



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:

HFLRepair at Workshop

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-051-349-19-021

检测方法 Inspection Method : RT

报告编号 Report No. : CJP-WR-051-349-RT001-19-021

页数 Number of pages : 3

报告日期 Report Date : 2019.04.10

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

射线检测报告
RADIOGRAPHIC INSPECTION REPORT

项目名称:

Project Name:HFL Repair at Workshop

报告日期

Report Date:2019.04.10

报告编号

Report No.CJP-WR-051-349-RT001-19-021

检测地点 Test Position		诚锦鹏车间 CJP Workshop		放射源 Source		XXG-2505		底片黑度 Film Density		2.0~4.0		显影温度 Developing Temperature		20℃	
图纸号 Drawing No.		---		焦点尺寸 Focus Size		2×2		X-管电压 X-Tube Voltage		230kV		显影时间 Developing Time		5min	
执行标准 Executive Standard		ASME B31.3		增感方式 Intensifying Screen		Pb(0.1×2)mm		X-管电流(源强) X-Tube Current(Activity)		5mA		定影温度 Fixing Temperature		20℃	
工件材质 Material		---		焦距 SFD		1000mm		像质计IQI		ASTM - 1A		定影时间 Fixing Time		15min	
检测比例 Testing Rate		100%		胶片类性 Film Type		AGFA-C7		曝光时间 Exposure Time		4min		透照方法 Exposure Technique		DWSI	
序号 No.	工件号 Workpiece No.	焊缝号 Weld No.	焊工号 Welder No.	底片编号 Film No.	焊接方法 Welding Process	焊缝长度 W. L(mm)	直径/厚度 Dia/THK (mm)	缺陷情况 Defect Condition (mm)	意见 Judge		返修次数 Repair Times	返修报告 Repair Report No.			
									级别 Grade	结果 Result					
1	AR+N2×2	---	---	A	GTAW	---	Φ15.5×1.5	N. S. D	---	Acc	---	---			
2	AR+N2×2	---	---	B	GTAW	---	Φ15.5×1.5	N. S. D	---	Acc	---	---			
3	AR+N2×2	---	---	C	GTAW	---	Φ15.5×1.5	N. S. D	---	Acc	---	---			
4	AR+N2×AR	---	---	A	GTAW	---	Φ15.5×1.5	N. S. D	---	Acc	---	---			
5	AR+N2×AR	---	---	B	GTAW	---	Φ15.5×1.5	夹钨(Φ0.5×1)	---	Acc	---	---			
6	AR+N2×AR	---	---	C	GTAW	---	Φ15.5×1.5	N. S. D	---	Acc	---	---			
END															
注(Notes): 未熔合(LOF-Lack of Fusion) 根部凹陷(RC-Root Concavity) 裂纹(C-Crack) 气孔(P-Porosity) 夹渣(S.I-Slag Inclusion) 未焊透(LOP-Lack of Penetration) 咬边(UC-Undercut) 无记录缺陷(N. S. D-No Recordable Defect) 合格(Acc-Acceptance) 不合格(Re-Rejection)															
签字 Signature		检验员(Inspector)				技术监督(Tech. Supervisor)				签字授权人(Authorized Signee)					
日期 Date		2019.04.10				2019.04.10				2019.04.10					



备注

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The data and result of the inspection report that unsealed can not be proved to society.

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