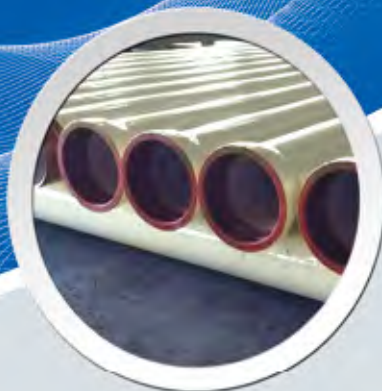


迁安市津唐球墨铸管有限公司

Qian'an Jintang Ductile Iron Pipes Co., Ltd.

集采矿、选矿、炼铁、铸造、铸管、管件、阀门于一体的专业化球墨铸铁产品生产企业

Professional ductile iron product manufacturer integrating mining, ore dressing, iron making, casting, cast pipes, pipe fittings and valves



一切为您的需求服务！
Do everything for your needs!



公司简介 COMPANY PROFILE

迁安市津唐球墨铸管有限公司创建于2001年,是一家集采矿、选矿、炼铁、铸造、铸管、管件、阀门于一体的专业化球墨铸铁产品生产企业。

公司主要产品为离心球墨铸铁管,铸管厂建有冷模法铸管生产线四条,年产优质铸造生铁40万吨, DN80—DN2600mm离心球墨铸铁管30万吨。被中国铸造协会评为首届全国铸造行业“专精特新优势中小企业”,全国铸造行业千强企业,“津唐”商标为著名商标。

整体通过了ISO9001质量管理体系认证,ISO14001环境管理体系认证和GB/T28001职业健康安全管理体系认证。

迁安市津唐球墨铸管有限公司真诚欢迎各位莅临指导、洽谈合作!

Founded in 2001, Qian'an Jintang Ductile Iron Pipes Co., Ltd. is a professional ductile iron product manufacturer integrating mining, ore dressing, iron making, casting, cast pipes, pipe fittings and valves.

Our company's main products are centrifugal ductile iron pipes. Four water cooled mould cast pipe production lines are built in the pipe casting factory, with an annual output of 400,000 tons of high-quality foundry pig iron and 300,000 tons of DN80-DN2600mm centrifugal ductile iron pipes. We were awarded by the China Foundry Association as "a specialized, fined, peculiar and new advantageous small and medium-sized enterprise" in the first national foundry industry and one of the top 1,000 enterprises in the foundry industry. The trademark "Jintang" is a famous trademark.

Our company has passed ISO9001 quality management system certification, ISO14001 environmental management system certification and GB/T28001 occupational health and safety management system certification.

Qian'an Jintang Ductile Iron Pipes Co., Ltd. sincerely welcomes you to visit and negotiate cooperation!

No.2

MANUFACTURING PROCESS

制造工艺

生产流程图
Production flow chart



No.1

PRODUCT INTRODUCTION

产品介绍

离心球墨铁管至今在世界上已成为上水管的材料，并且正逐渐推广应用燃气管道系统中，其原因在于离心球墨铸管具有钢管的强度与所需的伸长率，而且耐腐蚀性能是钢管的两倍以上。柔性接口可以有效地起到防震效果。

我公司可以提供符合 ISO2531/7186 或 EN545/598 等标准要求，生产 DN80—DN2600 的各规格范围的球墨铸铁管。

Centrifugal ductile iron pipes have become the material of water application pipes in the world, and are gradually being promoted in gas pipeline systems, because the centrifugal ductile iron pipes have the strength of steel pipes and the required elongation and their corrosion resistance is more than twice that of the steel pipes. Flexible joint can effectively prevent earthquake.

Our company can provide various specifications of ductile iron pipes of DN80-DN2600 in accordance with the standards of ISO2531/7186 or EN545/598.

No.3 QUALITY CONTROL

产品的质量控制



每支球墨铸铁管都要进行严格的在线检测,检测项目包括,铁水成分、金相、抗拉强度、延伸率、硬度、产品尺寸、产品外观、水压、水泥内衬厚度、喷锌厚度、喷漆厚度,确保每个产品都符合标准。

Each ductile iron pipe is subjected to strict on-line inspection. The test items include molten iron composition, metallographic phase, tensile strength, elongation, hardness, dimension, appearance, water pressure, cement lining thickness, zinc spraying thickness and paint spraying thickness to ensure that each product meets the standards.

机械性能 Mechanical properties

专业化球墨铸铁 Specialized ductile iron			
机械性能 Mechanical properties	离心球墨铸铁管 Centrifugal ductile iron pipe	普通灰铁管 Ordinary gray iron pipe	钢管 Steel pipe
抗拉强度 (Mpa) Tensile strength (Mpa)	≥ 420	150-260	≥ 400
抗弯强度 (Mpa) Bending strength (Mpa)	≥ 590	200-360	≥ 400
延伸率 (%) Elongation (%)	DN80-DN1000 ≥ 10 DN1100-DN2600 ≥ 7	忽略 Ignore	≥ 18
布氏硬度 (HBS) Brinell hardness (HBS)	≤ 230	≤ 230	约 140 About 140

水压测试 Hydrostatic test

专业化球墨铸铁 Specialized ductile iron	
公称直径 DN(mm) Nominal diameter DN (mm)	水压试验压力 (Mpa) Hydraulic test pressure (Mpa)
DN80-300	5
DN350-600	4
DN700-1000	3.2
DN1100-2000	2.5
DN2200-2600	1.8



水泥测试 Cement test

专业化球墨铸铁 Specialized ductile iron

公称直径 DN (mm) Nominal diameter DN (mm)	最小厚度 (mm) Minimum thickness (mm)
DN80-300	3
DN350-600	5
DN700-1200	6
DN1400-2000	9

内外防护 Internal and external protection

专业化球墨铸铁 Specialized ductile iron

内防护 Internal protection

普通水泥
铝酸盐水泥
抗硫酸盐水泥
Ordinary cement
Aluminate cement
Sulfate resistant cement

外防护 External protection

喷锌 (130g/m³、200g/m³、400g 锌铝合金) + 沥青漆
聚氨酯、环氧树脂、PE
Spray zinc (130g/m³, 200g/m³, 400g zinc-aluminum alloy)
+ bitumen paint
Polyurethane, epoxy resin, PE



金属锌涂层 Metal zinc coating

金属锌涂层要求每平方米管道最小喷锌量为 130g，某一点最小量不低于 110g/m²。
The metal zinc coating requires a minimum zinc spray of 130g per square meter of pipeline and a minimum of not less than 110g/m² at a certain point.

沥青涂层 Asphalt coating

外部沥青涂层要求平均厚度不小于 70 微米，某一点的最下厚度不小于 50 微米。
The external asphalt coating requires an average thickness of not less than 70 micrometers, and the lowest thickness at a certain point is not less than 50 micrometers.

技术参数 Technical Parameters

T 型接口 (K9 级 标准有效长度 6 米) T-type joint (K9 standard effective length 6 meters)

专业化球墨铸铁 Specialized ductile iron					
公称直径 Nominal diameter mm	公称外径 Nominal outer diameter mm	标称壁厚 Nominal wall thickness mm	直部每米重量 Straight weight kg/m	承口近似重量 Approximate socket weight kg	总重量 (近似值) Total weight (approximate) kg
80	98	6.0	12.2	3.4	77
100	118	6.0	14.9	4.3	95
125	144	6.0	18.3	5.7	119
150	170	6.0	21.8	7.1	144
200	222	6.3	30.1	10.3	194
250	274	6.8	40.2	14.2	255
300	326	7.2	50.8	18.6	323
350	378	7.7	63.2	23.7	403
400	429	8.1	75.5	29.3	482
450	480	8.6	89.7	38.3	575
500	532	9.0	104.3	42.8	669
600	635	9.9	137.3	59.3	882
700	738	10.8	173.9	79.1	1123
800	842	11.7	215.2	102.6	1394
900	945	12.6	260.2	129.9	1691
1000	1048	13.5	309.3	161.3	2017
1200	1255	15.3	420.1	237.7	2758
1400	1462	17.1	547.2	279.3	3669
1600	1668	18.9	690.3	375.4	4668
1800	1875	20.7	850.1	490.6	5803
2000	2082	22.5	1026.3	626.4	7068

(1): 外径正公差 +1 毫米
(1): Outer diameter positive tolerance + 1 mm

(2): 铸管标准公差壁厚如下
(2): Standard tolerance wall thickness of cast pipes is as follows
E=6mm, 公差 -1.3mm E > 6mm, 公差 - (1.3+0.001DN)
E=6mm, tolerance - 1.3mm E>6mm, tolerance - (1.3+0.001DN)

K9 T 型可允许的偏转角度 K9 T-type allowable deflection angle

(DN80 1400mm 管长 6m) (DN80 1400mm pipe length 6m)

专业化球墨铸铁 Specialized ductile iron			
公称直径 Nominal diameter mm	安装时允许的偏转角度 Allowable installation deflection angle	公称直径 Nominal diameter mm	安装时允许的偏转角度 Allowable installation deflection angle
80	5°00'	500	3°00'
100	5°00'	600	3°00'
150	5°00'	700	2°00'
200	4°00'	800	2°00'
250	4°00'	900	2°00'
300	4°00'	1000	1°50'
350	3°00'	1200	1°30'
400	3°00'	1400	1°30'
450	3°00'		

S 型接口 (K9 级 标准有效长度 6 米) S-type interface (K9 standard effective length 6 meters)

专业化球墨铸铁 Specialized ductile iron					
公称直径 Nominal diameter DN mm	公称外径 Nominal outer diameter DE mm	标称壁厚 Nominal wall thickness e mm	直部每米重量 Straight weight kg/m	承口近似重量 Approximate socket weight kg	总重量 (近似值) Total weight (approximate) kg
100	118	6.0	14.9	9.0	98
150	169	6.0	21.8	11.7	143
200	220	6.3	30.1	17.8	198
250	272	6.8	40.2	21.8	263
300	323	7.2	50.8	27.5	332
350	374	7.7	63.2	33.5	413
400	426	8.1	75.5	40.4	493
500	528	9.0	104.3	50.4	676
600	631	9.9	137.3	65.2	889
700	733	10.8	173.9	85.4	1129

N1 型接口 (K9 级 标准有效长度 6 米)
N1-type interface (K9 standard effective length 6 meters)

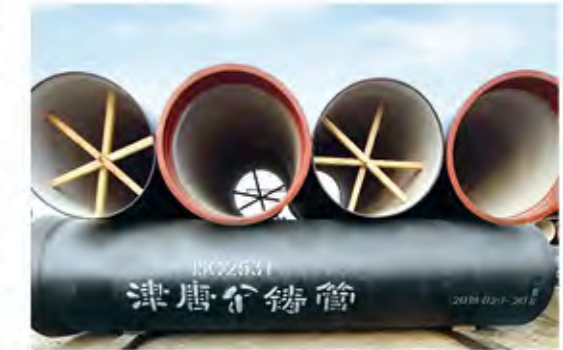
专业化球墨铸铁 Specialized ductile iron					
公称直径 Nominal diameter DN mm	公称外径 Nominal outer diameter DE mm	标称壁厚 Nominal wall thickness e mm	直部每米重量 Straight weight kg/m	承口近似重量 Approximate socket weight kg	总重量 (近似值) Total weight (approximate) kg
100	118	6.0	14.9	10.3	100
150	169	6.0	21.8	13.9	145
200	220	6.3	30.1	17.9	199
250	272	6.8	40.2	22.6	264
300	323	7.2	50.8	27.3	332
350	375.5	7.7	63.2	32.3	412
400	426	8.1	75.5	38	491
500	528	9.0	104.3	48.4	674
600	631	9.9	137.3	59.4	883

K 型接口 (K9 级 标准有效长度 6 米)
K-type interface (K9 standard effective length 6 meters)

专业化球墨铸铁 Specialized ductile iron					
公称直径 Nominal diameter DN mm	公称外径 Nominal outer diameter DE mm	标称壁厚 Nominal wall thickness e mm	直部每米重量 Straight weight kg/m	承口近似重量 Approximate socket weight kg	总重量 (近似值) Total weight (approximate) kg
1200	1255	15.3	420.1	201	2722
1400	1462	17.1	547.2	265.8	3549
1500	1565	18.0	616.7	298.8	3999
1600	1668	18.9	690.3	375.4	4517
1800	1875	20.7	850.1	490.6	5591
2000	2082	22.5	1026.3	626.4	6784
2200	2288	24.3	1217.3	784.2	8094
2400	2495	26.1	1427.2	1108	9671
2600	2702	27.9	1652.4	1295	11209

DN1200 以上管型，采取热模法，无论从生产工序工艺还是对离心机、整涂工序、控制参数、熔炼以及涂衬都有较高的要求。

铸铁前需对铁水进行取样分析，熔炼化铁前对铸铁块取样进行光谱分析，出铁时电炉铁水温度控制在 1400°C - 1550°C，镇静时间 ≥ 10 分钟，球化包温度控制在 ≥ 1370°C，≤ DN2000 拔管温度 ≤ 900°C，≥ DN2000 拔管温度 ≤ 800°C (拔管时接管托轮必须处于旋转状态)。



A heated mould method is adopted for pipes of DN1200 or above, which has high requirements for either the production process or the centrifuge machine, coating process, control parameters, smelting and lining.

Molten iron should be sampled and analyzed before iron casting, ingots should be sampled for spectroscopic analysis before smelting, the temperature of the molten iron in the electric furnace is controlled at 1400°C-1550°C when tapping, the stable time is ≥10 minutes, the temperature of nodulizing ladles is controlled at ≥1370°C, the drawing temperature of pipes ≤DN2000 is ≤ 900°C, and the drawing temperature of pipes ≥ DN2000 is ≤ 800°C (the take-over roller must be in a rotating state when drawing).

壁厚标准 Wall thickness standards

专业化球墨铸铁 Specialized ductile iron						
规格 T 型 Specification T type	C25 级 / 有压污水壁厚 Level C25/ pressurized sewage wall thickness		K8 壁厚 K8 wall thickness K8		K9 壁厚 K9 wall thickness K9	
	标准壁厚 Standard wall thickness mm	最小壁厚 Minimum wall thickness mm	标准壁厚 Standard wall thickness mm	最小壁厚 Minimum wall thickness mm	标准壁厚 Standard wall thickness mm	最小壁厚 Minimum wall thickness mm
1100	12.6	10.2	12.8	10.4	14.4	12
1200	13.6	11.1	13.6	11.1	15.3	12.8
1400	15.7	13	15.2	12.5	17.1	14.4
1500	16.7	13.9	16	13.2	18	15.2
1600	17.7	14.8	16.8	13.9	18.9	16
1800	19.7	16.6	18.4	15.3	20.7	17.6
2000	21.8	18.5	20	16.7	22.5	19.2
2200XT2	--	--	--	--	24.3	20.8
2400XT2	--	--	--	--	26.1	22.4
2600XT2	--	--	--	--	27.9	24

No.4

JOINT INTRODUCTION OF T-TYPE DUCTILE IRON PIPE

T 型接口球墨铸铁管接口介绍



T 型接口又叫 T 型承插划入式柔性接口，是球墨铸铁管最常用的接口型式。使用历史 60 年，是密封效果最佳的接口。

The T-type joint, also known as the T-type socket-spigot flexible joint, is the most common joint for ductile iron pipes. With a history of 60 years, it is the best joint for sealing.

T 型接口密封原理 Sealing principle of T-type joint

T 型接口安装时，管子在插口外壁挤压，安放在承口内的橡胶圈，使其压缩变形，而产生一定的接触压力，利用橡胶圈的自密封作用来保持接口的密封性。

When the T-type joint is installed, the pipe is squeezed on the outer wall of the spigot, the rubber ring placed in the socket is compressed and deformed to generate certain contact pressure, and the self-sealing action of the rubber ring is used to maintain the sealing property of the joint.

T 型接口特点 Characteristics of T-type joint

该接口具有结构简单、安装方便、密封性能好等特点，在窗口结构上考虑了密封圈和接口的偏转，通过控制插口的安装深度，使得接头具有一定的抽象伸缩量，因此这种接口能适应一定的基础沉降，同时可利用其偏转角度实现管线长距离的转向安装，接口。胶圈有硬胶和软胶两部分组成，硬胶对管道接口有一定的支撑和对心作用。

The joint has the characteristics of simple structure, convenient installation, good sealing property and the like. The deflection of the sealing ring and the interface is considered in the window structure. By controlling the installation depth of the spigot, the interface has certain abstract expansion and contraction, so the interface can adapt to certain foundation settlement, and at the same time, the long-distance steering installation of the interface on the pipeline can be realized using its deflection angle. The rubber ring is composed of two parts: hard rubber and soft rubber, wherein the hard rubber has certain supporting and centering effect on the pipeline interface.

涉及领域 Fields involved

有 / 无压输水，饮用水，污水管线

地下地上铺设，且管道的敷设坡度不超过 20%（地上铺设）或 25%（地下铺设）

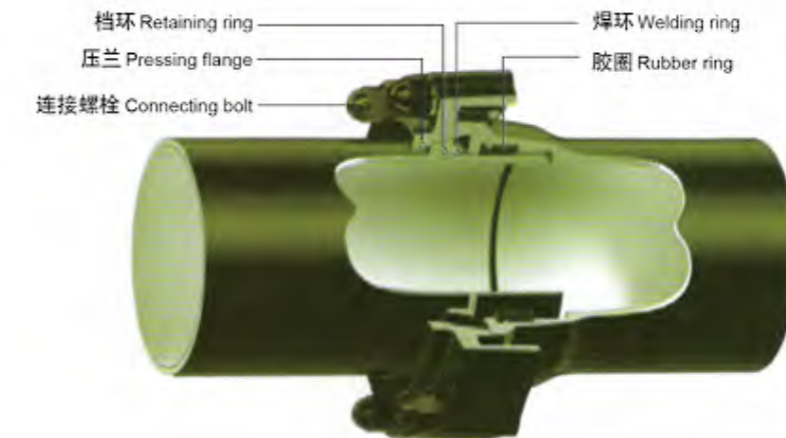
Water delivery with/without pressure, drinking water, sewage pipeline

Laying on and under the ground, the laying slope of the pipeline is not more than 20% (ground laying) or 25% (underground laying)

JOINT INTRODUCTION OF TF SELF-ANCHORING JOINT DUCTILE IRON PIPE

TF 自锚管接口球墨铸铁管接口介绍

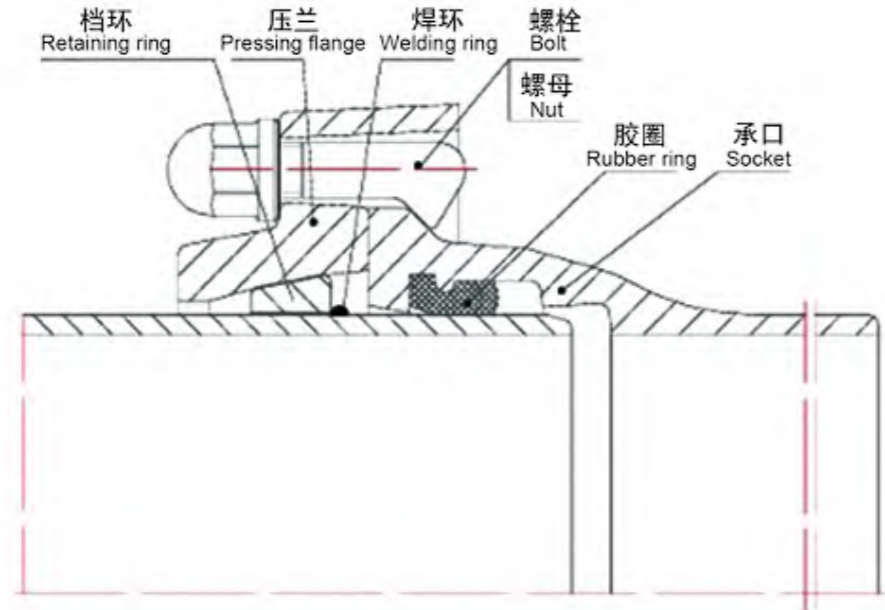
接口结构 Interface structure



TF 型接口结构示意图
Structure diagram of TF-type joint

TF 自锚接口采用了 T 型接口的密封结构。相比 T 型接口，它增加了焊接在管子插口端的焊环、活动开口挡环、特殊压兰以及连接螺栓以及附件，使接口具有较好的抗拔脱能力。挡环和压兰之间可以滑动，使接口具有一定的轴向伸缩和偏转能力。

The TF self-anchoring joint uses the sealing structure of the T-type joint. Compared with the T-type joint, it adds a welding ring welded at the pipe spigot end, a movable opening retaining ring, a special pressing flange, a connecting bolt and accessories, so that the interface has better pull-out resistance. The retaining ring and the pressing flange can slide, so that the joint has certain axial expansion and deflection abilities.



TF 自锚管推出的必要性 Necessity of TF self-anchoring pipe promotion

由于管线在安装时，经常会遇到地基的不均匀沉陷、转弯处无法安装支墩等的现实情况。所以，解决接口的防拔脱问题就显得非常重要。从而开发了 TF 型自锚式接口球墨铸铁管。

When a pipe is installed, it often encounters the actual situations that the foundation is not settled uniformly, piers cannot be installed at the turn, etc. So, it is very important to solve the problem of pull-out resistance of the interface. Thus, TF self-anchoring joint ductile iron pipes were developed.

TF 自锚式球墨铸铁管的工作原理 Working principle of TF self-anchoring ductile iron pipe

压力管线在拐弯、三通等处产生的轴向推力使接口处的承插口组件产生相对位移。插口端轴向应力通过焊环、挡环、压兰、连接螺栓传递给承口，从而实现了轴向应力的传递，使接口具备防滑脱能力。当形成约束连接一定长度的管道与周围土壤的摩擦力超过管道内部产生的轴向应力时，就能保证管道的安全运行，从而避免了砌筑混凝土支墩。

The axial thrust generated by the pressure line at corners, tees, etc. causes relative displacement of the spigot assembly at the interface. The axial stress of the spigot end is transferred to the socket through the welding ring, the retaining ring, the pressing flange and the connecting bolt, thereby realizing the transfer of the axial stress and enabling the interface to have the anti-slip capability. When the friction between the pipe having the constrained length and the surrounding soil exceeds the axial stress generated inside the pipe, the safe operation of the pipe can be guaranteed, thereby avoiding the construction of concrete piers.

使用领域 Applications

在下列情况下可通过铺设一定长度的自锚接口球墨铸铁管来防止管线接口滑脱：

1. 弯头、三通、异径管和堵头等处；
2. 当管线的敷设坡度超过 20%（地上铺设）或 25%（地下铺设）时；
3. 设置混凝土支墩不经济时（如大口径高压管线等）或在某些特殊情况下，设置支墩措施不能实施时，如：

- (1) 施工场地过于狭窄，没有空间设置规范规定的十吨；
- (2) 施工工期紧张等。

The pipeline interface can be prevented from slipping by laying a length of self-anchoring interface ductile iron pipe under the following situations:

- 1, at elbows, tees, reducers, plugs, etc.;
- 2, when the laying slope of the pipeline is more than 20% (ground laying) or 25% (underground laying);
- 3, when the setting of concrete piers is not economic (such as large-caliber high-pressure pipelines, etc.) or cannot be implemented in some special cases, for example:
 - (1) the construction site is too narrow, and there is no space to set ten tons as specified in the criteria;
 - (2) the construction period is short, etc.

TF 自锚接口球墨铸铁管的技术参数
Technical parameters of TF self-anchoring joint ductile iron pipe

专业化球墨铸铁 Specialized ductile iron									
DN	DE (mm)	D1 (mm)	C (mm)	θ	单支管道末端位移量 Single pipe end displacement	Lu(mm)	K9		
80	98	236	76	5	522	6000	6.0	25	
100	118	257	89			6.0			
150	170	312	92			6.0			
200	222	364	95	4	418	6.3			
250	274	426	105			6.8			
300	326	495	7.2						
350	378	550	3	314	7.7	16			
400	429	608			100		8.1		
500	532	718			110		9.0		
600	635	834	115	9.9					
700	738	960	150	2	209		10.8		
800	842	1072	160				11.7		
900	945	1187	175				12.6		
1000	1048	1297	185	1.5	157		13.5	10	
1100	1152	1412	200				14.4		
1200	1255	1525	215				15.3		
					157/213	6000/8150			

T 型球墨铸铁管的安装

Installation of T-type ductile iron pipe

清理承口插口→清理胶圈→安装胶圈→下管（排管）→在插口外表和胶圈上刷润滑剂
→顶推管子使之插入承口→检查。

Clean the socket and spigot → clean the rubber ring → install the rubber ring → detach the pipe (discharge the pipe) → brush the lubricant on the outer surface of the spigot and the rubber ring → push the pipe to insert into the socket → check.

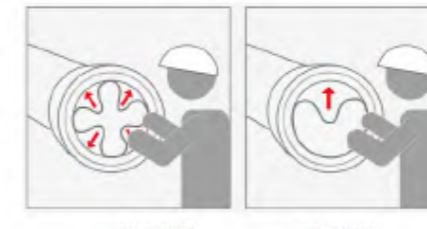
球墨铸铁给水管安装要点:

Installation points of ductile iron water supply pipe:

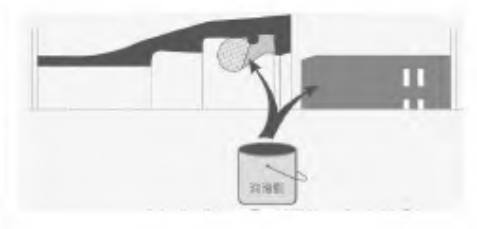
- 清理管口：将承口内的所有杂物清除擦洗干净。
- 清理胶圈、上胶圈：将胶圈上的粘着物清擦干净，把胶圈弯为“梅花形”或“8”字形装入承口槽内，并用手沿整个胶圈按压一遍，或用橡皮锤砸实，确保胶圈各个部分不翘不扭，均匀地卡在槽内。
- 在插口外表面和胶圈上涂刷润滑剂：将润滑剂均匀地涂刷在承口安装好的胶圈内表面、在插口外表面涂刷润滑剂时要将插口线以外的插口部位全部刷匀。
- Clean the socket: remove all debris from the socket.
- Clean and install the rubber ring: clean the adhesive on the rubber ring, bend the rubber ring into a plum shape or 8 shape and install it into the socket, press the entire rubber ring once by hand or tamp it with a rubber mallet to ensure that each part of the rubber ring is not warped or twisted and is evenly caught in the groove.
- Brush the lubricant to the outer surface of the spigot and the rubber ring: brush the lubricant evenly on the inner surface of the rubber ring installed on the socket, and brush the entire spigot outside the spigot line when brushing the outer surface of the spigot.



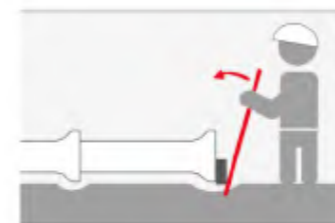
清理承口示意图
Schematic diagram of cleaning the socket



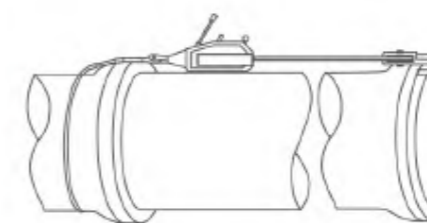
胶圈安装示意图
Installation diagram of the rubber ring



涂润滑剂示意图
Schematic diagram of brushing the lubricant



DN80-DN150 安装示意图
DN80-DN150 installation diagram



中口径安装示意图
Medium caliber installation diagram



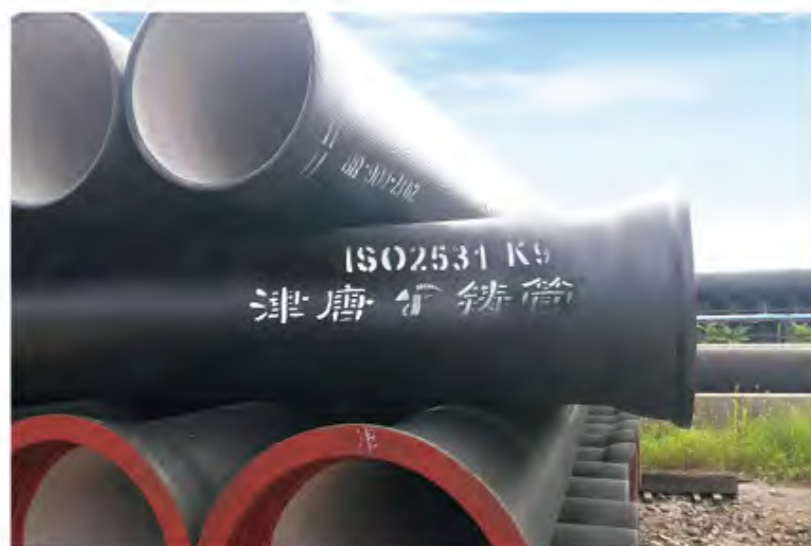
大口径安装示意图
Large caliber installation diagram

胶圈安装

Install the rubber ring

- 球墨铸铁管在安装“T”型橡胶圈前，先用钢丝刷清理承口内侧胶圈球头座及凸像座槽沟，表面应平整光滑，无任何机械杂质。然后在球头座处刷一层与胶圈不起反应的润滑剂（或肥皂剂）。
- 往承口内安装“T”型胶圈时，用右手将胶圈握成“凹”型，左手配合将胶圈硬凸缘牢固压入定位沟槽内，定位后再依次将胶圈压平展，紧固于承口内。
- 球墨铸铁管在安装“T”型橡胶圈时，为了便于安装，可以将胶圈两点握成“∞”型，这样就可以从两侧将凸缘先压入定位槽内，防止凸缘弹出定位沟槽。
- 球墨铸铁管的“T”型橡胶圈安装完毕后，在胶圈内表面刷一层润滑剂薄膜以利于插口的推入。
- 插口端头到插入深度标记这一段外皮清理后，也刷一层润滑剂，然后用合适的工具（撬棍、手拉葫芦等），将插口保持同心地插入承口座，直到第一条标记线消失为止。
- 球墨铸铁管的“T”型橡胶圈安装安毕后，应用特别的塞尺，沿四周控测一次间隙，以判断胶圈位置是否正确无误。
- 球墨铸铁管的“T”型胶圈低于0摄氏度气温将变硬，因此安装管道时，应事先将胶圈贮存在大于10摄氏度的室内。
- 球墨铸铁管及胶圈在运输过程中，防止日晒、雨淋，严禁锐器刺扎及油物质侵袭。
- 球墨铸铁管的胶圈应贮存于阴凉干燥处，勿扭折变形，防止损伤和污垢，避免阳光直接照晒。

- Before the “T” type rubber ring is installed at the ductile iron pipe, clean the rubber ring ball seat inside the socket and the convex seat groove with a wire brush to ensure a smooth surface without any mechanical impurities. Then brush a layer of lubricant (or soap) that does not react with the rubber ring at the ball seat.
- When the “T” type rubber ring is installed into the socket, hold the rubber ring into a “concave” shape with the right hand, press the hard flange of the rubber ring firmly into the positioning groove with the left hand, flatten the rubber ring after positioning, and fasten it in the socket.
- When the “T” rubber ring is installed at the ductile iron pipe, in order to facilitate the installation, the rubber ring can be held in a “∞” shape at two points, so that the flange can be first pressed into the positioning groove from two sides to prevent the flange from popping up the positioning groove.
- After the “T” rubber ring of the ductile iron pipe is installed, brush a layer of lubricant film on the inner surface of the rubber ring to facilitate the pushing of the spigot.
- After the outer surface from the spigot end to the insertion depth mark is cleaned, also brush a layer of lubricant, then use an appropriate tool (a crowbar, a chain hoist, etc.) to insert the spigot concentrically into the socket seat till the first marking line disappears.
- After the “T” rubber ring of the ductile iron pipe is installed, use a special feeler gauge to measure the clearance along four sides to judge whether the position of the rubber ring is correct.
- The “T” rubber ring of the ductile iron pipe will become hard at the temperature of less than 0°C . Therefore, when a pipe is installed, the rubber ring should be stored in a room of more than 10°C in advance.
- Ductile iron pipes and rubber rings are protected from sunlight and rain during transportation, and sharp puncturing and oil attack are prohibited.
- The rubber rings of the ductile iron pipes should be stored in a cool and dry place, should not be twisted or deformed to prevent damage and dirt, and should be protected from direct sunlight.



津唐铸管
管通天下

JINTANG DI PIPE
PIPE TO WORLD



涂层 Coating

聚氨酯 PU 球墨铸铁管的特点:
Characteristics of polyurethane (PU) ductile iron pipe:

01

耐油性能好, 是天然橡胶耐油性能的 15-20 倍;
Good oil resistance, 15-20 times the oil resistance of natural rubber;

02

耐磨性能好, 是天然橡胶耐磨性能的 30-50 倍;
Good wear resistance, 30-50 times the wear resistance of natural rubber;

03

耐老化性好, 是天然橡胶耐老化性能的 5 倍;
Good aging resistance, 5 times the aging resistance of natural rubber;

04

耐扯断强度是天然橡胶的 3 倍
3 times the breaking strength of natural rubber

05

具有高弹性、高伸长率、高强度;
High elasticity, high elongation, high strength;

06

阻尼性能好, 内壁光滑, 液体阻力小, 液压损失少;
Good damping performance, smooth inner wall, low liquid resistance, less hydraulic loss;

07

外观漂亮, 软管弯曲半径小, 无毒无味, 耐冲击, 耐疲劳, 轻便灵活, 其重量是橡胶软管的百分之三十至七十;
Attractive appearance, small bending radius of hose, no toxicity or odor, impact resistance, fatigue resistance, portability, 30 to 70 percent of the weight of a rubber hose;

08

阻燃性好, 无毒无味。耐冲击、耐疲劳, 安全可靠
Good flame retardancy, no toxicity or odor. Impact resistance, fatigue resistance, high safety and reliability



红色环氧漆的特性:
Characteristics of red epoxy paint:

环氧漆的组成: 本产品是由环氧树脂、防锈颜料、填料、增塑剂调配而成成分一, 固化剂为成分二。
Composition of epoxy paint: this product is composed of epoxy resin, anti-rust pigment, filler and plasticizer as ingredients 1 and curing agent as ingredient 2.

环氧漆的特性: 耐水、耐酸碱、防锈性能好。与钢铁、水泥面粘接力强。适用于钢铁设备、管道的耐水、耐油、耐化学试剂, 作防护打底之用, 也可作水泥底材的打底或底面合一防护之用。

Characteristics of epoxy paint: good resistance to water, acid, alkali and rust; strong adhesion to steel and cement; it is suitable for the water resistance, oil resistance and chemical resistance of steel equipment and pipelines as a protective primer, and can also be used as a primer for the cement substrate or for the protection of the bottom surface.

No.5

CONSTRUCTION CASE

施工案例

重点工程项目: Key project

承德市六沟镇工业聚集区输水管线项目
Water Pipeline Project in Industrial Cluster, Liugou Town, Chengde City

唐山市滦南县城市政工程项目
Urban Municipal Engineering Project in Luannan County, Tangshan City

抚顺市输配水管网改造工程
Water Transport and Distribution Pipe Network Reconstruction Project in Fushun City

阜平县东城区一、二期路网工程
First, Second Phase Road Network Project of Dongcheng District, Fuping County



No.6

ATTENTIONS OF TRANSPORTATION, STACKING AND LOADING

运输及堆放装车的注意事项

我公司有专业的物流人员负责货物运输工作，并与多家实力较强的运输企业有着多年业务关系。

DN80-DN250：通常是打捆包装

DN300-DN2600：通常是散装

运输过程中，通常使用木板、木条、钢丝绳、草绳、草垫对铸管进行绑扎固定，出口铸管可以通过散货船、集装箱运输，内销铸管可以通过汽运、火运以及船运。

Our company has professional logistics personnel responsible for goods transportation, and has many years of business relations with many powerful transportation companies.

DN80-DN250: usually bundled

DN300-DN2600: usually bulk

During transportation, cast pipes are usually tied and fixed with boards, battens, wire ropes, straw ropes and straw mats, exported cast pipes can be transported by bulk carriers and containers, and domestic cast pipes can be transported by trucks, trains and ships.

装车和堆放

Loading and stacking

- 球墨铸铁管在装车时，伸出车体外部分不得超过球墨铸铁管长度的四分之一。
- 球墨铸铁管在搬运和堆放过程中，应防止碰伤、变形和损坏。
- 存放球墨铸铁管的地面应平坦松软，硬地面应垫木块。
- 管架上每层球管应将承、插口相间平放，并用木块垫好，上下两层管方向垂直，打捆得要求符合工艺规定，逐捆检验。
- When ductile iron pipes are loaded, the parts outside the vehicle body shall not exceed one quarter of the length of the ductile iron pipes.
- Ductile iron pipes should be protected from bump, deformation and damage during carrying and stacking.
- The floor for storing ductile iron pipes should be flat and soft, and the hard floor should be padded with wood blocks.
- Each layer of ductile iron pipes on the pipe rack should be placed flat with alternating sockets and spigots and padded with wooden blocks, the upper and lower layers of pipes are oriented vertically, and the pipes should be bundled in accordance with process requirements and are checked bundle by bundle.

运输 Transportation

目测跟踪，陆路、海路及铁路运输，装车方式不能影响球铁管的质量，在运输过程中不能存在影响产品质量的因素或现象；每车、每批发货本厂库房监装；货到中转站（港口、火车站）进行全程监控。

For visual tracking, land, sea and rail transportation, the loading mode cannot affect the quality of ductile iron pipes, and there can be no factors or phenomena affecting product quality during transportation; every vehicle and every batch of products are supervised and loaded by our factory warehouse; the whole course is monitored as the products are delivered to the transfer stations (ports, train stations).

销售网络 SALES NETWORK



以本公司的优质铁水为原料,采用高炉—中频电炉双联工艺,产品质量稳定,外观精美,畅销东北、华北、华东等地,并出口到中东、欧美等国外市场。

The products made of our company's high-quality molten iron as the raw material by the blast furnace-medium frequency electric furnace double process are stable in quality and exquisite in appearance, and therefore, are sold well in Northeast China, North China, East China and other places, and exported to the Middle East, Europe and America and other foreign markets.

售后服务 AFTER-SALES SERVICE



自津唐铸管进入国内外市场以来，我们一直恪守质量过硬、客户满意的方针，始终坚持为客户服务、对客户负责、让客户满意的服务宗旨，在全国市场以及国外市场赢得广大客户的信赖和好评，我公司产品多年以来经多家地市级、县级自来水公司长期使用，一直零维护。为此，我们做出如下服务承诺：

Since Jintang cast pipes have entered the domestic and foreign markets, we have always adhered to the principle of high quality and customer satisfaction, and the service tenets of serving customers, being responsible to customers and satisfying customers. We have won the trust and praise of vast customers in the national and foreign markets. Our company's products have been used for many years by many municipal and county-level water supply companies, and are always zero-maintenance. To this end, we make the following service commitments:

售后服务 After-sales service

公司具有良好的售后服务体系和完善的售后制度，并已成立专门的售后服务团队，并可以到现场进行指导安装，对客户提出的意见给予及时的正面答复。

Our company has a good after-sales service system and a perfect after-sales system, and has set up a dedicated after-sales service team to guide installation on site and give timely and positive answers to the opinions put forward by customers.

技术服务 Technical service

采购方可派员到河北迁安市我公司生产基地进行技术交流，可随时到生产车间及检验室参观指导，我方将派专业技术人员进行接待和沟通技术疑问。在工地现场，根据采购方要求，我方可派出专职技术人员在现场提供技术指导服务。多年来，我们始终坚持在安装初期到现场与设计、施工、监理等各方技术人员进行沟通和交流，并在此基础上提出施工优化方案建议。安装过程中出现问题在接通知后及时赶至现场，及时提供技术支持并定期回访，在调试阶段，配合施工方调试运行并参与有关验收报告的签认。

多年来，我们发挥行业和技术优势，始终坚持为项目业主节省投资、提高工效尽最大努力。我们配合客户，经我方提供技术服务，即使是很多第一次使用球墨铸铁管的县市自来水公司及农村饮水安全工程，都是一次性打压试验成功、验收合格。

Purchasers can send personnel to the production base of our company in Qian'an City, Hebei Province for technical exchange, and can visit the production workshops and inspection rooms at any time. We will send professional and technical personnel to receive and communicate technical questions. At the construction site, we can send full-time technical personnel to provide technical guidance services on site according to the requirements of the purchasers. Over the years, we have always insisted on communication and exchange with the technical personnel of design, construction, supervision and other aspects on site in the initial stage of installation, and proposed the construction optimization plans on this basis. For the problems occurring during the installation process, we rushed to the site in time after receiving the notice to provide technical support and regular return visit. In the debugging phase, we cooperated with the construction party to debug the operation and participate in the signing of relevant acceptance reports.

Over the years, we have taken the advantages of the industry and technology, and always strive to save the investment and improve the efficiency of the project owners. We cooperate with customers and provide technical services. Even many urban water supply companies and rural drinking water safety projects that use our ductile iron pipes for the first time are successful in one-time bulge test, inspection and acceptance.

备品备件 Spare parts

公司各种型号管材及配件配有相对比例的库存，如有需要可随时发货。

Our company's various types of pipes and fittings are equipped with a relative proportion of stock, which can be delivered at any time if necessary.

服务响应时间 Service response time

7×24 小时全天服务，24 小时内到现场 7×24 hours all day service, 24 hours to the scene

承诺质保期 Committed warranty period

产品在正常安装和使用协议期内出现质量问题，我方负责免费更换并承担直接损失。

If any product has quality problems during the normal installation and the use agreement period, we are responsible for free replacement and direct loss.



专业·专注·专心
PROFESSION DEDICATION CONCENTRATION

迁安市津唐球墨铸管有限公司
Qian'an Jintang Ductile Iron Pipe Co., Ltd.

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