



深圳市诚锦鹏实业有限公司
SHENZHEN CHENGJINPENG INDUSTRIAL CO., LTD

无损检测报告

NONDESTRUCTIVE TESTING REPORT

工程名称 Project Name: HYSY115FPSO 气量超限改造工程

管道电仪保温类改造人员机具服务

HYSY115FPSO Gas Excess Reform Project Pipeline Electrical Instrument

Thermal Insulation Retrofit Personnel and Machinery Services

委托单位 Commission Unit : 深圳市海基实业有限公司

委托单位地址 Client Address: 深圳市南山区南海大道新能源大厦 A 座 11B10 室

工程编号 Project No. : CJP-WR-094-030-19-052

检测方法 Inspection Method : MT

报告编号 Report No. : CJP-WR-094-030-MT001-19-052

页数 Number of pages : 共 12 页

报告日期 Report Date : 2019.09.24

批准人 Approved by : [Signature]



检测单位: 深圳市诚锦鹏实业有限公司

CONTRACTOR: SHENZHEN CHENGJINPENG INDUSTRIAL CO.,LTD

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深圳市诚锦鹏实业有限公司
SHENZHEN CHENGJINPENG INDUSTRIAL CO.,LTD

磁粉检测报告
MAGNETIC PARTICLE INSPECTION REPORT

项目名称: HYSY115FPSO气量超限改造工程管道电仪保温类改造人员机具服务

报告日期

报告编号

Project Name:HYSY115FPSO Gas Excess Reform Project Pipeline Electrical Instrument Thermal Insulation Retrofit Personnel and Machinery Services

Report Date: 2019.09.24

Report No.:CJP-WR-094-030-MT001-19-052

检测地点 Testing Position	HYSY115	执行标准 Executive Standard	API-1104	仪器型号 Instrument Type	ZCM-AD22012	提升力 Lifting Power	≥45N		
检测比例 Testing Rate	100%	合格级别 Acceptance Grade	--	仪器编号 Instrument No.	CJP-CF-20	磁粉 Magnetic Particle	MT-BW		
图纸号 Drawing No.	--	表面状态 Surface Condition	Smooth	磁轭类型 Yoke Type	AC-Yoke	反差剂 Contrast Agent	FA-5		
工件材质 Workpiece Material	A106	灵敏度试块 Sensitivity block	A1(30/100)	磁化方法 Magnetizing Method	Successive	磁化时间 Magnetizing Time	1`3s		
工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态 HTS	坡口形式 Groove Form	焊接方法 Welding Process	焊缝长度 W.L(mm)	缺陷编号 Defect No.	缺陷性质及大小 DNS	评定意见 Judge
2"-DC-66255-A2BZ-HT45	W011	23	--	V	GTAW	188	--	--	Acc
2"-DC-66255-A2BZ-HT45	W011	23A	--	V	GTAW	188	--	--	Acc
2"-DC-66255-A2BZ-HT45	W011	23B	--	V	GTAW	188	--	--	Acc
2"-DC-66255-A2BZ-HT45	W011	24	--	V	GTAW	188	--	--	Acc
2"-DC-66255-A2BZ-HT45	W011	26	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	27	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	28A	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	28B	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	28C	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	28D	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	29	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	29A	--	V	GTAW	188	--	--	Acc
备注:热处理状态(HTS--Heat Treatment State) Notes:缺陷性质及大小 (DNS--Defect Nature and Size)				未熔合 (LOF--Lack of Fusion) 未焊透 (LOP--Lack of Penetration) 夹渣 (S.I--Slag Inclusion) 裂纹 (C--Crack) 气孔 (P--Porosity) 合格 (Acc--Acceptance) 不合格 (Rej-Rejection)					
签字 Signature		检验员 (Inspector)		技术监督 (Tech. Supervisor)		签字授权人 (Authorized Signee)			
日期 Date		2019.09.24		2019.09.24		2019.09.24			



深圳市诚锦鹏实业有限公司
SHENZHEN CHENGJINPENG INDUSTRIAL CO.,LTD

磁粉检测报告 (续表)
MAGNETIC PARTICLE INSPECTION REPORT

项目名称: HYSY115FPSO 气量超限改造工程管道电仪保温类改造人员机具服务

报告日期

报告编号

Project Name: HYSY115FPSO Gas Excess Reform Project Pipeline Electrical
Instrument Thermal Insulation Retrofit Personnel and Machinery Services

Report Date: 2019.09.24

Report No.: CJP-WR-094-030-MT001-19-052

工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态 HTS	坡口形式 Groove Form	焊接方法 Welding Process	焊缝长度 W.L. (mm)	缺陷编号 Defect No.	缺陷性质及大小 DNS	评定意见 Judge
2"-FD-32094-A2BZ	W078	29B	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	31	--	V	GTAW	188	--	--	Acc
2"-FD-32094-A2BZ	W078	35A	--	V	GTAW	188	--	--	Acc
2"-WF-42094-A2BZ	W011	46	--	V	GTAW	188	--	--	Acc
2"-WF-42094-A2BZ	W011	46B	--	V	GTAW	188	--	--	Acc
2"-WF-42094-A2BZ	W011	48	--	V	GTAW	188	--	--	Acc
2"-WF-42094-A2BZ	W011	48A	--	V	GTAW	188	--	--	Acc
2"-WF-42094-A2BZ	W011	51	--	V	GTAW	188	--	--	Acc
2"-WF-42094-A2BZ	W011	52	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	53B	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	54C	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	55	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	56	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	57	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	57A	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	58	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	59B	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	59D	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	61	--	V	GTAW	188	--	--	Acc
2"-CR-70155-A2BZ-HT45	W036	61A	--	V	GTAW	188	--	--	Acc

备注: 热处理状态 (HTS--Heat Treatment State)

Notes: 缺陷性质及大小 (DNS--Defect Nature and Size)

未熔合 (LOF--Lack of Fusion) 未焊透 (LOP--Lack of Penetration) 夹渣 (S.I--Slag Inclusion)
裂纹 (C--Crack) 气孔 (P--Porosity) 合格 (Acc--Acceptance) 不合格 (Rej--Rejection)

签字 Sign	检验员 (Inspector) Li Le	技术监督 (Tech. Supervisor) Tang Xuezu	签字授权人 (Authorized Signee) Zhang
日期 Date	2019.09.24	2019.09.24	2019.09.24



磁粉检测报告 (续表)

MAGNETIC PARTICLE INSPECTION REPORT

项目名称: HYSY115FPSO 气量超限改造工程管道电仪保温类改造人员机具服务

报告日期

报告编号

Project Name: HYSY115FPSO Gas Excess Reform Project Pipeline Electrical
Instrument Thermal Insulation Retrofit Personnel and Machinery Services

Report Date: 2019.09.24

Report No.: CJP-WR-094-030-MT001-19-052

工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态 HTS	坡口形式 Groove Form	焊接方法 Welding Process	焊缝长度 W. L (mm)	缺陷编号 Defect No.	缺陷性质及大小 DNS	评定意见 Judge
2"-N2-38049-A2BZ	W036	68	---	V	GTAW	188	---	---	Acc
2"-N2-38049-A2BZ	W036	70	---	V	GTAW	188	---	---	Acc
2"-N2-38049-A2BZ	W036	70A	---	V	GTAW	188	---	---	Acc
2"-N2-38049-A2BZ	W036	70B	---	V	GTAW	188	---	---	Acc
2"-N2-38049-A2BZ	W036	72	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	83	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	83A	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	83B	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	83C	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	84	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	85A	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	86	---	V	GTAW	188	---	---	Acc
2"-CR-70257-A2BZ-HT45	W078	86C	---	V	GTAW	188	---	---	Acc
2"-CR-70156-A2BZ-HT45	W036	90	---	V	GTAW	188	---	---	Acc
2"-CR-70156-A2BZ-HT45	W036	91A	---	V	GTAW	188	---	---	Acc
2"-CR-70156-A2BZ-HT45	W036	92	---	V	GTAW	188	---	---	Acc
2"-CR-70156-A2BZ-HT45	W036	93	---	V	GTAW	188	---	---	Acc
2"-CR-70156-A2BZ-HT45	W036	93A	---	V	GTAW	188	---	---	Acc
2"-CR-70156-A2BZ-HT45	W036	95	---	V	GTAW	188	---	---	Acc
2"-CR-70156-A2BZ-HT45	W036	97	---	V	GTAW	188	---	---	Acc

备注: 热处理状态 (HTS--Heat Treatment State)

Notes: 缺陷性质及大小 (DNS--Defect Nature and Size)

未熔合 (LOF--Lack of Fusion) 未焊透 (LOP--Lack of Penetration) 夹渣 (S.I--Slag Inclusion)

裂纹 (C--Crack) 气孔 (P--Porosity) 合格 (Acc--Acceptance) 不合格 (Rej--Rejection)

签字 Sign	检验员 (Inspector) Li Le	技术监督 (Tech. Supervisor) Tang Yuzhu	签字授权人 (Authorized Signee) 2019.09.24
日期 Date	2019.09.24	2019.09.24	2019.09.24



MAGNETIC PARTICLE INSPECTION REPORT

报告编号

Report No. :CJP-WR-094-030-MT001-19-052

Form No:CJP/WR.MT02 Rev:E/0

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-030-MT001-19-052



23



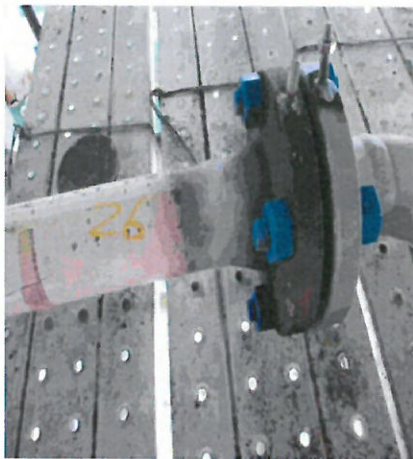
23A



23B



24



26



27



28A



28B



28C

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

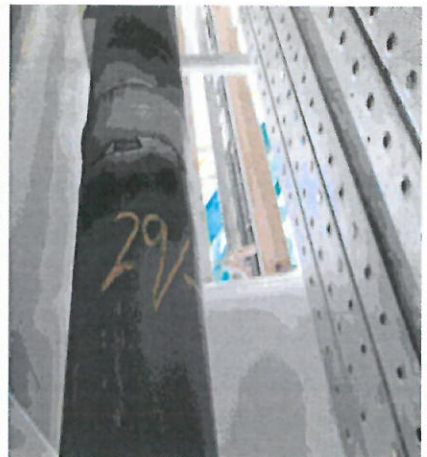
Report No: CJP-WR-094-030-MT001-19-052



28D



29



29A



29B



31



46



46B



48



48A

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-030-MT001-19-052



51



52



53B



54C



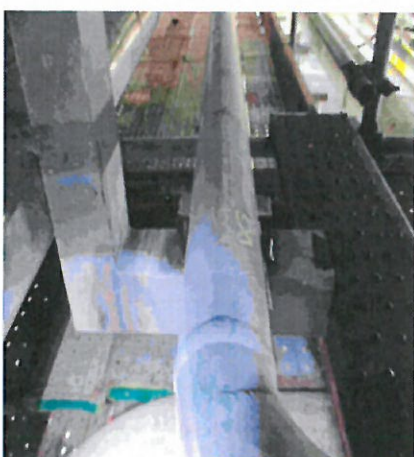
55



56/57



57A



58



59B

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-030-MT001-19-052



59D



61



61A



68



70



70A



70B



83



83A/83B/83C

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-030-MT001-19-052



84



85A



86



86C



90



91A



92



93



93A

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-030-MT001-19-052



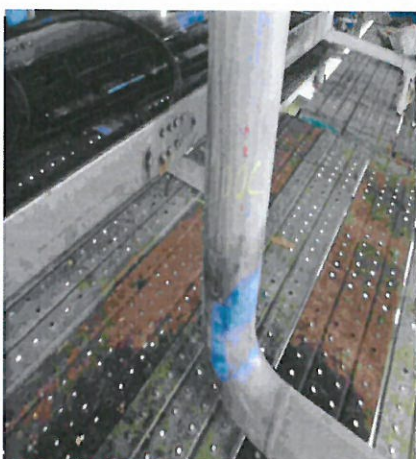
95



97



100/100A



100C



100D



40A



35A



备注

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Contractor: Shenzhen Chengjinpeng Industrial Co.,LTD

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