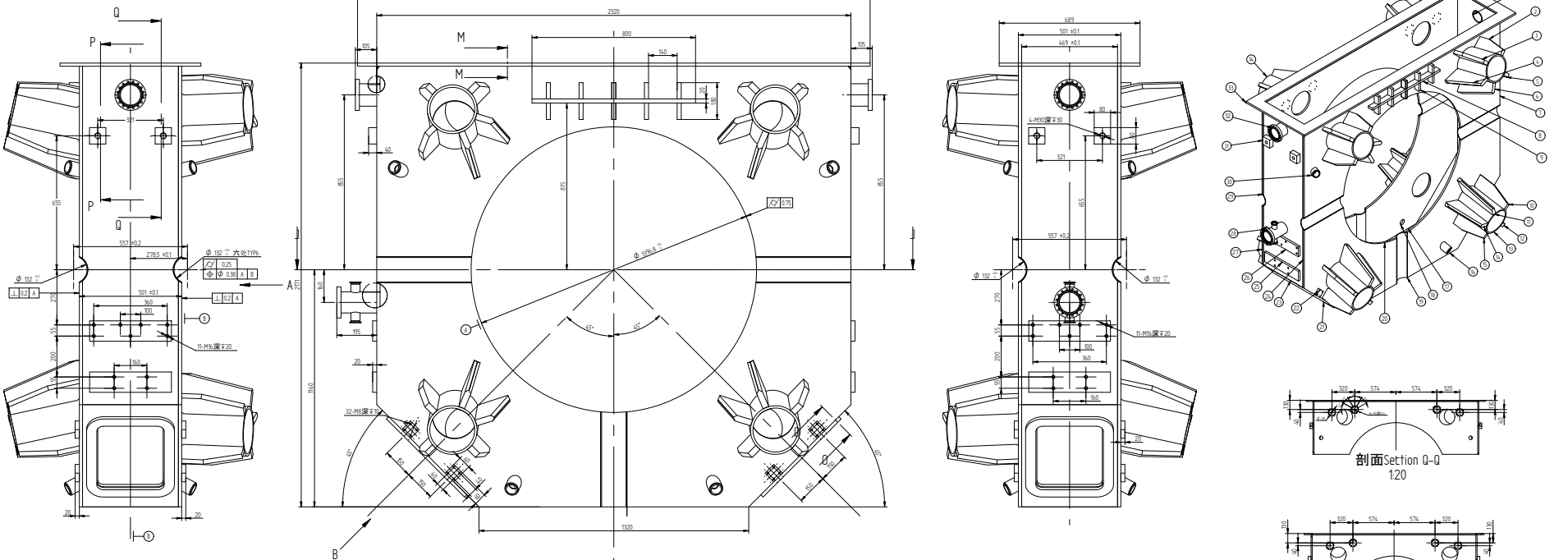
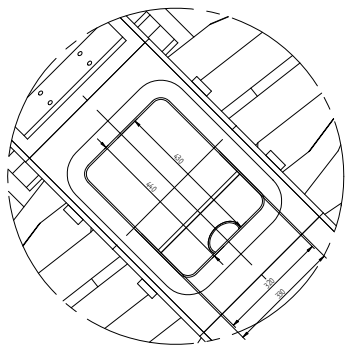
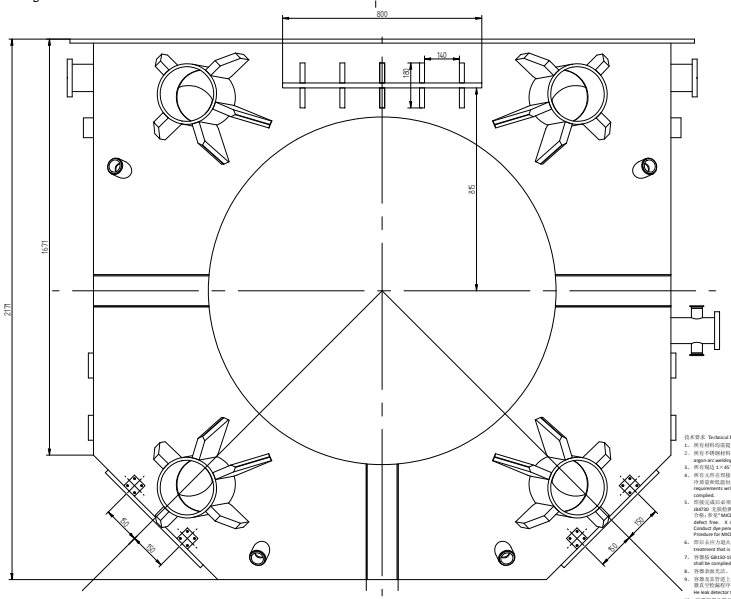


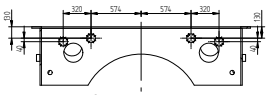


B向局部放大图Scaled B View

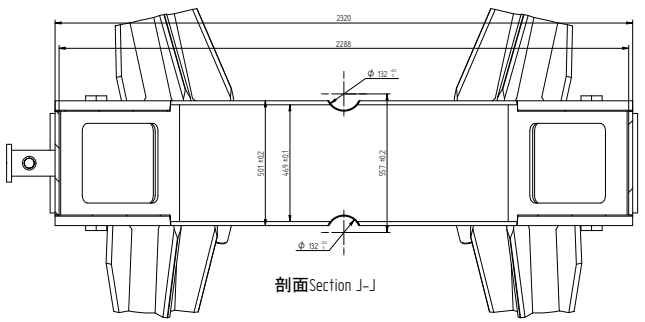


视图 A

剖面Section Q-Q
1:20



剖面Section P-P
1:20



剖面Section J-J

技术要求 Technical Req.:

1. 所有材料应提供材料质量证书Properties certificate shall be provided for all material.
2. 所有不锈钢材料的焊接均采用氩弧焊，焊丝牌号为 H0Cr21Ni10Ti/SI. steel parts shall be welded with argon-arc welding method and H0Cr21Ni10 solder.
3. 所有锐边 1×45° 倒钝，去尖角，毛刺和飞边Chamfer edge to 1x45° and trim sharp degas.
4. 所有元件在焊接和氦检前须进行处理，去除油脂、污物、灰尘等，并干燥保存。详细参见 "MAGE冷质量和低温加固真空容器的元件预检程序"./Clean all parts before welding or assembly and keep dry. All requirements written in "Cleaning and Welding Procedure for MAGE Cold Mass and Cryostat" shall be complied.
5. 焊接完成后必须对焊缝进行外观检查，焊缝表面不得有裂缝、气孔、未熔合或咬边等焊接缺陷，按JB4730 无损检测要求。对接型缝应行射线无损检测，A 相为合格，其他型缝应行渗透检测，I 级为合格，参见 "MAGE 冷质量和低温加固真空容器的元件预检程序"./ Visually check welding seams, they shall be defect free. X ray inspect all seamwelding and shall be graded II; and comply JB4730 procedure. Conduct dye penetration test on other welding and shall be graded I. Refer to "Cleaning and Welding Procedure for MAGE Cold Mass and Cryostat"
6. 焊后表面光滑无气、内侧抛光，表面粗糙为Dimension finishing shall be conducted after annealing treatment that is following the welding. Electrically polish surfaces.
7. 焊接按GB150-1998《钢制压力容器》进行制造，检验和密封GB150-1998 《Steel Pressure Vessel》 shall be complied for vacuum vessel fabrication, test and acception inspection shall comply.
8. 焊接表面无过、牛皮状层缺，刻痕等缺陷Weld surface shall be scratch and defect free.
9. 焊接完毕进行各个焊缝的氦质谱检漏试验，漏率≤1×10^{-9}Pa·m^3/s，参见 "MAGE 冷质量和低温加固真空容器的元件预检程序"./Refer to "Vacuum Leak Check Procedure for MAGE Cold Mass and Cryostat", use the He leak detector to test all welding seams and leakage shall be <1×10^{-9}Pa·m^3/s.
10. 焊接检查合格后，用干燥氮气进行充气试验，试验压力 0.125MPa，压保持不 GB150，Comply to GB150, Dry Nitrogen gas with 0.125Mpa pressure test.
11. 加工方面以确认，必须对尺寸进行检查和机械中心对称标记./ After completing assembly, check all dimensions and calibrate mechanical center.

未注尺寸公差按 GB/T 1804-2000 m 级，未注形位公差按 GB/T 1184-1996 k 精密级。See cell in the frame for un-marked tolerances.

14	MMSF-0400-0014	冷质量支撑筒组4	SUPPORT ASSY.PART 4	4	304		41.3
13	MMSF-0400-0013	冷质量支撑筒3	SUPPORT CYLINDER 3	4	304		44.9
12	MMSF-0400-0012	冷质量支撑筒组3	SUPPORT ASSY.PART 3	4	304		43.7
11	MMSF-0400-0011	冷质量支撑筒组4	SUPPORT ASSY.PART 4	4	304		44.9
10	MMSF-0400-0010	冷质量支撑筒组3	SUPPORT ASSY.PART 3	4	304		43.7
9	MMSF-0400-0009	真空筒体环筋2	VACUUM CHAMBER RIB 2	24	304		13.0
8	MMSF-0400-0008	真空筒体环筋1	VACUUM CHAMBER RIB 1	2	304		13.5
7	MMSF-0400-0007	焊接1－1	WELDING 1-1 FOR VACUUM CHAMBER	1	304		177.8
6	MMSF-0400-0006	冷质量支撑筒组4	SUPPORT ASSY.PART 4	4	304		44.9
5	MMSF-0400-0005	冷质量支撑筒组3	SUPPORT ASSY.PART 3	4	304		43.7
4	MMSF-0400-0004	冷质量支撑筒组2	SUPPORT ASSY.PART 2	4	304		41.3
3	MMSF-0400-0003	冷质量支撑筒组4	SUPPORT ASSY.PART 4	4	304		39.5
2	MMSF-0400-0002	冷质量支撑筒组3	SUPPORT ASSY.PART 3	4	304		23.7
1	MMSF-0400-0001	对接2	BUTT WELD 2 FOR VACUUM CHAMBER	1	304		96.2
序号	代号	名称		数量	材料	单重	总重

设 计				SSRF上海光源	
绘 图					
校 核		计算机文件名	MMSF-0400-0000A09	MEE超导耦合磁铁	
审 核		制图软件	Solid Edge	真空室主容器	
会 签		数 量	重 量 比 例	图 幅	
审 定		1:1	750.22	A0	
批 准		共 2张	第 1张	MMSF-0400-0000	版本 A

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