ADVANCED PRODUCTION TECHNOLOGY

外焊缝研磨

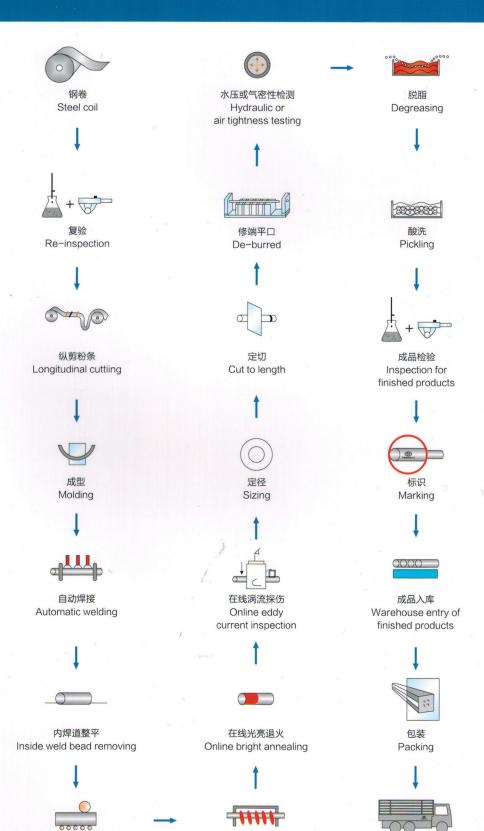
Outside seam grinding

aysen

先进的生产工艺

连续成型生产工艺流程图 (生产线设备产品)

The continuous molding production process flow chart (the production line equipment products)



在线固溶热处理

Online solution annealing

Delivery

aysen

PARTIAL EQUIPMENTS OF THE PRODUCTION PROCESS

生产工艺部分设备















方管系列 SQUARE TUBES

(Outside	外径 e Diameter)				厚度 Thi (mi	ckness m)			
(inch)	(mm)	0.8	0.9	1.0	1.2	1.5	2.0	2.5	3.0
	□10×10								
. 4	□12×12							-	
1/2 × 1/2	□12.7 × 12.7								
	□15×15								
5/8 × 5/8	□15.9 × 15.9								
	□18×18								
3/4 × 3/4	□19.1 × 19.1								
	□20×20								
7/8×7/8	□22.2 × 22.2								
	□23×23								
	□24×24			7					
1×1	□25.4 × 25.4								
	□28×28								
	□30×30								
1-1/4 × 1-1/4	□31.8 × 31.8								
	□35×35)				
1-1/2×1-1/2	□38.1 × 38.1				1				
	□40×40				/				
	□48×48								
	□50 × 50				1				
2×2	□50.8 × 50.8				944				
	□60×60	H							
2-1/2×2-1/2	□63.5 × 63.5								
	□70×70								
3×3	□76.2×76.2								
	□80×80								
3-1/2×3-1/2	□88.9 × 88.9								
	□100×100								
4×4	□101.6 × 101.6								



矩形管系列 RECTANGULAR TUBES

外径 (Outside Diameter)				厚度 Th (m	ickness m)			
(mm)	0.8	0.9	1.0	1.2	1.5	2.0	2.5	3.0
□10×20								
□10×30								
□10×40								
□10×50								
□10×60		1						N. N. Carlot
□10×80								
□12.7 × 25.4								
□15×30							1000	
□15×40								
□15×50								
□20×30								
□20 × 40								
□20 × 50								
□20×60								
□20×70								
□25 × 38								
□25.4 × 38.1								
□25 × 50								
□25.4 × 50.8								
□30 × 40								4
□30 × 50								
□30 × 60								
□30×70								
□40×60								
□40×80								
□40 × 100								
□45×75	1							
□45 × 95								
□50 × 100								
□60 × 100								
□60 × 120								

异型管系列 SLOT TUBES & OVAL TUBES

		TV4P	4014a .	槽深 depth of	厚度 (Thickness)					
产品 item	槽 slot	形状 Shape	规格 size (mm)	channel	(mm)					
		Onape	(11111)	(mm)	0.8	0.9	1.0	1.2	1.5	2.0
			38.1	15 × 15						
			42.4	24 × 24						
			42.4	15 × 15						
			48.3	27 × 30						
	single slot		50.8	15 × 15	1					
C型管			50.8	20 × 20						
round slot			63	20 × 20						
tubes			63	25 × 25						
			76	25 × 25						
			50.8	15 × 15						
	double slot		76	25 × 25						
			87 × 65	15 × 15						
椭圆管	single slot	single slot 80 × 40 15 × 15	15×15							
Oval			10×20							
Tubes &			12×24							
平椭圆管 elliptical			15 × 30							
tubes			20×40							
			30 × 60	- 1						
		()	40 × 60							
			40 × 80							

ASTM A249 / GB / T245 / JIS G3463 / DIN 17457



锅炉、热交换器管和冷凝器不锈钢焊管 STAINLESS STEEL WELDED TUBES FOR BOILER, HEAT EXCHANGER AND CONDENSER

ASTM A269

STAINLESS STEEL WELDED TUBES FOR ORDINARY SERVICE

ASTM A249 ASTM A269 规格尺寸表(SPECIFICATION)

外 Dutside l	·径 Diameter						厚度「	Thickness	s(mm)				
inch	mm	0.5	0.6	0.7	0.8	0.9		1.2	1.5		2.5		
	9.5												7
	1.2												
1/2"	12.7									15			
	13									7			
	14												
5/8"	15.9												
3/4"	19.1												
7/8"	22.2												
1"	25.4												
1-1/8"	28.6												
1-1/4"	31.8		199										
1-1/2"	38.1												
	40												
. 5	45	1										_	
2"	50.8												
	52												
2-1/4"	57.15	7.8-											~
2-3/8"	60.3												
2-1/2"	63.5												-
	70												
3"	76.2		_										
	85												
3-1/2"	88.9												
4"	101.6												
4-1/8"	104.78												
4-1/4"	107.95	,											
4-1/2"	114.3												
5-1/4"	133.35						Red Line						
6-1/4"	158.75							,					
3-5/8"	219.08												

ASTM A249尺寸公差表(DIMENSION TOLERANCE TABLE)

外 Outside [厚度 Thickness	长度 Length		
<25.4mm	± 0.10mm				
≥25.4mm~38.1mm	± 0.15mm				
≥38.1mm~50.8mm	± 0.20mm	/	OD<50.8mm +3.0mm~0mm		
≥50.8mm~63.5mm	± 0.25mm	± 10%			
≥63.5mm~76.2mm	± 0.30mm	± 10%			
≥76.2mm~101.6mm	± 0.38mm		OD≥50.8mm +5.0mm~0mm		
≥101.6mm~190.5mm	+0.38mm -0.64mm				
≥190.5mm~228.6mm	+0.38mm -1.14mm				

ASTM A269尺寸公差表(DIMENSION TOLERANCE TABLE)

外径 Outside Dia		厚度 Thickness	长度 Length	
<38.1mm	± 0.13mm			
≥38.1mm~88.9mm	± 0.25mm			
≥88.9mm~139.7mm	± 0.38mm	OD<12.7mm ± 15%	OD<38.1mm +3.2mm~0mm	
≥139.7mm~203.2mm	± 0.76mm	OD≥12.7mm ± 10%	OD≥38.1mm +4.8mm~0mm	
≥203.2mm~304.8mm	± 1.01mm		9	
≥304.8mm~355.6mm	± 1.26mm			

ASTM A270 / DIN 11850 / ISO 2037

食品卫生用不锈钢钢管 STAINLESS STEEL SANITARY TUBING



ASTM A270规格尺寸表(SPECIFICATION)

外 Outside [径 Diameter	厚度 Thickness(mm)							
inch		1.2	1.5		2.5				
3/4"	19.1								
7/8"	22.2								
1"	25.4								
1-1/8"	28.6					20.			
1-1/4"	31.8	\				2			
1-1/2"	38.1								
	40								
	45				97				
2"	50.8					· ·			
War and the same	52				- ·				
2-1/4"	57.15								
2-3/8"	60.3								
2-1/2"	63.5								
	70	-				30			
3"	76.2								
	85								
3-1/2"	. 88.9								
4"	101.6								
4-1/8"	104.78								
4-1/4"	107.95								
4-1/2"	114.3		4.						
5-1/4"	133.35								
6-1/4"	158.75								
8-5/8"	219.08		V						

ASTM A270尺寸公差表 (DIMENSION TOLERANCE TABLE)

外径 Outside Dia	meter	厚度 Thickness	长度 Length		
<25.40mm	± 0.13mm				
≥25.40mm~50.80mm	± 0.20mm	1			
≥50.80mm~76.20mm	± 0.25mm	1 .	OD<101.60mm +3.20mm~0mm		
≥76.20mm~101.60mm	± 0.38mm	± 10.00%			
≥101.60mm~139.70mm	± 0.38mm	f.	OD≥101.60mm +4.80mm~0mm		
≥139.70mm~203.20mm	± 0.76mm				
≥203.20mm~304.80mm	± 1.27mm				