



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: 惠州 32-5 油田综合调整惠州 33-1 油田联合开发

项目井口管线回接标段一 焊工考试

Huizhou 32-5 Oilfield Comprehensive Adjustment Huizhou 33-1

Oilfield Joint Development Project Wellhead Pipeline Marking

Section 1 Welder Examination

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-051-329-18-069

检测方法 Inspection Method : RT

报告编号 Report No. : CJP-WR-051-329-RT001-18-069

页数 Number of pages : 3

报告日期 Report Date : 2018.10.26

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

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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:惠州32-5油田综合调整惠州33-1油田联合开发项目井口管线回接标段一 焊工考试
Project Name:Huizhou 32-5 Oilfield Comprehensive Adjustment Huizhou 33-1 Oilfield
Joint Development Project Wellhead Pipeline Marking Section 1 Welder Examination

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检测地点 Test Position	太平洋车间 QPOC 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	220KV	显影时间 Developing Time	5min				
执行标准 Executive Standard	ASME IX-2017	增感方式 Intensifying Screen	pb0.1×2mm	X-管电流(源强) X-Tube Current(Activity)	5mA	定影温度 Fixing Temperature	20℃				
工件材质 Material	UNS C70600 A106B	焦距 SFD	600mm	像质计IQI	ASTM 4A ASTM 1B	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	4.2 min	透照方法 Exposure Technique	垂直透照				
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	P-01	-	H020	A	GTAW	60.3	60.3/4	---	---	Acc	---
2	P-01	-	H020	B	GTAW	60.3	60.3/4	---	---	Acc	---
3	P-01	-	H020	C	GTAW	60.3	60.3/4	---	---	Acc	---
4	P-02	-	HY007	A	GTAW	60.3	60.3/4	---	---	Acc	---
5	P-02	-	HY007	B	GTAW	60.3	60.3/4	PΦ1×1	---	Acc	---
6	P-02	-	HY007	C	GTAW	60.3	60.3/4	PΦ1×1	---	Acc	---
7	P-03	-	HY007	A	GTAW	60.3	60.3/11.07	---	---	Acc	---
8	P-03	-	HY007	B	GTAW	60.3	60.3/11.07	---	---	Acc	---
8	P-03	-	HY007	C	GTAW	60.3	60.3/11.07	---	---	Acc	---
10	P-04	-	HY004	A	GTAW	60.3	60.3/4	---	---	Acc	---
11	P-04	-	HY004	B	GTAW	60.3	60.3/4	---	---	Acc	---
12	P-04	-	HY004	C	GTAW	60.3	60.3/4	---	---	Acc	---

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(Rej-Rejection)

签字 Signature	检验员(Inspector) Li Jie	技术监督(Tech. Supervisor) Tang Yue Zu	签字授权人(Authorized Signee) Tang Yue Zu
日期 Date	2018-10-26	2018.10.26	2018.10.26



备注

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