

I. Design Specifications and Standards

I. The design of this product is based on TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations" NB/T47052-2016 "Simple Pressure Vessel"

Design pressure	MPa	0.84	Container categories	Class I (simple container)
Work pressure	MPa	0.8	full volume	m ³ 0.3
Pressure test pressure	MPa	1.26	Corrosion allowance	mm 0.5
Set temperture	°C	150	Welded joint factor	φ 1
Operating temperature	°C	<150	Design method	Computational Method Design
Medium		Air or nitrogen	Product model code	JHa-0.84
Media properties		Non-toxic, non-flammable	Empty weight	77 kg
Design life		10 years	Quality kg	Stainless steel /
Main material		Q235-B	Water filling weight	/

The measured thickness of the cylinder body after forming is not less than 2.82mm; the measured thickness of the head after forming is not less than 2.81mm

II: MANUFACTURING, INSPECTION AND ACCEPTANCE CRITERIA

TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations" NB/T47052-2016 "Simple Pressure Vessel"

Safety valve opening pressure	MPa	0.84	Calculated thickness of barrel mm	/
test medium		Water	Welding Process	Automatic welding
Product batch number	Tower	≤500 Tower	X-ray inspection location	For the intersection of Class A weld, the detection length is greater than or equal to 200mm
Welding Specifications		NB/T47015-2011	Welded joint NDT	X-ray film quality Not lower than AB class
			Eligibility criteria	NB/T 47013.2-2015 III class

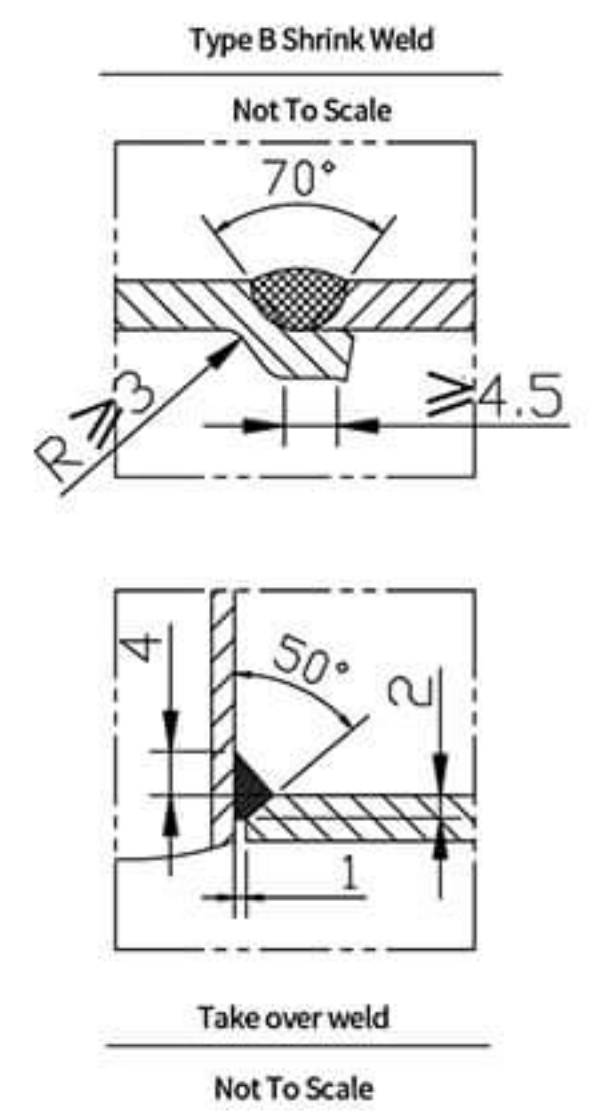
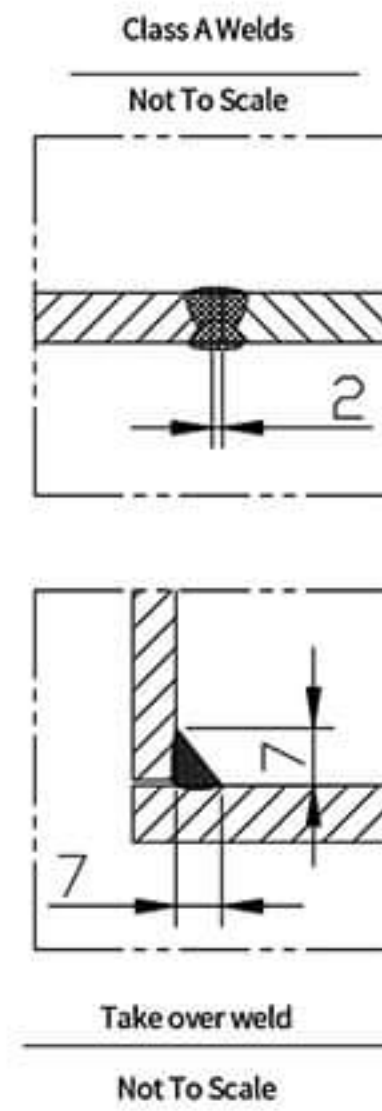
Technical requirements: 1. The orientation of the nozzle and support of this equipment is as shown in the top view. Recommended safety valve model: A28H-10.
 2. Container radiographic inspection in accordance with NB/T 47052-2016 8.3.2.3.
 3. Type B weld seam manufacturing units can choose the type of necking or backing plate according to the actual manufacturing process.
 4. The painting, packaging and transportation of this equipment comply with NB/T 10558-2021 "Pressure Vessel Coating and Transportation Packaging".
 5. The equipment is strictly used for overpressure and overtemperature; regularly check the safety accessories; regularly clean the sewage and carbon deposits in the tanks and pipes.
 6. This equipment can only be used in conventional environments, and it is forbidden to use it in corrosive environments such as acid, alkali, and salt.
 7. The user unit needs to test and record the wall thickness of the container regularly (the cycle does not exceed 3 months). If the amount of thinning exceeds the corrosion allowance, it must be stopped immediately.
 8. The nameplate is in accordance with the provisions of Annex G of the solid volume regulation, and the thickness of the cylinder, head and connecting pipe is allowed to be replaced by thick.
 9. It is forbidden to use if there are more than 0.3mm dents or scratches on the surface of the shell.

III. Welding Table

Material	Q235-B	20	
Q235-B	H08A/HJ431	J422	
Q235-B	ER50-6	ER50-6	

Nozzle Table

Symbol	Nominal Size	Link Size Or Standard	Form of sealing surface	Use	Remark
N1	15	GB/T 7306.1-2000, Rp1/2	Internal thread	Safety valve	
N2	15	GB/T 7306.1-2000, R1/2	External thread	Sewage outlet	
N3	25	GB/T 7306.1-2000, Rp1	Internal thread	Air intake	
N4	25	GB/T 7306.1-2000, Rp1	Internal thread	Air outlet	
N5		M14×1.5	Internal thread	Pressure gauge port	



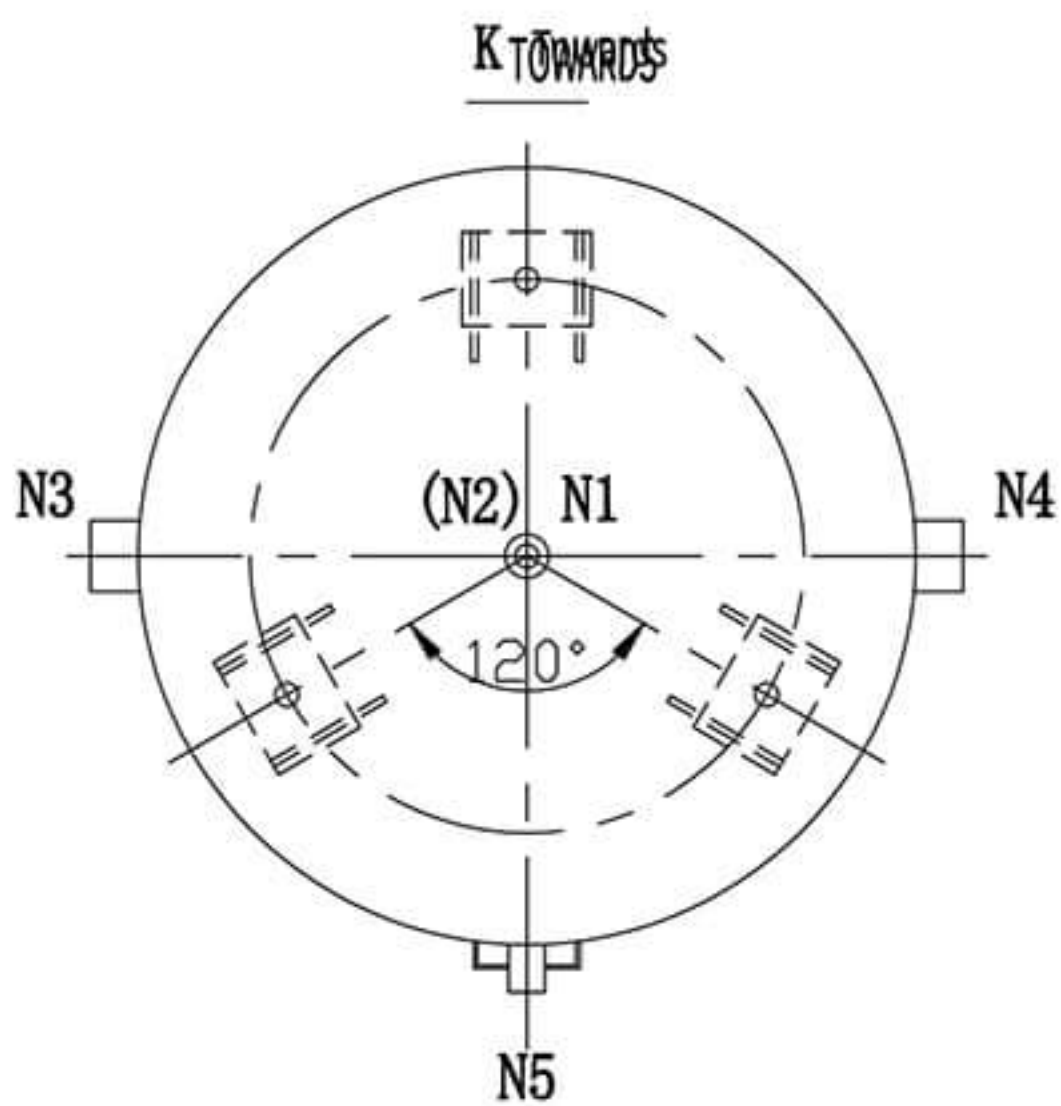
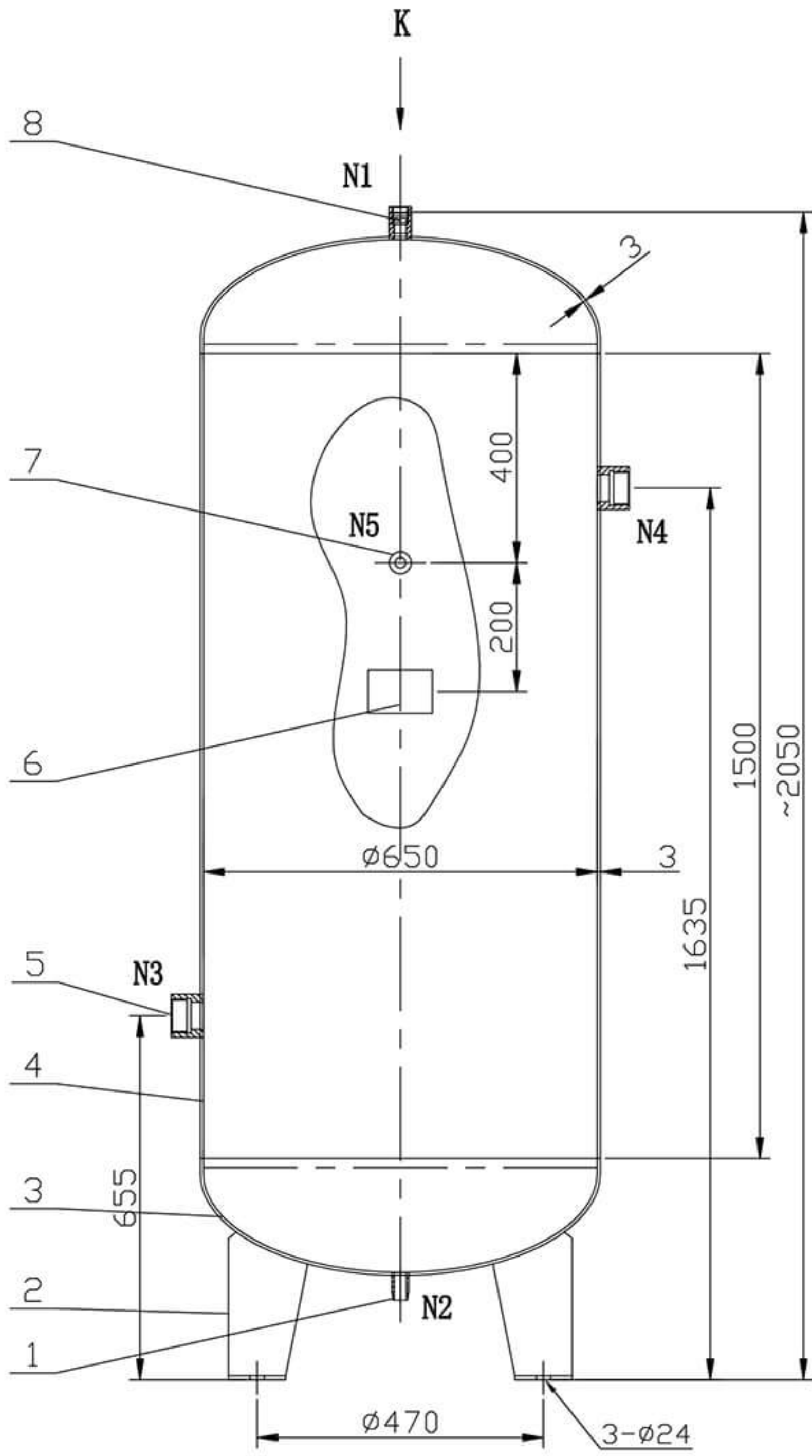
Regular product size error rate:

Total height ≤ 50mm, connection height ≤ 50mm, center distance and relative position of support bolt holes ≤ 100mm, Take over the verticality ≤ 10 degrees. This error rate serves as a product acceptance criterion.

If you have higher requirements for dimensional accuracy, please contact the business manager to increase the price for customization.

The manufacturer reserves the right to optimize and improve on the basis of this drawing without prior notice.

SERIAL NUMBER	CODE	NAME	QUANTITY	MATERIAL	APIECE	TOTAL	REMARK
					QUALITY		
		JIANGSU MINNUO MACHINERY MANUFACTURING CO., LTD.					
CERTIFICATE NUMBER	TS2241257-2025	DESIGN	CHKD	APPR	AUTH'D	DATE	
PROJECT		DRAWING NAME	GAS TANK ASSEMBLY DRAWING				
WORK AREA		DRAWING NO.	CQ-0.3/0.8.0				
PROPORTION	1 of 1	DRAWING NO.	CQ-0.3/0.8.0				



I. Design Specifications and Standards
 I. The design of this product is based on TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"
 NB/T47052-2016 "Simple Pressure Vessel"

Design pressure	MPa	0.84	Container categories	Class I (simple container)	
Work pressure	MPa	0.8	Full volume	m ³ 0.6	
Pressure test pressure	MPa	1.26	Corrosion allowance	mm 0.5	
Set temperature	°C	150	Welded joint factor	φ 1	
Operating temperature	°C	<150	Design method	Computational Method Design	
Medium	Air or nitrogen		Product model code	JHa-0.84	
Media properties	Non-toxic, non-flammable		Quality kg	Empty weight	125 kg
Design life	10 years			Stainless steel	/
Main material	Q345R			Water filling weight	/

The measured thickness of the cylinder body after forming is not less than 2.29mm; the measured thickness of the head after forming is not less than 2.29mm

II: MANUFACTURING, INSPECTION AND ACCEPTANCE CRITERIA
 TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"
 NB/T47052-2016 "Simple Pressure Vessel"

Safety valve opening pressure	MPa	0.84	Calculated thickness of cylinder	/
Test medium	Water		welding process	A and B welding head requirements Automatic welding
Product batch number	Tower	≤500 Tower	X-ray inspection location	For the intersection of Class A weld, the detection length is greater than or equal to 200mm Automatic welding
Welding Specifications	NB/T47015-2011		X-ray film quality	Not lower than AB class
			Eligibility criteria	NB/T 47013.2-2015 III Class

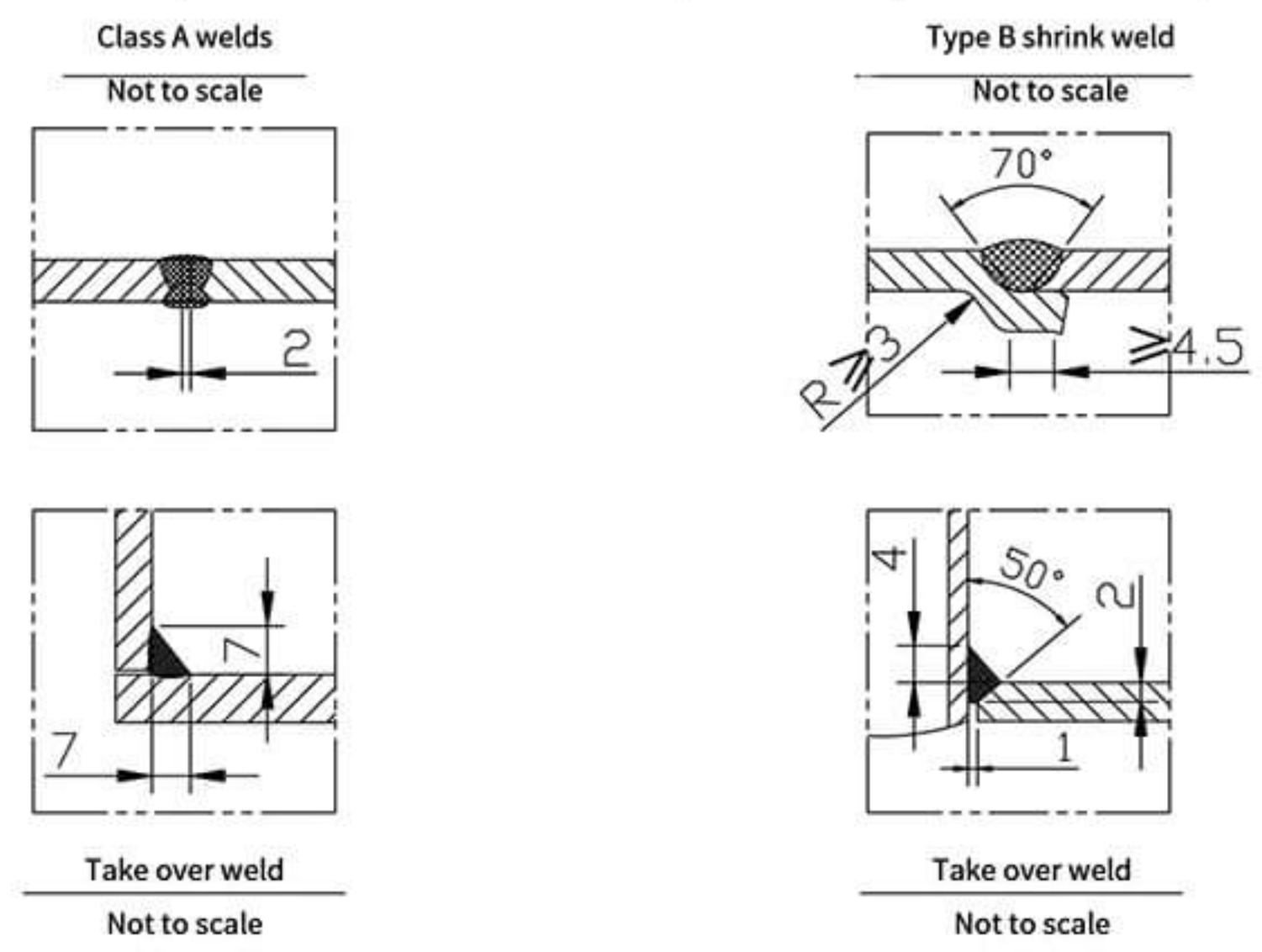
Technical requirements: 1. The orientation of the nozzle and support of this equipment is as shown in the top view. Recommended safety valve model: A28H-10.
 2. Container radiographic inspection in accordance with NB/T 47052-2016 8.3.2.3.
 3. Type B weld seam manufacturing units can choose the type of necking or backing plate according to the actual manufacturing process.
 4. The painting, packaging and transportation of this equipment comply with NB/T 10558-2021 "Pressure Vessel Coating and Transportation Packaging".
 5. The equipment is strictly used for overpressure and overtemperature; regularly check the safety accessories; regularly clean the sewage and carbon deposits in the tanks and pipes.
 6. This equipment can only be used in conventional environments, and it is forbidden to use it in corrosive environments such as acid, alkali, and salt.
 7. The user unit needs to test and record the wall thickness of the container regularly (the cycle does not exceed 3 months). If the amount of thinning exceeds the corrosion allowance, it must be stopped immediately.
 8. The nameplate is in accordance with the provisions of Annex G of the solid volume regulation, and the thickness of the cylinder, head and connecting pipe is allowed to be replaced by thick.
 9. It is forbidden to use if there are more than 0.3mm dents or scratches on the surface of the shell.

III. Welding Table

Material	Q345R	20	
Q345R	J507+H10Mn2/HJ431	J507	
Q345R	ER50-6	ER50-6	

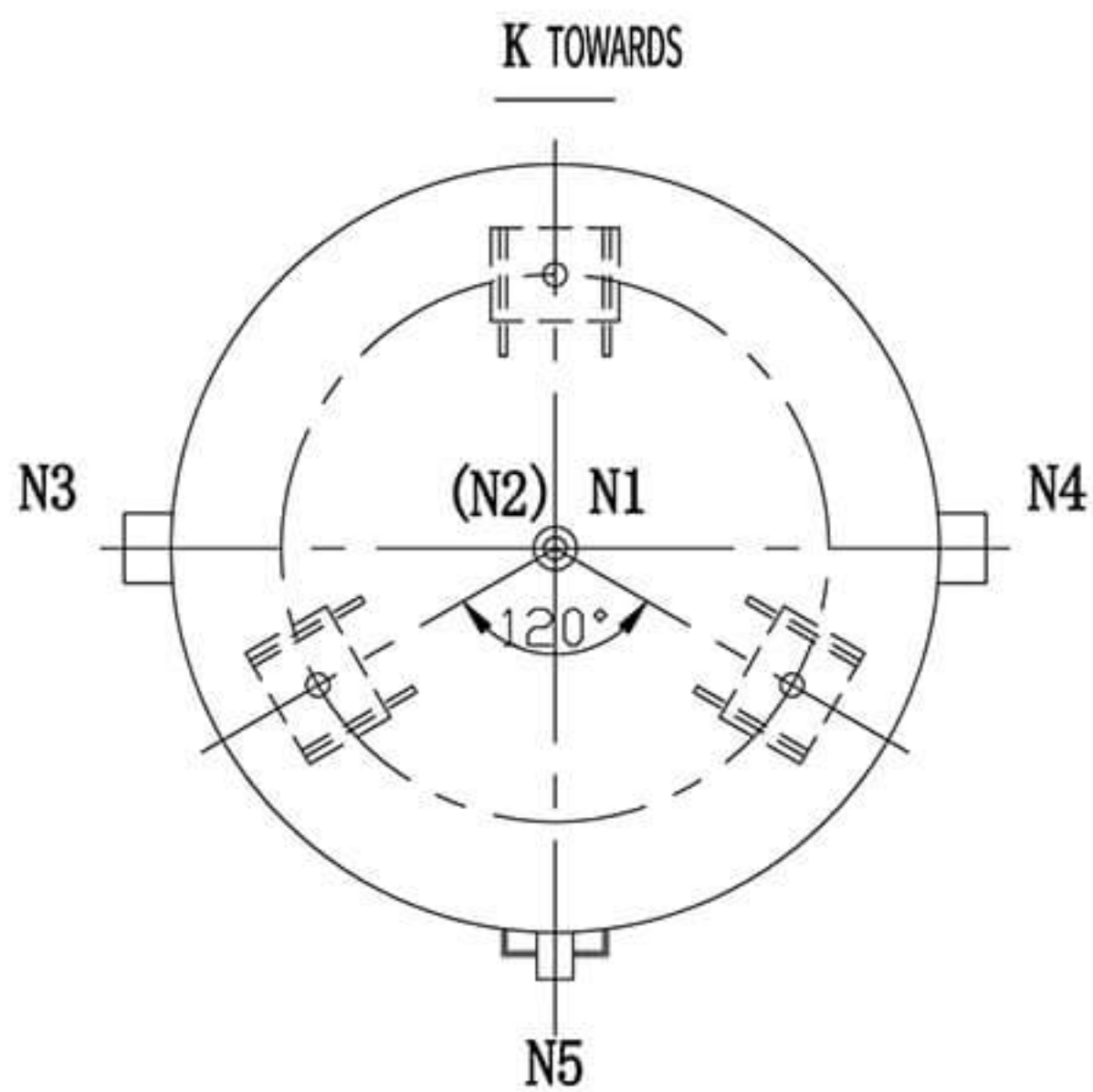
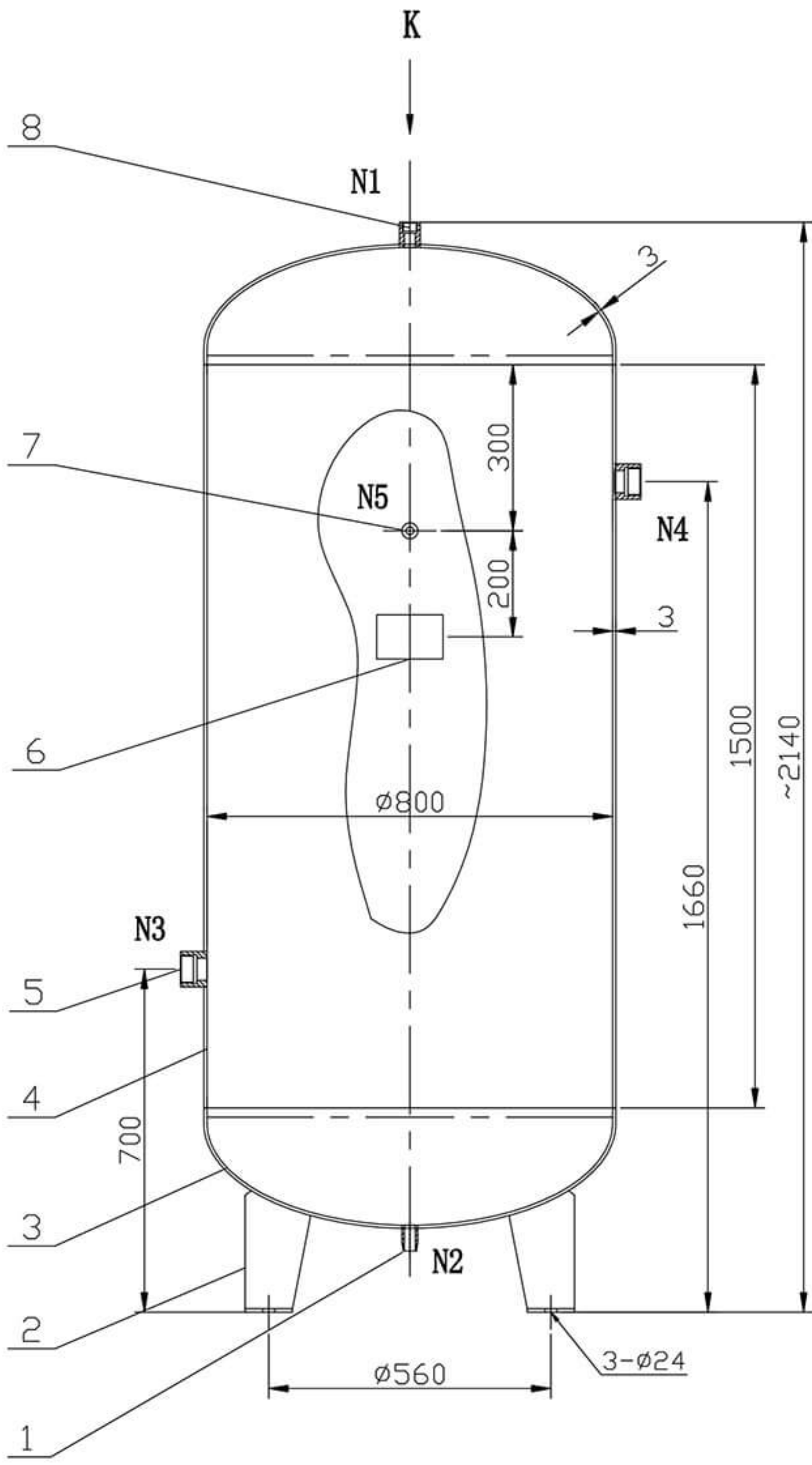
Nozzle table

Symbol	Nominal Size	Link size or standard	Form of sealing surface	Use	Remark
N1	20	GB/T 7306.1-2000, Rp3/4	Internal thread	Safety valve	
N2	15	GB/T 7306.1-2000, R1/2	External thread	Sewage outlet	
N3	40	GB/T 7306.1-2000, Rp1-1/2	Internal thread	Air intake	
N4	40	GB/T 7306.1-2000, Rp1-1/2	Internal thread	Air outlet	
N5		M20×1.5	Internal thread	Pressure gauge port	



Regular product size error rate:
 Total height ≤ 50mm, connection height ≤ 50mm, center distance and relative position of support bolt holes ≤ 100mm,
 Take over the verticality ≤ 10 degrees. This error rate serves as a product acceptance criterion.
 If you have higher requirements for dimensional accuracy, please contact the business manager to increase the price for customization.
 The manufacturer reserves the right to optimize and improve on the basis of this drawing without prior notice.

SERIAL NUMBER	CODE	NAME	QUANTITY	MATERIAL	APIECE	TOTAL	REMARK
					QUALITY	QUALITY	
	JIANGSU MINNUO MACHINERY MANUFACTURING CO., LTD.						
CERTIFICATE NUMBER	TS2241257-2025	DESIGN	CHKD	APPR	AUTH'D	DATE	
PROJECT		DRAWING NAME		GAS TANK ASSEMBLY DRAWING			
WORK AREA							
PROPORTION	1 of 1	DRAWING NO.	CQ-0.6/0.8.0				



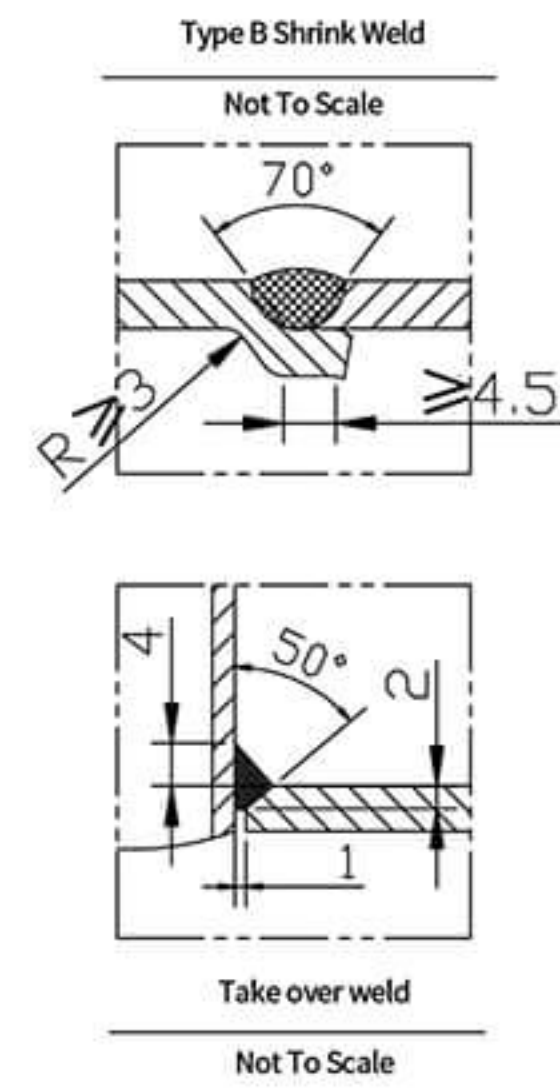
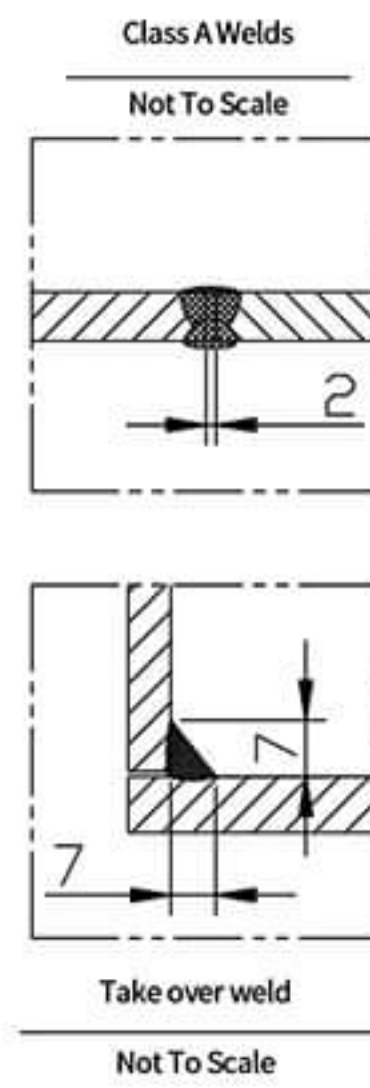
I、 Design Specifications and Standards		This product is designed according to TSG 21-2016 "Stationary Pressure Vessel Safety Technology Supervision Regulations" NB/T47052-2016 "Simple Pressure Vessel"	
Design pressure	MPa	0.84	Container categories
Work pressure	MPa	0.8	Class I (simple container)
Pressure test pressure	MPa	1.26	Full volume
Set temperature	℃	150	m ³
Operating temperature	℃	<150	Corrosion allowance
Medium	air or nitrogen	Welded joint factor	mm
Media properties	Non-toxic, non-flammable	Design method	φ
Design life	10 years	Product model code	1
Main material	Q345R	Quality	Emptyweight
			Waterfillingweight
			kg
			/
			/

The measured thickness of the cylinder body after forming is not less than 2.7mm; the measured thickness of the head after forming is not less than 2.7mm			
II: MANUFACTURING, INSPECTION AND ACCEPTANCE CRITERIA		TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations" NB/T47052-2016 "Simple Pressure Vessel" +	
Safety valve opening pressure	MPa	0.84	Calculated thickness of cylinder
Test medium	Water		/
Product batch number	Station	≤500 Station	Welding Process
Welding Specifications	NB/T47015-2011		Class A welding head requirements
			Submerged arc automatic welding
			X-ray inspection location
			For the intersection of Class A weld, the detection length is greater than or equal to 200mm
			X-ray film quality
			Not lower than AB class
			Eligibility criteria
			NB/T 47013.2-2015 III Class

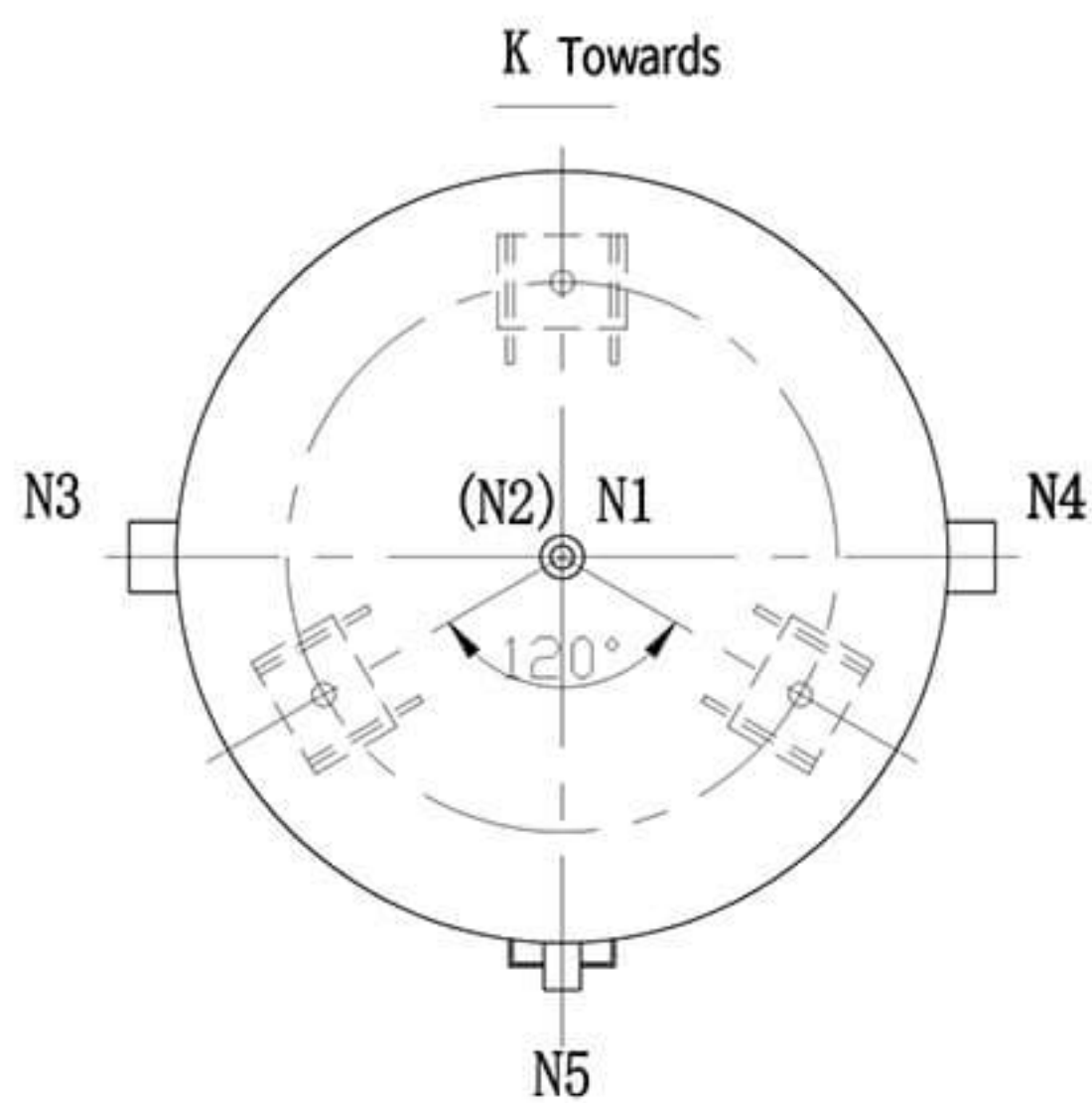
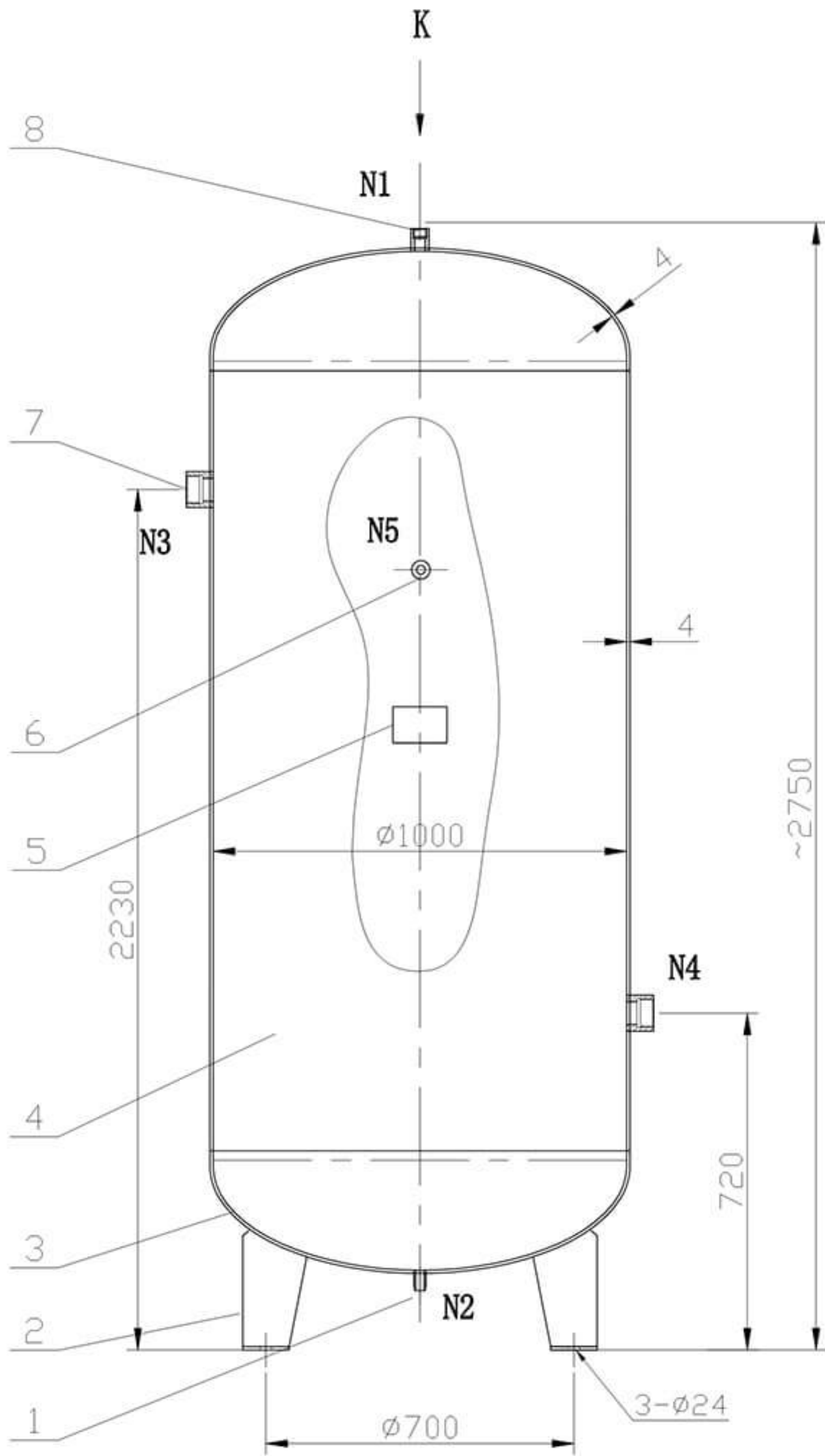
Technical requirements: 1. The orientation of the nozzle and support of this equipment is as shown in the top view. Recommended safety valve model: A28H-10.
 2. For each welder product of Class A weld, at least one product shall be selected for radiographic inspection.
 3. Type B weld seam manufacturing units can choose the type of necking or backing plate according to the actual manufacturing process.
 4. The painting, packaging and transportation of this equipment comply with NB/T 10558-2021 "Pressure Vessel Coating and Transportation Packaging".
 5. The equipment is strictly used for overpressure and overtemperature; regularly check the safety accessories; regularly clean the sewage and carbon deposits in the tanks and pipes.
 7. The user shall regularly (period not more than 3 months) test and record the wall thickness of the container. If the thinning amount exceeds the corrosion allowance, it must stop using it immediately.
 8. The nameplate is in accordance with the provisions of Annex G of the solid volume regulation, and the thickness of the cylinder, head and connecting pipe is allowed to be replaced by thick.
 9. It is forbidden to use if there are more than 0.3mm dents or scratches on the surface of the shell.

III、 Welding table			
Material	Q345R	20	
Q345R	J507+H10Mn2/HJ431	J507	
Q345R	ER50-6	ER50-6	

Nozzle table					
Symbol	Nominal size	Link size or standard	Form of sealing surface	Use	Remark
N1	20	GB/T 7306.1-2000, Rp3/4	Internal thread	Safety valve	
N2	15	GB/T 7306.1-2000, R1/2	External thread	Sewage outlet	
N3	40	GB/T 7306.1-2000, Rp1-1/2	Internal thread	Air intake	
N4	40	GB/T 7306.1-2000, Rp1-1/2	Internal thread	Air outlet	
N5		M20×1.5	Internal thread	Pressure gauge port	



SERIAL NUMBER	CODE	NAME	QUANTITY	MATERIAL	A PIECE	TOTAL	REMARK
					QUALITY		
	JIANGSU MINNUO MACHINERY MANUFACTURING CO., LTD.						
CERTIFICATE NUMBER	TS2241257-2025	DESIGN	CHKD	APPR	AUTH'D	DATE	
PROJECT	DRAWING NAME			GAS TANK ASSEMBLY DRAWING			
WORK AREA							
PROPORTION	1 of 1	DRAWING NO.	CQ-1.0/0.8.0				



Design specifications and standards GB/T 150.1~4-2011 "Pressure Vessel", TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"

Design pressure	MPa	0.84	Container categories	Class I	
Work pressure	MPa	0.8	Full volume	m ³ 2	
Pressure test pressure	MPa	1.05	Corrosion allowance	mm 1	
Set temperature	°C	110	Welded joint factor	φ 0.85/0.8	
Operating temperature	°C	<100	Insulation	Material /	
Medium		Air or nitrogen		Thickness /	
Media properties		Non-toxic, non-flammable	Quality Kg	Empty weight	310 kg
Design life		10 years		Stainless steel	/
Main material		Q345R		Water filling weight	/

II: Manufacturing, inspection and acceptance standards GB/T 150.1-4-2011 "Pressure Vessel", TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"

post weld heat treatment	/	Welded Structure	HG/T20583-2011		
paint	JB/T 4711-2003	Types of welded joints	Detection rate	Test standard	Passing grade
Safety valve opening pressure	MPa 0.84		NDT	≥20%	NB/T47013.2-2015
test medium	Water	A	Container	/	/
Air tightness pressure test	MPa /	B	Container	/	/
		C	Container	/	/
		D	Container	/	/
Welding procedure	NB/T47015-2011	Forging Standard	NB/T47008-2017		

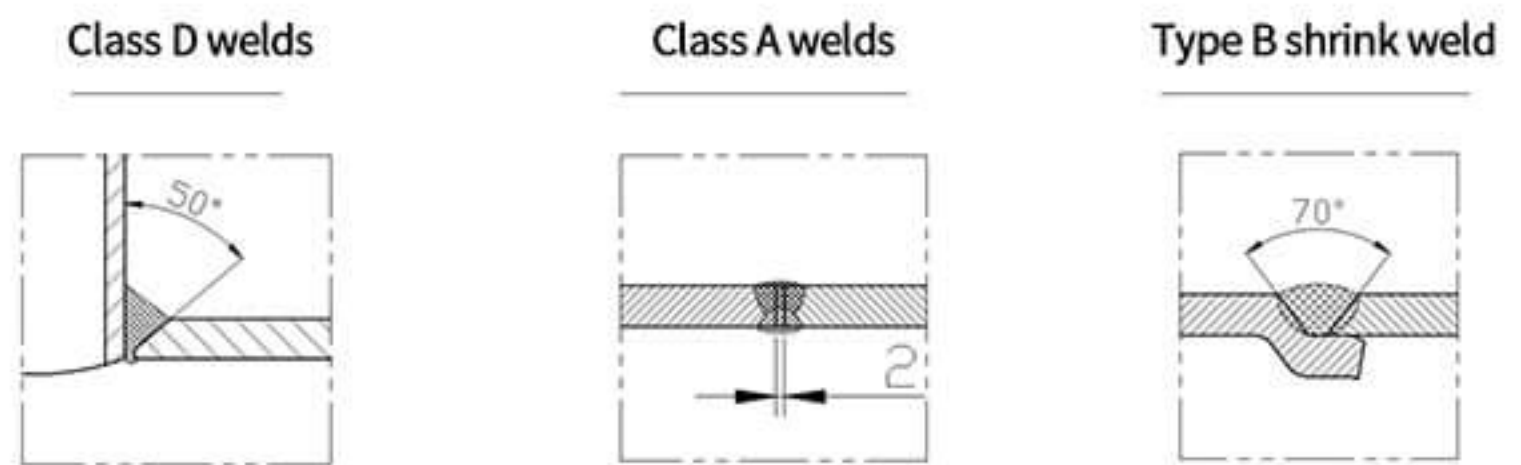
Technical requirements: 1. The orientation of the nozzle and support of this equipment is as shown in the top view.
 2. The calculated thickness of the cylinder should be regularly inspected according to the requirements of the capacity gauge.
 3. The paint, packaging and transportation of this equipment are in accordance with JB/T4711-2003 "Pressure Vessel Coating and Transportation Packaging".
 4. The equipment is strictly used for overpressure, overtemperature and overrange; regularly check the safety accessories; regularly clean the sewage and carbon deposits in the tanks and pipes.
 5. Class B Weld manufacturing unit can choose the type of necking or backing plate according to the actual manufacturing process.
 6. The nameplate is in accordance with the provisions of Annex G of the solid volume regulation, and the thickness of the cylinder, head and connecting pipe is allowed

III. Welding rod table

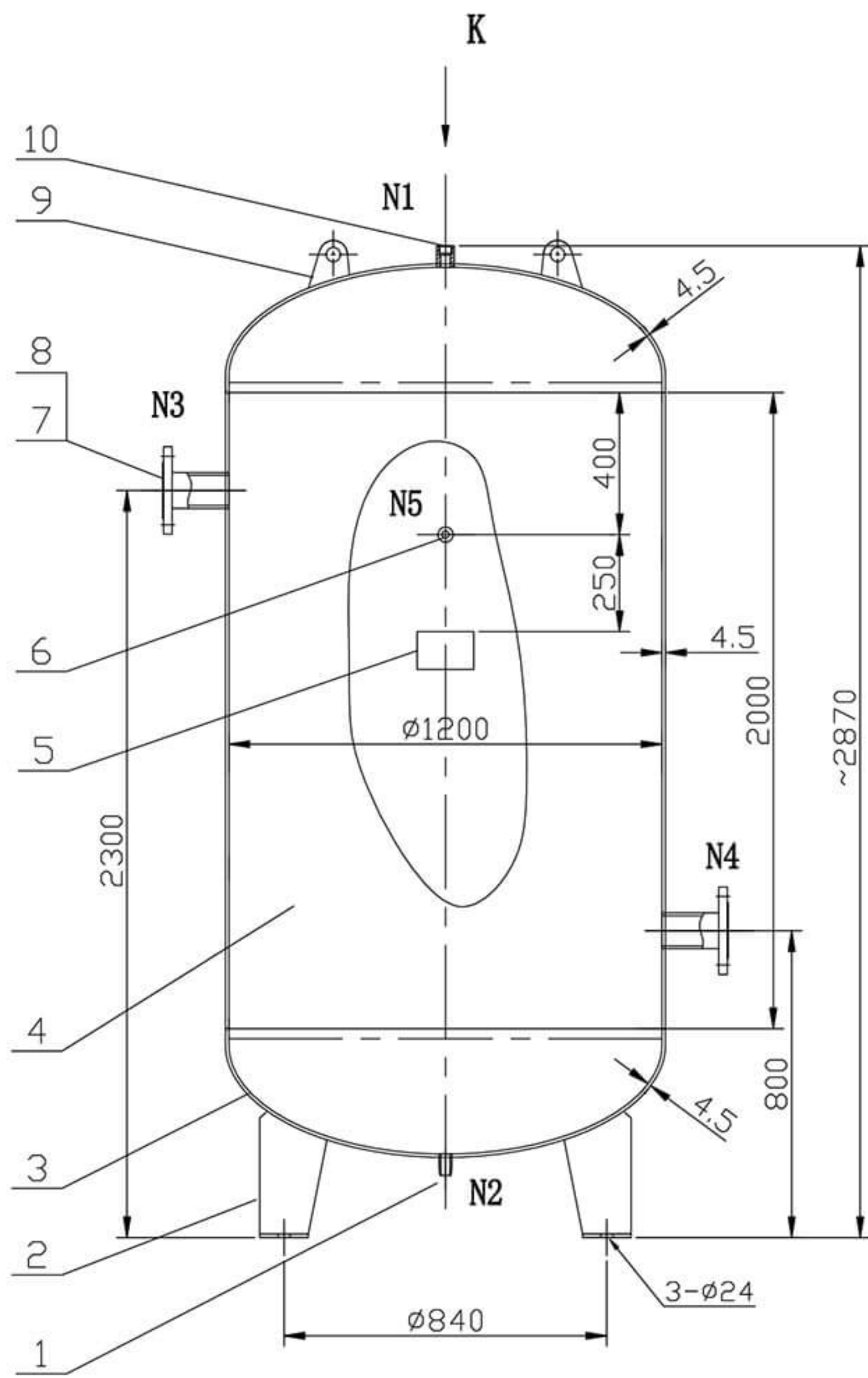
Material	Q345R	20		
Q345R	J507+H10Mn2/HJ431	J507		
Q345R	J507	J507		

Nozzle table

Symbol	Nominal size	Link size or standard	Sealing surface	Purpose or name	Tube size	Remark
N1	25	GB/T 7306.1-2000, Rp1	Internal thread	safety valve		
N2	15	GB/T 7306.1-2000, R1/2	External thread	sewage outlet		
N3	50	GB/T 7306.1-2000, Rp2	Internal thread	air outlet		
N4	50	GB/T 7306.1-2000, Rp2	Internal thread	air intake		
N5		M20×1.5	Internal thread	pressure gauge port		



Jiangsu Minnuo Machinery Manufacturing Co., Ltd.						
Certificate Number	TS2241257-2025	DESIGN	CHKD	APPR	AUTH'D	DATE
project	DRAWING NAME			GAS TANK ASSEMBLY DRAWING		
Work area						
Proportion	1 of 1	DRAWING NO.	CQ-2.0/0.8.0			



I. Design specifications and standards GB/T 150.1~4-2011 "Pressure Vessel", SG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"

Design pressure	MPa	0.84	Container categories	Class I	
Work pressure	MPa	0.8	full volume	m ³ 3	
Pressure test pressure	MPa	1.05	Corrosion allowance	mm 1	
Set temperature	°C	110	Welded joint factor	φ 0.85/0.8	
Operating temperature	°C	<100	Insulation	Material /	
Medium		Air or nitrogen		Thickness /	
Media properties		Non-toxic, non-flammable	Quality Kg	Empty weight	510 kg
Design life		10 years		Stainless steel	/
Main material		Q345R		Water filling weight	/

II: Manufacturing, inspection and acceptance standards GB/T 150.1~4-2011 "Pressure Vessel", TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"

Post weld heat treatment	/	Welded structure	HG/T20583-2011		
Paint	NB/T 10558-2021	Types of welded joints	Detection rate	Test standard	Passing grade
Safety valve opening pressure	MPa 0.84		A Container	≥20%	NB/T47013.2-2015
Test medium	Water	B Container	/	/	/
Air tightness pressure test	MPa /	C Container	/	/	/
Welding Specifications	NB/T47015-2011	D Forging Standard	NB/T47008-2017		

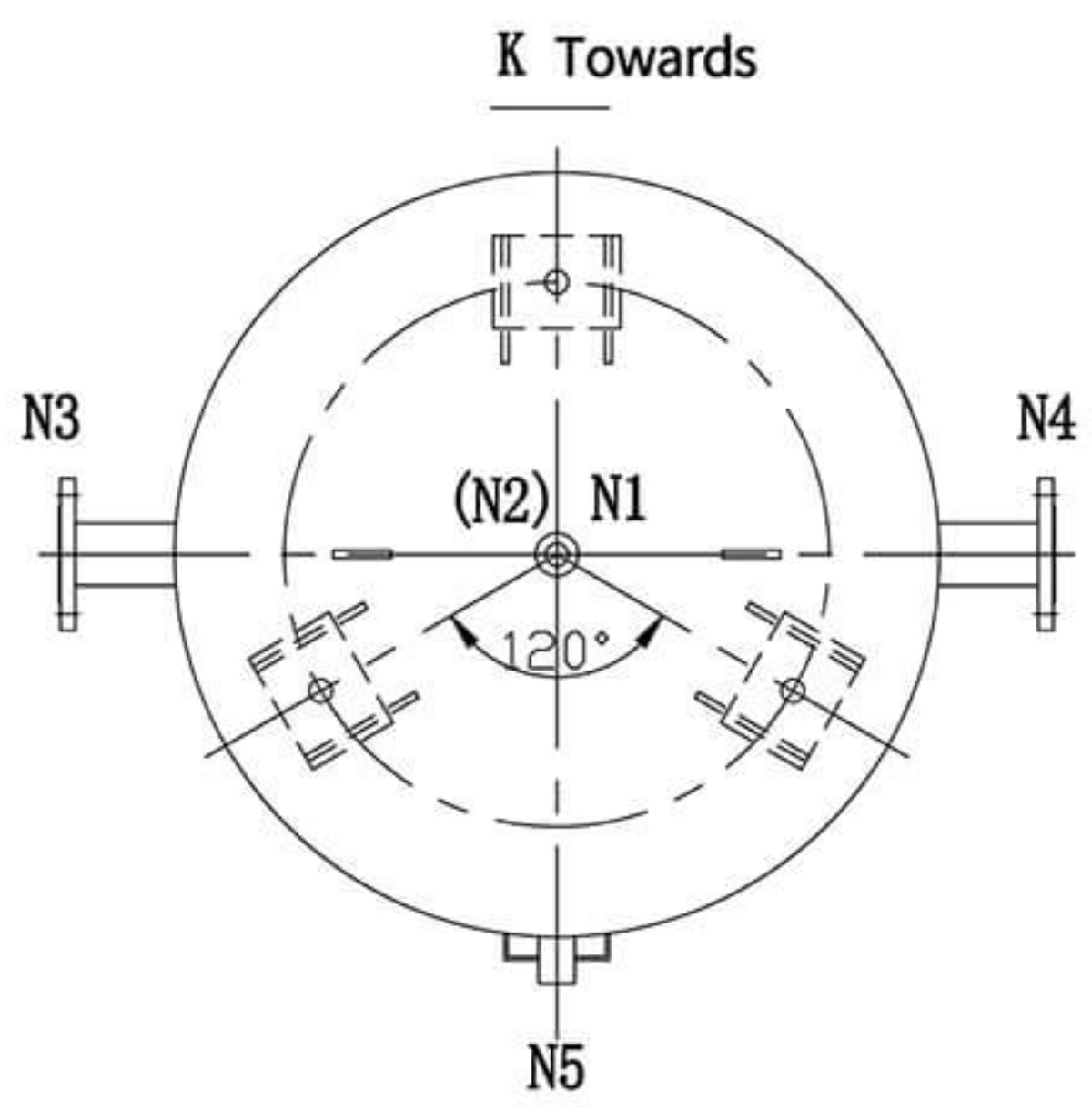
Technical requirements: 1. The orientation of the nozzle and support of this equipment is as shown in the top view.
 2. The technical level of X-ray inspection quality is not lower than AB level.
 3. Type B weld seam manufacturing units can choose the type of necking or backing plate according to the actual manufacturing process.
 4. The user unit needs to test and record the wall thickness of the container on a regular basis (the cycle does not exceed 3 months).
 If the amount of thinning exceeds the corrosion allowance, it must be stopped immediately.
 5. The painting, packaging and transportation of this equipment comply with NB/T 10558-2021 "Pressure Vessel Coating and Transportation Packaging".
 6. The equipment is strictly used for overpressure and overtemperature; regularly check the safety accessories; regularly clean the sewage and carbon deposits in the tanks and pipes.
 7. This equipment can only be used in conventional environments, and it is forbidden to use it in corrosive environments such as acid, alkali, and salt.
 8. The nameplate is in accordance with the provisions of Annex G of the solid volume regulation, and the thickness of the cylinder, head and connecting pipe is allowed to be replaced by thick.

III. Welding rod table

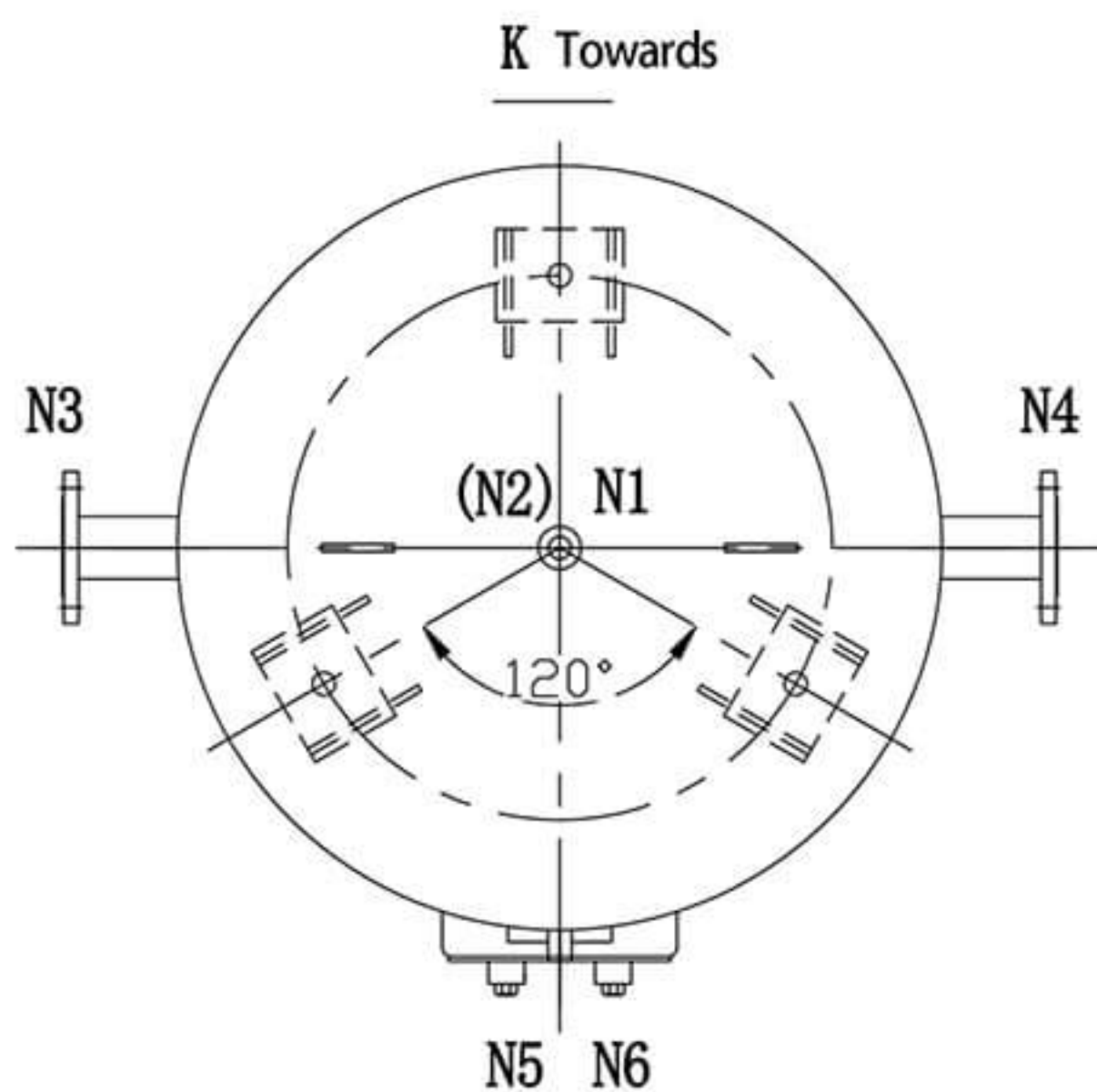
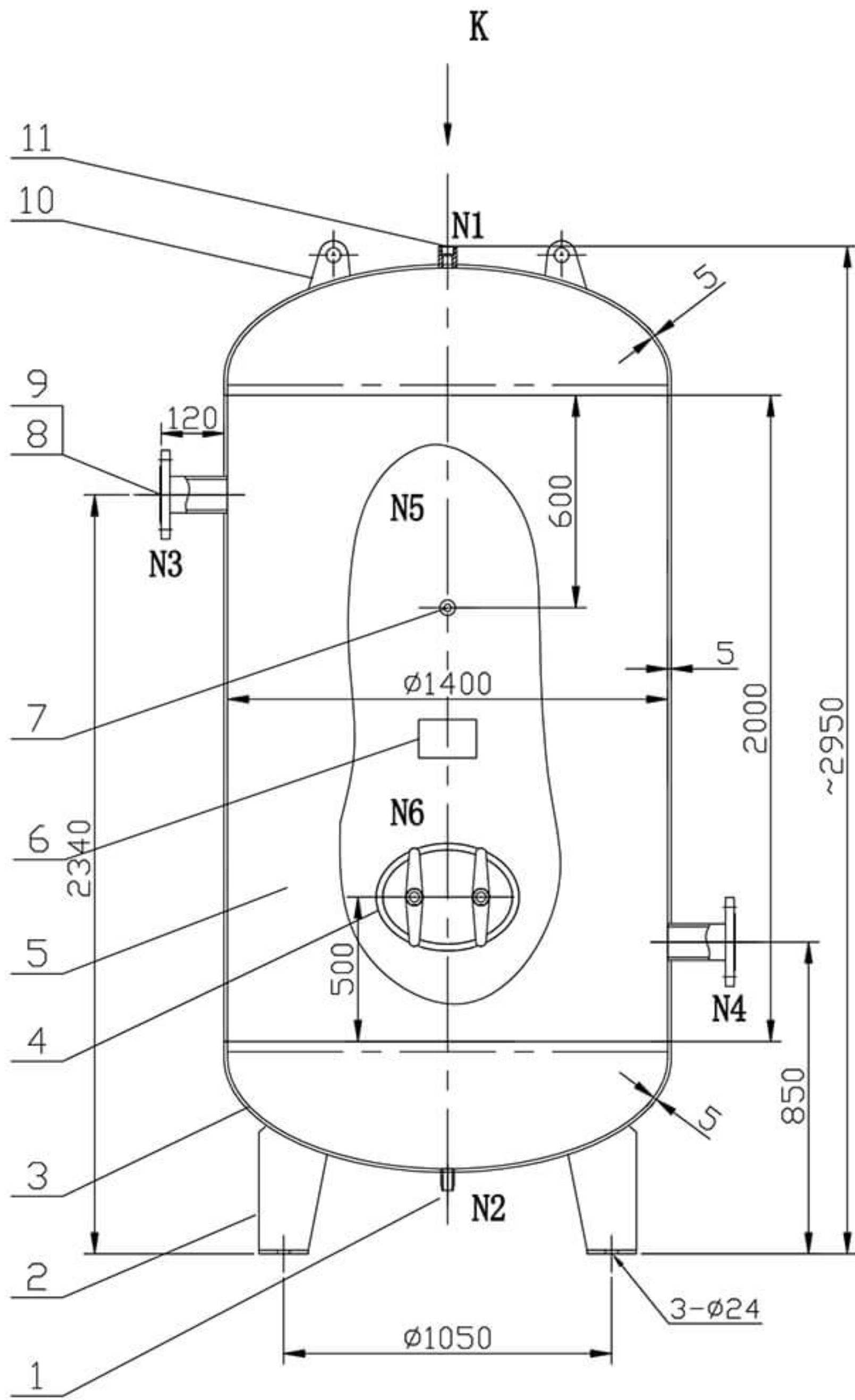
Material	Q345R	20		
Q345R	J507+H10Mn2/HJ431	J507		
Q345R	ER50-6	ER50-6		

Nozzle table

Symbol	Nominal size	Link size or standard	Sealing surface	Purpose or name	Tube size	Remark
N1	32	GB/T 7306.1-2000, Rp1-1/4	Internal thread	Safety valve		
N2	20	GB/T 7306.1-2000, R3/4	External thread	Sewage outlet		
N3	80	HG/T 20592-2009 PL80(B)-16	RF	Air outlet	φ89×6	
N4	80	HG/T 20592-2009 PL80(B)-16	RF	Air intake	φ89×6	
N5		M20×1.5	Internal thread	Pressure gauge port		



SERIAL NUMBER	CODE	NAME	QUANTITY	MATERIAL	APIECE	TOTAL	REMARK
					QUALITY		
		JIANGSU MINNUO MACHINERY MANUFACTURING CO., LTD.					
CERTIFICATE NUMBER	TS2241257-2025	DESIGN	CHKD	APPR	AUTH'D	DATE	
PROJECT		DRAWING NAME		GAS TANK ASSEMBLY DRAWING			
WORK AREA							
PROPORTION	1 of 1	DRAWING NO.	CQ-3.0/0.8.0				



I. Design specifications and standards GB/T 150.1-4-2011 "Pressure Vessel", TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"

Design pressure	MPa	0.84	Container categories	Class I
Work pressure	MPa	0.8	Full volume	m ³ 4
Pressure test pressure	MPa	1.05	Corrosion allowance	mm 1
Set temperature	°C	110	Welded joint factor	φ Vertical 0.85/ Ring 0.8
Operating temperature	°C	<100	Insulation	Material /
Medium		Air or nitrogen		Thickness /
Media properties		Non-toxic, non-flammable	Quality	Empty weight
Design life		10 years		Stainless steel /
Main material		Q345R		Water filling weight /

II: Manufacturing, inspection and acceptance standards GB/T 150.1-4-2011 "Pressure Vessel", TSG 21-2016 "Stationary Pressure Vessel Safety Technical Supervision Regulations"

Post weld heat treatment	/	Welded structure	HG/T20583-2011			
Paint	NB/T 10558-2021	Types of welded joints	Detection rate	Test standard	Passing grade	
Safety valve opening pressure	MPa 0.84		N	≥20%	NB/T47013.2-2015	RT-III
Test medium	Water		A			
Airtightness pressure test	MPa /		D			
Welding Specifications	NB/T47015-2011	T	C			
		D	Container	/	/	
		C	Container	/	/	
		D	Container	/	/	
Forging Standard	NB/T47008-2017					

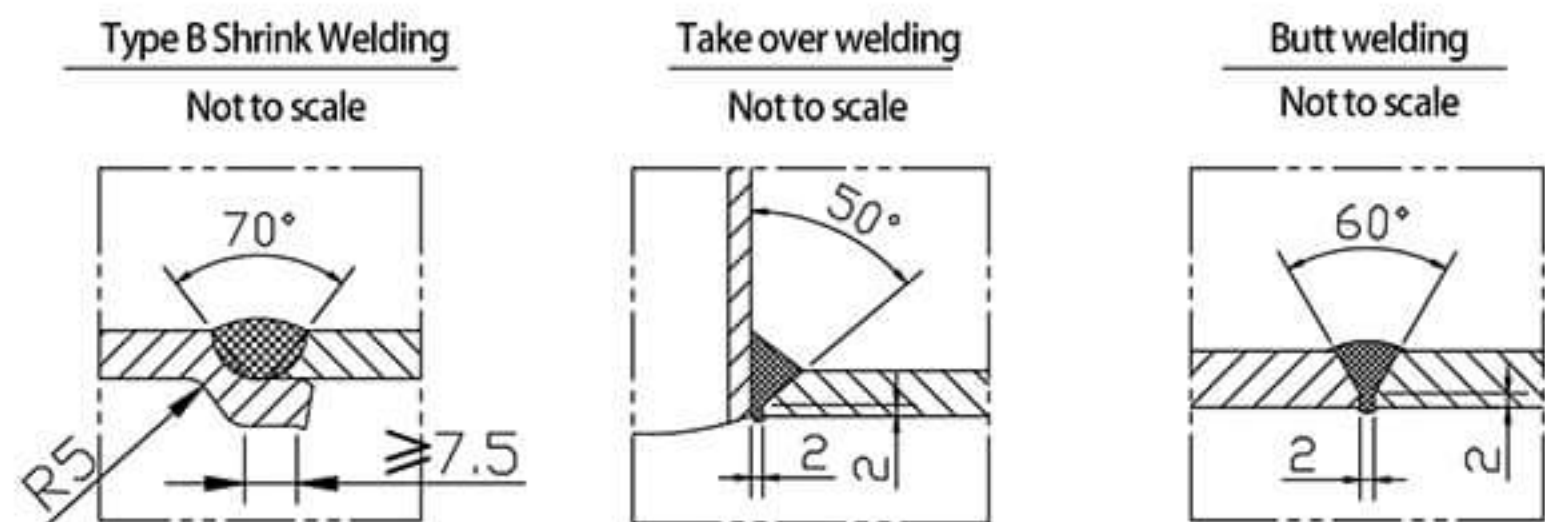
Technical requirements: 1. The orientation of the nozzle and support of this equipment is as shown in the top view. Recommended safety valve model A28H-10.
 2. The technical level of X-ray inspection quality is not lower than AB level
 3. Type B weld seam manufacturing units can choose the type of necking or backing plate according to the actual manufacturing process.
 4. The user unit needs to test and record the wall thickness of the container on a regular basis (the cycle does not exceed 3 months). If the amount of thinning exceeds the corrosion allowance, it must be stopped immediately.
 5. The painting, packaging and transportation of this equipment comply with NB/T 10558-2021 "Pressure Vessel Coating and Transportation Packaging".
 6. The equipment is strictly used for overpressure and overtemperature; regularly check the safety accessories; regularly clean the sewage and carbon deposits in the tanks and pipes.
 7. This equipment can only be used in conventional environments, and it is forbidden to use it in corrosive environments such as acid, alkali, and salt.
 8. The nameplate is in accordance with the provisions of Annex G of the solid volume regulation, and the thickness of the cylinder, head and connecting pipe is allowed to be replaced by thick.

III. Welding table

Material	Q345R	20		
Q345R	J507+H10Mn2/HJ431	J507		
Q345R	ER50-6	ER50-6		

Nozzle table

Symbol	Nominal size	Link size or standard	Sealing surface	Purpose or name	Tube size	Remark
N1	32	GB/T 7306.1-2000, Rp1-1/4	Internal thread	Safety valve		
N2	20	GB/T 7306.1-2000, R3/4	External thread	Sewage outlet		
N3	100	HG/T 20592-2009 PL100(B)-16	RF	Air outlet	φ108×6	
N4	100	HG/T 20592-2009 PL100(B)-16	RF	Air intake	φ108×6	
N5		M20×1.5	Internal thread	Pressure gauge port		
N6	300×400	NB/T 47040-2013	Flat	Manhole		



Regular product size error rate:
 Total height < 50mm, connection height < 50mm, center distance and relative position of support bolt holes < 100mm,
 Take over the verticality < 10 degrees. This error rate serves as a product acceptance criterion.
 If you have higher requirements for dimensional accuracy, please contact the business manager to increase the price for customization.
 The manufacturer reserves the right to optimize and improve on the basis of this drawing without prior notice.

SERIAL NUMBER	CODE	NAME	QUANTITY	MATERIAL	PIECE	TOTAL	REMARK
					QUALITY	QUALITY	
		JIANGSU MINNUO MACHINERY MANUFACTURING CO., LTD.					
CERTIFICATE NUMBER	TS2241257-2025	DESIGN	CHKD	APPR	AUTH'D	DATE	
PROJECT		DRAWING NAME		GAS TANK ASSEMBLY DRAWING			
WORK AREA							
PROPORTION	1 of 1	DRAWING NO.	CQ-4.0/0.8.0				

I. DESIGN SPECIFICATIONS AND STANDARDS GB/T 150.1~4-2011 "PRESSURE VESSEL", TSG 21-2016 "STATIONARY PRESSURE VESSEL SAFETY TECHNICAL SUPERVISION REGULATIONS"

Design pressure	MPa	0.84	Container categories	I类
Work pressure	MPa	0.8	full volume	m ³ 5
Pressure test pressure	MPa	1.05	Corrosion allowance	mm 1
Set temperature	°C	110	Welded joint factor	φ 0.85/0.8
Operating temperature	°C	<100	Insulation	Material /
Medium		Air or nitrogen		Thickness /
Media properties		Non-toxic, non-flammable	Quality Kg	Empty weight 729 kg
Design life		10 years		Stainless steel /
Main material		Q345R		Water filling weight /

Post weld heat treatment	/	Welded structure	HG/T20583-2011					
Paint	JB/T 4711-2003	Types of welded joints	N	A	Container	Detection rate ≥20%	Test standard NB/T47013.2-2015	Passing grade RT-III
Safety valve opening pressure	MPa 0.84			B				
Test medium	Water		T	C	Container	/	/	/
Air tightness pressure test	MPa /			D				
Welding Specifications	NB/T47015-2011	Forging Standard	NB/T47008-2017					

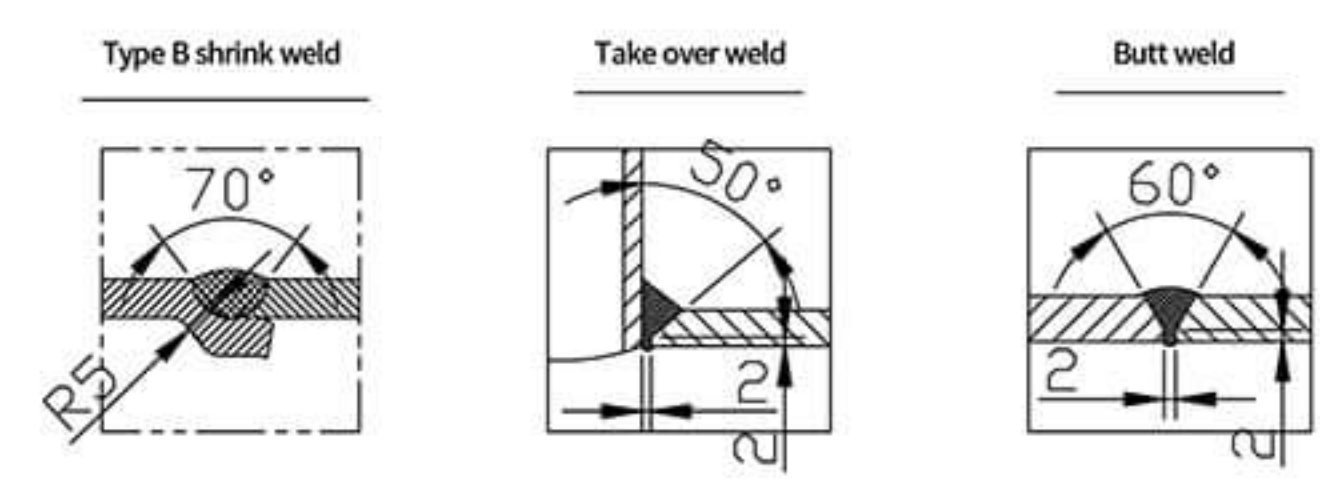
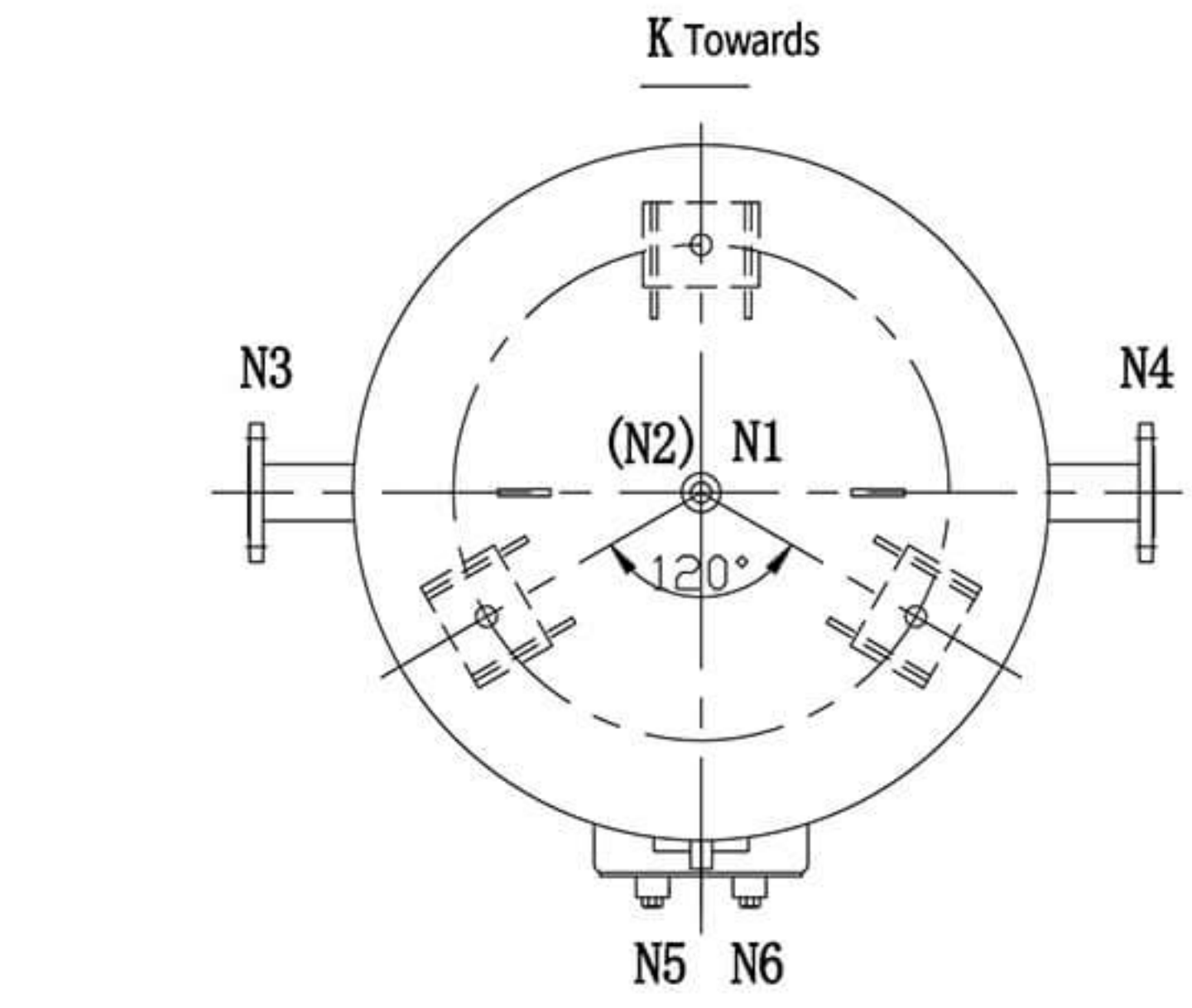
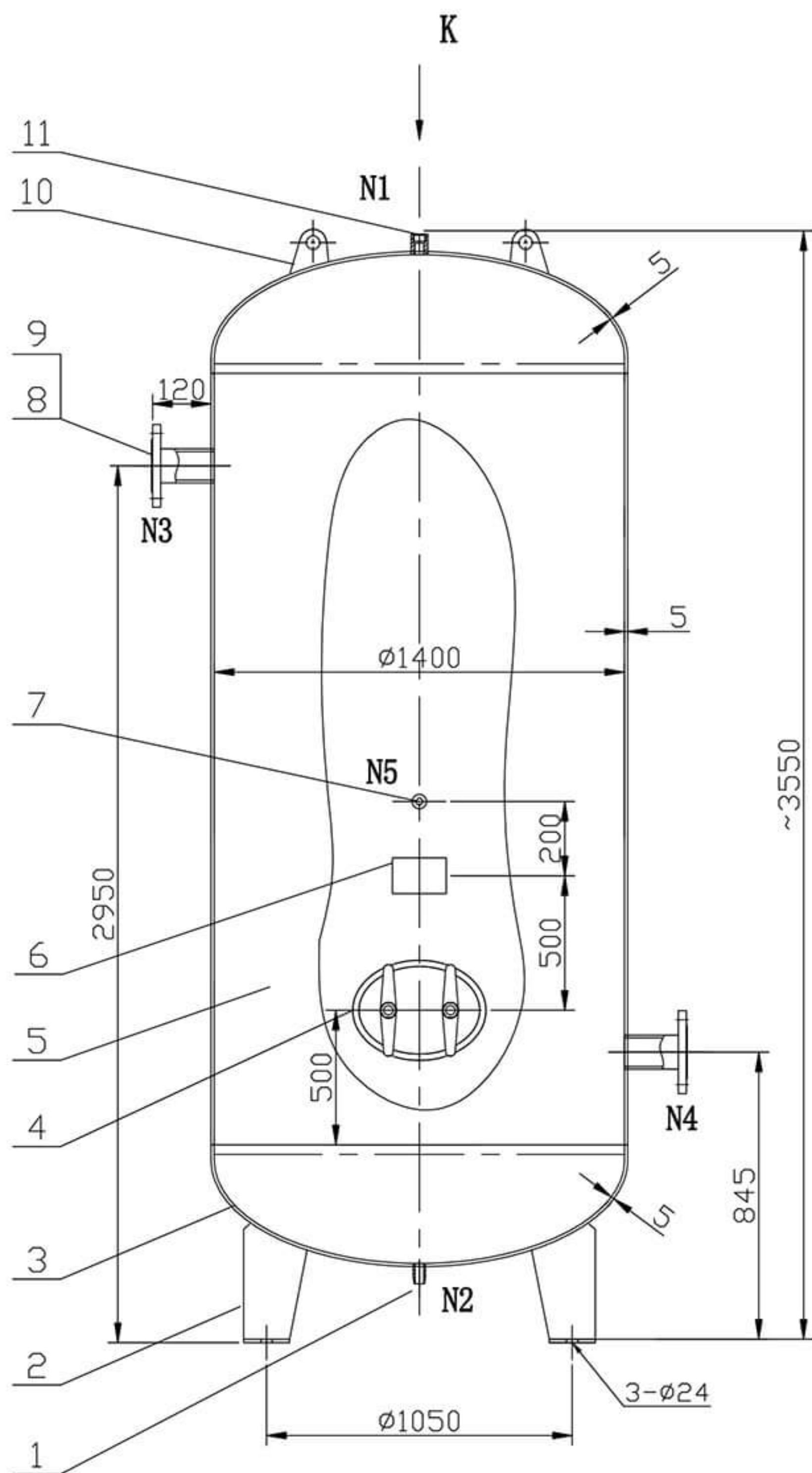
Technical requirements: 1. The orientation of the nozzle and support of this equipment is as shown in the top view.
 2. The technical level of X-ray inspection and inspection quality is not lower than AB level.
 3. Type B welding seam manufacturing unit can choose the type of necking or backing plate according to the actual manufacturing process.
 4. The user should check and record the wall thickness of the container on a regular basis (the cycle does not exceed 3 months). If the thinning amount exceeds the corrosion allowance, it must stop using it immediately.
 5. The paint, packaging and transportation of this equipment are in accordance with JB/T4711-2003 "Pressure Vessel Coating and Transportation Packaging".
 6. The equipment is strictly used for overpressure, overtemperature, and overrange; regularly check the safety accessories; regularly clean the sewage and carbon deposits in the tanks and pipes.
 7. This equipment can only be used in conventional environments, and it is forbidden to use it in corrosive environments such as acid, alkali, and salt.
 8. The nameplate is in accordance with the provisions of Annex G of the solid volume regulation, and the thickness of the cylinder, head and connecting pipe is allowed to be replaced by thick.

III. Welding rod table

Material	Q345R	20		
Q345R	J507+H10Mn2/HJ431	J507 (ER50-6)		
Q345R	J507	J507 (ER50-6)		

Nozzle table

Symbol	Nominal size	Link size or standard	Sealing surface	Purpose or name	Tube size	Remark
N1	32	GB/T 7306.1-2000, Rp1-1/4	Internal thread	Safety valve		
N2	20	GB/T 7306.1-2000, R3/4	External thread	Sewage outlet		
N3	100	HG/T 20592-2009 PL100(B)-16	RF	Air outlet	φ108×6	
N4	100	HG/T 20592-2009 PL100(B)-16	RF	Air intake	φ108×6	
N5		M20×1.5	Internal thread	Pressure gauge port		
N6	300×400	NB/T 47040-2013	Flat	Manhole		



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Work area		DRAWING NO.		CQ-5.0/0.8.0		
Proportion	1 of 1					