



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 : RT

报告编号 Report No. : CJP-WR-094-030-RT001-19-052

页数 Number of pages : 共 7 页

报告日期 Report Date : 2019.09.23

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

地 址: 深圳市南山区月亮湾大道 2076 号高科大厦六层 C3

ADDRESS: C3F6, GAOKE BUILDING, NO.2076, YUELIANGWAN BLVD, NANSHAN DISTRICT, SHENZHEN

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射线检测报告

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

报告日期

报告编号

Report Date: 2019.09.23

Report No.

CJP-WR-094-030-RT001-19-052

检测地点 Test Position	HYSY115		放射源 Source	X射线机		底片黑度 Film Density	2.0~4.0		显影温度 Developing Temperature	20℃	
图纸号 Drawing No.	---		焦点尺寸 Focus Size	2×2		X-管电压 X-Tube Voltage	190/180/270Kv		显影时间 Developing Time	5min	
执行标准 Executive Standard	API-1104		增感方式 Intensifying Screen	Pb(0.1×2)mm		X-管电流(源强) X-Tube Current(Activity)	5mA		定影温度 Fixing Temperature	20℃	
工件材质 Material	A106		焦距 SFD	500mm		像质计 IQI	Fe10-16		定影时间 Fixing Time	15min	
检测比例 Testing Rate	10%		胶片类性 Film Type	AGFA-C7		曝光时间 Exposure Time	1/0.8/1.5min		透照方法 Exposure Technique	DWSI/DWDI	

序号 No.	工件号 Workpiece No.	焊缝号 Weld No.	焊工号 Welder No.	底片编号 Film No.	焊接方法 Welding Process	焊缝长度 W. L(mm)	直径/厚度 Dia/THK (mm)	缺陷情况 Defect Condition(mm)	意见 Judge		返修次数 Repair Times	返修报告 Repair Report No.
									级别 Grade	结果 Result		
1	2"-DC-66255-A2BZ-HT45	23	W011	A	GTAW	188	Φ60×5.5	--	--	Acc	--	--
2	2"-DC-66255-A2BZ-HT45	23	W011	B	GTAW	188	Φ60×5.5	--	--	Acc	--	--
3	2"-DC-66255-A2BZ-HT45	23	W011	C	GTAW	188	Φ60×5.5	--	--	Acc	--	--
4	2"-FD-32094-A2BZ	35A	W078	A	GTAW	188	Φ60×5.5	--	--	Acc	--	--
5	2"-FD-32094-A2BZ	35A	W078	B	GTAW	188	Φ60×5.5	--	--	Acc	--	--
6	2"-FD-32094-A2BZ	35A	W078	C	GTAW	188	Φ60×5.5	--	--	Acc	--	--
7	2"-WF-42094-A2BZ	48	W011	A	GTAW	188	Φ60×5.5	PΦ1×1	--	Acc	--	--
8	2"-WF-42094-A2BZ	48	W011	B	GTAW	188	Φ60×5.5	--	--	Acc	--	--
8	2"-WF-42094-A2BZ	48	W011	C	GTAW	188	Φ60×5.5	--	--	Acc	--	--
10	2"-CR-70155-A2BZ-HT45	53A	W036	A	GTAW	188	Φ60×5.5	--	--	Acc	--	--
11	2"-CR-70155-A2BZ-HT45	53A	W036	B	GTAW	188	Φ60×5.5	--	--	Acc	--	--

注(Notes): 未熔合(LOF-Lack of Fusion) 根部凹陷(RC-Root Concavity) 裂纹(C-Crack) 气孔(P-Porosity) 夹渣(S.I-Slag Inclusion)
未焊透(LOP-Lack of Penetration) 咬边(UC-Undercut) 无记录缺陷(N.S.D-No Recordable Defect) 合格(Acc-Acceptance) 不合格(Rej-Rejection)

签字 Signature	检验员(Inspector) Li Le	技术监督(Tech. Supervisor) Tang Yuzun	签字授权人(Authorized Signee) Tang Yuzun
日期 Date	2019.09.23	2019.09.23	2019.09.23



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

射线检测报告 (续表)

RADIOGRAPHIC 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: 2019.09.23

Report No. CJP-WR-094-030-RT001-19-052

序号 No.	工件号 Workpiece No.	焊缝号 Weld No.	焊工号 Welder No.	底片编号 Film No.	焊接方法 Welding Process	焊缝长度 W. L (mm)	直径/厚度 Dia/THK (mm)	缺陷情况 Defect Condition (mm)	意见 Judge		返修次数 Repair Times	返修报告 Repair Report No.
									级别 Grade	结果 Result		
12	2"-CR-70155-A2BZ-HT45	53A	W036	C	GTAW	188	Φ60×5.5	---	---	Acc	---	---
13	2"-CR-70155-A2BZ-HT45	53B	W036	A	GTAW	188	Φ60×5.5	弧坑裂纹1mm	---	Acc	---	---
14	2"-CR-70155-A2BZ-HT45	53B	W036	B	GTAW	188	Φ60×5.5	---	---	Acc	---	---
15	2"-CR-70155-A2BZ-HT45	53B	W036	C	GTAW	188	Φ60×5.5	---	---	Acc	---	---
16	2"-N2-38049-A2BZ	70B	W011	A	GTAW	188	Φ60×5.5	---	---	Acc	---	---
17	2"-N2-38049-A2BZ	70B	W011	B	GTAW	188	Φ60×5.5	---	---	Acc	---	---
18	2"-N2-38049-A2BZ	70B	W011	C	GTAW	188	Φ60×5.5	---	---	Acc	---	---
19	2"-N2-38049-A2BZ	72	W011	A	GTAW	188	Φ60×5.5	---	---	Acc	---	---
20	2"-N2-38049-A2BZ	72	W011	B	GTAW	188	Φ60×5.5	---	---	Acc	---	---
21	2"-N2-38049-A2BZ	72	W011	C	GTAW	188	Φ60×5.5	---	---	Acc	---	---
22	2"-CR-70257-A2BZ-HT45	84	W078	A	GTAW	188	Φ60×5.5	---	---	Acc	---	---
23	2"-CR-70257-A2BZ-HT45	84	W078	B	GTAW	188	Φ60×5.5	---	---	Acc	---	---
24	2"-CR-70257-A2BZ-HT45	84	W078	C	GTAW	188	Φ60×5.5	---	---	Acc	---	---
25	2"-CR-70156-A2BZ-HT45	90	W036	A	GTAW	188	Φ60×5.5	---	---	Acc	---	---
26	2"-CR-70156-A2BZ-HT45	90	W036	B	GTAW	188	Φ60×5.5	---	---	Acc	---	---
27	2"-CR-70156-A2BZ-HT45	90	W036	C	GTAW	188	Φ60×5.5	---	---	Acc	---	---
28	4"-FL-34308-A2BZ-P	40A	W078	0-1	GTAW	358	Φ114×6	---	---	Acc	---	---
29	4"-FL-34308-A2BZ-P	40A	W078	1-2	GTAW	358	Φ114×6	---	---	Acc	---	---
30	4"-FL-34308-A2BZ-P	40A	W078	2-3	GTAW	358	Φ114×6	---	---	Acc	---	---
31	4"-FL-34308-A2BZ-P	40A	W078	3-4	GTAW	358	Φ114×6	PΦ1×1	---	Acc	---	---

注(Notes): 未熔合(LOF-Lack of Fusion) 根部凹陷(RC-Root Concavity) 裂纹(C-Crack) 气孔(P-Porosity) 夹渣(S. I -Slag Inclusion)
未焊透(LOP-Lack of Penetration) 咬边(UC-Undercut) 无记录缺陷(N. S. D-No Recordable Defect) 合格(Acc-Acceptance) 不合格(Rej-Rejection)

签字 Signature	检验员(Inspector) Li Le	技术监督(Tech. Supervisor) Tang Yuesu	签字授权人(Authorized Signee) Tang Yuesu
日期 Date	2019.09.23	2019.09.23	2019.09.23

射线检测报告 (续表)

RADIOGRAPHIC 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. 23

Report No.

CJP-WR-094-030-RT001-19-052

序号 No.	工件号 Workpiece No.	焊缝号 Weld No.	焊工号 Welder No.	底片编号 Film No.	焊接方法 Welding Process	焊缝长度 W.L(mm)	直径/厚度 Dia/THK (mm)	缺陷情况 Defect Condition(mm)	意见 Judge		返修次数 Repair Times	返修报告 Repair Report No.
									级别 Grade	结果 Result		
32	4"-FL-34308-A2BZ-P	40A	W078	4-0	GTAW	358	Φ114×6	--	--	Acc	--	--
33	16"-CR-20005-A2BZ-HT45	186	HJ13006	0-1	GTAW	1275	Φ406×12.7	P Φ1×4	--	Acc	--	--
34	16"-CR-20005-A2BZ-HT45	186	HJ13006	1-2	GTAW	1275	Φ406×12.7	--	--	Acc	--	--
35	16"-CR-20005-A2BZ-HT45	186	HJ13006	2-3	GTAW	1275	Φ406×12.7	--	--	Acc	--	--
36	16"-CR-20005-A2BZ-HT45	186	HJ13006	3-4	GTAW	1275	Φ406×12.7	--	--	Acc	--	--
37	16"-CR-20005-A2BZ-HT45	186	HJ13006	4-5	GTAW	1275	Φ406×12.7	P Φ2×2	--	Acc	--	--
38	16"-CR-20005-A2BZ-HT45	186	HJ13006	5-0	GTAW	1275	Φ406×12.7	--	--	Acc	--	--
39	16"-CR-20005-A2BZ-HT45	188A	HJ13006	0-1	GTAW	1275	Φ406×12.7	P Φ1×1	--	Acc	--	--
40	16"-CR-20005-A2BZ-HT45	188A	HJ13006	1-2	GTAW	1275	Φ406×12.7	P Φ1×1	--	Acc	--	--
41	16"-CR-20005-A2BZ-HT45	188A	HJ13006	2-3	GTAW	1275	Φ406×12.7	--	--	Acc	--	--
42	16"-CR-20005-A2BZ-HT45	188A	HJ13006	3-4	GTAW	1275	Φ406×12.7	--	--	Acc	--	--
43	16"-CR-20005-A2BZ-HT45	188A	HJ13006	4-5	GTAW	1275	Φ406×12.7	P Φ1×2	--	Acc	--	--
44	16"-CR-20005-A2BZ-HT45	188A	HJ13006	5-0	GTAW	1275	Φ406×12.7	P Φ1×1	--	Acc	--	--
END												

注(Notes)：未熔合(LOF-Lack of Fusion) 根部凹陷(RC-Root Concavity) 裂纹(C-Crack) 气孔(P-Porosity) 夹渣(S.I-Slag Inclusion)
 未焊透(LOP-Lack of Penetration) 咬边(UC-Undercut) 无记录缺陷(N.S.D-No Recordable Defect) 合格(Acc-Acceptance) 不合格(Rej-Rejection)

签字 Signature	检验员(Inspector) Lile	技术监督(Tech.Supervisor)	签字授权人(Authorized Signee)
日期 Date	2019.09.23	Tang Yuzhen 2019.09.23	Tang Yuzhen 2019.09.23

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-030-RT001-19-052



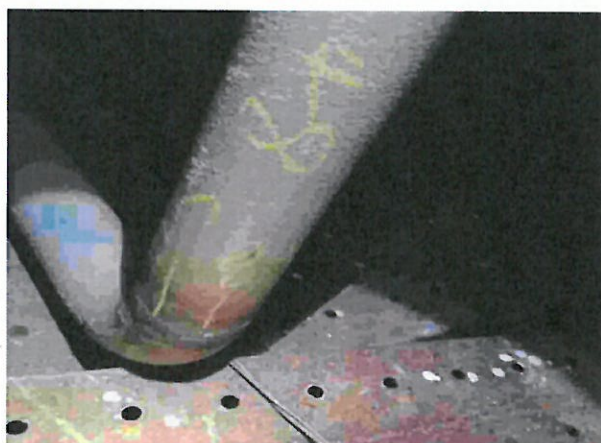
23



35A



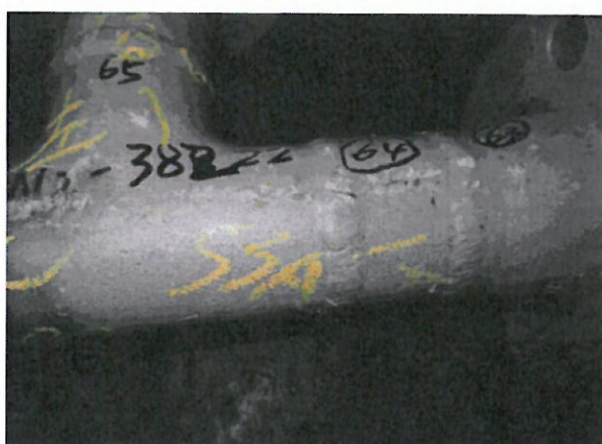
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48



53B



53A

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-030-RT001-19-052



70B



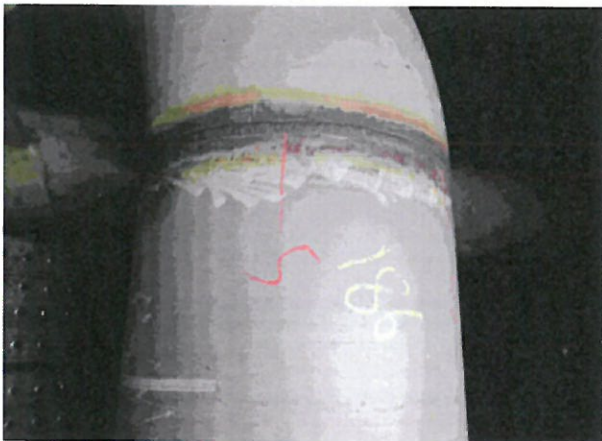
72



84



90



186



188A



备注

Remark

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Report without the specified inspection stamp of CJP company is invalid.
2. 报告无操作人员或评片人、技术监督、技术负责人签字无效。
Report without the signatures of operator of film judge, tech. supervisor and tech. principal is invalid.
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Report is only responsible for the inspective pieces.
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Client should inform CJP company within 15 days if there're any question about the inspective result.
7. 本报告一式三份；本公司存档一份，客户两份。
Report is in triplicity, original stored in CJP company, two copies for client.
8. 未加盖 CMA 章的检测报告，不具备向社会起证明作用的数据和结果。
The data and result of the inspection report that unsealed can not be proved to society.

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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