



技术要求

1. 除图中标注AⅡ焊缝外,其余焊缝外观质量应符合Q/SY 073 002.1-2012中的B类Ⅱ级要求。
2. [G01], [G02]为关键焊缝要求超声波探伤,应符合GB/T 11345中的检测等级B级。
3. 表面喷涂三底漆面漆,喷涂面积 7.8m^2 。

产品图样按Q/SY
012 005执行

30	QZJ006215183	Bracket, Boom HeadSACITONE.10.2.1	1		65.373	
29	QZJ006215190	Reinforced Plate ■ SACITONE.10.2.24	2	钢板B-8/HG785	1.757	
28	QZJ006215187	Pipe ■SACITONE.10.2.11	1	钢管φ65×4/HSM770	1.960	
27	QZJ006215198	Cornicle ■SACITONE.10.2.18	1	钢管φ45×3/Q345B	0.666	
26	QZJ006215210	Reinforced Plate ■ SACITONE.10.2.25	2	钢板B-8/HG785	0.441	
25	10665525	-QWS.13.1.1	2		1.321	
24	QZJ006215217	Cornicle ■SACITONE.10.2.11	1	钢管φ45×3/Q345B	1.352	
23	QZJ006215204	Chord ■SACITONE.10.2.3	1	钢管φ85×4/HSM770	13.612	
22	QZJ006215215	Cornicle ■SACITONE.10.2.16	1	钢管φ45×3/Q345B	1.812	
21	QZJ006215218	Pipe ■SACITONE.10.2.9	1	钢管φ50.8×4/HSM770	3.975	
20	QZJ006215193	Pipe■SACITONE.10.2.21	1	钢管φ101.6×6.3/HSM890	8.832	
19	QZJ006215185	Chord ■SACITONE.10.2.4	1	钢管φ85×4/HSM770	13.626	
18	QZJ006215211	Cornicle ■SACITONE.10.2.15	1	钢管φ45×3/Q345B	1.571	
17	QZJ006215202	Pipe■SACITONE.10.2.22	1	钢管φ101.6×6.3/HSM890	8.821	
16	QZJ006215192	Plate■SACITONE.10.2.2	2	钢板B-20/HG785	2.360	
15	QZJ006215186	Plate■SACITONE.10.2.1	2	钢板B-30/HG785	1.970	
14	QZJ006215191	Folding arm bracket■SACITONE.10.2.3	1		0.573	
13	QZJ006215219	Cornicle ■SACITONE.10.2.20	1	钢管φ65×4/HSM770	1.009	
12	QZJ006215201	Pipe ■SACITONE.10.2.14	1	钢管φ65×4/HSM770	1.960	
11	QZJ006215189	Pipe ■ SACITONE.10.2.10	1	钢管φ50.8×4/HSM770	3.044	
10	QZJ006215196	Chord ■ SACITONE.10.2.5	1	钢管φ85×4/HSM770	9.286	
9	QZJ006215206	Pipe ■ SACITONE.10.2.13	1	钢管φ50.8×4/HSM770	3.028	
8	QZJ006215208	Fixed seat■SACITONE.10.2.2	1		27.922	
7	QZJ006215214	Chord ■SACITONE.10.2.6	1	钢管φ85×4/HSM770	9.286	
6	QZJ006215195	Cornicle ■SACITONE.10.2.19	1	钢管φ65×4/HSM770	1.689	
5	QZJ006215205	Plate ■SACITONE.10.2.8	2	钢板B-20/HG785	2.552	
4	QZJ006215216	Plate ■SACITONE.10.2.7	4	钢板B-20/HG785	3.662	
3	10462569	QW100.1.8.3.18	3	圆钢φ2-6/Q235A	0.017	
2	QZJ006215194	Pipe ■SACITONE.10.2.12	1	钢管φ50.8×4/HSM770	3.964	
1	10013822	Locating shaft100GAL.1.4.1.1	1	圆钢φ2-25/35	0.118	

[illegible]

三一重工股份有限公司

2st-section truss

QZJ006215188

SAC1200E.10.2