HEADER RXt	封头材料 HEADER MATERIAL	连接形式 CONNECTION TYPE	用途 USAGE	外管口尺寸 NOZZLE END PREPARATION
N1	300	φ324X21.5	SB241-5083-H112 ⚠	R205X40 ⚠	SB209-5083-H112	WELDING	A INLET	φ324X21.5
N2	300	φ324X21.5	SB241-5083-H112 ⚠	R205X40 ⚠	SB209-5083-H112	WELDING	A OUTLET	φ324X21.5
N3	400	φ406X10 ⚠	SB209-5083-H112	R235X18 ⚠	SB209-5083-H112	WELDING	B INLET	φ406X10 ⚠
N4	400	φ406X10 ⚠	SB209-5083-H112	R235X18 ⚠	SB209-5083-H112	WELDING	B OUTLET	φ406X10 ⚠

表 3 液压及气密性试验要求 TABLE. 3 REQ. FOR HYDRAULIC TEST AND LEAK TEST

试验方式	MODE	形式	HORIZONTAL			
液压试验 HYDRAULIC TEST	介质 MEDIUM	洁净无油水	CLEAN WATER FREE OF OIL			
	温度 TEMP. °C	4~37				
气密试验介质	PENUMATIC LEAK TEST MEDIUM	洁净无油空气	CLEAN AIR FREE OF OIL			
流道 STREAM		A	B			保压时间(分钟) MINIMUM DURATION(MIN.)
液压试验压力 HYDRAULIC TEST PRESSURE (Mpa) 1.5DP		9.90	2.85			30
气密性试验压力 PENEUMATIC TIGHT TEST PRESSURE (Mpa) 1.1DP		7.26	2.09			120
试压过程中，无异响，无可见变形，无容管严响 DURING TESTING, NO ABNORMAL NOISE,NO LEAKAGE,NO VISIBLE DEFORMATION.						

技术要求：
1. 本设备按ASME第八卷第一分册2007版和A09的要求设计、制造、检验与验收,并打U钢印.
2. 芯体翅片按第八卷第一分册2007版和A09中UG-101(m)做爆证试验.
3. 芯体的钎焊按钎焊的要求执行.
4. 根据UNF-65和UG-84,不需要冲击试验.
5. 清洗标准按中泰PE5102-2006标准执行.
6. 本产品的焊接和无损检测按受压焊缝要求执行.
7. 压力试验、气密性试验按表3和PE5107-2006《铝制板翅式换热器的试验及检验标准》执行.
8. 在各管口打上相应的管口符号.
9. 所有通道试验合格后烘干，露点测试温度-5℃,合格后充0.02~0.05MPa的氮气氦封.
10.所有流道在气密性试验合格后按PE5133-2009《氦质谱检漏仪SFJ-231检漏规程》做氦质谱检漏,并符合ASME规定第V卷2007&A09版第10章的要求.

TECHNICAL SPECIFICATION:
1. DESIGN,MANUFACTURE, INSPECTION AND TEST SHOULD BE IN ACCORDANCE WITH ASME CODE SECTION VIII,DIV.1(2007EDTION &A09) AND PUT THE "U" STEEL SEAL ON THE NAMEPLATE.
2. PROOF TEST OF FINS SHOULD BE PERFORMED IN ACCORDANCE WITH ASME CODE SECTION VIII,DIV.1(2007EDTION &A09) UG-101(m).
3. CORE SHOULD BE BRAZED IN ACCORDANCE WITH REQ. FOR BRAZED WELDS.
4. IMPACT TEST SHOULD BE NOT REQUIRED IN ACCORDANCE WITH UNF-65 AND UG-84.
5. CLEANING: AS PER ZHONGTAI STANDARD PE5102-2006.
6. UNIT SHOULD BE WELDED AND NONDESTRUCTIVE EXAMINED IN ACCORDANCE WITH REQ. FOR WELDED PRESSURE JOINTS TAB.4.
7. PNEUMATIC TEST AND LEAK TEST ARE ACCORDANDING TO TAB.3 AND PE5107-2006 "TESTING AND INSPECTION STANDARD FOR ALUMINIUM PLATE-FIN HEAT EXCHANGERS".
8. EACH NOZZLE BE MARKED WITH NOZZLE SYMBOL AT THE SPECIFIED PLACE.
9. AFTER LEAK TEST, THE UNIT SHOULD BE DRIED AND PURGED, THE DEW POINT TEMPERATURE SHOULD BE −5℃.THEN THE STREAM SHOULD BE FILLED WITH N2 AT PRESSURE OF 0.02~0.05MPa.
10.AFTER PENUMATIC LEAK TEST ALL STREAM HELIUM LEAK TEST SHOULD BE PERFORMATED ACCORDING TO PE5133-2009 "LEAK TEST SPECIFICATION FOR SFJ-231 HELIUM MASS SPECTROMETER" ,AND IN CONFORMENCE TO ARTICLE 10 APPENDIX OF ASME SECTION V CODE: 2007 EDITION 2009 ADDENDA .

序号 NO.	代号 DRAWING NO.	名称 NAME	数量 QUAN.	材料(名称/牌号) MATERIAL	单重 SIG.WEI.	总重 TOT. WEI.	备注 REMARK

标记 MARK	数量 QUANTITY	文件更改单号 DOCUMENT AND NO.	签名 SIGNATURE	日期 DATE
设计 DESIGNED BY				
校对 CHECKED BY				
审核 REVIEWED BY				
批准 APPROVED BY				
会签 COUNTERSIGNED BY				

原料气/贫气换热器
FEED GAS/LEAN GAS EXCHANGER

总图
GENERAL DRAWING

BS592.000 REV.1

图样标记 MARK | 质量 WEIGHT(kg) | 比例 SCALE 1:10

页码 PAGE NO: 1 /1

中泰项目号 Zhongtai Project No.:

杭州中泰过程设备有限公司
Hangzhou Zhongtai Process Equipment Co., Ltd.

工作号 JOB No.	6907
设备位号 EQUIPMENT TAG No.	11-EP-012
项目名称 PROJECT TITLE	BPCP
用户 CLIENT NAME	BCPL-ASSAM

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