



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: 西江油田 2018 年第一批生产工艺
和公用管线集中制作更换服务标段一

The First Batch of Production Processes and Public Pipelines in Xijiang
Oilfield in 2018 Centralized Production and Replacement Service Section 1

委托单位 Commission Unit : 湛江市安海结构工程服务有限公司

委托单位地址 Client Address: 湛江坡头区

工程编号 Project No. : CJP-WR-167-003-19-054

检测方法 Inspection Method : RT

报告编号 Report No. : CJP-WR-167-003-RT001-19-054

页数 Number of pages : 共 7 页

报告日期 Report Date : 2019.08.09

批准人 Approved by : 检验检测专用章

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:西江油田2018年第一批生产工艺和公用管线集中制作更换服务标段一

报告日期

报告编号

Project Name: The First Batch of Production Processes and Public Pipelines in Xijiang

Report Date: 2019. 08. 09

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Oilfield in 2018 Centralized Production and Replacement Service Section 1

检测地点 Test Position	XJ243B平台		放射源 Source	X射线机		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	2×2mm		X-管电压 X-Tube Voltage	190/220kV		显影时间 Developing Time	5min		
执行标准 Executive Standard	ASME B31.3 ASME BPVC V		增感方式 Intensifying Screen	Pb(0.1×2)mm		X-管电流(源强) X-Tube Current(Activity)	5mA		定影温度 Fixing Temperature	20℃		
工件材质 Material	A106		焦距 SFD	500mm		像质计 IQI	ASTM 1B/1A		定影时间 Fixing Time	15min		
检测比例 Testing Rate	25%		胶片类性 Film Type	AGFA-C7		曝光时间 Exposure Time	1.6/1.8min		透照方法 Exposure Technique	DWDI 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 级别 Grade 结果 Result		返修次数 Repair Times	返修报告 Repair Report No.
1	4"-PW-DPPB-V-2001	1	---	0-1	GTAW	358mm	Φ114×8.6	---	---	Acc	---	---
2	4"-PW-DPPB-V-2001	1	---	1-2	GTAW	358mm	Φ114×8.6	---	---	Acc	---	---
3	4"-PW-DPPB-V-2001	1	---	2-3	GTAW	358mm	Φ114×8.6	PΦ2×1	---	Acc	---	---
4	4"-PW-DPPB-V-2001	1	---	3-4	GTAW	358mm	Φ114×8.6	---	---	Acc	---	---
5	4"-PW-DPPB-V-2001	1	---	4-0	GTAW	358mm	Φ114×8.6	---	---	Acc	---	---
6	4"-PW-DPPB-V-2001	3	---	0-1	GTAW	358mm	Φ114×8.6	---	---	Acc	---	---
7	4"-PW-DPPB-V-2001	3	---	1-2	GTAW	358mm	Φ114×8.6	PΦ1×1	---	Acc	---	---
8	4"-PW-DPPB-V-2001	3	---	2-3	GTAW	358mm	Φ114×8.6	PΦ1×1	---	Acc	---	---
9	4"-PW-DPPB-V-2001	3	---	3-4	GTAW	358mm	Φ114×8.6	---	---	Acc	---	---
10	4"-PW-DPPB-V-2001	3	---	4-0	GTAW	358mm	Φ114×8.6	---	---	Acc	---	---
11	2"-PW-DPPB-V-2001	4	---	A	GTAW	190mm	Φ60.3×5.5	---	---	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)
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) Ou Baohua	技术监督(Tech. Supervisor) Tang Xuezu	签字授权人(Authorized Signee) Tang Xuezu
日期 Date	2019.08.09	2019.08.09	2019.08.09



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: 西江油田2018年第一批生产工艺和公用管线集中制作更换服务标段一

报告日期

报告编号

Project Name: The First Batch of Production Processes and Public Pipelines in Xijiang Oilfield in 2018 Centralized Production and Replacement Service Section 1

Report Date: 2019. 08. 09

Report No. CJP-WR-167-003-RT001-19-054

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		
12	2"-PW-DPPB-V-2001	4	---	B	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
13	2"-PW-DPPB-V-2001	4	---	C	GTAW	190mm	Φ60.3×5.5	PΦ1×1	---	Acc	---	---
14	2"-PW-DPPB-V-2001	6	---	A	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
15	2"-PW-DPPB-V-2001	6	---	B	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
16	2"-PW-DPPB-V-2001	6	---	C	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
17	2"-PW-DPPB-V-2001	7	---	A	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
18	2"-PW-DPPB-V-2001	7	---	B	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
19	2"-PW-DPPB-V-2001	7	---	C	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
20	2"-PW-DPPB-V-2001	9	---	A	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
21	2"-PW-DPPB-V-2001	9	---	B	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
22	2"-PW-DPPB-V-2001	9	---	C	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
23	2"-PW-DPPB-V-2001	10	---	A	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
24	2"-PW-DPPB-V-2001	10	---	B	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
25	2"-PW-DPPB-V-2001	10	---	C	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
26	2"-PW-DPPB-V-2001	11	---	A	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
27	2"-PW-DPPB-V-2001	11	---	B	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
28	2"-PW-DPPB-V-2001	11	---	C	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
29	2"-PW-DPPB-V-2001	12	---	A	GTAW	190mm	Φ60.3×5.5	---	---	Acc	---	---
30	2"-PW-DPPB-V-2001	12	---	B	GTAW	190mm	Φ60.3×5.5	---	---	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)
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)

	检验员 (Inspector)	技术监督 (Tech. Supervisor)	签字授权人 (Authorized Signee)
签字 Signature	Ou Banghua	Tang Yueen	Tang Yueen
日期 Date	2019.08.09	2019.08.09	2019.08.09



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射线检测报告 (续表)

RADIOGRAPHIC INSPECTION REPORT

项目名称:西江油田2018年第一批生产工艺和公用管线集中制作更换服务标段一

报告日期

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Project Name: The First Batch of Production Processes and Public Pipelines in Xijiang Oilfield in 2018 Centralized Production and Replacement Service Section 1

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									级别 Grade	结果 Result		
31	2"-PW-DPPB-V-2001	12	--	C	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
32	2"-PW-DPPB-V-2001	14	--	A	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
33	2"-PW-DPPB-V-2001	14	--	B	GTAW	190mm	Φ60.3×5.5	PΦ1×1	--	Acc	--	--
34	2"-PW-DPPB-V-2001	14	--	C	GTAW	190mm	Φ60.3×5.5	PΦ1×1	--	Acc	--	--
35	2"-PW-DPPB-V-2001	15	--	A	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
36	2"-PW-DPPB-V-2001	15	--	B	GTAW	190mm	Φ60.3×5.5	PΦ1×1	--	Acc	--	--
37	2"-PW-DPPB-V-2001	15	--	C	GTAW	190mm	Φ60.3×5.5	PΦ1×1	--	Acc	--	--
38	2"-PW-DPPB-V-2001	16	--	A	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
39	2"-PW-DPPB-V-2001	16	--	B	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
40	2"-PW-DPPB-V-2001	16	--	C	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
41	2"-PW-DPPB-V-2001	20	--	A	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
42	2"-PW-DPPB-V-2001	20	--	B	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
43	2"-PW-DPPB-V-2001	20	--	C	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
44	2"-PW-DPPB-V-2001	21	--	A	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
45	2"-PW-DPPB-V-2001	21	--	B	GTAW	190mm	Φ60.3×5.5	--	--	Acc	--	--
46	2"-PW-DPPB-V-2001	21	--	C	GTAW	190mm	Φ60.3×5.5	--	--	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)
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日期 Date	2019.08.09	2019.08.09	2019.08.09

检测报告附图 SKETCH OF DETECTION POSITION

报告编号:

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4 " -PW-DPPB-V-2001-1



4 " -PW-DPPB-V-2001-3



2 " -PW-DPPB-V-2001-4



2 " -PW-DPPB-V-2001-6



2 " -PW-DPPB-V-2001-7 /9 /10



2 " -PW-DPPB-V-2001-11

检测报告附图
SKETCH OF DETECTION POSITION

报告编号:

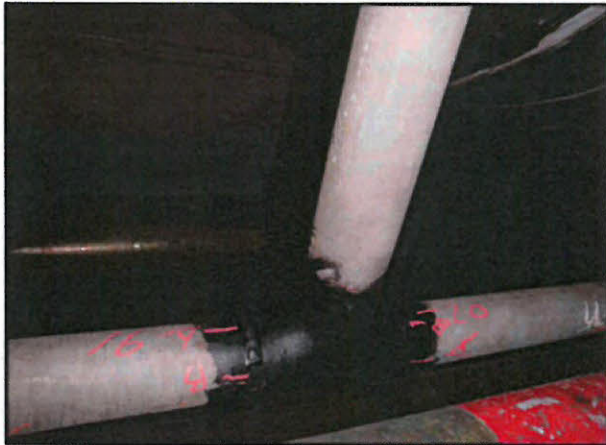
Report No: CJP-WR-167-003-RT001-19-054



2 " -PW-DPPB-V-2001-12



2 " -PW-DPPB-V-2001-14/15



2 " -PW-DPPB-V-2001-16/20



2 " -PW-DPPB-V-2001-21



备注

Remark

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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

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