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

JT/T 1282-2019

**Steel discharge pipeline
(English Translation)**

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Foreword

This standard is in accordance with GB/T Draft the rules given in 1-2009.

This standard was proposed and managed by the National Port Standardization Technical Committee Dredging Equipment Sub-Technical Committee (SAC/TC 530/SC1).

This standard was drafted. China Communications Construction Co., Ltd., CCCC Dredging (Group) Co., Ltd., CCCC Shanghai Waterway Bureau has Co., Ltd., CCCC Tianjin Waterway Bureau Co., Ltd., CCCC Guangzhou Waterway Bureau Co., Ltd., Shanghai Communications Construction General Contracting Co., Ltd., China and Hong Kong Dredging Co., Ltd., CCCC Shanghai Airlines Bureau Channel Construction Co., Ltd., CCCC Dredging Technology and Equipment National Engineering Research Center Co., Ltd.

1 Scope

This standard specifies the form, structure and size, technical requirements, test methods, inspection rules, as well as marking, packaging, and transportation of steel sludge pipes.

Input and storage requirements.

This standard applies to the production, inspection and use of steel sludge pipes. The maintenance of the steel sewage pipe can refer to the use.

2 Normative references

The following documents are essential for the application of this document. For dated references, only the dated version applies to this article. For undated references, the latest version (including all amendments) applies to this document.

GB/T 191 Packing, storage and transportation icon GB/T 241 Hydraulic test method for metal pipes GB/T 700 carbon structural steel GB/T 709-2006 Size, shape, weight and allowable deviation of hot rolled steel plate and steel strip GB/T 1804-2000 General tolerances Linear and angular tolerances without tolerances GB/T 6092 square ruler GB/T 6315 Vernier, band meter and digital display universal angle ruler GB/T 8923. 1 Visual evaluation of surface cleanliness of steel surfaces before application of coatings Part 1. Uncoated steel Corrosion level and treatment level on the surface and steel surface after the original coating has been completely removed GB/T 9056 metal ruler GB/T 9124-2010 Technical requirements for steel pipe flanges GB/T 1134 Nondestructive testing contact ultrasonic pulse echo thickness measurement method GB/T 21389 Vernier, band meter and digital caliper GB/T 3513 Technical requirements for acceptance of ship painting quality GB/T 3718 Ship coating film thickness detection requirements QB/T 2443-2011 steel tape measure CCS Materials and Welding Code

3 Terms and definitions, symbols

3.1

Terms and definitions the following terms and definitions apply to this document.

3.1.1

Steel drainage pipe steel die pinine A steel pipe with a certain length and flange connection used for conveying mud in dredging and filling engineering.

3.1.2

Straight pipe pepper Steel sludge pipe with straight axis.

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3.1.3

Elbow bend

The steel sludge pipe made by welding several steel short pipes is inscribed in a circle.

3.1.4

Multi-channel tube multi-channel pipe the sum of the number of inlets and outlets is greater than two and the steel sludge pipes with the same diameter are used.

3.1. Five

Amount of misalignment between moment tolerance the amount of deviation of the butt edges of the plates not on the same plane.

3.2

Symbol

C --- flange thickness, unit is millimeter (mm);

D1 --- outer diameter of flange, unit is millimeter (mm);

D2 --- the diameter of the center circle of the bolt hole, in millimeters (mm);

D3 --- Flange inner diameter, unit is millimeter (mm);

D4--Inner diameter, unit is millimeter (mm);

D5 --- Inner diameter of flange bolt hole, unit is millimeter (mm);

L --- length of straight pipe, unit is millimeter (mm);

L1 --- length of main pipe, unit is millimeter (mm);

L2 --- length of branch pipe, unit is millimeter (mm);

L3 --- The distance from the intersection of the main pipe and the centerline of the branch pipe to the flange at the outlet of the main pipe, the unit is millimeter (mm);

n--the number of flange bolt holes;

S --- wall thickness of the pipe body, unit is millimeter (mm);

t1 --- side length of bracket, unit is millimeter (mm);

t2 --- cut angle length of bracket, unit is millimeter (mm);

alpha --- The angle between the main pipe and the center line of the branch pipe, the unit is degree (°);

theta --- The included angle between the flange planes at both ends of the elbow, in degrees (°).

4 Form, structure and dimensions 4.1 form Steel sludge pipes can be divided into the following three forms according to their appearance.

a) straight pipe;

b) elbows;

c) Multi-channel tubes.

4.2 Structure and dimensions 4.2.1 straight pipe the structure of straight pipe is shown in Figure 1. See Table A for the dimensions of straight pipe. 1.

4.2.2 Elbows

The structure of the elbow is shown in Figure 2. Refer to Table A for the dimensions of the elbow. 2.

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Figure 1 Schematic diagram of straight pipe structure

Figure 2 Schematic diagram of the elbow structure

4.2.3 multi-channel tube

4.2.3.1 The structure of the multi-channel tube is shown in Figure 3, and the dimensions of the multi-channel tube are shown in Table A. 3.

4.2.3.2 The length of the branch pipe (L2), the distance between the intersection of the main pipe and the centerline of the branch pipe and the flange of the discharge port of the main pipe (L3) should not be less than 2 times.

Blue inner diameter (D3).

4.2.4 Flange bracket

4.2.4.1 The structure of the flange bracket is shown in Figure 4. Refer to Appendix A for the thickness of the bracket.

4.2.4.2 The length of the flange bracket and the angle of the bracket cut are calculated according to formula (1) and formula (2), respectively.

D1-D3

2-10 (1)

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Figure 3 Schematic diagram of multi-channel tube structure

Figure 4 Schematic diagram of flange bracket

4.3 Product model

The product structure of the steel sludge pipe is shown in Figure 5.

Figure 5 Model structure of steel sewage pipe

Example. A steel sludge pipe with a custom code of ABD, an inner diameter of 850mm, a wall thickness of 12mm, a year of manufacture in 2015, and a number of 2001.

For. ABCDC850-12-15-2001.

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