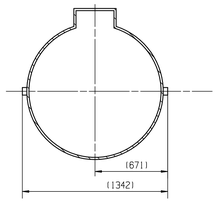
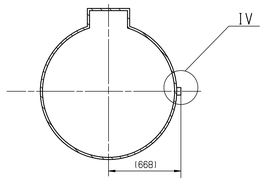


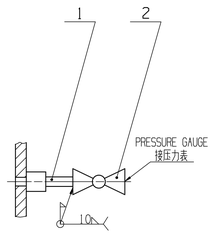
I
1:2



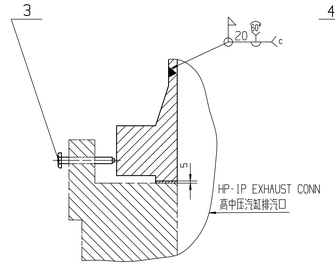
(TC CONN)
A-A(热电偶接口)
1:20



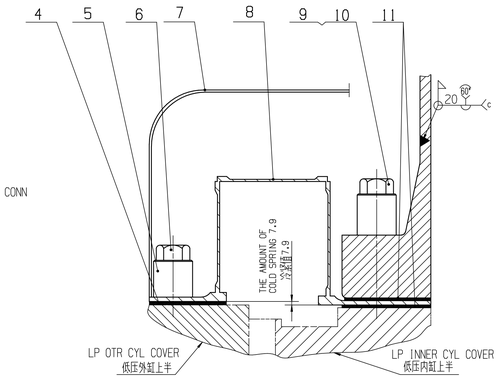
(PRESSURE GAUGE CONN)
B-B(压力表接口)
1:20



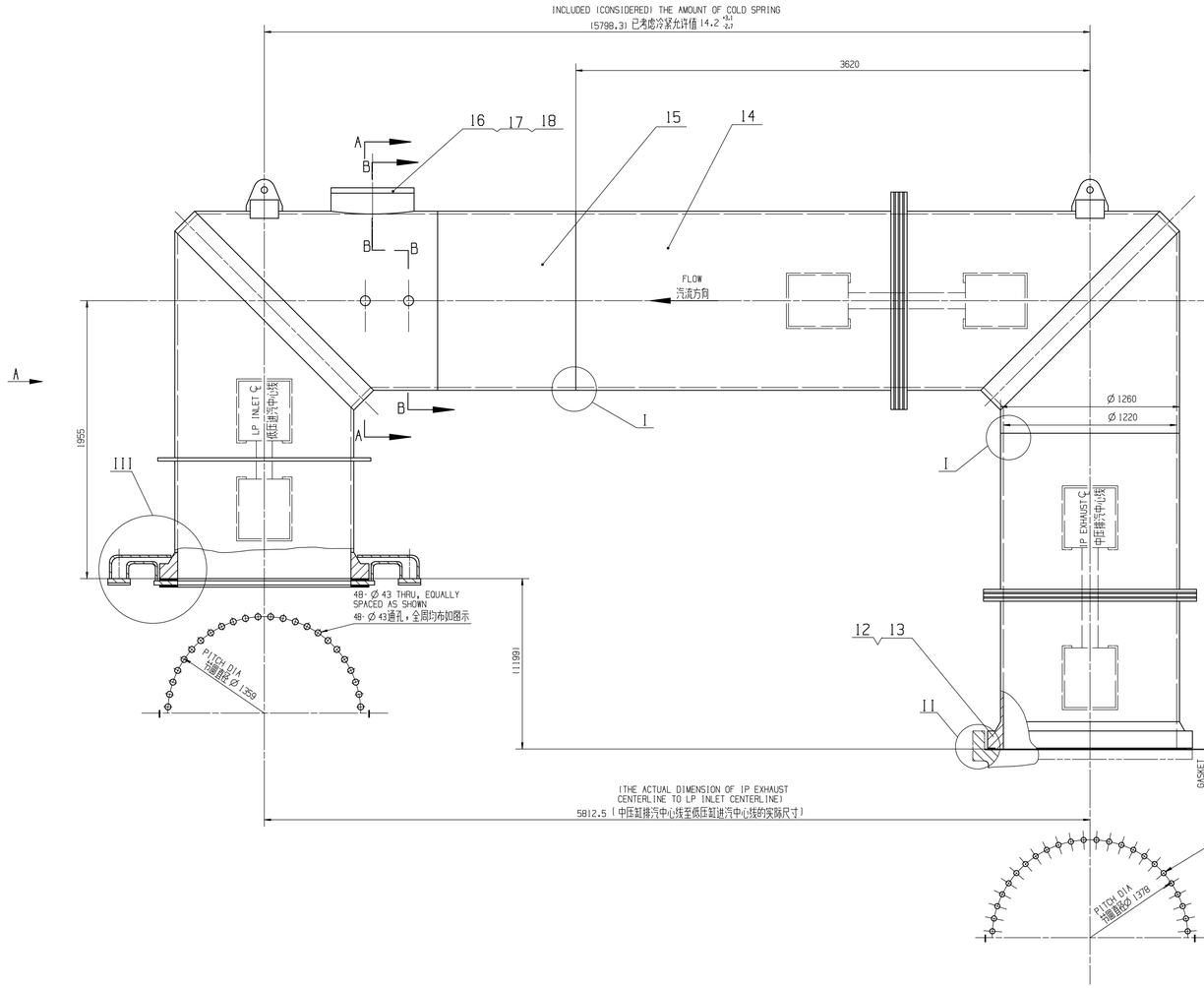
IV
1:5

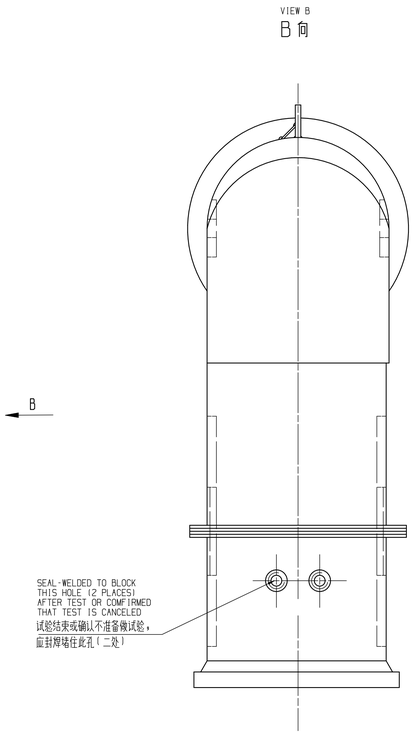


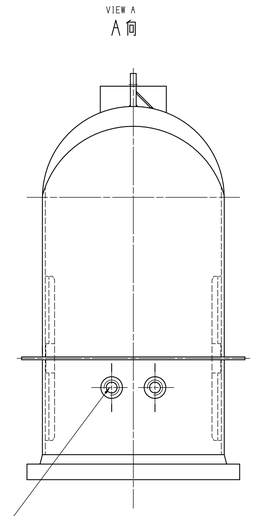
II
1:5



III
1:4







NOTES

1 IN THE OVER-CROSS PIPE, TIGHTEN BOLTS IN ALL FLANGES, WHOSE COLD TIGHTENED MOMENT IS THAT 620N.m FOR M27, 1150N.m FOR M33X3, 1910N.m FOR M39X3, THE ALLOWED TOLERANCE IS 0-5%.
2 THE OVER-CROSS PIPE, RELEVANT GASKET AND SEAL DIAPHRAGM INSTALLED ON TOP OF THE IP-LP CYL. THEN TIGHTEN THE SCREWS & BOLTS TO CONN THE FLANGE ONTO THE INLET OF LP CYL.
3 USE JACKING SCREW TO JACK AND LOCATE THE FLANGE OF OVER -CROSS PIPE ON THE OUTLET OF IP CYL. THEN CONN THE FLANGE TO THE OUTLET TO COMPLETE THE ASSEMBLY.
4 ITEM 14 AND ITEM 15 LOCATED CORRECTLY WHEN WELDED.
5 THE APPLIED STEAM CONDITIONS FOR OVER-CROSS PIPE:
TEMP ≤ 388° C
PRESSURE ≤ 1.38MPa.
6 AFTER THE FLANGE TAKEN LOAD FOR SEVERAL HOURS UNDER AT LEAST 2/3 OF THE OPERATING TEMP, THE BOLTS ON THE FLANGE OF THE INLET OF LP CYL MUST BE RE-TIGHTENED ACC.TO THE SPECIFIED RADIAL-SYMM SEQUENCE. THE BOLT (ITEM 6) RE-TIGHTENED FOR HALF CIRCLE, THE NUT(ITEM 10)RE-TIGHTENED FOR ONE CIRCLE.
7 FOR THE UNIT 1, KKS CODE IS 10MAC00BR801.
FOR THE UNIT 2, KKS CODE IS 20MAC00BR801.
FOR THE UNIT 3, KKS CODE IS 30MAC00BR801.
FOR THE UNIT 4, KKS CODE IS 40MAC00BR801.
8 ASSY W.T. IS 11160Kg.

技术要求

1. 连通管所有法兰中的螺栓控制紧力为M27冷紧力矩为620N.m，M33X3冷紧力矩为1150N.m,M39X3冷紧力矩为1910N.m，允许偏差均为0～5%.
2. 连通管跟相应的垫片和顶部密封板一起装在中低压汽缸上，然后按要求1拧紧低压进汽口处连通管法兰螺栓.
3. 用顶升螺钉将连通管法兰顶回到中压缸排汽口就位，然后按要求1用螺栓将连通管法兰联接到中压缸排汽口，完成装配.
4. 焊接时件号14与15需正确定位.
5. 本连通管适用蒸汽参数 汽温 ≤ 388° C
汽压 ≤ 1.38MPa
6. 在法兰经受至少为 2/3 的运行温度几小时后，低压缸进汽法兰面上的螺栓必须按规定的径向对称顺序来重新拧紧，螺栓件6再拧紧半圈，螺母件10再拧紧1圈.
7. 对于1号机组，KKS码是10MAC00BR801.
对于2号机组，KKS码是20MAC00BR801.
对于3号机组，KKS码是30MAC00BR801.
对于4号机组，KKS码是40MAC00BR801.
8. 总重量为11160Kg。

OWNER:-	JSW Energy (Ratnagiri) Limited
OWNER CONSULTANT:-	TCE CONSULTING ENGINEERS LTD
上海电气 SHANGHAI ELECTRIC	SHANGHAI ELECTRIC GROUP CO.,LTD
上海汽轮机有限公司 SHANGHAI TURBINE CO. LTD.	4X300MW THERMAL POWER STATION JAIGAD, RATNAGIRI DIST., MAHARSHTRA

版号 REV.No.	日期 Date	修改内容摘要 Modification Content	修改 Modify	校核 Check	批准 Approve

批准 Approve		校核 Check	刘衡涛	IP-LP OVERCROSS PPG
审核 Review	王伟	设计 Designer	何晓伟	中低压连通管
日期 Date	08.9	比例 Scale	1:15	图号 DWG.NO. K156.60.22-I/1E06 版号 REV. 0

DESIGN STAGE