

ICS 91.140.10
CCS P 46

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**INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

CJ/T 246-2018

Replacing CJ/T 246-2007; CJ/T 200-2004

**Preformed directly buried steam insulating pipes and fittings
for urban heating
(English Translation)**

Issued on: August 24, 2018

Implemented on: April 1, 2019

**Issued by: Ministry of Housing and Urban-Rural Development of the
People's Republic of China**

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces CJ/T 200-2004 "Technical Conditions for Prefabricated Direct Buried Steam Insulation Pipes for Urban Heating" and CJ/T 246-2007 Technical conditions for heating prefabricated direct buried steam insulation pipe fittings. Compared with CJ/T 200-2004 and CJ/T 246-2007, except for editing the main technical content changes outside the sexual modification are as follows.

---Modified the working pressure of the applicable pipeline in the scope;

--- Modified some terms and definitions;

--- Removed the contents of the fiberglass outer protective tube;

---Modified the requirements for the wall thickness of the working pipe;

---Modified the welding requirements for steel parts;

--- Modified the insulation performance requirements;

--- Revised the material requirements and test methods for each part.

This standard was proposed by the Institute of Standardization of the Ministry of Housing and Urban-Rural Development.

This standard is under the jurisdiction of the Urban Heating Standardization Technical Committee of the Ministry of Housing and Urban-Rural Development.

This standard was drafted. China Urban Construction Research Institute Co., Ltd., Zhejiang University Energy Engineering Design and Research Institute Co., Ltd., Beijing Construction Engineering Quality Fourth Inspection Institute, Shanghai Kehua Thermal Pipe Co., Ltd., Dalian Kehua Thermal Pipe Co., Ltd., Beijing Haote Pipeline Equipment Co., Ltd., Haotian Energy Saving Equipment Co., Ltd., Shanghai Xinhua Architectural Design Co., Ltd., Tianjin Pipeline Engineering Group Co., Ltd.

Division Insulation Pipe Factory, Jiangsu Hongxin Pipeline Design Co., Ltd., Ningbo Wanli Pipeline Co., Ltd.

1 Scope

This standard specifies the terms and definitions of urban heating prefabricated direct buried steam insulation pipes (hereinafter referred to as insulation pipes) and pipe fittings, generally Requirements,, test methods, inspection rules, marking, transportation and storage.

This standard is applicable to direct buried steel with a working pressure of steam medium less than or equal to 2.5 MPa and a temperature less than or equal to 350 °C.

Manufacturing and inspection of steam protection pipes and piping accessories.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only the dated version applies to this article.

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 985.1 Recommended groove for gas welding, electrode arc welding, gas shielded welding and high energy beam welding GB/T 985.2 recommended groove for submerged arc welding GB/T 3087 seamless steel pipe for low and medium pressure boilers GB/T 3091 welded steel pipe for low pressure fluid transportation GB/T 3198 aluminum and aluminum alloy foil GB/T 8163 seamless steel pipe for conveying fluid GB/T 8923.1-2011 - Determination of surface cleanliness of steels - Part 1 . Uncoated Corrosion grade and treatment grade of the steel surface and the surface of the steel after the original coating is completely removed GB/T 9711 oil and gas industrial pipeline transportation system steel pipe Types and parameters of GB/T 12459 steel butt welded pipe fittings GB/T 12777 metal bellows expansion joint general technical conditions GB/T 13401 steel butt welded pipe fittings technical specification GB/T 17393 Specification for Thermal Insulation Materials for Austenitic Stainless Steel GB/T 17430 Evaluation method for maximum use temperature of thermal insulation materials GB/T 28638-2012 Thermal insulation loss test and insulation effect evaluation method for thermal insulation structure of urban heating pipes GB/T 29046 Urban heating prefabricated direct buried thermal insulation pipeline technical index detection method GB/T 29047-2012 high-density polyethylene outer tube rigid polyurethane foam prefabricated direct buried insulation pipe and fittings CJ J28 Code for construction and acceptance of urban heating pipe network engineering CJ J/T 104 Technical Specifications for Directly Buried Steam Pipes for Urban Heating JC/T 618 Chemical analysis method for soluble chloride, fluoride, silicate and sodium ions in thermal insulation materials NB/T 47013.2-2015 Non-destructive testing of pressure equipment - Part 2. Radiographic testing NB/T 47013.3-2015 Non-destructive testing of pressure equipment - Part 3. Ultrasonic testing NB/T 47013.4-2015 Non-destructive testing of pressure

equipment - Part 4. Magnetic particle testing SY/T 5037 submerged arc welded steel pipe
for ordinary fluid conveying pipeline SY/T 5257 Induction heating elbow for oil and gas
transmission ASTM C1371-04a Standard Test Method for Density of Materials Near Room
Temperature Using Portable Emissivity Meters