



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: NH5 2#伸缩节修理

NH5 2#Expansion Joint Repair

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-083-164-19-079

检测方法 Inspection Method : RT

报告编号 Report No. : CJP-WR-083-164-RT001-19-079

页数 Number of pages : 共 6 页

报告日期 Report Date : 2019.11.10

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

地 址: 深圳市南山区月亮湾大道 2076 号高科大厦六层 C3

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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:NH5 2#伸缩节修理

报告日期

报告编号

Project Name:NH5 2#Expansion Joint Repair

Report Date:2019.11.10

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检测地点 Test Position	惠州库房 Huizhou Storeroom	放射源 Source	XXG-3005/CJP-XS-11	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	2.5×2.5mm	X-管电压 X-Tube Voltage	280kv	显影时间 Developing Time	5min
执行标准 Executive Standard	API 1104	增感方式 Intensifying Screen	Pb(0.1×0.1)mm	X-管电流(源强) X-Tube Current(Activity)	5mA	定影温度 Fixing Temperature	20℃
工件材质 Material	4130	焦距 SFD	685mm/760mm	像质计 IQI	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	7.5/8.5min	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	NH5-RJF-2TJ-006	W1	RJF-05	0-1	GTAW+SMAW	1916	610×16	PΦ1×3	---	Acc	---	---
2	NH5-RJF-2TJ-006	W1	RJF-05	1-2	GTAW+SMAW	1916	610×16	PΦ2×1	---	Acc	---	---
3	NH5-RJF-2TJ-006	W1	RJF-05	2-3	GTAW+SMAW	1916	610×16	PΦ2.5×1	---	Acc	---	---
4	NH5-RJF-2TJ-006	W1	RJF-05	3-4	GTAW+SMAW	1916	610×16	密孔/LOF 20mm	---	Rej	---	---
5	NH5-RJF-2TJ-006	W1	RJF-05	3-4R1	GTAW+SMAW	1916	610×16	PΦ3×1	---	Acc	---	---
6	NH5-RJF-2TJ-006	W1	RJF-05	4-5	GTAW+SMAW	1916	610×16	密孔	---	Rej	---	---
7	NH5-RJF-2TJ-006	W1	RJF-05	4-5R1	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
8	NH5-RJF-2TJ-006	W1	RJF-05	5-6	GTAW+SMAW	1916	610×16	C	---	Rej	---	---
8	NH5-RJF-2TJ-006	W1	RJF-05	5-6R1	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
10	NH5-RJF-2TJ-006	W1	RJF-05	6-7	GTAW+SMAW	1916	610×16	C /LOF 10mm	---	Rej	---	---
11	NH5-RJF-2TJ-006	W1	RJF-05	6-7R1	GTAW+SMAW	1916	610×16	PΦ1×1	---	Acc	---	---
12	NH5-RJF-2TJ-006	W1	RJF-05	7-0	GTAW+SMAW	1916	610×16	LOF 10mm	---	Rej	---	---

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) 条缺(E.I-Elongated Indication)
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)	技术监督(Tech. Supervisor)	签字授权人(Authorized Signee)
日期 Date	2019.11.10	2019.11.10	2019.11.10



深圳市诚锦鹏实业有限公司
SHENZHEN CHENGJINPENG INDUSTRIAL CO.,LTD

射线检测报告 (续表)

RADIOGRAPHIC INSPECTION REPORT

项目名称:NH5 2#伸缩节修理

报告日期

报告编号

Project Name:NH5 2#Expansion Joint Repair

Report Date:2019.11.10

Report No.:CJP-WR-083-164-RT001-19-079

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		
13	NH5-RJF-2TJ-006	W1	RJF-05	7-0R1	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
14	NH5-RJF-2TJ-006	W2	RJF-05	0-1	GTAW+SMAW	1916	610×16	PΦ2×1	---	Acc	---	---
15	NH5-RJF-2TJ-006	W2	RJF-05	1-2	GTAW+SMAW	1916	610×16	PΦ2×1	---	Acc	---	---
16	NH5-RJF-2TJ-006	W2	RJF-05	2-3	GTAW+SMAW	1916	610×16	E. I 2mm	---	Acc	---	---
17	NH5-RJF-2TJ-006	W2	RJF-05	3-4	GTAW+SMAW	1916	610×16	PΦ1×2	---	Acc	---	---
18	NH5-RJF-2TJ-006	W2	RJF-05	4-5	GTAW+SMAW	1916	610×16	密孔/C	---	Rej	---	---
19	NH5-RJF-2TJ-006	W2	RJF-05	4-5R1	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
20	NH5-RJF-2TJ-006	W2	RJF-05	5-0	GTAW+SMAW	1916	610×16	密孔/LOF 20mm	---	Rej	---	---
21	NH5-RJF-2TJ-006	W2	RJF-05	5-0R1	GTAW+SMAW	1916	610×16	PΦ1×1/E. I 3mm	---	Acc	---	---
22	NH5-RJF-2TJ-003	W3	RJF-05	0-1	GTAW+SMAW	1916	610×16	LOF 38mm, 122mm	---	Rej	---	---
23	NH5-RJF-2TJ-003	W3	RJF-05	0-1R1	GTAW+SMAW	1916	610×16	LOF 6mm	---	Acc	---	---
24	NH5-RJF-2TJ-003	W3	RJF-05	1-2	GTAW+SMAW	1916	610×16	密孔	---	Rej	---	---
25	NH5-RJF-2TJ-003	W3	RJF-05	1-2R1	GTAW+SMAW	1916	610×16	E. I 2mm	---	Acc	---	---
26	NH5-RJF-2TJ-003	W3	RJF-05	2-3	GTAW+SMAW	1916	610×16	C	---	Rej	---	---
27	NH5-RJF-2TJ-003	W3	RJF-05	3-4	GTAW+SMAW	1916	610×16	E. I 10mm×2	---	Rej	---	---
28	NH5-RJF-2TJ-003	W3	RJF-05	3-4R1	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
29	NH5-RJF-2TJ-003	W3	RJF-05	4-5	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
30	NH5-RJF-2TJ-003	W3	RJF-05	5-0	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
31	NH5-RJF-2TJ-003	W4	RJF-05	0-1	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
32	NH5-RJF-2TJ-003	W4	RJF-05	1-2	GTAW+SMAW	1916	610×16	PΦ2×1	---	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) 条缺(E.I-Elongated Indication)
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) Lin Wenzhong	技术监督(Tech. Supervisor) Tang Yuesu	签字授权人(Authorized Signee) Tang Yuesu
日期 Date	2019.11.10	2019.11.10	2019.11.10



深圳市诚锦鹏实业有限公司
SHENZHEN CHENGJINPENG INDUSTRIAL CO.,LTD

射线检测报告 (续表)

RADIOGRAPHIC INSPECTION REPORT

项目名称:NH5 2#伸缩节修理

报告日期

报告编号

Project Name:NH5 2#Expansion Joint Repair

Report Date:2019.11.10

Report No.:CJP-WR-083-164-RT001-19-079

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		
33	NH5-RJF-2TJ-003	W4	RJF-05	2-3	GTAW+SMAW	1916	610×16	C	---	Rej	---	---
34	NH5-RJF-2TJ-003	W4	RJF-05	2-3R1	GTAW+SMAW	1916	610×16	---	---	Acc	---	---
35	NH5-RJF-2TJ-003	W4	RJF-05	3-4	GTAW+SMAW	1916	610×16	PΦ3×1	---	Acc	---	---
36	NH5-RJF-2TJ-003	W4	RJF-05	4-5	GTAW+SMAW	1916	610×16	PΦ1×1	---	Acc	---	---
37	NH5-RJF-2TJ-003	W4	RJF-05	5-0	GTAW+SMAW	1916	610×16	夹钎Φ1×1	---	Acc	---	---
38	NH5-RJF-2TJ-006	W5	RJF-05	0-1	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
39	NH5-RJF-2TJ-006	W5	RJF-05	1-2	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
40	NH5-RJF-2TJ-006	W5	RJF-05	2-3	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
41	NH5-RJF-2TJ-006	W5	RJF-05	3-4	GTAW+SMAW	1674	533×16	夹钎Φ1×1	---	Acc	---	---
42	NH5-RJF-2TJ-006	W5	RJF-05	4-5	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
43	NH5-RJF-2TJ-006	W5	RJF-05	5-0	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
44	NH5-RJF-2TJ-006	W6	RJF-05	0-1	GTAW+SMAW	1674	533×16	E. I 2mm	---	Acc	---	---
45	NH5-RJF-2TJ-006	W6	RJF-05	1-2	GTAW+SMAW	1674	533×16	E. I 3mm	---	Acc	---	---
46	NH5-RJF-2TJ-006	W6	RJF-05	2-3	GTAW+SMAW	1674	533×16	PΦ2×1	---	Acc	---	---
47	NH5-RJF-2TJ-006	W6	RJF-05	3-4	GTAW+SMAW	1674	533×16	PΦ1×4	---	Acc	---	---
48	NH5-RJF-2TJ-006	W6	RJF-05	4-5	GTAW+SMAW	1674	533×16	PΦ1×4	---	Acc	---	---
49	NH5-RJF-2TJ-006	W6	RJF-05	5-0	GTAW+SMAW	1674	533×16	PΦ2×1	---	Acc	---	---
50	NH5-RJF-2TJ-006	W7	RJF-05	0-1	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
51	NH5-RJF-2TJ-006	W7	RJF-05	1-2	GTAW+SMAW	1674	533×16	PΦ1×1	---	Acc	---	---
52	NH5-RJF-2TJ-006	W7	RJF-05	2-3	GTAW+SMAW	1674	533×16	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) 一条缺(E.I-Elongated Indication)
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检验员(Inspector)		技术监督(Tech. Supervisor)		签字授权人(Authorized Signee)	
签字 Signature		Tang Yuzhu		Tang Yuzhu	
日期 Date		2019.11.10		2019.11.10	



深圳市诚锦鹏实业有限公司
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项目名称:NH5 2#伸缩节修理

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Report No.:CJP-WR-083-164-RT001-19-079

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		
53	NH5-RJF-2TJ-006	W7	RJF-05	3-4	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
54	NH5-RJF-2TJ-006	W7	RJF-05	4-5	GTAW+SMAW	1674	533×16	C	---	Rej	---	---
55	NH5-RJF-2TJ-006	W7	RJF-05	4-5R1	GTAW+SMAW	1674	533×16	PΦ1×1	---	Acc	---	---
56	NH5-RJF-2TJ-006	W7	RJF-05	5-0	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
57	NH5-RJF-2TJ-006	W8	RJF-05	0-1	GTAW+SMAW	1674	610×16	---	---	Acc	---	---
58	NH5-RJF-2TJ-006	W8	RJF-05	1-2	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
59	NH5-RJF-2TJ-006	W8	RJF-05	2-3	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
60	NH5-RJF-2TJ-006	W8	RJF-05	3-4	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
61	NH5-RJF-2TJ-006	W8	RJF-05	4-5	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
62	NH5-RJF-2TJ-006	W8	RJF-05	5-0	GTAW+SMAW	1674	533×16	PΦ1×1	---	Acc	---	---
63	NH5-RJF-2TJ-006	W9	RJF-05	0-1	GTAW+SMAW	1674	533×16	S.I 50mm/PΦ5×1/LOF 15mm	---	Rej	---	---
64	NH5-RJF-2TJ-006	W9	RJF-05	0-1R1	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
65	NH5-RJF-2TJ-006	W9	RJF-05	1-2	GTAW+SMAW	1674	533×16	LOF 15mm/密孔	---	Rej	---	---
66	NH5-RJF-2TJ-006	W9	RJF-05	1-2R1	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
67	NH5-RJF-2TJ-006	W9	RJF-05	2-3	GTAW+SMAW	1674	533×16	PΦ2×3	---	Acc	---	---
68	NH5-RJF-2TJ-006	W9	RJF-05	3-4	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
69	NH5-RJF-2TJ-006	W9	RJF-05	4-5	GTAW+SMAW	1674	533×16	---	---	Acc	---	---
70	NH5-RJF-2TJ-006	W9	RJF-05	5-0	GTAW+SMAW	1674	533×16	LOF 10mm/20mm C	---	Rej	---	---
71	NH5-RJF-2TJ-006	W9	RJF-05	5-0R1	GTAW+SMAW	1674	533×16	---	---	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) 条缺(E.1-Elongated Indication)
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签字 Signature	检验员(Inspector)	技术监督(Tech. Supervisor)	签字授权人(Authorized Signee)
	Liu Wenzhong	Tang Yuezhen	
日期 Date	2019.11.10	2019.11.10	



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.

2. 报告无操作人员或评片人、技术监督、技术负责人签字无效。

Report without the signatures of operator of film judge, tech. supervisor and tech. principal is invalid.

3. 本报告涂改无效。

Report with alteration will be invalid.

4. 本报告仅对被检产品受检部位负责。

Report is only responsible for the inspective pieces.

5. 未经检测单位同意不得复制本报告。

Report should not be copied without the agreement of CJP company.

6. 委托单位对检测结果若有异议，请于十五日内提出。

Client should inform CJP company within 15 days if there're any question about the inspective result.

7. 本报告一式三份：本公司存档一份，客户两份。

Report is in triplicity, original stored in CJP company, two copies for client.

8. 未加盖 CMA 章的检测报告，不具备向社会起证明作用的数据和结果。

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

检测单位：深圳市诚锦鹏实业有限公司

Contractor: Shenzhen Chengjinpeng Industrial Co.,LTD

地址：深圳市南山区月亮湾大道 2076 号高科大厦六层 C3

Address: Room C3, 6/F Gaoke Building, No.2076, Yueliangwan BLVD,
Nanshan District, Shenzhen.

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