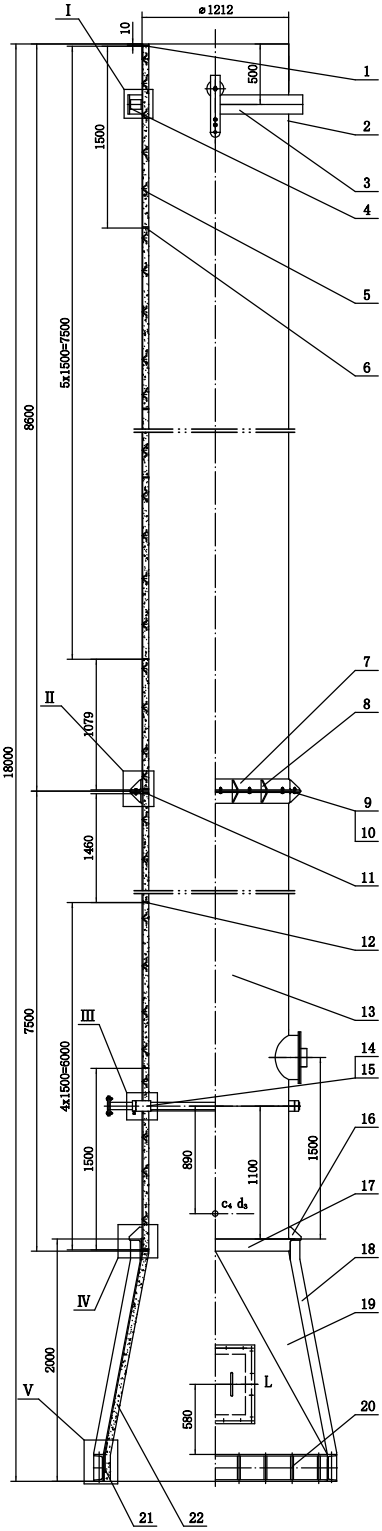


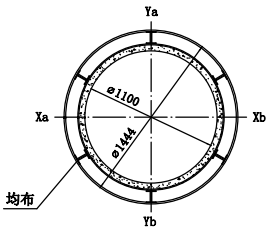


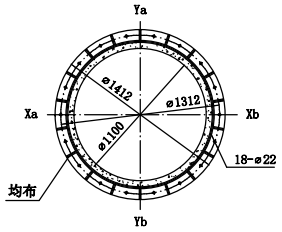


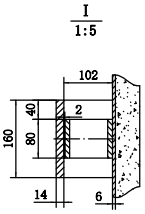


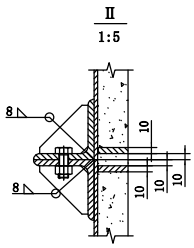


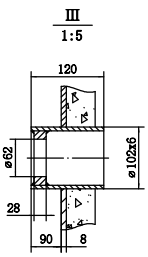


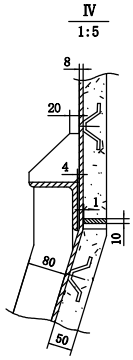


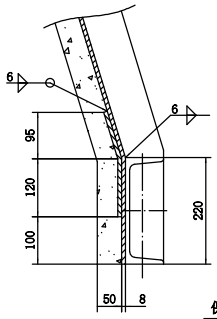


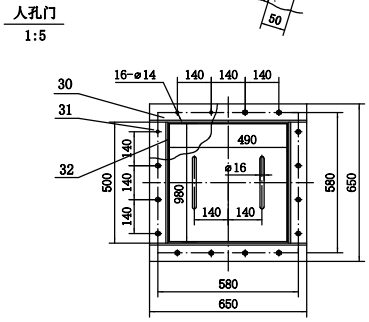


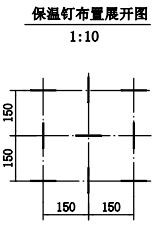


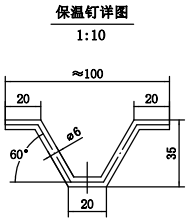


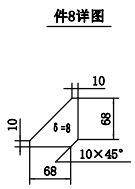


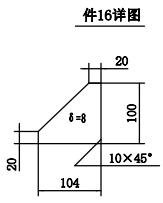


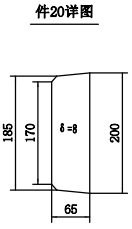


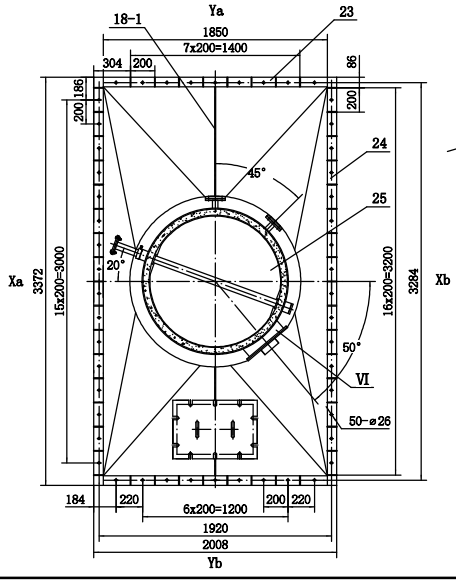


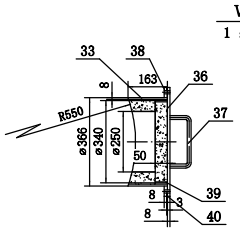


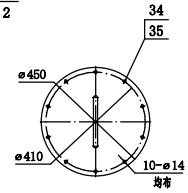


| 编号 | 名称 | 数量 | 规格 | 材料 | 单重 | 总重 | 备注 |
|---|---|---|---|---|---|---|---|
| | | | | | 质量 kg | | |
| 40 | 石棉板 | | | | | | |
| 39 | 保温圈 | 1 | δ=4 | Q235-B | | 1.7 | |
| 38 | 法兰圈 | 1 | δ=8 | Q235-B | | 4.5 | |
| 37 | 把手 | 1 | ⌀16 | Q235-B | | 0.6 | L=360 |
| 36 | 盖板 | 1 | δ=8 | Q235-B | | 12.5 | |
| 35 | 螺母 | 10 | M12 | Q235-B | | | GB/T41-2000 |
| 34 | 螺栓 | 10 | M12x35 | Q235-B | | | GBT/578-2000 |
| 33 | 钢板圈 | 1 | δ=8 | Q235-B | | 10.8 | |
| 32 | 扁钢 | 4 | 60x4 | Q235-B | 0.8 | 3.2 | L=500 |
| 31 | 角钢 | 2 | ∠75x75x8 | Q235-B | 4.5 | 9 | L=500 |
| 30 | 角钢 | 2 | ∠75x75x8 | Q235-B | 5.7 | 11.5 | L=640 |
| 29 | 把手 | 2 | ⌀16 | Q235-B | 0.56 | 1.1 | L=360 |
| 28 | 钢板 | 1 | δ=6 | Q235-B | | 19 | 640x640 |
| 27 | 螺母 | 16 | M12 | Q235-B | | | GB/T41-2000 |
| 26 | 螺栓 | 16 | M12x35 | Q235-B | | | GBT/578-2000 |
| 25 | 烟囱挡板 | 1 | | 组合件 | | 70 | |
| 24 | 槽钢 | 2 | [220×79×9 | Q235-B | 96 | 192 | L=3372 |
| 23 | 槽钢 | 2 | [220×79×9 | Q235-B | 52.6 | 105.2 | L=1850 |
| 22 | 耐火浇注料 | 3.5 | $m^3$ | SD-1.0 | 1000 | 3500 | |
| 21 | 衬板 | 1 | δ=6 | Q235-B | | 95 | |
| 20 | 槽钢筋板 | 50 | δ=8 | Q235-B | 0.7 | 38 | 见详图 |
| 19 | 锥段筒体 | 1 | δ=8 | Q235-B | | 876 | |
| 18-1 | 筋板条 | 2 | δ=10 | Q235-B | 12.1 | 24.2 | |
| 18 | 筋板条 | 2 | δ=10 | Q235-B | 15 | 30 | |
| 17 | 角钢圈 | 1 | ∠100x100x10 | Q235-B | | 67.4 | L=4460 |
| 16 | 筋板 | 18 | δ=8 | Q235-B | 0.45 | 8.1 | 见详图 |
| 15 | 套 | 2 | δ=20 | Q235-B | 0.3 | 0.6 | ⌀90/⌀78 |
| 14 | 套管 | 2 | ⌀102x6 | Q235-B | 1.7 | 3.4 | L=120 |
| 13 | 筒体钢板2 | 1 | δ=8 | Q235-B | | 1792 | H=7500 |
| 12 | 衬里支持圈4 | 4 | δ=6 | Q235-B | 8 | 32 | ⌀1194/⌀1100 |
| 11 | 衬里支持圈3 | 2 | δ=10 | Q235-B | 13.3 | 26.6 | ⌀1194/⌀1100 |
| 10 | 螺母 | 18 | M20 | Q235-B | | | GB/T41-2000 |
| 9 | 螺栓 | 18 | M20X60 | Q235-B | | | GB/T5781-2000 |
| 8 | 筋板 | 36 | δ=8 | Q235-B | 0.14 | 5.04 | 见详图 |
| 7 | 角钢圈法兰 | 2 | ∠100x100×10 | Q235-B | 67 | 134 | L=4434 |
| 6 | 衬里支持圈2 | 5 | δ=6 | Q235-B | 8.3 | 41.5 | ⌀1198/⌀1100 |
| 5 | 保温钉 | 2990 | ⌀6 | Q235-B | 0.022 | 66 | |
| 4 | 工字钢 | 6 | I100x68x4.5 | Q235-B | 0.9 | 5.4 | L=80 |
| 3 | 钢板圈 | 1 | δ=14 | Q235-B | | 70 | 4535x140 |
| 2 | 筒体钢板1 | 1 | δ=6 | Q235-B | | 1542 | H=8600 |
| 1 | 衬里支持圈 | 2 | δ=10 | Q235-B | 13.9 | 27.8 | ⌀1198/⌀1100 |

材 料 表

## 技术要求

1. 焊接采用电焊,焊条型号为E4303.焊接型式除图中注明外,均采用连续焊接,焊缝高度等于被焊件最小厚度
2. 烟囱内径轻质耐热衬里的施工应符合《圆筒形立管式加热炉技术规程》的规定.

东光华立石化机械厂

| | | | |
|---|---|---|---|
| 275-25-D114/D114(细)<br>焦油圆筒盘管式加热炉<br>烟囱 | | 图 号 | HL-F3001/11 |
| | | 设计项目 | |
| 宣主任 | 审 核 | 设计阶段 施工 | 重 量 8832kg |
| 宣 审 | 设 计 | 比 例 1:25 | 材 质 |
| 组 审 | 制 图 | 专 业 | 日 期 2011/9 |