



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: PY4-2A 高压管线更换

High Pressure Manifold Replacement on PY4-2A Platform

委托单位 Commission Unit : 深圳市海基实业有限公司

委托单位地址 Client Address: 惠州市大亚湾石化大道中前兴  
建材市场海基公司

工程编号 Project No. : CJP-WR-094-026-19-002

检测方法 Inspection Method : MT

报告编号 Report No. : CJP-WR-094-026-MT001-19-002

页数 Number of pages : 共12页

报告日期 Report Date : 2019.01.22

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

# 磁粉检测报告

## MAGNETIC PARTICLE INSPECTION REPORT

项目名称:PY4-2A高压管线更换

报告日期

报告编号:

Project :High Pressure Manifold Replacement on PY4-2A Platform

Report Date:

2019.01.22

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|                            |                   |                            |              |                            |                         |                          |                    |                |               |
|----------------------------|-------------------|----------------------------|--------------|----------------------------|-------------------------|--------------------------|--------------------|----------------|---------------|
| 检测地点<br>Testing Position   | PY4-2A平台          | 执行标准<br>Executive Standard | ASME B31.3   | 仪器型号<br>Instrument Type    | ZCM-AD22012             | 提升力<br>Lifting Power     | ≥45N               |                |               |
| 检测比例<br>Testing Rate       | ---               | 合格级别<br>Acceptance Grade   | ---          | 仪器编号<br>Instrument No.     | CJP-CF-20               | 磁粉<br>Magnetic Particle  | MT-BW              |                |               |
| 图纸号<br>Drawing No.         | ---               | 表面状态<br>Surface Condition  | 光滑<br>Smooth | 磁轭类型<br>Yoke Type          | AC-Yoke                 | 反差剂<br>Contrast Agent    | FA-5               |                |               |
| 工件材质<br>Workpiece Material | 35CrMo            | 灵敏度试块<br>Sensitivity block | A1(30/100)   | 磁化方法<br>Magnetizing Method | Successive              | 磁化时间<br>Magnetizing Time | 1`3s               |                |               |
| 工件编号<br>Workpiece No.      | 焊工号<br>Welder No. | 焊口号<br>Weld No.            | 热处理状态<br>HTS | 坡口形式<br>Groove Form        | 焊接方法<br>Welding Process | 焊缝长度<br>W.L( mm )        | 缺陷编号<br>Defect No. | 缺陷性质及大小<br>DNS | 评定意见<br>Judge |
| PY4-2A                     | ---               | W104                       | ---          | V                          | GTAW                    | 280                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W105                       | ---          | V                          | GTAW                    | 280                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W106                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W107                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W108                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W109                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W110                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W111                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W112                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W113                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W114                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W115                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |
| PY4-2A                     | ---               | W116                       | ---          | V                          | GTAW                    | 358                      | ---                | ---            | Acc           |

备注:热处理状态(HTS--Heat Treatment State)  
Notes:缺陷性质及大小(DNS--Defect Nature and Size)

未熔合(LOF--Lack of Fusion) 未焊透(LOP--Lack of Penetration) 夹渣(S.I--Slag Inclusion)  
裂纹(C--Crack) 气孔(P--Porosity) 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      | 2019.1.22      | 2019.1.22              | 2019.1.22                |



深圳市诚锦鹏实业有限公司

SHENZHEN CHENGJINPENG INDUSTRIAL CO.,LTD

# 磁粉检测报告

## MAGNETIC PARTICLE INSPECTION REPORT

项目名称:PY4-2A高压管线更换

报告日期

报告编号:

Project :High Pressure Manifold Replacement on PY4-2A Platform

Report Date: 2019.01.22

Report No.:CJP-WR-094-026-MT001-19-002

| 工件编号<br>Workpiece No. | 焊工号<br>Welder No. | 焊口号<br>Weld No. | 热处理状态<br>HTS | 坡口形式<br>Groove Form | 焊接方法<br>Welding Process | 焊缝长度<br>W.L( mm ) | 缺陷编号<br>Defect No. | 缺陷性质及大小<br>DNS | 评定意见<br>Judge |
|-----------------------|-------------------|-----------------|--------------|---------------------|-------------------------|-------------------|--------------------|----------------|---------------|
| PY4-2A                | --                | W117            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W118            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W119            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W120            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W121            | --           | V                   | GTAW                    | 280               | --                 | --             | Acc           |
| PY4-2A                | --                | W122            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W123            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W124            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W125            | --           | V                   | GTAW                    | 280               | --                 | --             | Acc           |
| PY4-2A                | --                | W126            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W127            | --           | V                   | GTAW                    | 358               | --                 | --             | Acc           |
| PY4-2A                | --                | W129            | --           | V                   | GTAW                    | 188               | --                 | --             | Acc           |
| PY4-2A                | --                | W130            | --           | V                   | GTAW                    | 188               | --                 | --             | Acc           |
| PY4-2A                | --                | W131            | --           | V                   | GTAW                    | 280               | --                 | --             | Acc           |
| PY4-2A                | --                | W132            | --           | V                   | GTAW                    | 188               | --                 | --             | Acc           |
| PY4-2A                | --                | W133            | --           | V                   | GTAW                    | 188               | --                 | --             | Acc           |
| PY4-2A                | --                | W134            | --           | V                   | GTAW                    | 188               | --                 | --             | Acc           |
| PY4-2A                | --                | W135            | --           | V                   | GTAW                    | 188               | --                 | --             | Acc           |
| PY4-2A                | --                | W136            | --           | V                   | GTAW                    | 188               | --                 | --             | Acc           |
| PY4-2A                | --                | W137            | --           | V                   | GTAW                    | 528               | --                 | --             | Acc           |
| PY4-2A                | --                | W138            | --           | V                   | GTAW                    | 528               | --                 | --             | Acc           |

备注:热处理状态(HTS--Heat Treatment State)

Notes:缺陷性质及大小 (DNS--Defect Nature and Size)

未熔合(LOF--Lack of Fusion) 未焊透( LOP--Lack of Penetration) 夹渣(S.I--Slag Inclusion)

裂纹(C--Crack) 气孔(P--Porosity) 合格(Acc--Acceptance) 不合格(Rej--Rejection)

|         |                          |                          |                           |
|---------|--------------------------|--------------------------|---------------------------|
| 签字 Sign | 检验员 (Inspector)          | 技术监督 (Tech. Supervisor)  | 签字授权人 (Authorized Signee) |
| 日期 Date | 04 bang hua<br>2019.1.22 | Tang Xue zu<br>2019.1.22 | 2019.1.22                 |



# MAGNETIC PARTICLE INSPECTION REPORT

报告编号:

Report No. :CJP-WR-094-026-MT001-19-002

Form No:CJP/WR.MT02 Rev:E/0



检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-026-MT001-19-002



W104



W105/W106



W107



W108



W109



W110



检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-026-MT001-19-002



W111



W112



W113



W114



W115



W116



检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-026-MT001-19-002



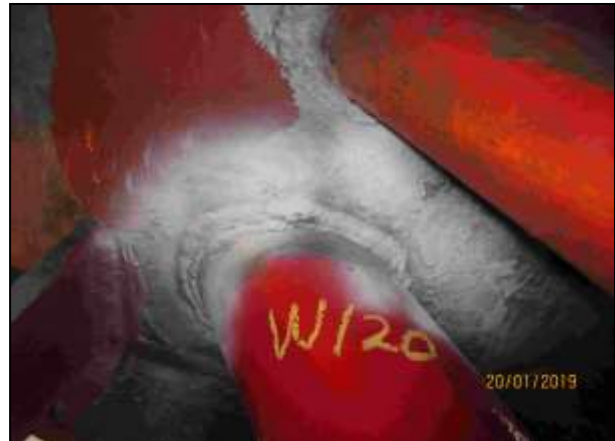
W117



W118



W119



W120



W121/W122



W123

检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-026-MT001-19-002



W124



W125/W126



W127



W129



W130



W131

检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-026-MT001-19-002



W132



W133



W134



W135/W136



W137



W138

检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

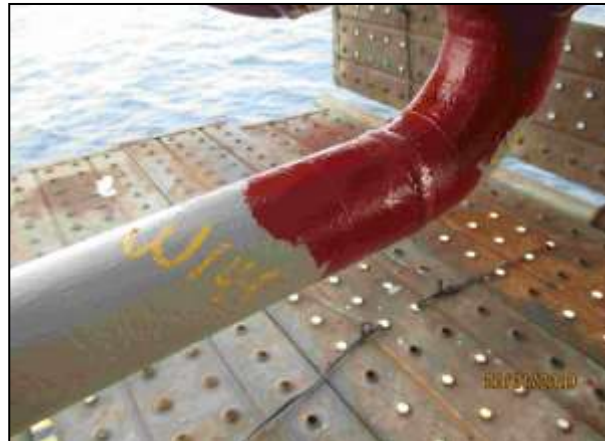
Report No: CJP-WR-094-026-MT001-19-002



W139



W140



W141



W142



W143

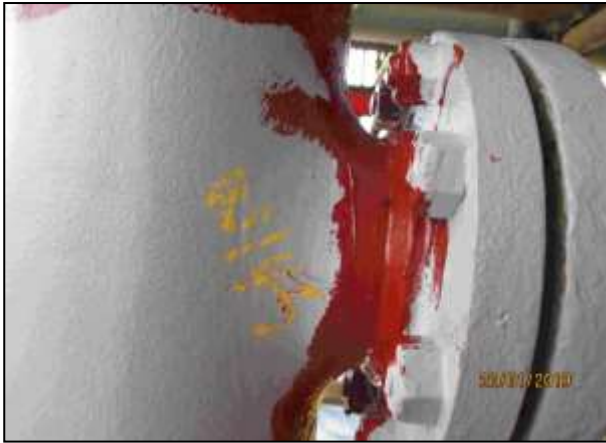


W144

检测报告附图  
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-094-026-MT001-19-002



W145



W146



W147



W148



W149



备注

Remark

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Report without the specified inspection stamp of CJP company is invalid.
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Report is only responsible for the inspective pieces.
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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.
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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

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