



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

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**Code for installation and acceptance for engineering equipment
of extrusion steel pipe**

挤压钢管工程设备安装与验收规范

(English Translation)

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1 General

1.0.1

In order to improve the installation level of extruded steel pipe engineering equipment, strengthen the quality control of the construction process, ensure the construction quality, achieve safety and environmental protection, and advance technology, this specification is formulated.

1.0.2

This specification is applicable to the installation and quality inspection of extruded steel pipe engineering equipment.

1.0.3

The installation and acceptance of extruded steel pipe engineering equipment shall not only comply with this specification, but also comply with the current relevant national standards.

2 Basic regulations

2.0.1

The construction site should have corresponding construction technical standards, quality management system, quality control and inspection system, construction organization design, and construction plan operation documents.

2.0.2

The engineering technical documents adopted and the requirements for installation quality in the contract shall comply with the provisions of this specification.

2.0.3

Changes to construction drawings should have documents signed by the design unit.

2.0.4

Measuring instruments used in quality inspection and acceptance should be calibrated and used within the validity period.

2.0.5

Before the equipment is installed, the foundation of the equipment should pass the acceptance inspection, the relevant factory buildings should have the conditions for equipment installation, the site should have water source, power supply, working plane and working space, and the transportation road should be unimpeded.

2.0.6

The center datum line and datum point shall be set for equipment installation, the permanent center mark plate and the elevation datum point shall be buried, and the

permanent center mark plate and the elevation datum point shall be remeasured regularly.

2.0.7

Equipment installation should be carried out according to the prescribed procedures. After each process is completed, inspection and acceptance should be carried out, and records should be formed. Those who have not been inspected shall not carry out the construction of the next process.

2.0.8

Secondary grouting of equipment and other concealed works shall be checked and accepted before concealment, and shall be documented.

2.0.9

The safety protection facilities of the equipment must be complete and reliable, and the action of the limit switch should be accurate.

2.0.10

Before the trial operation of the equipment, the installation of the equipment shall be checked and accepted.

2.0.11

The acceptance of equipment installation quality shall be carried out in accordance with sub-projects, and unit projects on the basis of self-inspection by the construction unit. The division of divisions and sub-projects should follow the provisions of Appendix A of this specification.

2.0.12

Sub-project quality acceptance shall meet the following requirements.

- 1 The main control item inspection should meet the quality standard requirements of this specification;
- 2 General item inspection results, machinery and equipment should all meet the quality standards of this specification;
- 3 Quality acceptance records and quality certification documents should be complete.

2.0.13

The sub-project quality acceptance shall meet the following requirements.

- 1 The quality of sub-projects contained in sub-projects shall pass the acceptance inspection;
- 2 Quality control data should be complete;
- 3 The no-load test run of the single equipment should be qualified.

2.0.14

Unit project quality acceptance shall meet the following requirements.

1. The quality of the sub-projects contained in the unit project shall pass the acceptance inspection;
- 2 Quality control data should be complete;
- 3 The no-load linkage trial operation of the equipment should be qualified;
- 4 The perception quality inspection should be qualified.

2.0.15

The project perception quality inspection items of the unit shall meet the following requirements, and each random check shall not be less than 10 places.

1. The bolts, nuts and washers of the connecting bolts should be fully configured. After tightening, the bolts should expose 2 to 3 threads of the nuts, and the exposed threads should not be damaged. The screwing direction of the bolts should be consistent except for structural reasons;
- 2 The sealing surface should not leak oil, air or water;
- 3 The pipeline layout should be reasonable, the arrangement should be neat, and the fixing should be firm;
- 4 The sound insulation and heat insulation materials should have uniform layer thickness, firm binding and smooth surface;
5. The paint should be applied evenly, without leakage, peeling, wrinkle and bubbles, and the color should be consistent;
- 6 Walking platforms, ladders and railings should be fixed firmly without appearance defects;
- 7 The welding seam should have uniform welding waves, and the welding slag and spatter should be cleaned up;
- 8 There should be no slag at the incision;
- 9 The finished equipment should have no defects, and the exposed processing surface should be well protected;
- 10 The construction site should be managed in an orderly manner, and there should be no sundries around the equipment.

2.0.16

When the quality of the inspection item does not meet the requirements of the corresponding professional quality acceptance specification, the inspection item should be re-accepted after rework. The inspection items that meet the design requirements shall be