



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-RT002-18-083

页数 Number of pages : 4

报告日期 Report Date : 2018.12.11

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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射线检测报告
RADIOGRAPHIC INSPECTION REPORT

项目名称: 南海二号伸缩节修理

报告编号

Project Name: Expansion Joint Maintenance on NH2

报告日期

Report No. CJP-WR-083-146-RT002-18-083

检测地点 Test Position	RJF Workshop	放射源 Source	Ir192	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	3×3	X-管电压 X-Tube Voltage	--	显影时间 Developing Time	5min				
执行标准 Executive Standard	API-1104	增强方式 Intensifying Screen	Pb0.1×2mm	X-管电流 (源强) X-Tube Current (Activity)	30ci	定影温度 Fixing Temperature	20℃				
工件材质 Material	X80/4130	焦距 SFD	274/317/307mm	像质计 IQI	ASTM 1B	定影时间 Fixing Time	15min				
检测比例 Testing Rate	100%	胶片类型 Film Type	AGFA-C7	曝光时间 Exposure Time	1.6/2.1min	透照方法 Exposure Technique	SWSI				
序号 No.	工件号 Workpiece No.	焊缝号 Weid 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.
1	NH2-RJF-TJ-005	W3	RJF-05	0-1	SMAW	285	544/19.5	PΦ1×2	--	Acc	--
2	NH2-RJF-TJ-005	W3	RJF-05	1-2	SMAW	285	544/19.5	PΦ1×1	--	Acc	--
3	NH2-RJF-TJ-005	W3	RJF-05	2-3	SMAW	285	544/19.5	PΦ2×1	--	Acc	--
4	NH2-RJF-TJ-005	W3	RJF-05	3-4	SMAW	285	544/19.5	PΦ4×3 条缺L=7mm	--	Rej	1
5	NH2-RJF-TJ-005	W3 R1	RJF-05	3-4	SMAW	285	544/19.5	PΦ1×4	--	Acc	--
6	NH2-RJF-TJ-005	W3	RJF-05	4-5	SMAW	285	544/19.5	PΦ2×1	--	Acc	--
7	NH2-RJF-TJ-005	W3	RJF-05	5-0	SMAW	285	544/19.5	--	--	Acc	--
8	NH2-RJF-TJ-005	W1	RJF-05	0-1	SMAW	248	630/19	--	--	Acc	--
9	NH2-RJF-TJ-005	W1	RJF-05	1-2	SMAW	248	630/19	PΦ1×1	--	Acc	--
10	NH2-RJF-TJ-005	W1	RJF-05	2-3	SMAW	248	630/19	--	--	Acc	--
11	NH2-RJF-TJ-005	W1	RJF-05	3-4	SMAW	248	630/19	PΦ2.5×1 Φ1×1	--	Acc	--
12	NH2-RJF-TJ-005	W1	RJF-05	4-5	SMAW	248	630/19	PΦ1×1	--	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) 合格 (Acc-Acceptance) 不合格 (Rej-Rejection)											
未焊透 (LOP-Lack of Penetration) 咬边 (UC-Undercut) 无记录缺陷 (N.S.D-No Recordable Defect)											
检验员 (Inspector)				技术监督 (Tech. Supervisor)				签字授权人 (Authorized Signee)			
签字 Signature				Li Jie				Tang Yue zu			
日期 Date				2018.12.11				2018.12.11			



射线检测报告 (续表)
RADIOGRAPHIC INSPECTION REPORT

项目名称:南海二号伸缩节修理

Project Name: Expansion Joint Maintenance on NH2

报告日期

Report Date:2018.12.11

报告编号

Report No. CJP-WR-083-146-RT002-18-083

序号 No.	工件号 Workpiece No.	焊缝号 Weid 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		
13	NH2-RJF-TJ-005	W1	RJF-05	5-6	SMAW	248	630/19	PΦ1×2	---	Acc	---	---
14	NH2-RJF-TJ-005	W1	RJF-05	6-7	SMAW	248	630/19	PΦ1×2	---	Acc	---	---
15	NH2-RJF-TJ-005	W1	RJF-05	7-0	SMAW	248	630/19	PΦ1×1	---	Acc	---	---
16	NH2-RJF-TJ-003	W6	RJF-05	0-1	SMAW	240	610/15.87	---	---	Acc	---	---
17	NH2-RJF-TJ-003	W6	RJF-05	1-2	SMAW	240	610/15.87	LOF L=40mm	---	Acc	---	---
18	NH2-RJF-TJ-003	W6	RJF-05	2-3	SMAW	240	610/15.87	---	---	Acc	---	---
19	NH2-RJF-TJ-003	W6	RJF-05	3-4	SMAW	240	610/15.87	---	---	Acc	---	---
20	NH2-RJF-TJ-003	W6	RJF-05	4-5	SMAW	240	610/15.87	---	---	Acc	---	---
21	NH2-RJF-TJ-003	W6	RJF-05	5-6	SMAW	240	610/15.87	---	---	Acc	---	---
22	NH2-RJF-TJ-003	W6	RJF-05	6-7	SMAW	240	610/15.87	---	---	Acc	---	---
23	NH2-RJF-TJ-003	W6	RJF-05	7-0	SMAW	240	610/15.87	LOF L=22mm	---	Acc	---	---
24	NH2-RJF-TJ-003	W5	RJF-05	0-1	SMAW	240	610/15.87	---	---	Acc	---	---
25	NH2-RJF-TJ-003	W5	RJF-05	1-2	SMAW	240	610/15.87	---	---	Acc	---	---
26	NH2-RJF-TJ-003	W5	RJF-05	2-3	SMAW	240	610/15.87	PΦ2×1	---	Acc	---	---
27	NH2-RJF-TJ-003	W5	RJF-05	3-4	SMAW	240	610/15.87	---	---	Acc	---	---
28	NH2-RJF-TJ-003	W5	RJF-05	4-5	SMAW	240	610/15.87	---	---	Acc	---	---
29	NH2-RJF-TJ-003	W5	RJF-05	5-6	SMAW	240	610/15.87	LOF L=10mm	---	Acc	---	---
30	NH2-RJF-TJ-003	W5	RJF-05	6-7	SMAW	240	610/15.87	---	---	Acc	---	---
31	NH2-RJF-TJ-003	W5	RJF-05	7-0	SMAW	240	610/15.87	LOF L=10mm	---	Acc	---	---
END												
注(Notes): 未熔合(LOF-Lack of Fusion) 根部凹陷(RC-Root Concavity) 夹渣(S.I-Slag Inclusion) 合格(Acc-Acceptance) 不合格(Rej-Rejection)												
未焊透(LOP-Lack of Penetration) 咬边(UC-Undercut) 无记录缺陷(N.S.D-No Recordable Defect)												
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LiJie					Tang Yue zu					Tang Yue zu		
日期 Date					2018.12.11					2018.12.11		



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

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