



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: PY10-2 修井机井架应力测试

Stress Test of PY10-2 Platform Workover Rig Derrick

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: 宝安区松岗街道罗田社区龙山二路 1 号

工程编号 Project No. : CJP-WR-051-367-19-075

检测方法 Inspection Method : MT

报告编号 Report No. : CJP-WR-051-367-MT003-19-075

页数 Number of pages : 共 9 页

报告日期 Report Date : 2019.11.08

批准人 Approved by : (1)

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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: PY10-2修井机井架应力测试

报告日期

报告:

Project Name: Stress Test of PY10-2 Platform Workover Rig Derrick

Report Date: 2019. 11. 08

Report No.: CJP-WR-051-367-MT003-19-075

检测地点 Testing Position	PY10-2平台 PY10-2 Platform	执行标准 Executive Standard		AWS D1.1	仪器型号 Instrument Type	ZCM-AD22012		提升力 Lifting Power	≥45N
检测比例 Testing Rate	抽检	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		打磨 Grinding	磁轭类型 Yoke Type	AC-Yoke		反差剂 Contrast Agent	FA-5
工件材质 Workpiece Material	CS	灵敏度试块 Sensitivity block		A1(30/100)	磁化方法 Magnetizing Method	Successive		磁化时间 Magnetizing Time	1~3 S
工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态	坡口形式	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
井架下体双耳座1号(应力测试后)	—	W1	—	—	—	—	—	—	Acc
井架下体双耳座1号(应力测试后)	—	W2	—	—	—	—	—	—	Acc
井架下体双耳座1号(应力测试后)	—	W3	—	—	—	—	—	—	Acc
井架下体双耳座2号(应力测试后)	—	W1	—	—	—	—	—	—	Acc
井架下体双耳座2号(应力测试后)	—	W2	—	—	—	—	—	—	Acc
井架下体双耳座2号(应力测试后)	—	W3	—	—	—	—	—	—	Acc
井架下体双耳座2号(应力测试后)	—	W4	—	—	—	—	—	—	Acc
井架支座1号(应力测试后)	—	W1	—	—	—	—	—	—	Acc
井架支座1号(应力测试后)	—	W2	—	—	—	—	—	—	Acc
井架支座1号(应力测试后)	—	W3	—	—	—	—	—	—	Acc
井架支座2号(应力测试后)	—	W1	—	—	—	—	—	—	Acc
井架支座2号(应力测试后)	—	W2	—	—	—	—	—	—	Acc
井架支座2号(应力测试后)	—	W3	—	—	—	—	—	—	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	Lu Bo 2019. 11. 08	Tang Meizhu 2019. 11. 08	



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

项目名称:PY10-2修井机井架应力测试务

报告日期

报告:

Project Name:Stress Test of PY10-2 Platform Workover Rig Derrick

Report Date: 2019. 11. 08

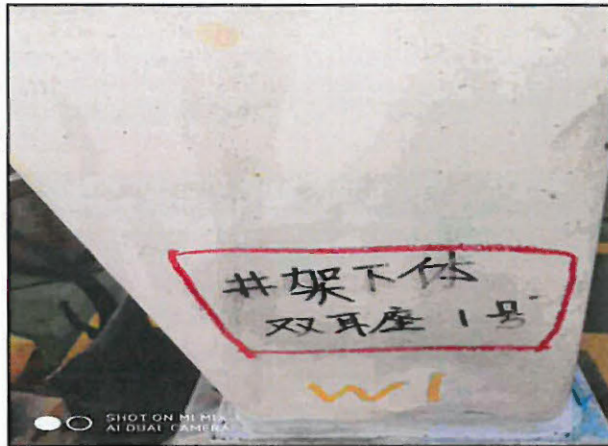
Report No.:JP-WR-051-367-MT003-19-075

工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态	坡口形式	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
井架支座2号(应力测试后)	---	W4	---	---	---	---	---	---	Acc
井架支座2号(应力测试后)	---	W5	---	---	---	---	---	---	Acc
井架支座2号(应力测试后)	---	W6	---	---	---	---	---	---	Acc
井架支座2号(应力测试后)	---	W7	---	---	---	---	---	---	Acc
井架支座2号(应力测试后)	---	W8	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W1	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W2	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W3	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W4	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W5	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W6	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W7	---	---	---	---	---	---	Acc
井架支座3号(应力测试后)	---	W8	---	---	---	---	---	---	Acc
井架支座4号(应力测试后)	---	W1	---	---	---	---	---	---	Acc
井架支座4号(应力测试后)	---	W2	---	---	---	---	---	---	Acc
井架支座4号(应力测试后)	---	W3	---	---	---	---	---	---	Acc
井架支座4号(应力测试后)	---	W4	---	---	---	---	---	---	Acc
井架支座4号(应力测试后)	---	W5	---	---	---	---	---	---	Acc
END									
备注:热处理状态(HTS--Heat Treatment State)					未熔合(LOF--Lack of Fusion) 未焊透(LOP--Lack of Penetration) 夹渣(S.I--Slag Inclusion)				
Notes:缺陷性质及大小 (DNS--Defect Nature and Size)					裂纹(C--Crack) 气孔(P--Porosity) 合格(Acc--Acceptance) 不合格(Rej-Rejection)				
签字 Sign		检验员 (Inspector)			技术监督 (Tech. Supervisor)		签字授权人 (Authorized Signee)		
日期 Date		Lu Bo 2019. 11. 08			Ang Yuezun 2019. 11. 08		2019. 11. 08		

检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

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井架下体双耳座 1 号 W1 (应力测试后)



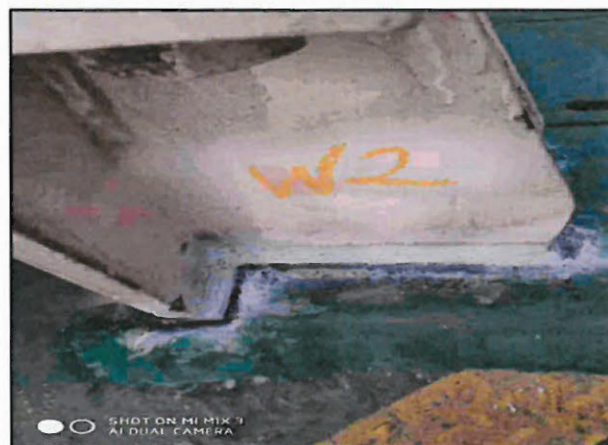
井架下体双耳座 1 号 W2 (应力测试后)



井架下体双耳座 1 号 W3 (应力测试后)



井架下体双耳座 2 号 W1 (应力测试后)



井架下体双耳座 2 号 W2 (应力测试后)



井架下体双耳座 2 号 W3 (应力测试后)

检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-367-MT003-19-075



井架下体双耳座 2 号 W4 (应力测试后)



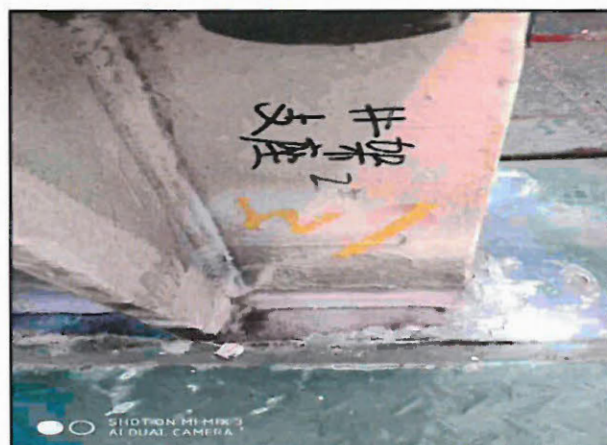
井架支座 1 号 W1 (应力测试后)



井架支座 1 号 W2 (应力测试后)



井架支座 1 号 W3 (应力测试后)



井架支座 2 号 W1 (应力测试后)

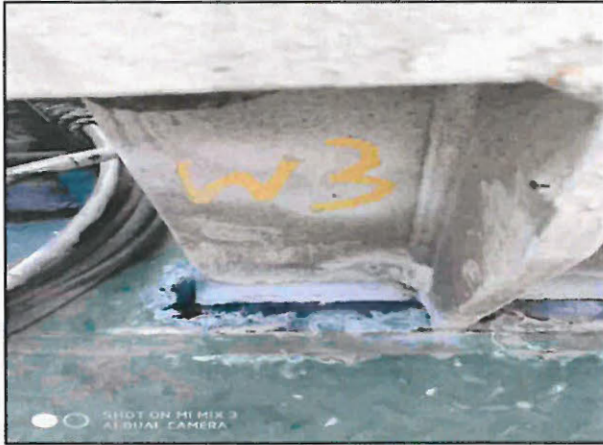


井架支座 2 号 W2 (应力测试后)

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-367-MT003-19-075



井架支座 2 号 W3 (应力测试后)



井架支座 2 号 W4 (应力测试后)



井架支座 2 号 W5 (应力测试后)



井架支座 2 号 W6 (应力测试后)



井架支座 2 号 W7 (应力测试后)



井架支座 2 号 W8 (应力测试后)

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

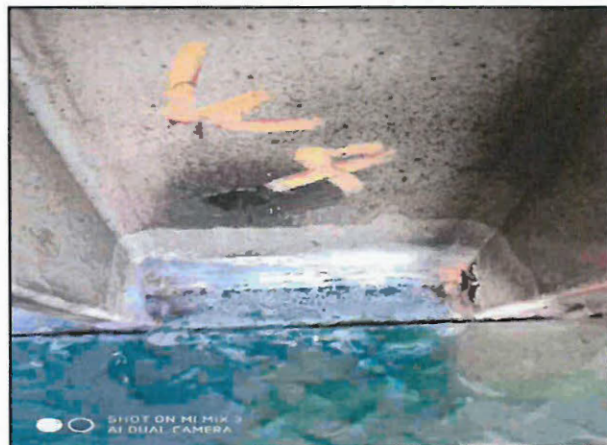
Report No: CJP-WR-051-367-MT003-19-075



井架支座 3 号 W1/W2(应力测试后)



井架支座 3 号 W3(应力测试后)



井架支座 3 号 W4(应力测试后)



井架支座 3 号 W5(应力测试后)



井架支座 3 号 W6(应力测试后)



井架支座 3 号 W7(应力测试后)

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-367-MT003-19-075



井架支座 3 号 W8(应力测试后)



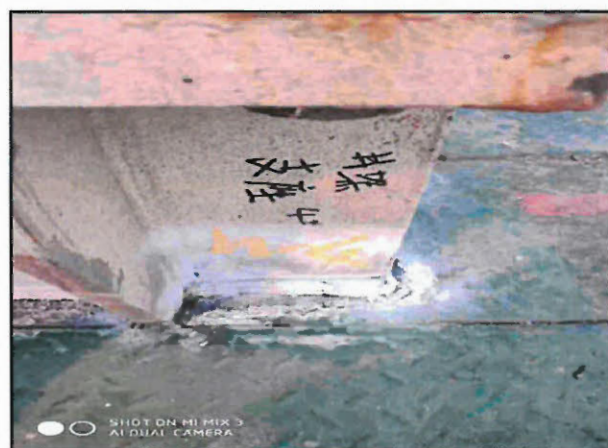
井架支座 4 号 W1(应力测试后)



井架支座 4 号 W2(应力测试后)



井架支座 4 号 W3(应力测试后)



井架支座 4 号 W4(应力测试后)



井架支座 4 号 W5(应力测试后)



备注

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Contractor: Shenzhen Chengjinpeng Industrial Co.,LTD

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