



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: 南海二号伸缩节修理

Expansion Joint Maintenance on NH2

委托单位 Commission Unit : 深圳市任俊锋实业有限公司

委托单位地址 Client Address: 惠州市惠阳区淡水镇新桥村

工程编号 Project No. : CJP-WR-083-146-18-083

检测方法 Inspection Method : RT

报告编号 Report No. : CJP-WR-083-146-RT001-18-083

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报告日期 Report Date : 2018.12.11

批准人 Approved by :



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射线检测 报告  
RADIOGRAPHIC INSPECTION REPORT

项目名称:南海二号伸缩节修理

Project Name: Expansion Joint Maintenance on NH2

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| 检测地点               |              | R/JF Workshop |        | 放射源                 |     | Ir192       |        | 底片黑度                  |     | 2.0~4.0    |     | 显影温度             |     | 20℃               |     |
|--------------------|--------------|---------------|--------|---------------------|-----|-------------|--------|-----------------------|-----|------------|-----|------------------|-----|-------------------|-----|
| Test Position      |              | ---           |        | 焦点尺寸                |     | 3×3         |        | X-管电压                 |     | ---        |     | 显影时间             |     | 5min              |     |
| 图纸号                |              | API-1104      |        | 增感方式                |     | Pb(0.1×2)mm |        | X-管电流(源强)             |     | 30 Ci      |     | 定影温度             |     | 20℃               |     |
| Drawing No.        |              | X80/4130      |        | 焦距 SFD              |     | 117mm/307mm |        | 像质计 IQI               |     | ASTM IB    |     | 定影时间 Fixing Time |     | 15min             |     |
| 执行标准               |              | 100%          |        | 胶片类型 Film Type      |     | AGFA-C7     |        | 曝光时间 Exposure Time    |     | 1.2/1.6min |     | 透照方法             |     | DWSI/SWSI         |     |
| Executive Standard |              | ---           |        | Intensifying Screen |     | ---         |        | 缺陷情况                  |     | ---        |     | 返修次数             |     | 返修报告              |     |
| Workpiece No.      |              | Weld No.      |        | Welding Process     |     | W.L.(mm)    |        | Defect Condition (mm) |     | Grade      |     | Repair Times     |     | Repair Report No. |     |
| No.                |              | No.           |        | No.                 |     | (mm)        |        | (mm)                  |     | Result     |     | Result           |     | Result            |     |
| 1                  | NH2-2#TJ-010 | W1            | RJF-05 | 0-1                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | Acc | ---              | --- | ---               | --- |
| 2                  | NH2-2#TJ-010 | W1            | RJF-05 | 1-2                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | Acc | ---              | --- | ---               | --- |
| 3                  | NH2-2#TJ-010 | W1            | RJF-05 | 2-3                 | --- | 57.6        | 110/22 | PΦ3*1                 | --- | ---        | Acc | ---              | --- | ---               | --- |
| 4                  | NH2-2#TJ-010 | W1            | RJF-05 | 3-4                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | Acc | ---              | --- | ---               | --- |
| 5                  | NH2-2#TJ-010 | W1            | RJF-05 | 4-5                 | --- | 57.6        | 110/22 | PΦ3*1                 | --- | ---        | Acc | ---              | --- | ---               | --- |
| 6                  | NH2-2#TJ-010 | W1            | RJF-05 | 5-0                 | --- | 57.6        | 110/22 | PΦ2*1                 | --- | ---        | Acc | ---              | --- | ---               | --- |
| 7                  | NH2-2#TJ-010 | W2            | RJF-05 | 0-1                 | --- | 57.6        | 110/22 | LOF L=11mm            | --- | ---        | Acc | ---              | --- | ---               | --- |
| 8                  | NH2-2#TJ-010 | W2            | RJF-05 | 1-2                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | Acc | ---              | --- | ---               | --- |
| 8                  | NH2-2#TJ-010 | W2            | RJF-05 | 2-3                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | Acc | ---              | --- | ---               | --- |
| 10                 | NH2-2#TJ-010 | W2            | RJF-05 | 3-4                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | Acc | ---              | --- | ---               | --- |
| 11                 | NH2-2#TJ-010 | W2            | RJF-05 | 4-5                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | Acc | ---              | --- | ---               | --- |
| 12                 | NH2-2#TJ-010 | W2            | RJF-05 | 5-0                 | --- | 57.6        | 110/22 | ---                   | --- | ---        | 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.Slag Inclusion)

未焊透 (LOP-Lack of Penetration) 咬边 (IIC-Undercut) 无记录缺陷 (N.S.D-No Recordable Defect) 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

日期 Date

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# RADIOGRAPHIC INSPECTION REPORT

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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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