



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: SS AMAZONIA 伸缩节修理

SS AMAZONIA Expansion Joint Inspection

委托单位 Commission Unit : 深圳市京铭石油设备发展有限公司

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-083-157-19-053

检测方法 Inspection Method : MT

报告编号 Report No. : CJP-WR-083-157-MT019-19-053

页数 Number of pages : 共 14 页

报告日期 Report Date : 2019.07.25

批准人 Approved by : 李



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: C3F6, GAOKE BUILDING, NO.2076, YUELIANGWAN BLVD, NANSHAN DISTRICT, SHENZHEN

电 话 Tel: 0755-86274981/26440278

URL: <http://www.cjpsz.com> E-mail: cjpsz126@126.com



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:SS AMAZONIA 伸缩节修理

报告日期

报告编号:

Project Name :SS AMAZONIA Expansion Joint Inspection

Report Date:

2019.07.25

Report No.:CJP-WR-083-157-MT019-19-053

检测地点 Testing Position	惠州车间 Huizhou Workshop	执行标准 Executive Standard	VGS8.3.2-S1/VGS8.3.3-S2	仪器型号 Instrument Type	CYD-8000	提升力 Lifting Power	—		
检测比例 Testing Rate	100%	合格级别 Acceptance Grade	—	仪器编号 Instrument No.	CJP-CF-29	磁粉 Magnetic Particle	MT-BW		
图纸号 Drawing No.	—	表面状态 Surface Condition	Ra≤25 μm	磁轭类型 Yoke Type	—	反差剂 Contrast Agent	FA-5		
工件材质 Workpiece Material	X80	灵敏度试块 Sensitivity block	A1(30/100)	磁化方法 Magnetizing Method	线圈法/偏心导体法	磁化时间 Magnetizing Time	1`3s		
工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态 HTS	坡口形式 Groove Form	焊接方法 Welding Process	焊缝长度 W.L(mm)	缺陷编号 Defect No.	缺陷性质及大小 DNS	评定意见 Judge
H166637-1	—	W1	—	—	—	—	—	—	Acc
H166637-1	—	W2	—	—	—	—	—	—	Acc
H166637-1	—	W3	—	—	—	—	—	—	Acc
H166637-1	—	W4	—	—	—	—	—	—	Acc
H166637-1	—	W5	—	—	—	—	—	—	Acc
H166637-1	—	W6	—	—	—	—	—	—	Acc
H166637-1	—	W7	—	—	—	—	—	—	Acc
H166637-1	—	W8	—	—	—	—	—	—	Acc
H166637-1	—	W9	—	—	—	—	—	—	Acc
H166637-1	—	W10	—	—	—	—	—	—	Acc
H166637-1	—	W11	—	—	—	—	—	—	Acc
H166637-1	—	W12	—	—	—	—	—	—	Rej
H166637-1	—	W13	—	—	—	—	—	—	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		2019.07.25		2019.07.25		2019.07.25			



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:SS AMAZONIA 伸缩节修理

报告日期

报告编号:

Project Name :SS AMAZONIA Expansion Joint Inspection

Report Date: 2019.07.25 Report No.:CJP-WR-083-157-MT019-19-053

工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态 HTS	坡口形式 Groove Form	焊接方法 Welding Process	焊缝长度 W.L(mm)	缺陷编号 Defect No.	缺陷性质及大小 DNS	评定意见 Judge
H166637-1	---	W14	---	---	---	---	---	---	Acc
H166637-1	---	A1	---	---	---	---	---	---	Acc
H166637-1	---	A2	---	---	---	---	---	---	Acc
H166637-1	---	A3	---	---	---	---	---	---	Acc
H166637-1	---	A4	---	---	---	---	---	---	Acc
H166637-1	---	A5	---	---	---	---	---	---	Acc
H166637-1	---	A6	---	---	---	---	---	---	Acc
H166637-1	---	A7	---	---	---	---	---	---	Acc
H166637-1	---	A8	---	---	---	---	---	---	Acc
H166637-1	---	B1	---	---	---	---	---	---	Acc
H166637-1	---	B2	---	---	---	---	---	---	Acc
H166637-1	---	B3	---	---	---	---	---	---	Acc
H166637-1	---	B4	---	---	---	---	---	---	Acc
H166637-1	---	B5	---	---	---	---	---	---	Acc
H166637-1	---	B6	---	---	---	---	---	---	Acc
H166637-1	---	B7	---	---	---	---	---	---	Acc
H166637-1	---	B8	---	---	---	---	---	---	Acc
H166637-1	---	B9	---	---	---	---	---	---	Acc
H166637-1	---	B10	---	---	---	---	---	---	Acc
H166637-1	---	C1	---	---	---	---	---	---	Acc
H166637-1	---	C2	---	---	---	---	---	---	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) Li Le	技术监督(Tech. Supervisor) Tan Yuezun	签字授权人(Authorized Signee)
日期 Date	2019.07.25	2019.07.25	2019.07.25



磁粉检测报告

MAGNETIC PARTICLE INSPECTION REPORT

项目名称:SS AMAZONIA 伸缩节修理

报告日期

报告编号:

Project Name :SS AMAZONIA Expansion Joint Inspection

Report Date: 2019.07.25 Report No.:CJP-WR-083-157-MT019-19-053

工件编号 Workpiece No.	焊工号 Welder No.	焊口号 Weld No.	热处理状态 HTS	坡口形式 Groove Form	焊接方法 Welding Process	焊缝长度 W.L(mm)	缺陷编号 Defect No.	缺陷性质及大小 DNS	评定意见 Judge
H166637-1	--	C3	--	--	--	--	--	C	Rej
H166637-1	--	C4	--	--	--	--	--	--	Acc
H166637-1	--	C5	--	--	--	--	--	--	Acc
H166637-1	--	C6	--	--	--	--	--	--	Acc
H166637-1	--	C7	--	--	--	--	--	--	Acc
H166637-1	--	C8	--	--	--	--	--	--	Acc
H166637-1	--	C9	--	--	--	--	--	--	Acc
H166637-1	--	C10	--	--	--	--	--	--	Acc
H166637-1	--	D1	--	--	--	--	--	--	Acc
H166637-1	--	D2	--	--	--	--	--	--	Acc
H166637-1	--	D3	--	--	--	--	--	--	Acc
H166637-1	--	D4	--	--	--	--	--	--	Acc
H166637-1	--	D5	--	--	--	--	--	C	Rej
H166637-1	--	D6	--	--	--	--	--	--	Acc
H166637-1	--	D7	--	--	--	--	--	--	Acc
H166637-1	--	D8	--	--	--	--	--	--	Acc
H166637-1	--	D9	--	--	--	--	--	C	Rej
H166637-1	--	D10	--	--	--	--	--	--	Acc
H166637-1	--	1#	--	--	--	--	--	--	Acc
H166637-1	--	2#	--	--	--	--	--	--	Acc
H166637-1	--	3#	--	--	--	--	--	--	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) Li Le	技术监督 (Tech. Supervisor) Tang Yuesun	签字授权人 (Authorized Signee) Li Le
日期 Date	2019.07.25	2019.07.25	2019.07.25



MAGNETIC PARTICLE INSPECTION REPORT

报告编号:

Report Date: 2019.07.25 Report No.:CJP-WR-083-157-MT019-19-053

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

检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

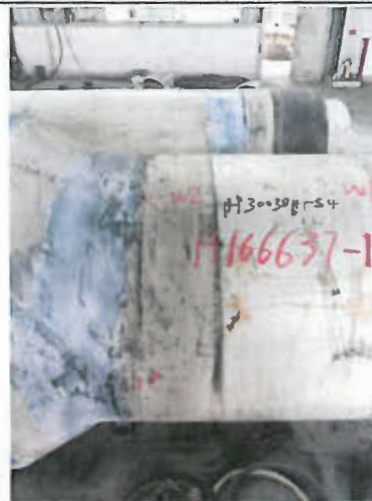
Report No: CJP-WR-083-157-MT019-19-053



H166637-1



H166637-1 W1



H166637-1 W2



H166637-1 W3



H166637-1 W4



H166637-1 W5



H166637-1 W6



H166637-1 W7



H166637-1 W8

检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-083-157-MT019-19-053



H166637-1 W9



H166637-1 W10



H166637-1 W11 W12



H166637-1 W12



H166637-1 W13



H166637-1 W14



H166637-1 A



H166637-1 A1



H166637-1 A2

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-083-157-MT019-19-053



H166637-1 A3



H166637-1 A4



H166637-1 A5



H166637-1 A6



H166637-1 A7



H166637-1 A8



H166637-1 B



H166637-1 B1



H166637-1 B2

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-083-157-MT019-19-053



H166637-1 B3



H166637-1 B4



H166637-1 B5



H166637-1 B6



H166637-1 B7



H166637-1 B8



H166637-1 B9



H166637-1 B10



H166637-1 C

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-083-157-MT019-19-053



H166637-1 C1



H166637-1 C2



H166637-1 C3



H166637-1 C3



H166637-1 C4



H166637-1 C5



H166637-1 C6



H166637-1 C7



H166637-1 C8

检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-083-157-MT019-19-053



H166637-1 C9



H166637-1 C10



H166637-1 D



H166637-1 D1



H166637-1 D2



H166637-1 D3



H166637-1 D4



H166637-1 D5



H166637-1 D5

检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-083-157-MT019-19-053



H166637-1 D6



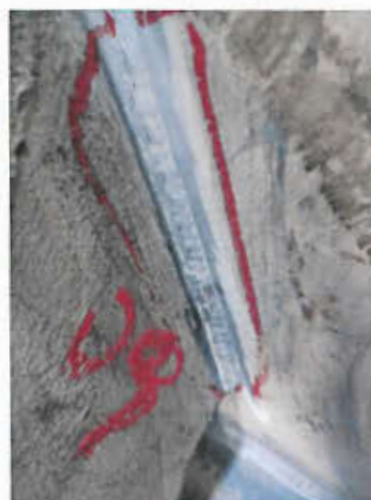
H166637-1 D7



H166637-1 D8



H166637-1 D9



H166637-1 D9



H166637-1 D10



H166637-1 1#



H166637-1 2#



H166637-1 3#



检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

Report No: CJP-WR-083-157-MT019-19-053



H166637-1 4#



H166637-1 5#



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.

电话/TEL: 0755-86274981/26440278

URL: <http://www.cjpsz.com> E-mail: cjpsz126@126.com