



给水用聚乙烯(PE)管道系统

POLYETHYLENE(PE) PIPINGS SYSTEMS FOR WATER SUPPLY

XINGHE GROUP



江苏星河集团有限公司

JIANGSU XINGHE GROUP LIMITED COMPANY

完善的检测手段

Perfect testing methods

我公司依据 GB/T 13663《给水用聚乙烯(PE)管材》、GB/T13663.2《给水用聚乙烯(PE)管道系统 第2部分:管件》以及其它国家标准和企业标准,对生产的聚乙烯、PE-RT 管材、管件进行检测。

我公司按照标准中的技术要求配备了所需的检测设备并进行试验,各项性能指标均符合标准的要求,在同行业中处于领先地位。

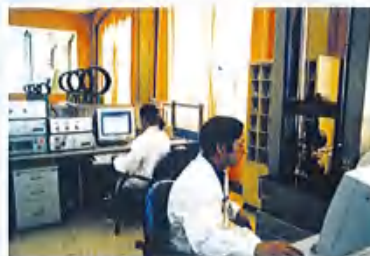
The company tests the produced PE, PE-RT pipes and fittings according to GB/T 13663<water supply PE pipes>, GB/T 13663.2<water supply PE piping system second part: Pipe Fitting> and some other national standards and company standards.

Our company equips the needed testing equipment and carries out tests according to standard technology, every property index can meet the standard requirement and takes a leading stand in the pipeline area.

主要检测设备

Testing Equipment

- ④ 静液压试验机
- ④ 氧化诱导时间测试仪
- ④ 电子万能试验机
- ④ 水份含量测定仪
- ④ 熔体流动速率测定仪
- ④ 简支梁冲击试验机
- ④ 落锤冲击试验机
- ④ 精密试验烘箱
- ④ Hydrostatic Strength Tester
- ④ Oxygen Induction Time Tester
- ④ Universal Electron Testing Machine
- ④ Moisture Content Tester
- ④ Melt Flow Rate Tester
- ④ Simplex Support Impact Tester
- ④ Hammer Dropping Impact Tester
- ④ Cycle Temperature-control Oven



聚乙烯管材

PE Pipes

◆真正的绿色建材,“星河”聚乙烯管道拥有无毒性,无结垢,不滋生细菌的健康品质,无毒无害,完全符合国家饮用水卫生指标的要求;

◆卓越的耐腐蚀性能——除少数强氧化剂外,可耐多种化学介质的侵蚀;无电化学腐蚀。

◆长久的使用寿命——在额定温度、压力状况下,PE 管道可安全使用 50 年以上。

◆较好的耐冲击性——PE 管韧性好,耐冲击强度高,重物直接压过管道,不会导致管道破裂。

◆可靠的连接性能——PE 管热熔或电熔接口的强度高于管材本体,接缝不会由于土壤移动或活载荷的作用断开。

◆良好的施工性能——管道质轻,焊接工艺简单,施工方便,工程综合造价低。

◆耐压性强,管内壁可承受较高的压力;

◆无环境污染之忧,且在生产使用过程中,能加以回收利用,控制了资源的浪费,属于节能环保产品;

◆磨损性能好,在输送矿砂泥浆时聚乙烯管的耐磨性是钢管的 4 倍以上;

• True green construction materials, "Xinghe" PE pipes are non-poisonous, no fouling, not breeding bacterium. They are healthy products that can meet the requirement of China drinking-water hygiene index.

• Good corrosion-resisting property: Except some strong oxidant, the products can resist the corrosion of several kinds of chemical medium, no electrochemistry corrosion.

• Long useful-life: Under the specified temperature and pressure, PE pipes can be used for more than 50 years.

• Good anti-impact property: PE pipes have good ductility and good anti-impact property. The pipes will not break after heavy objects press over them.

• Reliable connecting property: The strength of hot-melt nozzles of electro-fused nozzles are higher than the body of pipes, the nozzles will not break because of the movement of soil or moveable load.

• Good construction property: The mass is light, welding technique is simple, convenient construction and low overall price.

• Good anti-pressure property, the inner wall can stand high pressure.

• Not pollute the environment, materials can be recycled during the process of producing and use. They are environmental protection and energy conservation products.

• Good abrasability, the abrasability is more than 4 times than steel pipes when carrying ore-sand and mud.

物理技术性能指标:

Physical Technical Indicators

序号 No.	项 目 Item	要 求 Requirement
1	密度 Density(g/cm ³)	0.941-0.965
2	炭黑含量 ¹⁾ (质量)Carbon black content(Quality)%	2.5±0.5
3	炭黑分散 Carbon black dispersion ¹⁾	≤等级 Grade3
4	颜料分散 Pigment dispersion ²⁾	≤等级 Grade3
5	氧化诱导时间 Oxidation induction time(200℃)min	≥20
6	熔体流动速率 Melt flow rate ³⁾ (5kg, 190℃)10min	与产品标称值的偏差不应超过 The deviation to the normal value of the product can not exceed ±25%

注: 1 仅适用于黑色管材; 2 仅适用于蓝色管材; 3 仅适用于混配料。

Note: 1 only applicable for black pipes 2 only applicable for blue pipes 3 only applicable for mixed materials

聚乙烯管材

PE Pipes

规格(等级): PE100 级

PE 管材公称压力和规格尺寸

Grade PE100

Nominal Pressure and Specification of PE Pipes

公称尺寸 Nominal Size	SDR26		SDR21		SDR17		SDR13.6		SDR11	
	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight
20	-	-	-	-	-	-	-	-	-	-
25	-	-	-	-	-	-	-	-	-	-
32	-	-	-	-	-	-	-	-	3.0	0.3
40	-	-	-	-	-	-	-	-	3.7	0.47
50	-	-	-	-	-	-	-	-	4.6	0.72
63	-	-	-	-	-	-	4.7	0.94	5.8	1.12
75	-	-	-	-	4.5	1.08	5.6	1.32	6.8	1.57
90	-	-	4.3	1.26	5.4	1.56	6.7	1.90	8.2	2.27
110	4.2	1.53	5.3	1.88	6.6	2.31	8.1	2.81	10	3.37
125	4.8	1.98	6	2.42	7.4	2.97	9.2	3.60	11.4	4.40
140	5.4	2.59	6.7	3.06	8.3	3.72	10.3	4.53	12.7	5.47
160	6.2	3.26	7.7	3.99	9.5	4.87	11.8	5.92	14.6	7.0
180	6.9	4.08	8.6	5.00	10.7	6.17	13.3	7.49	16.4	9.02
200	7.7	5.05	9.6	6.22	11.9	7.58	14.7	9.01	18.2	11.14
225	8.6	6.32	10.8	7.88	13.4	9.64	16.6	11.68	20.5	14.10
250	9.6	7.87	11.9	9.62	14.8	11.52	18.4	14.37	22.7	17.38
280	10.7	9.84	13.4	12.17	16.6	14.79	20.6	18.05	25.4	21.76
315	12.1	12.50	15	14.9	18.7	18.74	23.2	22.85	28.6	27.60
355	13.6	15.81	16.9	19.33	21.1	23.84	26.1	28.99	32.2	35.01
400	15.3	19.47	19.1	24.66	23.7	30.17	29.4	36.77	36.3	44.46
450	17.2	25.24	21.52	31.16	26.7	38.23	33.1	46.61	40.9	56.34
500	19.1	31.17	23.9	38.52	29.7	47.26	36.8	57.55	45.4	69.50
560	21.4	39.06	26.7	48.25	33.2	59.18	41.2	72.19	50.8	87.14
630	24.1	49.55	30	60.93	37.4	74.95	46.3	91.26	57.2	110.40
710	27.2	61.00	33.9	75.10	42.1	92.11	52.2	112.3	-	-
800	30.6	77.30	38.1	95.20	47.4	116.8	58.8	142.5	-	-
900	34.4	97.68	42.9	121.0	53.3	147.8	-	-	-	-
1000	38.2	120.6	47.7	149.0	59.3	182.7	-	-	-	-
1200	45.9	173.1	57.2	213.5	-	-	-	-	-	-

物理技术性能指标:

Physical Technology Specification

序号 No.	项 目 Item	性能指标 Property Index
1	断裂伸长率% Breakage elongation rate%	≥350
2	纵向回缩率(110℃), % Longitudinal shrinkage rate(110℃), %	≤3
3	氧化诱导时间(200℃), min Oxidation induction time(200℃), min	≥20
4	20℃静液压强度试验(环向应力 12.4MPa, 100h) statistic hydraulic strength test(ring stress)	不破裂不渗漏 No broken or leakage
5	80℃静液压强度试验(环向应力 5.5MPa, 165h) statistic hydraulic strength test(ring stress)	不破裂不渗漏 No broken or leakage
6	80℃静液压强度试验(环向应力 5.0MPa, 1000h) statistic hydraulic strength test(ring stress)	不破裂不渗漏 No broken or leakage
7	耐候性 ¹⁾ (管材累计接受 ≥3.5GJ/m ² 老化能量后) Weatherability (After the pipes have absorbed accumulated the aging of ≥3.5GJ/m ²)	80℃静液压强度试验 statistic hydraulic strength test(ring stress)(165h) 不破裂不渗漏 No broken or leakage
	断裂伸长率 Breakage elongation rate%	≥350
	氧化诱导时间 Oxidation induction time(200℃), min	≥10

1)仅适用于蓝色管材 1)only for blue pipes

聚乙烯管材

PE Pipes

规格(等级): PE80 级

PE 管材公称压力和规格尺寸

Grade PE80

Nominal Pressure and Specification of PE Pipes

公称尺寸 Nominal Size	SDR33		SDR21		SDR17		SDR13.6		SDR11	
	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight	壁厚 Wall Thickness	重量 Weight
20	-	-	-	-	-	-	-	-	-	-
25	-	-	-	-	-	-	-	-	2.3	0.19
32	-	-	-	-	-	-	-	-	2.9	0.30
40	-	-	-	-	-	-	-	-	3.7	0.47
50	-	-	-	-	-	-	-	-	4.6	0.72
63	-	-	-	-	-	-	4.7	0.94	5.8	1.12
75	-	-	-	-	4.5	1.08	5.6	1.32	6.8	1.57
90	-	-	4.3	1.26	5.4	1.56	6.7	1.90	8.2	2.27
110	-	-	5.3	1.88	6.6	2.31	8.1	2.81	10.00	3.37
125	-	-	6.0	2.42	7.4	2.97	9.2	3.60	11.4	4.40
140	4.3	2.00	6.7	3.06	8.3	3.72	10.3	4.53	12.7	5.47
160	4.9	2.61	7.7	4.00	9.5	4.87	11.8	5.92	14.6	7.00
180	5.5	3.29	8.6	5.00	10.7	6.17	13.3	7.49	16.4	9.02
200	6.2	4.11	9.6	6.22	11.9	7.58	14.7	9.01	18.2	11.14
225	6.9	5.15	10.8	7.88	13.4	9.64	16.6	11.68	20.5	14.10
250	7.7	6.37	11.9	9.62	14.8	11.52	18.4	14.37	22.7	17.38
280	8.6	7.39	13.4	12.17	16.6	14.80	20.6	18.05	25.4	21.76
315	9.7	10.10	15.0	14.90	18.7	18.74	23.2	22.85	28.6	27.60
355	10.9	12.80	16.9	17.33	21.1	23.84	26.1	29.00	32.2	35.01
400	12.3	16.26	19.1	24.66	23.7	30.17	29.4	36.77	36.3	44.46
450	13.8	20.49	21.5	31.16	26.7	38.24	33.1	46.61	40.9	56.34
500	15.3	24.55	23.9	38.52	29.7	47.26	36.8	57.55	45.4	69.50
560	17.2	31.70	26.7	48.25	33.2	59.18	41.2	72.20	50.8	87.14
630	19.3	40.00	30.0	60.93	37.4	74.95	46.3	91.26	57.2	110.40
710	21.8	49.24	33.9	75.11	42.1	92.11	52.2	112.3	-	-
800	24.5	62.32	38.1	95.20	47.4	116.8	58.8	142.5	-	-
900	27.6	79.1	42.9	120.5	53.3	147.8	-	-	-	-
1000	30.6	97.45	47.7	149.0	59.3	182.7	-	-	-	-
1200	36.7	139.7	57.2	213.5	-	-	-	-	-	-

物理技术性能指标:

Physical Technological Specification

序号 No.	项 目 Item	要 求 Requirement
1	断裂伸长率% Breakage elongation rat%	≥ 350
2	纵向回缩率(110℃), % Longitudinal shrinkage rate(110℃), %	≤ 3
3	氧化诱导时间(200℃), min Oxidation induction time(200℃), min	≥ 20
4	20℃静液压强度试验(环向应力 9.0MPa, 100h) Statistic hydraulic strength test(ring stress)	不破裂不渗漏 No broken or leakage
5	80℃静液压强度试验(环向应力 4.5MPa, 165h) Statistic hydraulic strength test(ring stress)	不破裂不渗漏 No broken or leakage
6	80℃静液压强度试验(环向应力 4.0MPa, 1000h) Statistic hydraulic strength test(ring stress)	不破裂不渗漏 No broken or leakage
7	耐候性 ¹⁾ (管材累计接受 ≥ 3.5GJ/m ² 老化能量后)	80℃静液压强度试验(165h) Statistic hydraulic strength test(ring stress)
	Weatherability (After the pipes have absorbed accumulated the aging of ≥ 3.5GJ/m ²)	断裂伸长率% Breakage elongation rat
		氧化诱导时间(200℃), min Oxidation induction time
		≥ 350
		≥ 10

1)仅适用于蓝色管材 only for blue pipes

给水用聚乙烯管件

PE Pipe Fitting

江苏星河集团公司生产的给水用聚乙烯管件产品经国家化学建筑材料测试中心检测,符合 GB/T 13663.2-2005《给水用聚乙烯(PE)管道系统 第2部分:管件》国家标准,管件原料采用与管材同一种的原料生产,管件主体任一点的壁厚应符合下表规定要求:

Our water supply PE pipe fitting comply with GB/T13663.2-2005<Water supply PE piping system second part: pipe fitting> national standard. The fittings are produced with the same material as the pipes. Wall thickness on any point of the body of the fitting complies with the specified requirements of the following table.

壁厚 Wall Thickness 原材料 Raw Material	管材 e_n Pipe	管件 E Pipe Fitting	相互关系 Mutual Relation	备注 Remark
管材	PE80	PE100	$E \geq 0.8e_n$	
管件原料	PE100	PE80	$E \geq 1.25e_n$	
Raw Materials of Pipe&Fitting	PE100	PE100	$E \geq 1.05e_n$	

注: e_n 为管材最小壁厚

emin Note: e_n means the minimum wall thickness emin

管件按连接方式分:

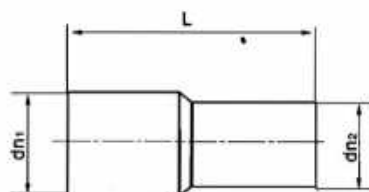
According to pipe fitting connection, pipe fittings can be divided into:



热熔注塑异径

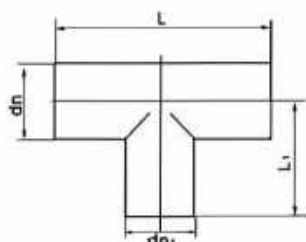
HOT-MELT PLASTIC INJECTION REDUCER

公称直径 Nominal Diameter $dn_1 \times dn_2$	L	产品代码 Product Code
110 × 40	245	
110 × 50	245	
110 × 63	105	
110 × 75	130	
110 × 90	130	
125 × 50	195	
125 × 63	100	
125 × 75	195	
125 × 90	100	
125 × 110	100	
160 × 63	120	
160 × 75	220	
160 × 90	120	
160 × 110	130	
160 × 125	220	
200 × 63	265	
200 × 75	265	
200 × 90	265	
200 × 110	175	
200 × 125	265	
250 × 160	265	
250 × 63	285	
250 × 75	285	
250 × 90	285	
250 × 110	285	
250 × 125	285	
250 × 160	175	
250 × 200	295	
315 × 250	225	
315 × 200	295	
315 × 160	225	
355 × 315	335	



热熔注塑三通

HOT-MELT PLASTIC INJECTION REDUCER

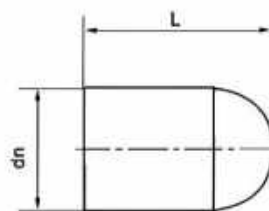


公称直径 Nominal Diameter $dn \times dn_2 \times dn$	L	L	产品代码 Product Code
50 × 50 × 50	220	110	
63 × 63 × 63	234	117	
90 × 90 × 90	300	150	
110 × 110 × 110	300	150	
125 × 125 × 25	350	175	
160 × 160 × 60	426	213	
200 × 200 × 200	470	235	
250 × 250 × 250	556	278	
315 × 315 × 315	670	335	
355 × 355 × 355	764	382	
400 × 400 × 400	860	430	

热熔注塑管帽

THOT-MELT PLASTIC INJECTION PIPE CAP

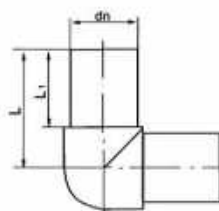
公称直径 Nominal Diameter dn	L	产品代码 Product Code
32	61	
40	66	
50	75	
63	85	
75	105	
90	115	
110	140	
125	137	
160	162	
200	186	
250	193	
315	230	
355	240	
400	250	



热熔注塑 90° 弯头

90° DEGREE ELBOW PIPE OF HOT-MELT PLASTIC INJECTION

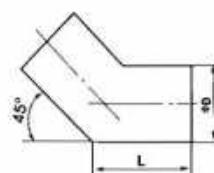
公称直径 Nominal Diameter dn	L	L1	产品代码 Product Code
32	71	50	
40	81.5	55	
50	93	60	
63	106	65	
75	122	75	
90	133	77	
110	157	85	
160	203	90	
220	268	130	
250	291	130	
315	346	150	
355	382	175	
400	430	200	



热熔注塑 45° 弯头

45° DEGREE ELBOW PIPE OF HOT-MELT PLASTIC INJECTION

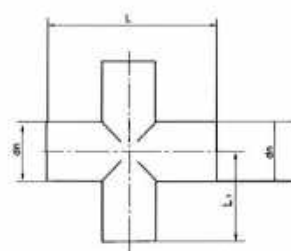
公称直径 Nominal Diameter dn	L	产品代码 Product Code
110	260	
125	275	
160	310	
200	350	
250	400	
315	465	



热熔注塑四通

HOT-MELT PLASTIC INJECTION TEE-JOINT

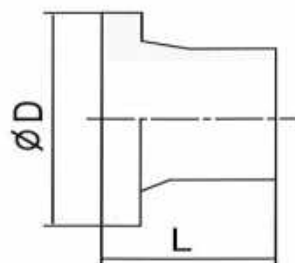
公称直径 Nominal Diameter dn	L	L ₁	产品代码 Product Code
50	220	110	
63	234	117	
90	300	150	
110	300	150	
125	350	175	
160	426	213	
200	470	235	
250	556	278	
315	670	335	
355	764	382	
400	860	430	



松套法兰(突缘接头)

PLASTIC COATING CORROSIVE-RESISTANT STEEL FLANGE PIECE

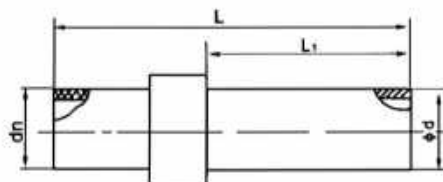
公称直径 Nominal Diameter dn	ΦD	L	产品代码 Product Code
63	102	80	
90	138	80	
110	158	85	
160	213	100	
200	268	120	
250	320	120	
315	370	120	
355	430	150	
400	482	150	
450	538	180	
500	585	180	
560	691	200	
630	691	200	



直管式钢塑接头

SEAMLESS STRAIGHT-PIPE STEEL-PLASTIC JOINT

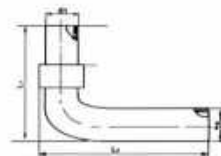
公称直径 Nominal Diameter PEdn × Φd(钢)	L	L ₁	产品代码 Product Code
25 × 27	395	230	
32 × 34	410	230	
40 × 42	410	230	
50 × 48	410	230	
63 × 60	410	230	
90 × 89	410	210	
110 × 108	410	210	
160 × 159	640	350	
200 × 203	730	400	
250 × 248	820	430	
315 × 299	830	450	



弯管式钢塑接头(90°)

SEAMLESS CURVED PIPE STEEL-PLASTIC JOINT (90 DEGREE)

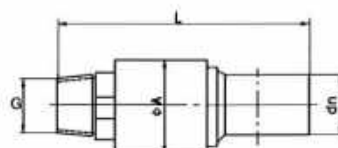
公称直径 Nominal Diameter dn × Φd	L ₁	L ₂	产品代码 Product Code
32 × 34	400	800	
40 × 42	380	920	
50 × 48	440	800	
63 × 60	500	880	



丝扣式钢塑接头(外螺纹)

BUTTON-BY-PE STEEL-PLASTIC JOINT OF NODULAR CAST IRON

公称直径 Nominal Diameter dn × Φd	ΦA	L	产品代码 Product Code
32 × 1"	55	180	
40 × 1 1/4"	65	185	
50 × 1 1/2"	75	185	
63 × 2"	88	195	



注:按用户要求可生产成内螺纹型式(定货时请说明)。

热熔焊制三通

TEE



公称直径 dn Nominal Diameter	产品代号 Product Code	公称直径 dn Nominal Diameter	产品代号 Product Code
180		500	
200		560	
225		630	
250		710	
315		800	
355		900	
400		1000	
450		1200	

热熔对焊管件(焊制管件)

星河热熔对焊焊制管件主要是大口径三通、弯头等。管件是用多角焊机将管材进行焊接在工厂加工成型。
工作压力满足管网的压力要求。
焊缝强度高于母材强度。
使用安全、可靠。
在管网的连接中既可以电熔焊又可以对接焊连接。

热熔焊制 22.5 度弯头

22.5 Deg Bend



公称直径 dn Nominal Diameter	产品代号 Product Code	公称直径 dn Nominal Diameter	产品代号 Product Code
180		500	
200		560	
225		630	
250		710	
315		800	
355		900	
400		1000	
450		1200	

Fabricated Fitting Series

Xinghe fabricated fittings are mostly larger diameter tees, elbows, etc.

The fittings are fabricated by butt welding in factory.

Working pressure can satisfy the requirement of the distribution network.

The strength at the welding joint is higher than the strength of pipe itself.

Safe and reliable.

The fittings can be welded by either electrofusion welding or butt welding in the connection of distribution network.

热熔焊制 45 度弯头

45 Deg Bend



公称直径 dn Nominal Diameter	产品代号 Product Code	公称直径 dn Nominal Diameter	产品代号 Product Code
180		500	
200		560	
225		630	
250		710	
315		800	
355		900	
400		1000	
450		1200	

热熔焊制 90 度弯头

90 Deg Bend



公称直径 dn Nominal Diameter	产品代号 Product Code	公称直径 dn Nominal Diameter	产品代号 Product Code
180		500	
200		560	
225		630	
250		710	
315		800	
355		900	
400		1000	
450		1200	

注:其它角度的对接管件可根据用户的特殊要求定制,具体事项请与本公司技术部门联系。

Note: Any angle required can be manufactured. Please contact the sales responsible for further information.



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