



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: 南海八号泥浆立管由任三通加工

Fabrication for Union Tees of Mud Riser on NH8 Platform

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-083-125-18-014

检测方法 Inspection Method : RT

报告编号 Report No. : CJP-WR-083-125-RT001-18-014

页数 No. of Pages : 共 4 页

报告日期 Report Date : 2018.03.29

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

射线检测报告
RADIOGRAPHIC INSPECTION REPORT

项目名称:南海八号泥泵立管由任三通加工

报告编号

报告日期

Project Name: Fabrication for Union Tees of Mud Riser on NH8 Platform

Report Date: 2018.03.29

Report No.: CJP-WR-083-125-RT001-18-014

检测地点 Test Position		RJP Workshop		放射源 Source		Se75		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		2.5×2.5		X-管电压 X-Tube Voltage		—		显影时间 Developing Time		5min	
检验标准 Acceptance Criteria		ASME B31.3		增强方式 Intensifying Screen		pb0.1×2mm		X-管电流 (源强) X-Tube Current (Activity)		57ci		定影温度 Fixing Temperature		20℃	
工件材质 Material		4130		焦距 SFD		140mm		象质计 IQI		ASTM IB		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		1min		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	NH8-ST	W1	RJFW05/03	0-1	GTAW/SAW	110	Φ141×19	Φ1×1	—	Acc	—	—			
2	NH8-ST	W1	RJFW05/03	1-2	GTAW/SAW	110	Φ141×19	—	—	Acc	—	—			
3	NH8-ST	W1	RJFW05/03	2-3	GTAW/SAW	110	Φ141×19	Φ2×2, Φ1×1	—	Acc	—	—			
4	NH8-ST	W1	RJFW05/03	3-0	GTAW/SAW	110	Φ141×19	—	—	Acc	—	—			
5	NH8-ST	W2	RJFW05/03	0-1	GTAW/SAW	110	Φ141×19	—	—	Acc	—	—			
6	NH8-ST	W2	RJFW05/03	1-2	GTAW/SAW	110	Φ141×19	—	—	Acc	—	—			
7	NH8-ST	W2	RJFW05/03	2-3	GTAW/SAW	110	Φ141×19	Φ1×1	—	Acc	—	—			
8	NH8-ST	W2	RJFW05/03	3-0	GTAW/SAW	110	Φ141×19	Φ2×2	—	Acc	—	—			
8	NH8-ST	W3	RJFW05/03	0-1	GTAW/SAW	110	Φ141×19	Φ2×1	—	Acc	—	—			
10	NH8-ST	W3	RJFW05/03	1-2	GTAW/SAW	110	Φ141×19	—	—	Acc	—	—			
11	NH8-ST	W3	RJFW05/03	2-3	GTAW/SAW	110	Φ141×19	Φ1.5×1 Φ1×4	—	Acc	—	—			
12	NH8-ST	W3	RJFW05/03	3-0	GTAW/SAW	110	Φ141×19	—	—	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) 夹杂 (S.I -Slag Inclusion) 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) 合格 (Acc-Acceptance)															
签字 Signature															
日期 Date															
Form No.: CJP/WR. RT01 Rev:E/0															



射线检测报告
RADIOGRAPHIC INSPECTION REPORT

项目名称:南海八号泥浆立管由任三通加工

报告日期

报告编号

Project Name: Fabrication for Union Tees of Mud Riser on NH8 Platform

Report Date: 2018.03.29

Report No.: CJP-WR-083-125-RT001-18-014

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	NH8-ST	W4	RJFW05/03	0-1	GTAW/SAW	110	Φ141×19	--	--	Acc	--	--
14	NH8-ST	W4	RJFW05/03	1-2	GTAW/SAW	110	Φ141×19	PΦ2×1	--	Acc	--	--
15	NH8-ST	W4	RJFW05/03	2-3	GTAW/SAW	110	Φ141×19	PΦ1×2	--	Acc	--	--
16	NH8-ST	W4	RJFW05/03	3-0	GTAW/SAW	110	Φ141×19	--	--	Acc	--	--
17	END											
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32												

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)
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 日期 Date 检验员 (Inspector) 技术监督 (Tech. Supervisor) 签字授权人 (Authorized Signee)

Ge Qiang 2018.03.29 Wangzhen 2018.03.29



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.

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Contractor: Shenzhen Chengjinpeng Industrial Co.,LTD

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