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 ： UT

报告编号 Report No. ： CJP-WR-051-361-UT001-19-063

页数 Number of pages ： 共 9 页

报告日期 Report Date ： 2019.08.29

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
ADDRESS: C3F6, GAOKE BUILDING,NO.2076,YUELIANGWAN BLVD,NANSHAN DISTRICT,SHENZHEN
电　话 Tel: 0755-86274981/26440278
URL: http://www.cjpsz.com　E-mail:cjpsz126@126.com

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

超 声 波 检 测 报 告
ULTRASONIC TESTING 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：　　报告编号：

Project Name: Lingshui 17-2 Gas Field Development Project-Section 1 for Head and COLLAR Protector Production　　Report Date: 2019.08.29　　Report No.: CJP-WR-051-361-UT001-19-063

检测地点 Test Position	QPOC	验收标准 Acceptance Criteria	AWS D1.1 ASME B31.3	仪器型号 Instrument Type	HS610e	基准灵敏度 Ref. Sensitivity	Φ1.5 Φ2.4×38.1
检测比例 Testing Rate	100%	合格级别 Acceptance Grade	--	仪器编号 Instrument No.	CJP-CS-22	检验灵敏度 Test Sensitivity	Φ1.5+12dB Φ2.4×38.1+12dB
图纸号 Drawing No.	OI-DWG-SPF-SP-1001 10"起始封头 / OI-DWG-SPF-SP-1002 10"终止封头 / OI-DWG-SPF-SP-1003 10"临时弃管封头	表面状态 Surface Condition	Grinding	灵敏度试块 Sensitivity Block	CSK-IA / ASME-1#	图 Drawing:	
材质 Material	CS	探头型号 Probe Type	2.5Z 8×12 A45/A60/A70	探头角度/入射点 Probe Angle / Index	45.5° 9.5mm/60.6° 7.5mm/70.8° 18mm		
焊接方法 Welding Process	GTAW/SMAW/GMAW	坡口型式 Groove Type	V/K	耦合剂 Couplant	工业浆糊		

工件编号 Workpiece No.	焊缝号 Weld No.	焊工号 Welder No.	厚度 THK (mm)	焊缝长度 W.L (mm)	探头角度 Probe Angle	缺陷编号 Defect No.	参考点 Reference Point X	Y	W	D	L	性质 Property	范围 Range	意见 Judge	返修报告号 Repair Report No.
OI-DWG-SPF-SP-1001-1	9	H-109	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1001-1	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1001-2	9	WI108	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1001-2	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1001-3	9	LW740	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1001-3	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1001-4	9	H-109	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1001-4	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1002-1	9	WI108	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1002-1	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1002-2	9	LW740	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--

注(Notes): X.Y.W.D.L:见图(See Drawing)， 未熔合(LOF--Lack of Fusion)， 未焊透(LOF--Lack of Penetration)， 裂纹(,C--Crack)， 夹渣(S.I--Slag Inclusion)，
气孔(P--Porosity)， 合格(Acc--Acceptance)， 不合格(Rej-Rejection).

	检验员(Inspector)	技术监督(Tech. Supervisor)	签字授权人(Authorized Signee)
签字 Sign:	Liu Wenzhong	Tang Yuzu	Tang Yubin
日期 Date:	2019.08.29	2019.08.28	2019.08.29

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

超声波检测报告（续表）
ULTRASONIC TESTING 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:　　报告编号:

Project Name:Lingshui 17-2 Gas Field Development Project-Section 1 for Head and COLLAR Protector Production　　Report Date:2019.08.29　　Report No.:CJP-WR-051-361-UT001-19-063

工件编号 Workpiece No.	焊缝号 Weld No.	焊工号 Welder No.	厚度 THK (mm)	焊缝长度 W.L (mm)	探头角度 Probe Angle	缺陷编号 Defect No.	参考点 Reference Point					性质 Property	范围 Range	意见 Judge	返修报告号 Repair Report No.
							X	Y	W	D	L				
OI-DWG-SPF-SP-1002-2	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1002-3	9	H-109	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1002-3	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1002-4	9	WI108	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1002-4	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1003-1	9	LW740	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1003-1	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1003-2	9	H-109	75	--	70.8°	--	--	--	--	--	--	--	--	Acc	--
OI-DWG-SPF-SP-1003-2	10	H001	18.3	--	45.5° /60.6°	--	--	--	--	--	--	--	--	Acc	--
END															

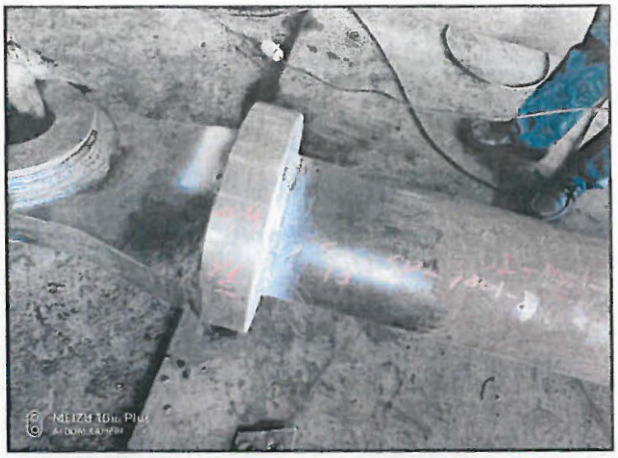
注(Notes): X.Y.W.D.L:见图(See Drawing)， 未熔合(LOF--Lack of Fusion)， 未焊透(LOP--Lack of Penetration)， 裂纹(,C--Crack)， 夹渣(S.I--Slag Inclusion)，
气孔(P--Porosity)， 合格(Acc--Acceptance)， 不合格(Rej-Rejection).

	检验员(Inspector)	技术监督(Tech. Supervisor)	签字授权人(Authorized Signee)
签字 Signature:	Liu Wenzhong	Tang Yuzu	Tang Yuzu
日期 Date:	2019.08.29	2019.08.29	2019.08.29

检测报告附图
SKETCH OF DETECTION POSITION

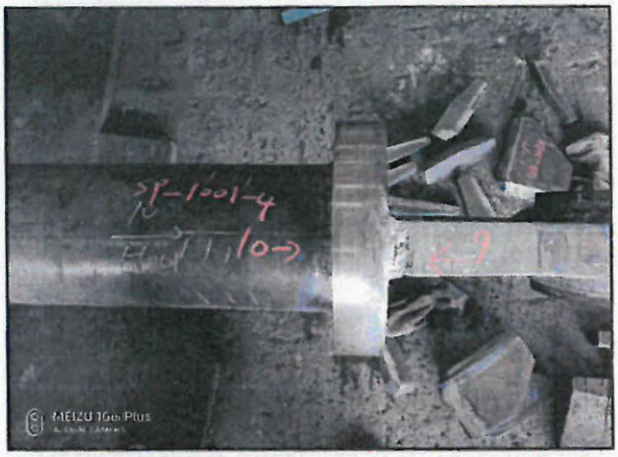
报告编号:
Report No：CJP-WR-051-361-UT001-19-063

OI-DWG-SPF-SP-1001-1- 9/10

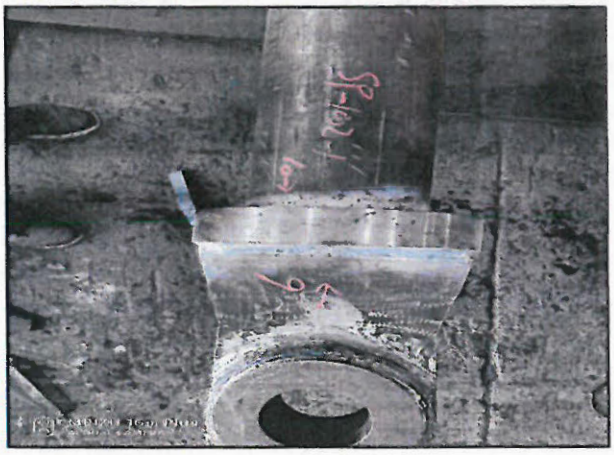


OI-DWG-SPF-SP-1001-2- 9/10

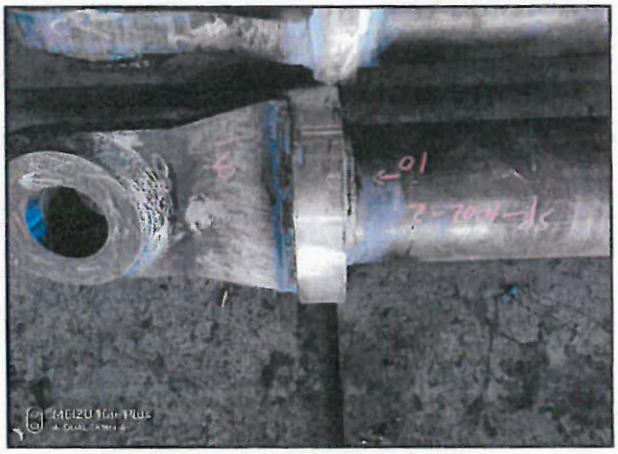
OI-DWG-SPF-SP-1001-3 9/10



OI-DWG-SPF-SP-1001-4 9/10



OI-DWG-SPF-SP-1002-1 9/10



OI-DWG-SPF-SP-1002-2 9/10

检测报告附图
SKETCH OF DETECTION POSITION

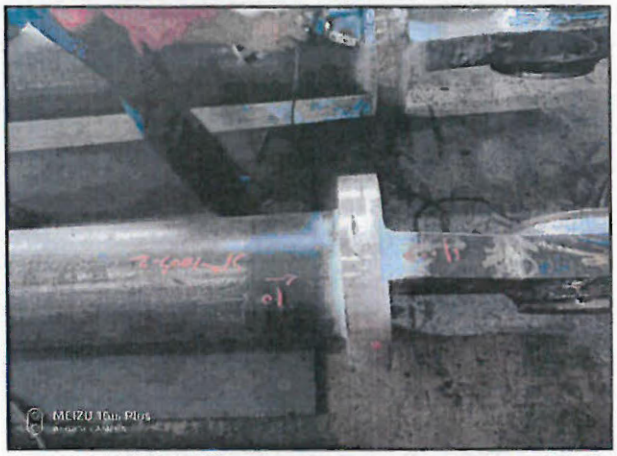
报告编号:

Report No：CJP-WR-051-361-UT001-19-063

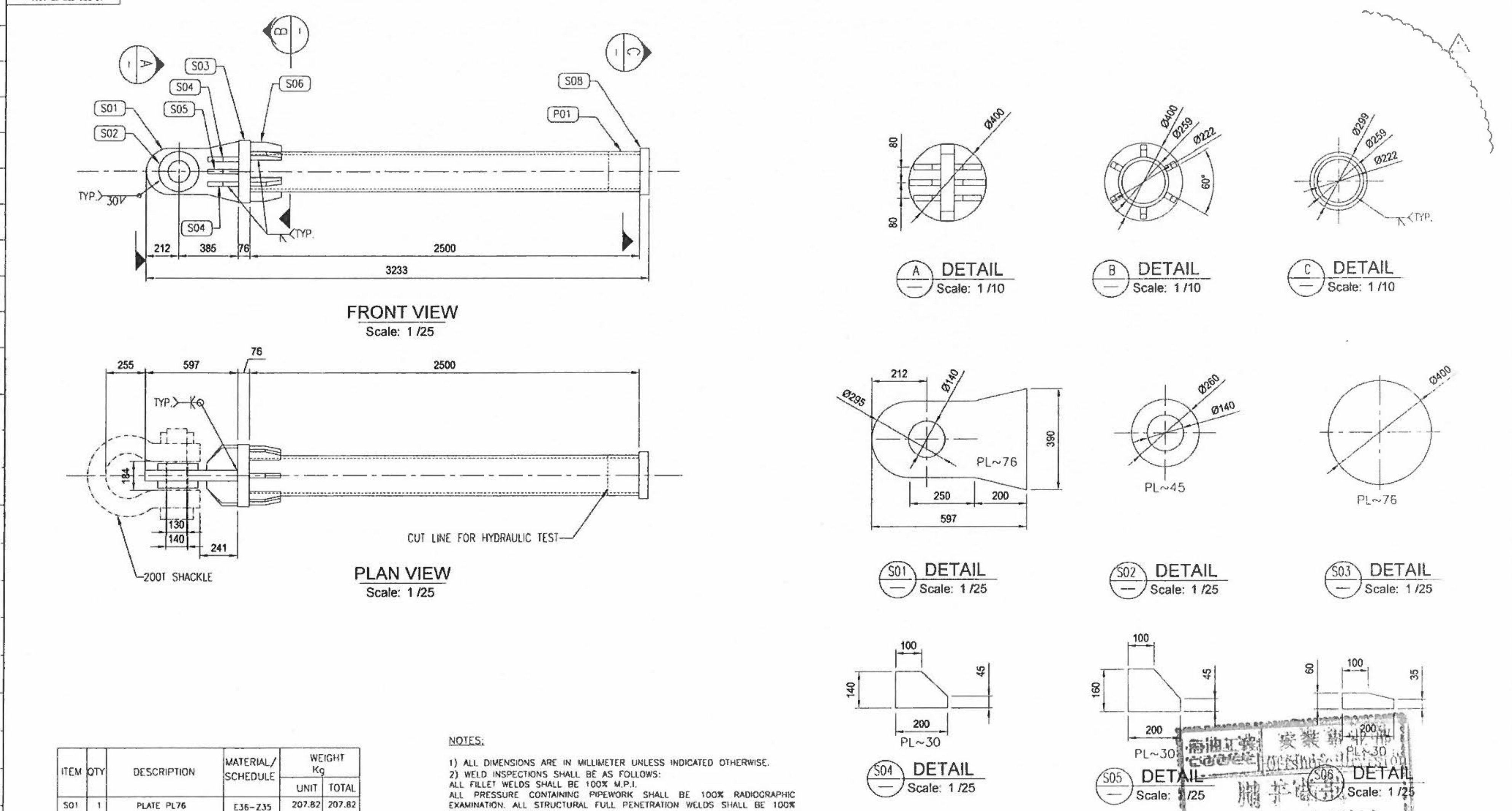
OI-DWG-SPF-SP-1002-3 9/10

OI-DWG-SPF-SP-1002-4 9/10

OI-DWG-SPF-SP-1003-1 9/10



OI-DWG-SPF-SP-1003-2 9/10



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	PIPE10"(WT.18.3mm)	APIX65	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 SHALE 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.

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

REVISION No.	DATE	DESCRIPTION	BY	CHK.	REV'D.	EXAM.	APPRD.
1	[illegible]	FOR GENERAL DESIGN MODIFICATION	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
0		ISSUED FOR APPROVAL	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]

Offshore Oil Engineering Co.,Ltd.

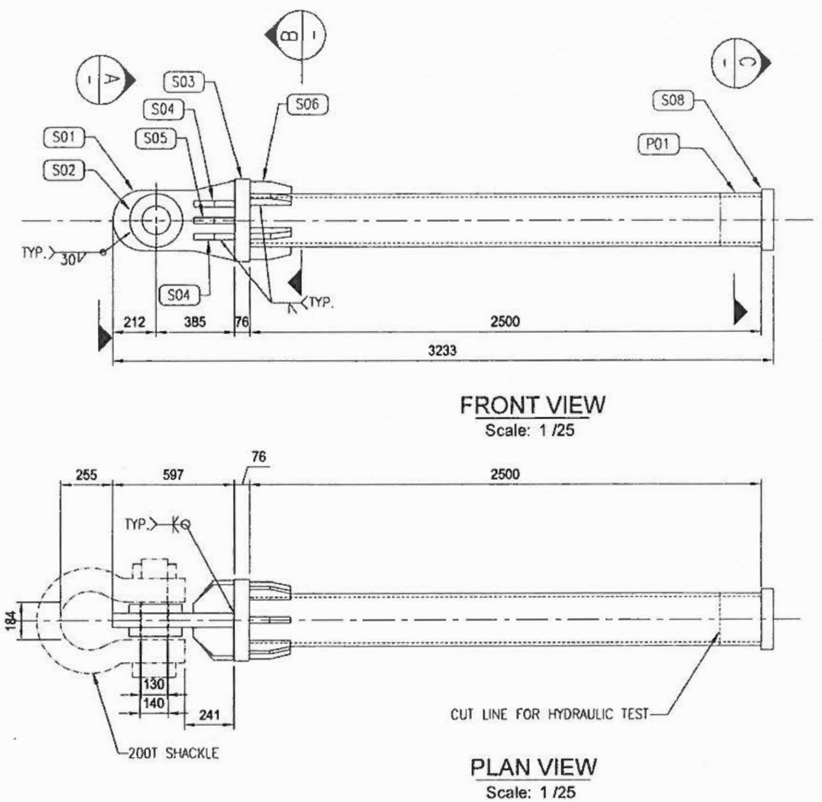
SIGNATORY	SIGNATURE	DATE
JOB No.	2018D15	
DRAWN		
DESIGNED	周杨	2019.7
CHECKED	[illegible]	2019.7
REVIEWED	[illegible]	2019.7
EXAMINED	[illegible]	2019.7
APPROVED	[illegible]	2019.7

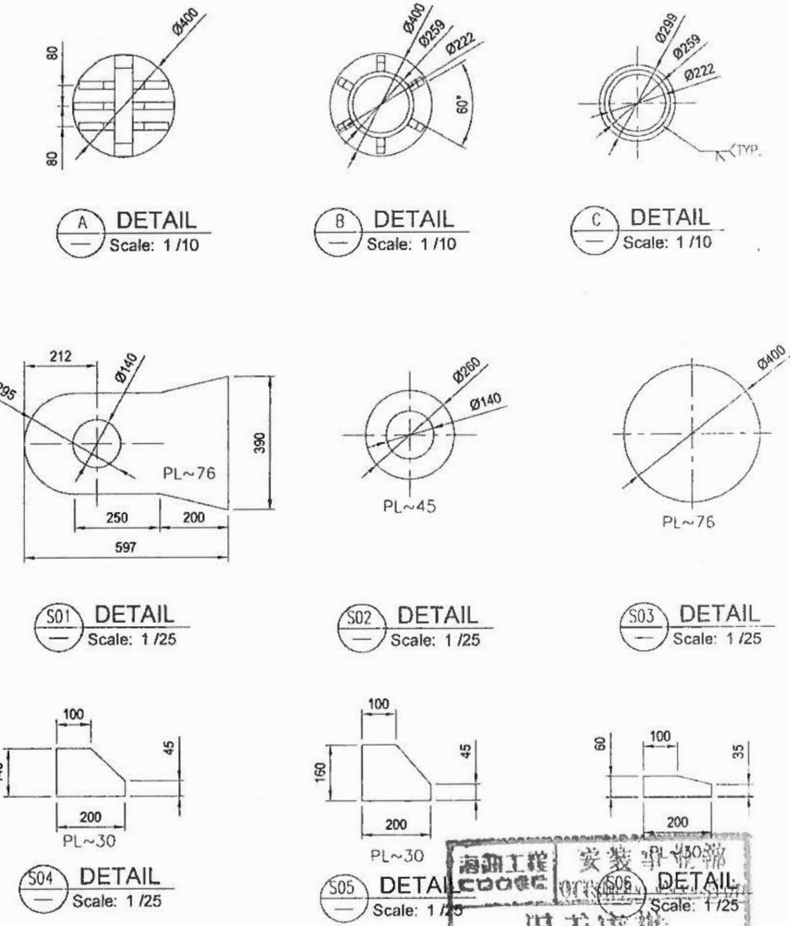
PROJECT: [illegible] GAS FIELD DEVELOPMENT

DRAWING OF 10IN PIPE START UP HEAD

SCALE: N.T.S.

REV. 1





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	PIPE10"(WT.18.3mm)	APIX65	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" LAYDOWN HEAD" SHOULD BE MARKED ON PIPE WITH BLACK PAINT, THE WORD HEIGHT SHALE 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.

用于审批
FOR APPROVAL

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

REVISION No.	DATE	DESCRIPTION	BY	CH'K.	REV'W.	EXAM.	APPRO.
1	2019.8.3	FOR GENERAL DESIGN MODIFICATION	周郁	孙淑超	周楠	李斌	陈永新
0		ISSUED FOR APPROVAL	ZA	[illegible]	ZA	LF	CYX

JOB No.	2018D15	
CLIENT	[illegible]	
SIGNATORY	SIGNATURE	DATE
DRAWN		
DESIGNED	周杨	2019.7
CHECKED	孙庆辉	2019.7
REVIEWED	周楠	2019.7
EXAMINED	李斌	2019.7
APPROVED	陈永新	2019.7

Offshore Oil Engineering Co.,Ltd.

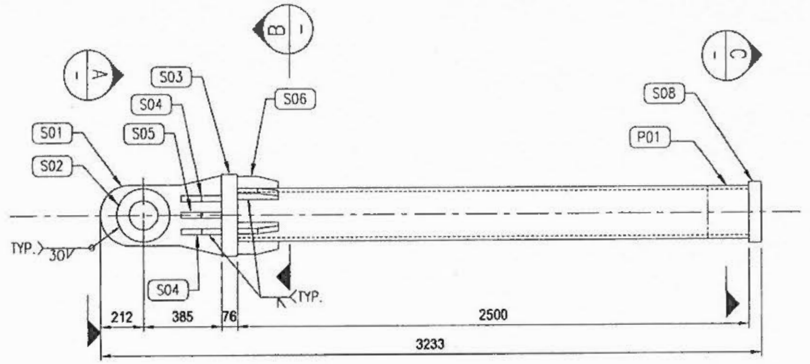
PROJECT: LS17-2 GAS FIELD DEVELOPMENT

DRAWING OF 10IN PIPE LAYDOWN HEAD

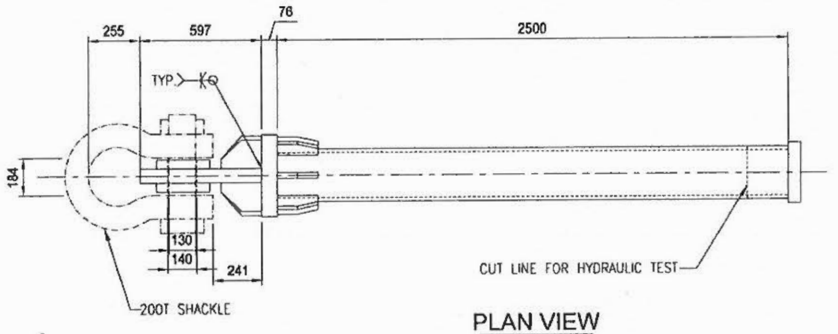
DWG No. [illegible]

CERTIF. No. [illegible]
SCALE N.T.S.
WEIGHT(kg) N.A.
REV. 1

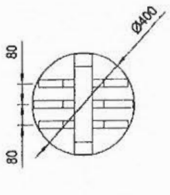
OI-DWG-SPF-SP-1003



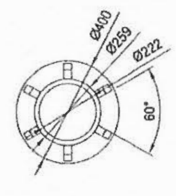
FRONT VIEW
Scale: 1 /25



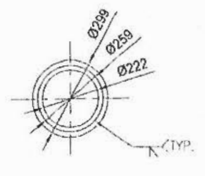
PLAN VIEW
Scale: 1 /25



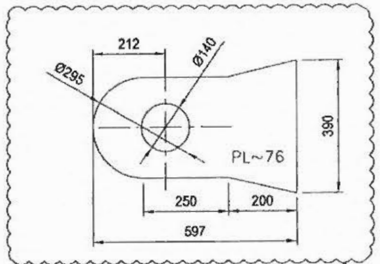
A DETAIL
Scale: 1 /10



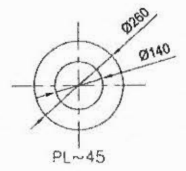
B DETAIL
Scale: 1 /10



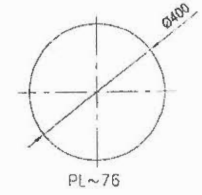
C DETAIL
Scale: 1 /10



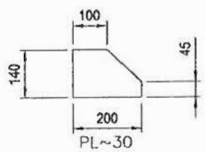
S01 DETAIL
Scale: 1 /25



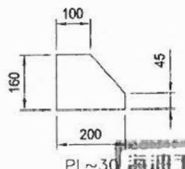
S02 DETAIL
Scale: 1 /25



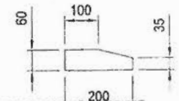
S03 DETAIL
Scale: 1 /25



S04 DETAIL
Scale: 1 /25



S05 DETAIL
Scale: 1 /25



S06 DETAIL
Scale: 1 /25

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	PIPE10"(WT.18.3mm)	APIX65	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" A&R HEAD" SHOULD BE MARKED ON PIPE WITH BLACK PAINT, THE WORD HEIGHT SHALE 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.

海油工程 安装事业部 Offshore
用于审批
FOR APPROVAL

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

REVISION No.	DATE	DESCRIPTION	BY	CH'K.	REV'D.	EXAM.	APPR.
1	2019.8.23	FOR GENERAL DESIGN MODIFICATION					
0		ISSUED FOR APPROVAL					

JOB No.	20180915	
CLIENT	[illegible]	
SIGNATORY	SIGNATURE	DATE
DRAWN		
DESIGNED	[illegible]	2019.7
CHECKED	[illegible]	2019.7
REVIEWED	[illegible]	2019.7
EXAMINED	[illegible]	2019.7
APPROVED	[illegible]	2019.7

Offshore Oil Engineering Co.,Ltd.

PROJECT: LS17-2 GAS FIELD DEVELOPMENT

DRAWING OF 10IN PIPE A&R HEAD

DWG No. OI-DWG-SPF-SP-1003

CERTIF. No. [illegible]
SCALE N.T.S
WEIGHT(Kg) N.A

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, Nanshan District, Shenzhen.
电话/TEL: 0755-86274981/26440278
URL: http://www.cjpsz.com E-mail:cjpsz126@126.com