

Technical requirements

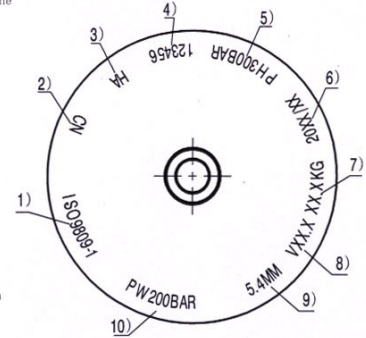
- 1 According to ISO 9809-1999 weld [cylinders with repeated filling of seamless steel cylinders - design, manufacture and testing tensile strength than the first part of the steel cylinders 1100Mpa] design, fabrication, inspection and acceptance.
- 2 Weld materials, and shall 34CrMo4 for aluminum and (or) of silicon steel calm. Chemical composition: %

| C | Mn | Si | P | S | Cr | Mo | Ni | V+Nb+Ti+B+Zr |
|-----------|-----------|-----------|-----------|--------|-----------|-----------|-------|--------------|
| 0.30~0.37 | 0.50~0.80 | 0.15~0.35 | ≤0.020 | ≤0.010 | 0.90~1.20 | 0.15~0.25 | ≤0.40 | ≤0.15 |
| | | | S+P≤0.025 | | | | | |
- 3 Weld adopts treatment weaken.
- 4 Weld main parameters:

| 公称容积, L | 瓶体长度L ₀ , mm | 瓶体重量, Kg |
|---------|-------------------------|----------|
| 36 | 1065 | 42.8 |
| 40 | 1170 | 46.6 |
| 46.7 | 1350 | 52.7 |
| 47 | 1360 | 53.1 |
| 50 | 1440 | 55.8 |
- 5 According to the requirement of users bottle threads, and ensure the bottleneck of wall thickness not less than the weld design wall thickness.
- 6 Hardness value: HB260~340.
- 7 The nominal pressure: 200bar.
- 8 Hydrostatic test pressure: 300bar.
- 9 The minimum practical blasting pressure: 480bar.

- 10 According to ISO 13769-2002 gas cylinders - symbol of the relevant requirements, mark symbol steel roller shall include at least the following contents:
 - 1) Product standard,
 - 2) Manufacturing countries,
 - 3) Manufacturing unit,
 - 4) Manufacturing serial number,
 - 5) Hydrostatic test pressure,
 - 6) The actual date of the original experiment,
 - 7) Measured volume weight,
 - 8) Actual volume
 - 9) Weld design wall thickness,
 - 10) The nominal pressure of work.
- 11 According to user requirements, the surface spraying in bottles used to identify the color coating.

Steel spreading marks



| | | | | HA08-05 | 0-1 | |
|------|----|-------|----|---|--|-----|
| 标记 | 处数 | 更改文件号 | 签字 | IWGA232-(36, 40, 46.7, 47, 50)-20 Steel seamless cylinders | 所属装配号 | 0 |
| 设计 | | | | | 重量 | 比例 |
| 校核 | | | | | | 1:3 |
| 标准检查 | | | | | | |
| 审定 | | | | | | |
| 批准 | | | | 34CrMo4 | QIQIHAER HUAN SPECIAL HIGH PRESSURE VESSLES CO., LTD | |