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GB/T 25714.1-2010

Molten iron ladles - Part 1: Types and basic parameters

铁液浇包 第1部分：型式与基本参数

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Foreword

GB/T 25714 "liquid iron ladle" is divided into two parts.

--- Part 1. Types and basic parameters;

--- Part 2. Technical requirements. This section GB/T 25714 Part 1. This section drafted in accordance with GB/T 1.1-2009 given rules. This part is proposed by China Machinery Industry Federation. This part of the National Foundry Machinery Standardization Technical Committee (SAC/TC186) centralized. This section is drafted. Qingdao Green Environmental Protection Equipment Co., Ltd., Qingdao Environmental Protection cupola furnace power plant, foundry machinery Weihai workers have Limited, Qingdao Environmental Protection Zhongzhida Melting Equipment Co., Ltd. Qingdao-Shengyuan Environmental Protection Equipment Co., Ltd. smelting. The main drafters of this section. Ronny first, Qin Yuqi, Chi Aviva, Duan Jin Ting, Chen Yongxiang. Liquid iron ladle Part 1. Types and basic parameters

1 Scope

China's national standard for the types and basic parameters of molten iron ladles. It is Part 1 of GB/T 25714 and specifies the types, the basic parameters and the designation of ladles used to hold and pour molten iron. An iron ladle differs from the steel ladle of GB/T 23583 in ways that follow from the metal and from the industry. Iron is poured at around fourteen hundred degrees rather than sixteen hundred, and it is handled in far smaller quantities: a foundry pours moulds of a few kilograms to a few tonnes, so the ladle sizes run from hand ladles a single operator carries through shank ladles carried by two, to crane and monorail ladles of several tonnes and the large transfer ladles that move iron from the cupola or induction furnace to the pouring station. That range is wider than any steelworks needs and the standard has to cover all of it. The forms follow the duty. A lip-pour ladle is tipped and pours over its edge, which is how nearly all iron is poured because the quantities are small and the operator needs to see the stream; a teapot ladle has an internal partition so the metal is drawn from below the surface, which holds back the slag and the dross floating on top and is used where the casting cannot tolerate inclusions; and

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a bottom-pour ladle is used for the largest work. The parameters are the nominal capacity, the internal and external dimensions, the freeboard, the trunnion or handle arrangement and the total mass full - which for a hand ladle determines whether a person can lift it and for a crane ladle what must lift it. Issued on 23 December 2010 and in force since 1 July 2011.

This section GB/T 25714 specifies the liquid iron ladle rated capacity, type and basic parameters. This section applies to the casting table with a round barrel iron ladle liquid (hereinafter referred to as a ladle).

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

JB/T 3000 model designation of foundry equipment Type 3 ladle

3.1 iron ladle by tilting way into the formula and antes ceremony.

3.2 ladle by driving into manual, electric, hydraulic, pneumatic.

3.3 ladle by lifting divided into manual, electric and pneumatic. Parameter 4 ladle

4.1 ladle main parameters for the rated capacity of the ladle.

4.2 ladle basic parameters in Table 1. Table

1 Basic parameters of liquid iron ladle Rated Capacity Clearance height mm Boring lining thickness mm Barrel thickness mm Gray iron ductile iron bottom side of the bottom side 0.3 5080405055 0.5 5080405055 0.75 5080455055 1.0 6090506055 1.5 70,100,607,055 2.0 80,120,608,066 2.5 80,120,608,066 3.0 90,130,709,066 4.0 1001508010066 5.0 1101508011088

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