



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: 陆丰平台停产管线更换及火炬臂防腐服务

Replacement of Outage Pipeline and Anti-corrosion Service of Torch Arm of Lufeng Platform

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-051-368-19-076

检测方法 Inspection Method : MT

报告编号 Report No. : CJP-WR-051-368-MT001-19-076

页数 Number of pages : 共 8 页

报告日期 Report Date : 2019.10.11

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

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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: 陆丰平台停产管线更换及火炬臂防腐服务

报告日期

报告编号:

Project Name: Replacement of Outage Pipeline and Anti-corrosion Service of Torch Arm of Lufeng Platform

Report Date: 2019. 10. 11

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检测地点 Testing Position	QPOC	执行标准 Executive Standard		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.	—	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	A105/A106/A234	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
IWO/19/08/A246	H001	W001	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H001	W002	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H001	W003	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H001	W004	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H001	W005	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H001	W006	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H001	W007	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H020	W008	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H020	W008A	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H020	W009	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H020	W009A	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H020	W010	—	V	GTAW	—	—	—	Acc
IWO/19/08/A246	H020	W010A	—	V	GTAW	—	—	—	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	Liu Wenzhong 2019.10.11	Tang Yuesu 2019.10.11	2019.10.11



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:陆丰平台停产管线更换及火炬臂防腐服务

报告日期

报告编号:

Project Name:Replacement of Outage Pipeline and Anti-corrosion Service of Torch Arm of Lufeng Platform

Report Date: 2019.10.11

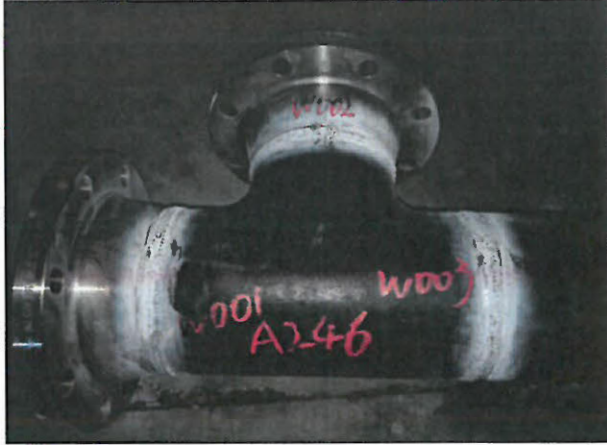
Report No.:CJP-WR-051-368-MT001-19-076

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
IWO/19/08/A246	H020	W011	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W012	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W015	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W018	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W019	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H001	W022	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H001	W023	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W024	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W025	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W026	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W027	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W028	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W029	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W030	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W031	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W032	---	V	GTAW	---	---	---	Acc
IWO/19/08/A246	H020	W033	---	V	GTAW	---	---	---	Acc
END									
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)				
		检验员 (Inspector)			技术监督 (Tech. Supervisor)		签字授权人 (Authorized Signee)		
签字 Sign		Lin Wenzhong			Tang Xue		2019.10.11		
日期 Date		2019.10.11			2019.10.11		2019.10.11		

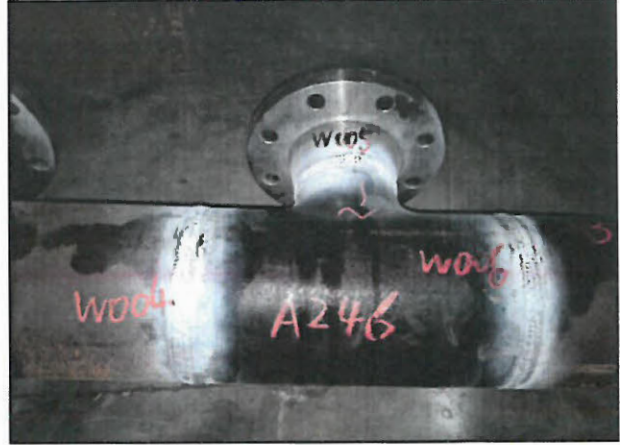
检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-368-MT001-19-076



W001 W002 W003



W004 W005 W006



W007



W008 W008A



W009 W009A



W010

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-368-MT001-19-076



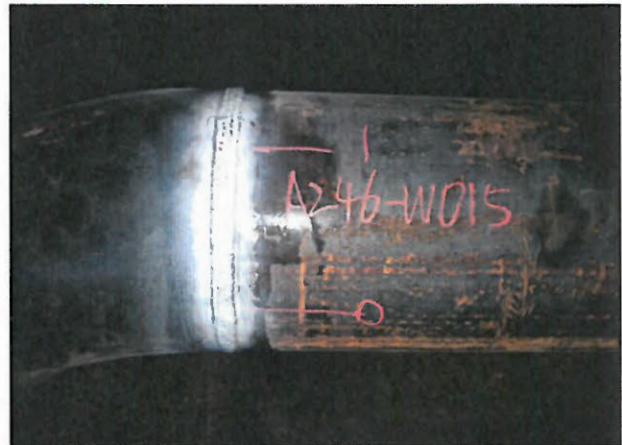
W010A



W011



W012



W015



W018

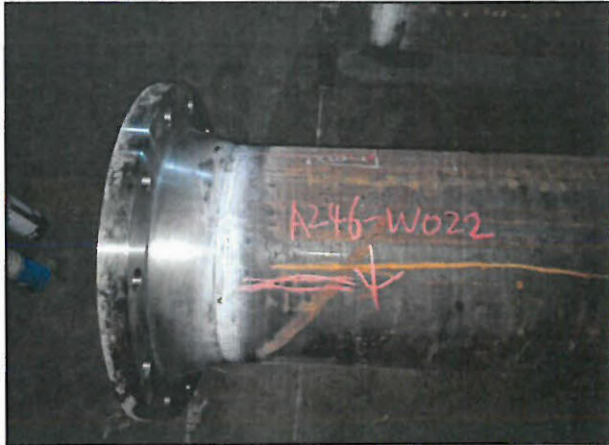


W019

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-368-MT001-19-076



W022



W023



W024



W025



W026



W027

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-051-368-MT001-19-076



W028



W029



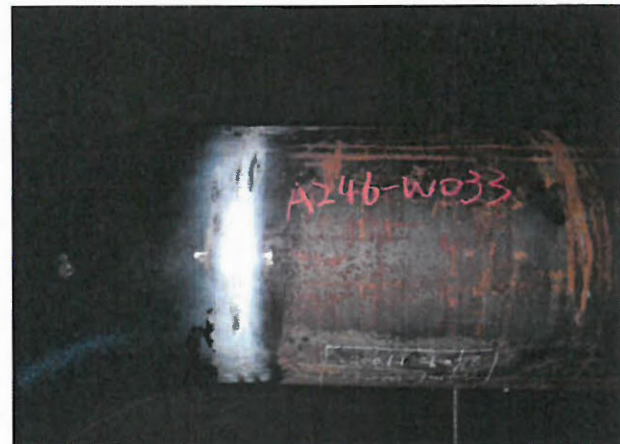
W030



W031



W032



W033



备注

Remark

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Report without the specified inspection stamp of CJP company is invalid.
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Report without the signatures of operator of film judge, tech. supervisor and tech. principal is invalid.
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Report is in triplicity, original stored in CJP company, two copies for client.
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The data and result of the inspection report that unsealed can not be proved to society.

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