



# 无损检测报告

## NONDESTRUCTIVE TESTING REPORT

工程名称 Project Name: 西江油田群在役设施改造项目原油外输泵采购

## Purchase of Crude Oil Pumps for In-service Facilities Renovation Project of Xijiang Oilfield Group

委托单位 Commission Unit : 青岛太平洋海洋工程(深圳)有限公司

委托单位地址 Client Address: 宝安区燕罗街道罗田社区龙山二路1号

工程编号 Project No. : CJP-WR-051-351-19-027

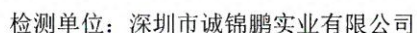
检测方法 Inspection Method : MT

报告编号 Report No. : CJP-WR--051-351-MT001-19-027

页数 Number of pages : 6

报告日期 Report Date : 2019.05.06

批准人 Approved by : 



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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: 西江油田群在役设施改造项目原油外输泵采购

报告日期

报告编号

Project Name: Purchase of Crude Oil Pumps for In-service Facilities Renovation Project of Xijiang Oilfield Group

Report Date: 2019.05.06

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|                                                                                     |                   |                            |              |                                                                                                                                                         |                            |                           |                    |                          |               |
|-------------------------------------------------------------------------------------|-------------------|----------------------------|--------------|---------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|---------------------------|--------------------|--------------------------|---------------|
| 检测地点<br>Testing Position                                                            | QPOC              | 执行标准<br>Executive Standard | AWS D1.1     |                                                                                                                                                         | 仪器型号<br>Instrument Type    | ZCM-A2202                 |                    | 提升力<br>Lifting Power     | ≥45N          |
| 检测比例<br>Testing Rate                                                                | 100%              | 合格级别<br>Acceptance Grade   | —            |                                                                                                                                                         | 仪器编号<br>Instrument No.     | CJP-CF-23                 |                    | 磁粉<br>Magnetic Particle  | MT-BW         |
| 图纸号<br>Drawing No.                                                                  | —                 | 表面状态<br>Surface Condition  | smooth       |                                                                                                                                                         | 磁轭类型<br>Yoke Type          | AC-Yoke                   |                    | 反差剂<br>Contrast Agent    | FA-5          |
| 工件材质<br>Workpiece Material                                                          | A106B             | 灵敏度试块<br>Sensitivity block | A1 30/100    |                                                                                                                                                         | 磁化方法<br>Magnetizing Method | Successive                |                    | 磁化时间<br>Magnetizing Time | 1~3s          |
| 工件编号<br>Workpiece No.                                                               | 焊工号<br>Welder No. | 焊口号<br>Weld No.            | 热处理状态<br>HTS | 坡口形式<br>Groove Form                                                                                                                                     | 焊接方法<br>Welding Process    | 焊缝长度<br>W.L (mm)          | 缺陷编号<br>Defect No. | 缺陷性质及大小<br>DNS           | 评定意见<br>Judge |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W1                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W2                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W3                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W4                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W5                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W6                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W7                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W8                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W9                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W10                        | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W11                        | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 3"-CR-20025-A2-HT45                                                                 | TPY001            | W12                        | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 2"-CR-20037-A2-HT45                                                                 | TPY001            | W1                         | —            | —                                                                                                                                                       | GTAW                       | —                         | —                  | —                        | ACC           |
| 备注: 热处理状态 (HTS—Heat Treatment State)<br>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)<br>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                                                                             |                   | 2019.05.06                 |              | 2019.05.06                                                                                                                                              |                            | 检验检测专用章                   |                    |                          |               |



磁粉检测报告 (续表)

报告编号

Report No. :CJP-WR--051-351-MT001-19-027

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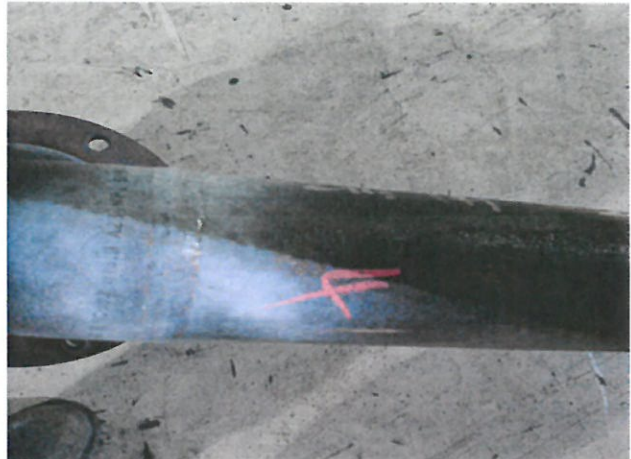
检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

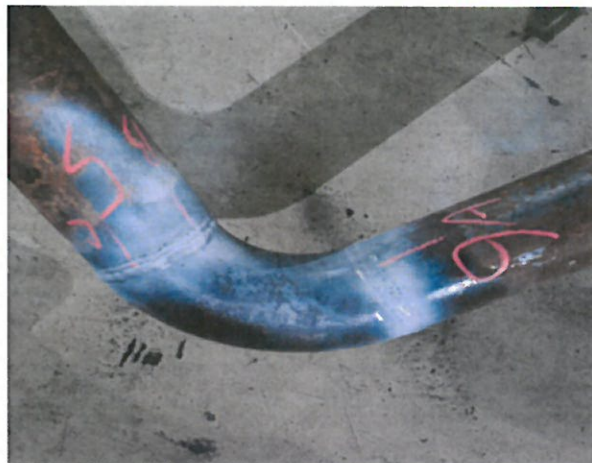
Report No: CJP-WR-051-351-MT001-19-023



3"-CR-20025-A2-HT45 W1 W2 W3



3"-CR-20025-A2-HT45 W4



3"-CR-20025-A2-HT45,W5 W6



3"-CR-20025-A2-HT45 W7 W8



3"-CR-20025-A2-HT45 W9 W10



3"-CR-20025-A2-HT45 W11 W12

检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-343-MT001-19-013



2"-CR-20037-A2-HT45 W1 W2



2"-CR-20037-A2-HT45 W3 W4 W5 W6



2"-CR-20037-A2-HT45 W7



备注

Remark

1. 报告无检测单位“检测专用章”无效。  
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.
3. 本报告涂改无效。  
Report with alteration will be invalid.
4. 本报告仅对被检产品受检部位负责。  
Report is only responsible for the inspective pieces.
5. 未经检测单位同意不得复制本报告。  
Report should not be copied without the agreement of CJP company.
6. 委托单位对检测结果若有异议，请于十五日内提出。  
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.

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