



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-MT001-19-063

页数 Number of pages : 共 9 页

报告日期 Report Date : 2019.08.29

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

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

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 1 for Head and COLLAR ProtectorProduction

Report Date:

2019. 08. 29

Report No. :CJP-WR-051-361-MT001-19-063

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 01-DWG-SPF-SP-1002 10"终止封头 01-DWG-SPF-SP-1003 10"临时弃管封头	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 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-1001-1	H-109	9	--	K	GTAW/GMAW	--	--	--	Acc
01-DWG-SPF-SP-1001-1	H001	10	--	V	GTAW/SMAW	--	--	--	Acc
01-DWG-SPF-SP-1001-2	WI108	9	--	K	GTAW/GMAW	--	--	--	Acc
01-DWG-SPF-SP-1001-2	H001	10	--	V	GTAW/SMAW	--	--	--	Acc
01-DWG-SPF-SP-1001-3	LW740	9	--	K	GTAW/GMAW	--	--	--	Acc
01-DWG-SPF-SP-1001-3	H001	10	--	V	GTAW/SMAW	--	--	--	Acc
01-DWG-SPF-SP-1001-4	H-109	9	--	K	GTAW/GMAW	--	--	--	Acc
01-DWG-SPF-SP-1001-4	H001	10	--	V	GTAW/SMAW	--	--	--	Acc
01-DWG-SPF-SP-1002-1	WI108	9	--	K	GTAW/GMAW	--	--	--	Acc
01-DWG-SPF-SP-1002-1	H001	10	--	V	GTAW/SMAW	--	--	--	Acc
01-DWG-SPF-SP-1002-2	LW740	9	--	K	GTAW/GMAW	--	--	--	Acc
01-DWG-SPF-SP-1002-2	H001	10	--	V	GTAW/SMAW	--	--	--	Acc
01-DWG-SPF-SP-1002-3	H-109	9	--	K	GTAW/GMAW	--	--	--	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	Du Bang hua 2019. 08. 29	Tang Yuezhu 2019. 08. 29	2019. 08. 29

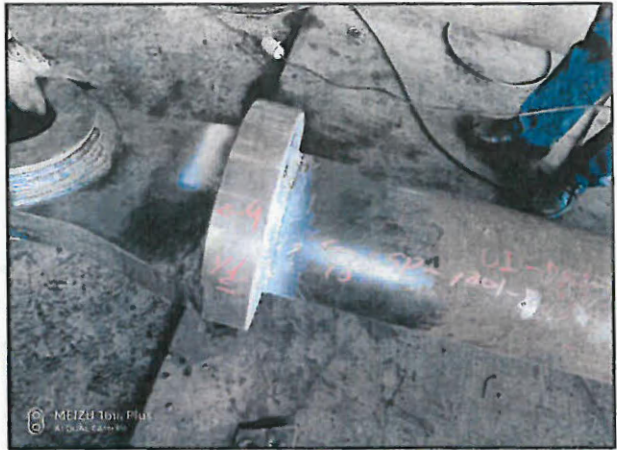
检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-361-MT001-19-063



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



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



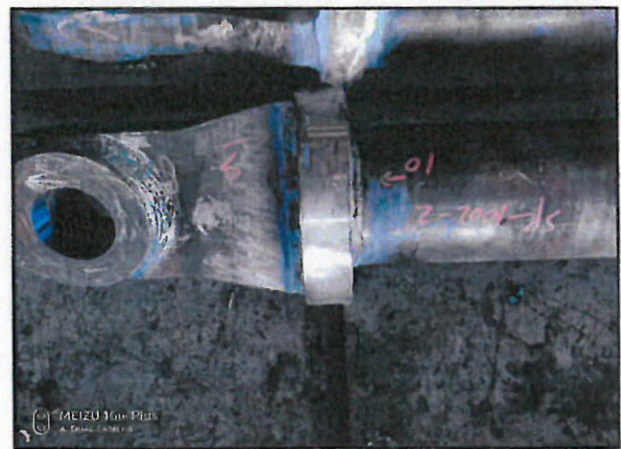
OI-DWG-SPF-SP-1001-3 9/10



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

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



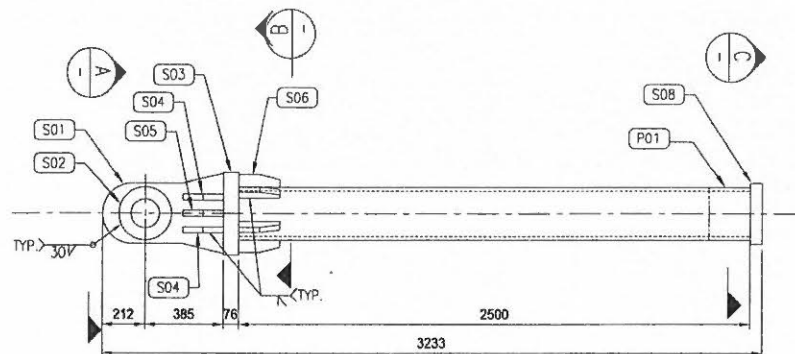
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OI-DWG-SPF-SP-1003-1 9/10

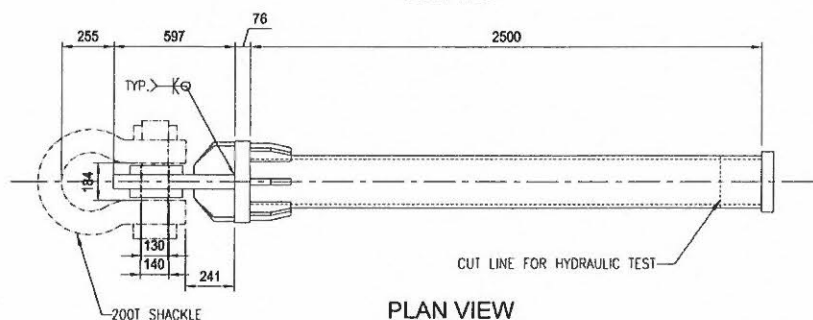


OI-DWG-SPF-SP-1003-2 9/10



FRONT VIEW

Scale: 1/25



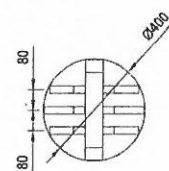
PLAN VIEW

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	

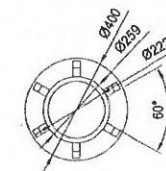
NOTES:

- 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.



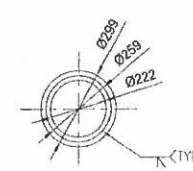
DETAIL A

Scale: 1/10



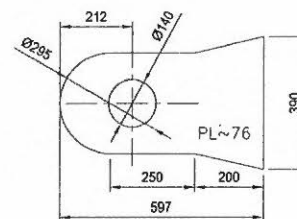
DETAIL B

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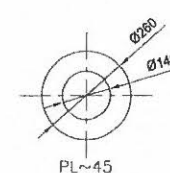
DETAIL C

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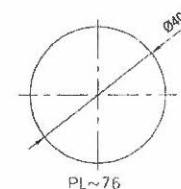
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Scale: 1/25



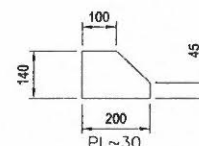
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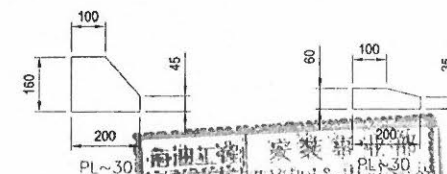
DETAIL S03

Scale: 1/25



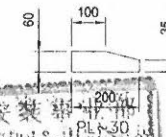
DETAIL S04

Scale: 1/25



DETAIL S05

Scale: 1/25



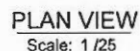
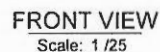
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Scale: 1/25



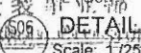
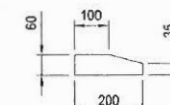
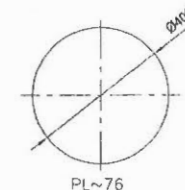
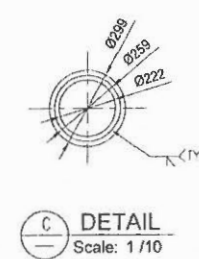
2	01-CAL-SPF-SP-1002	10IN FLOWLINE PIPELAY STATIC ANALYSIS
1	01-CAL-SPF-SP-1001	STRENGTH CHECK FOR 10IN PIPELINE PULLING HEAD
REF.#	DOCUMENT NO.	DESCRIPTION

REV. NO.	1	01-CAL-SPF-SP-1001	10IN FLOWLINE PIPELAY STATIC ANALYSIS	WANG	WANG	WANG	2019.7.12
	0	01-CAL-SPF-SP-1000	10IN FLOWLINE PIPELAY STATIC ANALYSIS	WANG	WANG	WANG	2019.7.12
REV. NO.	DATE	DESCRIPTION	BY	CHK'D	APP'D	DATE	
1	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	
2	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	
3	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	
4	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	
5	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	
6	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	
7	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	
8	2019.7.12	FOR APPROVAL	WANG	WANG	WANG	2019.7.12	



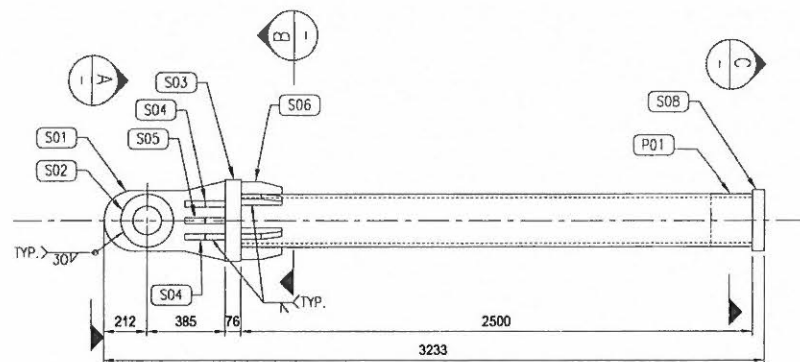
NOTES:

- 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(1.5X)M/PA 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 WELD HEIGHT SHALE BE CHOSEN IN 10MM.
- 5) THE QUANTITY OF HEADS IS TWO(2).
- 6) WELDING METHOD REFERS TO GB503.3-2011.
- 7) THE FLOODED PIPELAY TENSION IS 160 TONS, SAFETY FACTOR OF THE HEAD IS 2.0.



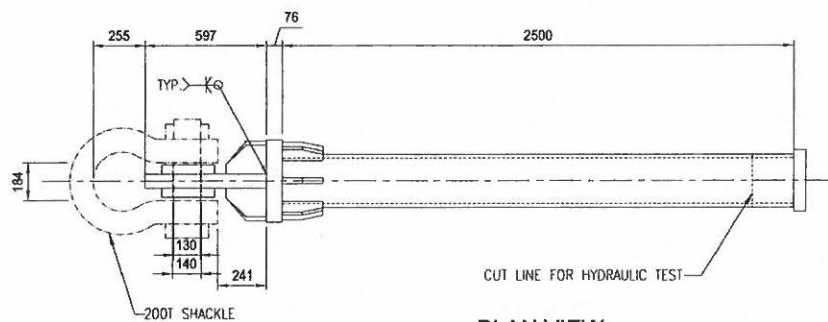
REVISION	1	2016.9.3	FOR GENERAL DESIGN MODIFICATION	周杨	林博	周杨	林博	徐红
	0		ISSUED FOR APPROVAL	ZY	SZY	ZY	LY	LYX
No.	DATE	DESCRIPTION	BY	CHK'D	APPR'D	EXAM	APPROV	
Item No.	2016.10.15							
CLIENT	CHINA TONGHAI OILFIELD	 Offshore Oil Engineering Co., Ltd.						
SIGNATURE	SIGNATURE	DATE	PROJECT: 1402-2 GAS FIELD DEVELOPMENT					DATE:
DESIGNED	周杨	2016.9.	DRAWING OF 101N PIPE LAYDOWN HEAD					DATE:
CHECKED	林博	2016.9.						DATE:
REVIEWED	周杨	2016.9.						DATE:
EXAMINED	李斌	2016.9.						DATE:
APPROVED	陈永强	2016.9.	DATE:	NO-100-019-01-1002				DATE:

0001-JS-445-040-10



FRONT VIEW

Scale: 1/25



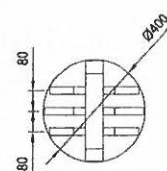
PLAN VIEW

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	16.65
P01	1	PIPE 10" (WT. 18.3mm)	APIX65	380.0	380.0
TOTAL					712.45

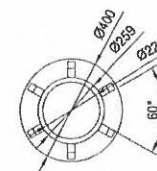
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- 3) LEAK TEST SHALL BE PERFORMED AT 24(1.5X16)MPA FOR 6 HOURS AT FABRICATION YARD.
- 4) THE SURFACE OF HEAD NEED TO BE COATED WITH ANTI-RUST YELLOW PAINT AND THE WORDS "10" A&R HEAD" SHOULD BE MARKED ON PIPE WITH BLACK PAINT, THE WORD HEIGHT SHALL 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.



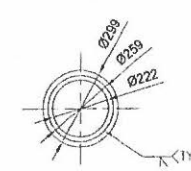
A DETAIL

Scale: 1/10



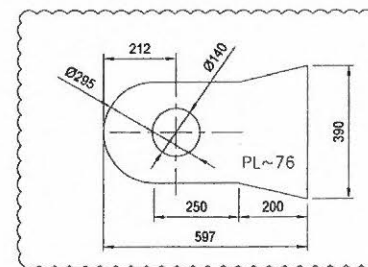
B DETAIL

Scale: 1/10



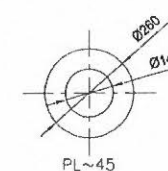
C DETAIL

Scale: 1/10



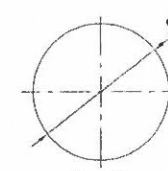
S01 DETAIL

Scale: 1/25



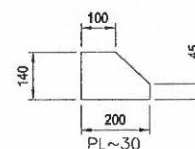
S02 DETAIL

Scale: 1/25



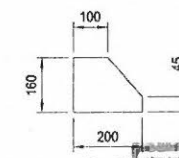
S03 DETAIL

Scale: 1/25



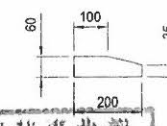
S04 DETAIL

Scale: 1/25



S05 DETAIL

Scale: 1/25



S06 DETAIL

Scale: 1/25



REV	DATE	DESCRIPTION	BY	CHK	DATE	CHK	DATE
1	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
2	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
3	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
4	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
5	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
6	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
7	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
8	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
9	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12
10	2019.7.12	FOR GENERAL DESIGN MODIFICATION	张永源	张永源	2019.7.12	张永源	2019.7.12

DRAWING OF 10IN PIPE A&R HEAD



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