



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: 陵水 17-2 气田开发工程项目-封头及 COLLAR

保护器制作标段一

Lingshui 17-2 Gas Field Development Project-Section 1 for Head and COLLAR Protector Production

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-051-361-19-063

检测方法 Inspection Method : MT

报告编号 Report No. : CJP-WR-051-361-MT002-19-063

页数 Number of pages : 共 20 页

报告日期 Report Date : 2019.09.23

批准人 Approved by : 

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

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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: 陵水 17-2 气田开发工程项目-封头及COLLAR保护器制作标段一

报告日期

报告:

Project Name:Lingshui 17-2 Gas Field Development Project-Section I for Head and COLLAR ProtectorProduction

Report Date:

2019. 09. 23

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检测地点 Testing Position	QPOC	执行标准 Executive Standard		AWS D1.1 ASME B31.3	仪器型号 Instrument Type	ZCM-A2202		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-21		磁粉 Magnetic Particle	MT-BW
图纸号 Drawing No.	01-DWG-SPF-SP-1001 10"起始封头/1002 10"终止封头/1003 10"临时弃管封头/1004 10"J-Collar保护器 /01-DWG-GEN-SP-0004吊管撑杆	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	热处理状态	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
		Weld No.	HTS						
01-DWG-SPF-SP-1001-1	H-109	W1	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W2	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W3	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W4	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W5	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W6	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W7	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W8	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W11	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W12	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W13	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W14	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H-109	W15	--	--	SMAW/FCAW	--	--	--	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(SL--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	Ou Bang hua 2019. 09. 23	Tang Yuezun 2019. 09. 23	2019. 09. 23



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: 陵水 17-2 气田开发工程项目-封头及COLLAR保护器制作标段一

报告日期

报告:

Project Name:Lingshui 17-2 Gas Field Development Project-Section 1 for Head and COLLAR Protector Production

Report Date: 2019.09.23

Report No.:CJP-WR-051-361-MT002-19-063

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 OGroove 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
OI-DWG-SPF-SP-1001-1	H-109	W16	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W1	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W2	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W3	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W4	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W5	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W6	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W7	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W8	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W11	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W12	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W13	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W14	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W15	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-2	WI108	W16	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-3	LW740	W1	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-3	LW740	W2	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-3	LW740	W3	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-3	LW740	W4	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1001-3	LW740	W5	--	--	SMAW/FCAW	--	--	--	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) Ou Bang hua 2019.09.23	技术监督(Tech. Supervisor) Tang Xuesu 2019.09.23	签字授权人(Authorized Signee) 2019.09.23
日期 Date			



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)
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项目名称: 陵水 17-2 气田开发工程项目-封头及COLLAR保护器制作标段一

报告日期

报告:

Project Name:Lingshui 17-2 Gas Field Development Project-Section 1 for Head and COLLAR Protector Production

Report Date: 2019.09.23

Report No.:CJP-WR-051-361-MT002-19-063

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
01-DWG-SPF-SP-1001-3	LW740	W6	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W7	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W8	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W11	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W12	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W13	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W14	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W15	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-3	LW740	W16	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W1	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W2	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W3	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W4	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W5	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W6	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W7	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W8	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W11	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W12	---	---	SMAW/FCAW	---	---	---	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)			技术监督(Tech. Supervisor)		签字授权人 (Authorized Signee)		
日期 Date		Ou Bang 699 2019.09.23			Tang Yuezhu 2019.09.23		2019.09.23		



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01-DWG-SPF-SP-1001-4	H-109	W13	---	---	SMAW/FCAW	---	---	---	Acc
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01-DWG-SPF-SP-1001-4	H-109	W15	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1001-4	H-109	W16	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W1	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W2	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W3	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W4	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W5	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W6	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W7	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W8	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W11	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-1	WI108	W12	---	---	SMAW/FCAW	---	---	---	Acc
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01-DWG-SPF-SP-1002-1	WI108	W14	---	---	SMAW/FCAW	---	---	---	Acc
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01-DWG-SPF-SP-1002-1	WI108	W16	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-2	LW740	W1	---	---	SMAW/FCAW	---	---	---	Acc

备注:热处理状态(HTS--Heat Treatment State)

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签字 Sign	检验员 (Inspector) Ou Bang luo	技术监督 (Tech. Supervisor) Tang Yezu	签字授权人 (Authorized Signee) 2019.09.23
日期 Date	2019.09.23	2019.09.23	2019.09.23



磁粉检测报告 (续表)

MAGNETIC PARTICLE INSPECTION REPORT

项目名称: 陵水 17-2 气田开发工程项目-封头及COLLAR保护器制作标段一

报告日期

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01-DWG-SPF-SP-1002-2	LW740	W2	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-2	LW740	W3	---	---	SMAW/FCAW	---	---	---	Acc
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01-DWG-SPF-SP-1002-2	LW740	W7	---	---	SMAW/FCAW	---	---	---	Acc
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01-DWG-SPF-SP-1002-2	LW740	W11	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-2	LW740	W12	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-2	LW740	W13	---	---	SMAW/FCAW	---	---	---	Acc
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01-DWG-SPF-SP-1002-3	H-109	W1	---	---	SMAW/FCAW	---	---	---	Acc
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01-DWG-SPF-SP-1002-3	H-109	W4	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-3	H-109	W5	---	---	SMAW/FCAW	---	---	---	Acc
01-DWG-SPF-SP-1002-3	H-109	W6	---	---	SMAW/FCAW	---	---	---	Acc

备注:热处理状态(HTS--Heat Treatment State)

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

签字 Sign	检验员 (Inspector) Ou Bang hu	技术监督 (Tech. Supervisor) Tang Xue zu	签字授权人 (Authorized Signee)
日期 Date	2019.09.23	2019.09.23	2019.09.23



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01-DWG-SPF-SP-1002-3	H-109	W8	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-3	H-109	W11	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-3	H-109	W12	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-3	H-109	W13	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-3	H-109	W14	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-3	H-109	W15	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-3	H-109	W16	--	--	SMAW/FCAW	--	--	--	Acc
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01-DWG-SPF-SP-1002-4	WI108	W2	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W3	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W4	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W5	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W6	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W7	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W8	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W11	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W12	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W13	--	--	SMAW/FCAW	--	--	--	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)	技术监督 (Tech. Supervisor)	签字授权人 (Authorized Signee)
日期 Date	Ou Bang hua 2019.09.23	Tang Xuezu 2019.09.23	2019.09.23



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

项目名称: 陵水 17-2 气田开发工程项目-封头及COLLAR保护器制作标段一

报告日期

报告:

Project Name:Lingshui 17-2 Gas Field Development Project-Section 1 for Head and COLLAR Protector Production

Report Date: 2019. 09. 23

Report No. :CJP-WR-051-361-MT002-19-063

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
01-DWG-SPF-SP-1002-4	WI108	W14	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W15	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1002-4	WI108	W16	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W1	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W2	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W3	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W4	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W5	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W6	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W7	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W8	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W11	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W12	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W13	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W14	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W15	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-1	LW740	W16	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-2	H001	W1	--	--	SMAW/FCAW	--	--	--	Acc
01-DWG-SPF-SP-1003-2	H001	W2	--	--	SMAW/FCAW	--	--	--	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) Du Bang Hua	技术监督 (Tech. Supervisor) Tang Yuezun	签字授权人 (Authorized Signee) 2019.09.23
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

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

项目名称: 陵水 17-2 气田开发工程项目-封头及COLLAR保护器制作标段一

报告日期

报告:

Project Name:Lingshui 17-2 Gas Field Development Project-Section 1 for Head and COLLAR Protector Production

Report Date: 2019. 09. 23

Report No.:CJP-WR-051-361-MT002-19-063

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
OI-DWG-SPF-SP-1003-2	H001	W3	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W4	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W5	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W6	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W7	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W8	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W11	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W12	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W13	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W14	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W15	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-SPF-SP-1003-2	H001	W16	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-GEN-SP-0004-1	H-109	W1-1	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-GEN-SP-0004-1	H-109	W1-2	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-GEN-SP-0004-2	WI108	W2-1	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-GEN-SP-0004-2	WI108	W2-2	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-GEN-SP-1004-A1	H001	A1	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-GEN-SP-1004-A2	H001	A2	--	--	SMAW/FCAW	--	--	--	Acc
OI-DWG-GEN-SP-1004-B1	H001	B1	--	--	SMAW/FCAW	--	--	--	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) Ou Bang hua	技术监督 (Tech. Supervisor) Tang Xunzhen	签字授权人 (Authorized Signee) 2019.09.23
日期 Date	2019.09.23	2019.09.23	



MAGNETIC PARTICLE INSPECTION REPORT

Report No. :CJP-WR-051-361-MT002-19-063

第 9 页 共 9 页 Page No: 9 / 9

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-361-MT002-19-063



整体图 1



整体图 2



整体图 3



吊管撑杆 W1-1



吊管撑杆 W1-2



吊管撑杆 W2-1

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-361-MT002-19-063



吊管撑杆 W2-1



整体图



10"J-Collar 保护器 A1



10"J-Collar 保护器 A2



10"J-Collar 保护器 B1



10"J-Collar 保护器 B2

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-361-MT002-19-063



10"J-Collar 保护器 C1



10"J-Collar 保护器 C2



10"J-Collar 保护器 D1



10"J-Collar 保护器 D2



10"J-Collar 保护器 E1



10"J-Collar 保护器 E2

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-361-MT002-19-063



10"J-Collar 保护器 F1



10"J-Collar 保护器 F2



10"J-Collar 保护器 G1



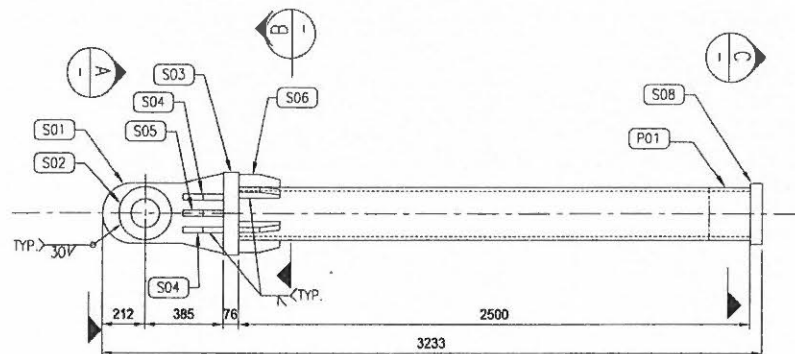
10"J-Collar 保护器 G2



10"J-Collar 保护器 H1

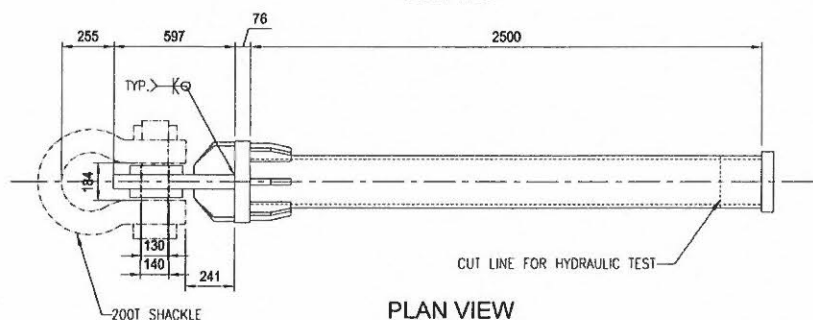


10"J-Collar 保护器 H2



FRONT VIEW

Scale: 1/25



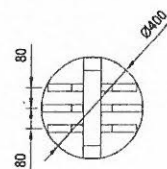
PLAN VIEW

Scale: 1/25

ITEM	QTY	DESCRIPTION	MATERIAL / SCHEDULE	WEIGHT Kg	
				UNIT	TOTAL
S01	1	PLATE PL76	E36-Z35	207.82	207.82
S02	2	PLATE PL45	D36-Z35	18.75	37.5
S03	1	PLATE PL76	E36-Z35	17.49	69.94
S04	4	PLATE PL30	D36	24.47	54.9
S05	2	PLATE PL30	D36	7.85	31.4
S06	6	PLATE PL30	D36	2.808	16.85
P01	1	PIPE 10" (WT. 18.3mm)	API X65	380.0	380.0
TOTAL				712.45	

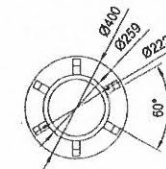
NOTES:

- 1) ALL DIMENSIONS ARE IN MILLIMETER UNLESS INDICATED OTHERWISE.
- 2) WELD INSPECTIONS SHALL BE AS FOLLOWS:
ALL FILLET WELDS SHALL BE 100% M.P.I.
ALL PRESSURE CONTAINING PIPEWORK SHALL BE 100% RADIOGRAPHIC EXAMINATION. ALL STRUCTURAL FULL PENETRATION WELDS SHALL BE 100% ULTRASONICALLY TESTED.
- 3) LEAK TEST SHALL BE PERFORMED AT 24(1.5X16)MPA FOR 6 HOURS AT FABRICATION YARD.
- 4) THE SURFACE OF HEAD NEED TO BE COATED WITH ANTI-RUST YELLOW PAINT AND THE WORDS "10" START-UP HEAD" SHOULD BE MARKED ON PIPE WITH BLACK PAINT, THE WORD HEIGHT SHALL BE CHOSEN IN 100MM.
- 5) THE QUANTITY OF HEADS IS TWO(2).
- 6) WELDING METHOD REFERS TO GB150.3-2011.
- 7) THE FLOODED PIPELAY TENSION IS 160 TONS, SAFETY FACTOR OF THE HEAD IS 2.0.



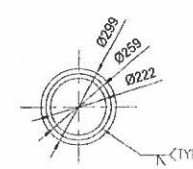
DETAIL A

Scale: 1/10



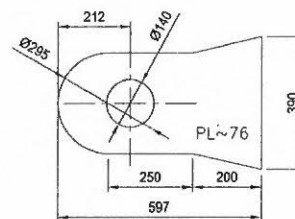
DETAIL B

Scale: 1/10



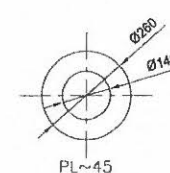
DETAIL C

Scale: 1/10



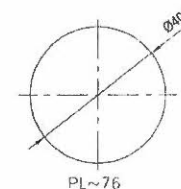
DETAIL S01

Scale: 1/25



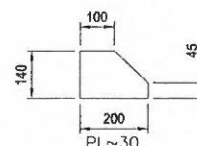
DETAIL S02

Scale: 1/25



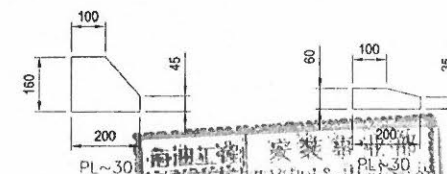
DETAIL S03

Scale: 1/25



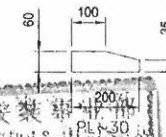
DETAIL S04

Scale: 1/25



DETAIL S05

Scale: 1/25



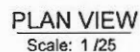
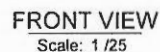
DETAIL S06

Scale: 1/25



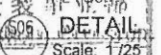
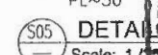
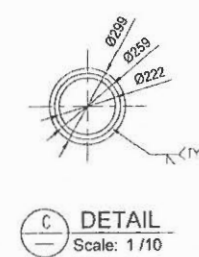
2	01-CAL-SPF-SP-1002	10IN FLOWLINE PIPELAY STATIC ANALYSIS
1	01-CAL-SPF-SP-1001	STRENGTH CHECK FOR 10IN PIPELINE PULLING HEAD
REF.#	DOCUMENT NO.	DESCRIPTION

NO.	1	FOR GENERAL DESIGN WHOLE LAYOUT	李强	李强	李强	李强	李强
NO.	0	ISSUED FOR APPROVAL	李强	李强	李强	李强	李强
NO.	DATE	DESCRIPTION	BY	CHK'D	APP'D	DATE	REVISION
1	2019.04.12						
CLIENT	Offshore Oil Engineering Co., Ltd.						
SIGNATORY	SIGNATORY	DATE	PROJECT: 1517-2 GAS FIELD PLATFORM				DATE: 2019.04.12
DESIGNED	周杨	2019.7	DRAWING OF 10IN PIPE STATIC LIFT-UP HEAD				DATE: 2019.04.12
CHECKED	孙文强	2019.7					DATE: 2019.04.12
APPROVED	周杨	2019.7					DATE: 2019.04.12
EXTENDED	李强	2019.7					DATE: 2019.04.12
APPROVED	孙文强	2019.7					DATE: 2019.04.12



NOTES:

- 1) ALL DIMENSIONS ARE IN MILLIMETER UNLESS INDICATED OTHERWISE.
- 2) WELD INSPECTIONS SHALL BE AS FOLLOWS:
 - a) ALL FILLET WELDS SHALL BE 100% M.P.I.
 - b) ALL PRESSURE CONTAINING PIPEWORK SHALL BE 100% RADIOGRAPHIC EXAMINATION. ALL STRUCTURAL FULL PENETRATION WELDS SHALL BE 100% ULTRASONICALLY TESTED.
- 3) LEAK TEST SHALL BE PERFORMED AT 24(1.5X16)VMPA FOR 6 HOURS AT FABRICATION YARD.
- 4) THE SURFACE OF HEAD NEED TO BE COATED WITH ANTI-RUST YELLOW PAINT. THE WORDS "10" LAYDOWN HEAD" SHOULD BE MARKED ON PIPE WITH BLACK PAINT, THE WORD HEIGHT SHALL BE CHOSEN IN 10MM.
- 5) THE QUANTITY OF HEADS IS TWO(2).
- 6) WELDING METHOD REFERS TO GB150.3-2011.
- 7) THE FLOODED PIPELAY TENSION IS 160 TONS, SAFETY FACTOR OF THE HEAD IS 2.0.



海關工程
C0000

安裝 單

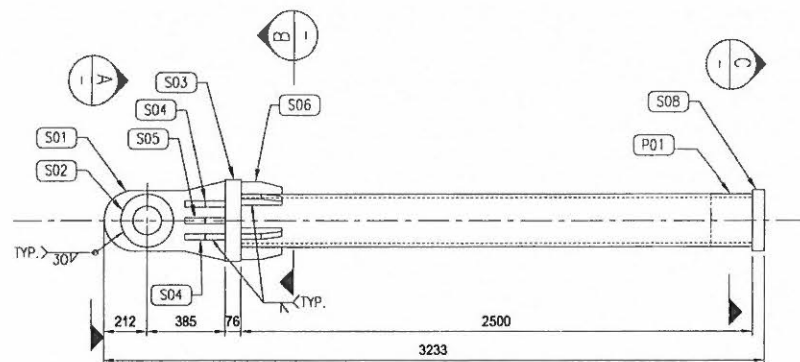
DETAIL
Scale: 1/25

FOR APPROVAL

2	01-CAL-SPF-SP-1002	10IN FLOWLINE PIPELAY STATIC ANALYSIS
1	01-CAL-SPF-SP-1001	STRENGTH CHECK FOR 10IN PIPELINE PULLING HEAD
REF.#	DOCUMENT NO.	DESCRIPTION

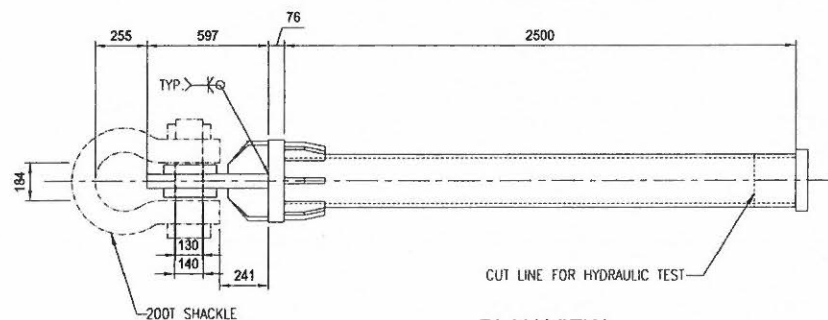
REVISION	1	FOR GENERAL DESIGN MODIFICATION	ZY	SQ	ZY	LJ	CX
0		ISSUED FOR APPROVAL					
No.	DATE	DESCRIPTION	BY	CHK'd	APP'G	FACD	MTRNG
批准 No.	2019/01/15						
CLIENT	CHINA PETROLEUM & CHEMICAL CORP.						
SIGNATURE	SIGNATURE	DATE	PROJECT: 1412-2 GAS FIELD DEVELOPMENT				UNITED STATES OF AMERICA
DRAWN	周杨	2019.7					SCALE:
CHECKED	孙文涛	2019.7					NO. / DATE
DESIGNED	周杨	2019.7					DEPARTMENT
EXAMINED	李星	2019.7					N/A
APPROVED	陈永强	2019.7	1407-XA-01-100-MS-SP-1002	REV.			

0001-JS-445-040-10



FRONT VIEW

Scale: 1/25



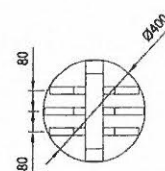
PLAN VIEW

Scale: 1/25

ITEM	QTY	DESCRIPTION	MATERIAL/ SCHEDULE	WEIGHT Kg	
				UNIT	TOTAL
S01	1	PLATE PL76	E36-Z35	207.82	207.82
S02	2	PLATE PL45	D36-Z35	18.75	37.5
S03	1	PLATE PL76	E36-Z35	17.49	69.94
S04	4	PLATE PL30	D36	24.47	54.9
S05	2	PLATE PL30	D36	7.85	31.4
S06	6	PLATE PL30	D36	2.808	16.85
P01	1	PIPE 10" (WT. 18.3mm)	API X65	380.0	380.0
TOTAL					712.45

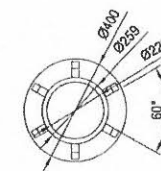
NOTES:

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- 3) LEAK TEST SHALL BE PERFORMED AT 24(1.5X16)MPA FOR 6 HOURS AT FABRICATION YARD.
- 4) THE SURFACE OF HEAD NEED TO BE COATED WITH ANTI-RUST YELLOW PAINT AND THE WORDS "10" A&R HEAD" SHOULD BE MARKED ON PIPE WITH BLACK PAINT, THE WORD HEIGHT SHALL BE CHOSEN IN 100MM.
- 5) THE QUANTITY OF HEADS IS TWO(2).
- 6) WELDING METHOD REFERS TO GB150.3-2011.
- 7) THE FLOODED PIPELAY TENSION IS 160 TONS, SAFETY FACTOR OF THE HEAD IS 2.0.



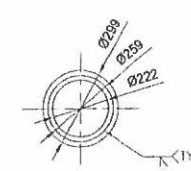
A DETAIL

Scale: 1/10



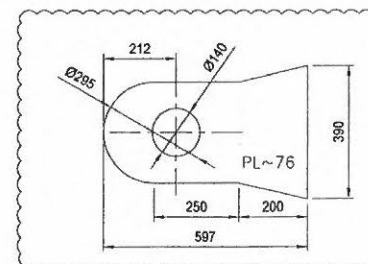
B DETAIL

Scale: 1/10



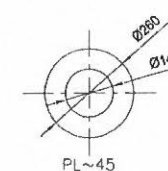
C DETAIL

Scale: 1/10



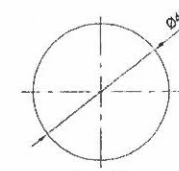
S01 DETAIL

Scale: 1/25



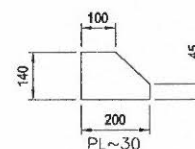
S02 DETAIL

Scale: 1/25



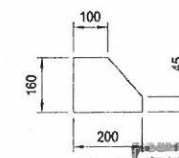
S03 DETAIL

Scale: 1/25



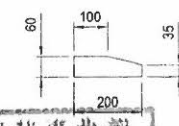
S04 DETAIL

Scale: 1/25



S05 DETAIL

Scale: 1/25



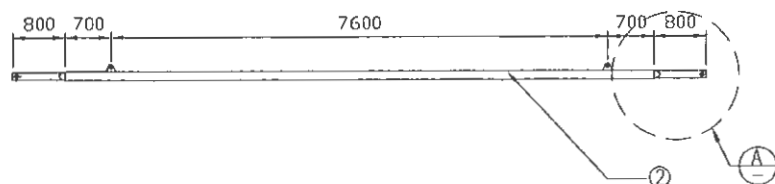
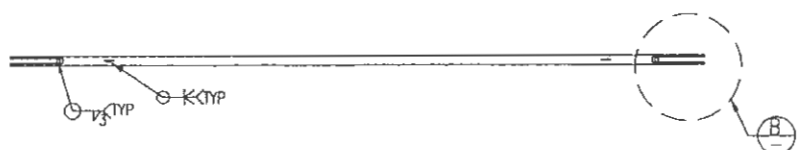
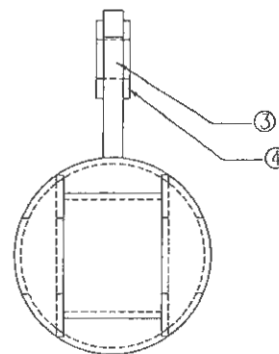
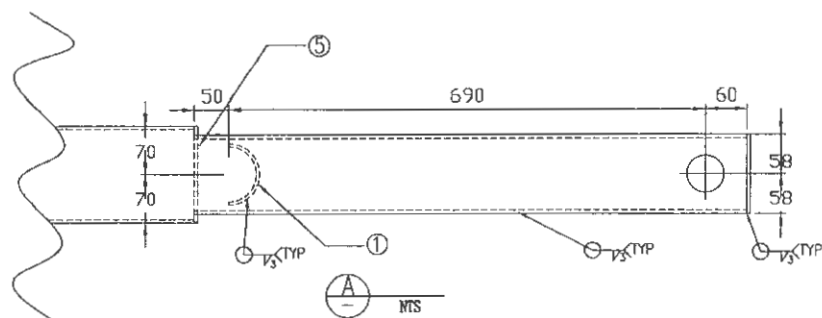
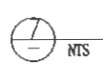
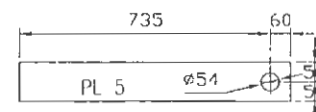
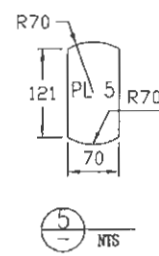
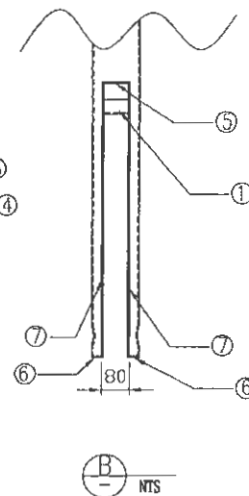
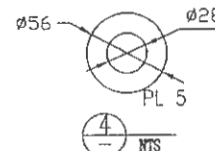
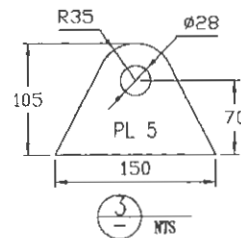
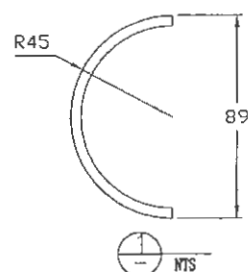
S06 DETAIL

Scale: 1/25



REV	DATE	DESCRIPTION	BY	CHK	REV	DATE	DESCRIPTION
1	2019.7	FOR GENERAL DESIGN	张永源	张永源	1	2019.7	FOR GENERAL DESIGN
2	2019.7	FOR GENERAL DESIGN	张永源	张永源	2	2019.7	FOR GENERAL DESIGN
3	2019.7	FOR GENERAL DESIGN	张永源	张永源	3	2019.7	FOR GENERAL DESIGN
4	2019.7	FOR GENERAL DESIGN	张永源	张永源	4	2019.7	FOR GENERAL DESIGN
5	2019.7	FOR GENERAL DESIGN	张永源	张永源	5	2019.7	FOR GENERAL DESIGN
6	2019.7	FOR GENERAL DESIGN	张永源	张永源	6	2019.7	FOR GENERAL DESIGN
7	2019.7	FOR GENERAL DESIGN	张永源	张永源	7	2019.7	FOR GENERAL DESIGN
8	2019.7	FOR GENERAL DESIGN	张永源	张永源	8	2019.7	FOR GENERAL DESIGN
9	2019.7	FOR GENERAL DESIGN	张永源	张永源	9	2019.7	FOR GENERAL DESIGN
10	2019.7	FOR GENERAL DESIGN	张永源	张永源	10	2019.7	FOR GENERAL DESIGN

DRAWING OF 10IN PIPE ACR HEAD

ISOMETRIC VIEW
NTSELEVATION
NTSVERTICAL VIEW
NTSSIDE VIEW
NTS

海油工程
COOEC

安装公司
Installation Company

征求意见
FOR COMMENTS

ITEM	QTY	DESCRIPTION	MATERIAL
1	2	Ø88mmxWT4.5mm pipe, 70mm	STEEL Q235A
2	1	Ø140mmxWT4.5mm, 10600mm	STEEL Q235A
3	2	PLATE 10mm THK 105mmx105mm	STEEL Q235A
4	4	PLATE 5mm THK Ø56mm ID28mm	STEEL Q235A
5	2	PLATE 5mm THK 121mmx70mm	STEEL Q235A
6	4	PLATE 5mm THK 115mmx20mm	STEEL Q235A
7	4	PLATE 5mm THK 795mmx116mm	STEEL Q235A

NOTE:

- ALL DIMENSIONS ARE IN MILLIMETER UNLESS INDICATED OTHERWISE.
- WELD INSPECTIONS SHALL BE AS FOLLOWS:
-100% VISUAL AND 100% UT AT ALL WELDS.
- THE SURFACE OF LIFTING BAR SHOULD BE COATED WITH YELLOW ANTI-RUST PAINT AND THE MARKS "LIFTING BAR" SHOULD BE CLEAR AND BIG, COATED WITH BLACK PAINT ON BOTH SIDES OF THE BAR.
- THE QUANTITY OF THE LIFTING BAR IS TWO (2).

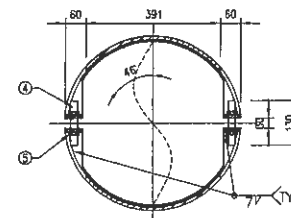
REVISION	No.	DATE	DESCRIPTION	BY	CHK	APP
1	1	20080810				
2	2	20080810				
3	3	20080810				
4	4	20080810				
5	5	20080810				
6	6	20080810				
7	7	20080810				
8	8	20080810				
9	9	20080810				
10	10	20080810				

JOB No.	20080810	CLIENT	Offshore Oil Engineering Co., Ltd.
DESIGNER	WANG JIA	PROJECT	LS17-2 GAS FIELD DEVELOPMENT
CHECKED	WANG JIA	DATE	20080810
APPROVED	WANG JIA	DATE	20080810
REVIEWED	WANG JIA	DATE	20080810
DESIGNED	WANG JIA	DATE	20080810
CHECKED	WANG JIA	DATE	20080810
APPROVED	WANG JIA	DATE	20080810

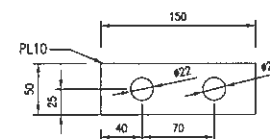
DRAWING OF PIPELINE LIFTING BAR

ICS USP SCS(01)-LS17-29

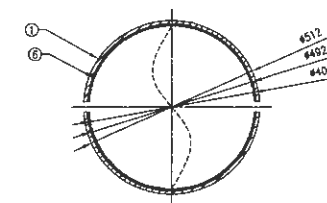
REVISION					
	No.	DATE	DESCRIPTION	BY	CHK'D. REV' #
JOB No.	2018WD015		 Offshore Oil Engineering Co., Ltd.		
CLIENT	CHONG MIN LEE KIN				
SIGNATURE	SIGNATURE	DATE	PROJECT: LS17-2 GAS FIELD DEVELOPMENT		CERTIF. No. A112007281
DRAWN					SCALE
MESASURED			DRAWING OF 10" PIPE COLLAR PROTECTOR		N.T.S.
CHECKED			(CN-USP- SC5(W)-LS17-2)		WEIGHT (kg)
REVIEWED					N/A
EXAMINED					
APPROVED			DWG No. 01-DWG-SPP-SP-1001		REV. 0



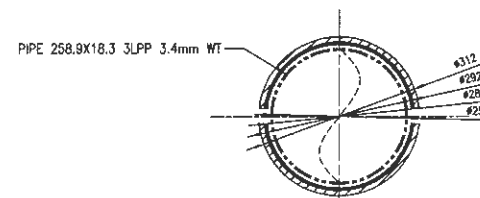
SECTION _____
SCALE N.T.S.



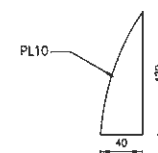
ITEM 2
SCALE N.T.S.



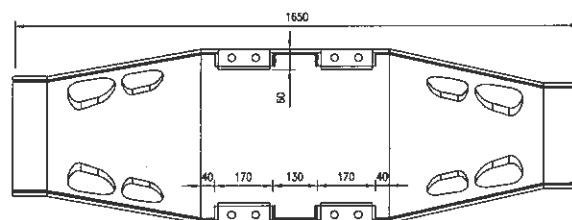
SECTION A
SCALE N.T.S.



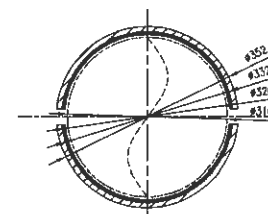
SECTION
SCALE N.T.S.



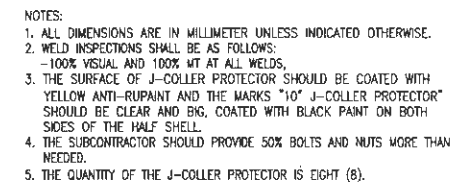
ITEM 3
SCALE N.T.S.



SECTION _____ (C)
SCALE N.T.S.



SECTION _____ (E)
SCALE N.T.S.



MATCHING VIEW
SCALE N.T.S

10 INCH J-COLLER—

10 INCH J-COLLER PROTECTOR



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.

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: Room C3, 6/F Gaoke Building, No.2076, Yueliangwan BLVD,
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