Joosh maye Jey NDT

1753

آزمون فلز پارس(پتروپالایش کنگان)

Radiography TEST Report for Piping

Report No.	597	Reference Standard:	ASME B 31.3	RT Device S/N:	573	Density:	2-4	Received Dose(µsv)		Geiger	Dosimeter	Radiographer Name	Personnel Code
Report Date:	30/04/1405	RT Instruction No.	J-104-IN-33	KV:		Sensitivity:	1/2			...	0	باور کریمی	1143
Radiography Date:	28/04/1405	RT Technique:		Source Power:	16 ci	Film Type:	MX125-NIF-10	130µsv		1226	0	رضا عیلی	1179
Request No.	598	SWSI ☐ DWSI ☑	DWDI ☑	Source Size:	2-2	Total Film Length:	861CM	120µsv		1190	0	عرامت اله صفایی	1123
Page:	1/2	IQI	10 - 16 Fe DIN	Exposure Time:	150min	Spoiled Film:	75CM			...	...	...	

Number of locations:	49	Total request (inch diameter/film sheet):	119	Number of radiographic lesions:	16	Total radiographed (inch diameter/film sheet):	(inch)	Start time:	20:00	End time:	5:00

Row	Joint No.	Line No.	RT No.	Size (inch)	Thk (mm)	Film Size	Segment	Material	Welder Stamp W1	Welder Stamp W2	Welding Process	Joint Type	Req No.	Weld Defect	Accept	Repair	Reshoot	Retake	Cut-Out	Remark
1	001	4-HC-10-21C21-A3X21-E	1757RWP2-RS	4	6.02	18*1	0~10	CS	PW-124			BW	598		☑	☐	☐	☐	☐	
2	006	4-FWA-10-06872-A1U26-E	4594P1-RP	4	6.02	18*1	34~0	CS	PW-052			BW	598		☑	☐	☐	☐	☐	
3	018	1.5-PRO-10-72D08-B6P21-JP	6747	1.5	5.08	15*3	ALL	LTCS	PW-028			BW	598		☑	☐	☐	☐	☐	
4	019	1.5-PRO-10-72D08-B6P21-JP	6748	1.5	5.08	15*3	ALL	LTCS	PW-137			BW	598		☑	☐	☐	☐	☐	
5	020	1.5-PRO-10-72D08-B6P21-JP	6750	1.5	5.08	15*3	ALL	LTCS	PW-137			BW	598		☑	☐	☐	☐	☐	
6	023	1.5-PRO-10-72D08-B6P21-JP	6753	1.5	5.08	15*3	ALL	LTCS	PW-077			BW	598		☑	☐	☐	☐	☐	
7	024	1.5-PRO-10-72D08-B6P21-JP	6754	1.5	5.08	15*3	ALL	LTCS	PW-137			BW	598		☑	☐	☐	☐	☐	
8	002	TR-HC-10-05118-A1P21(1)	6911	1.5	5.08	15*3	ALL	CS	PW-144			BW	598		☑	☐	☐	☐	☐	
9	037	3-HC-10-22A07-L3P07(3)	7031	2	2.77	15*2	ALL	SS	PW-012-1			BW	598		☑	☐	☐	☐	☐	
10	035	16-BDM-10-60B01-B1P21(RI)	7060	2	3.91	15*2	ALL	LTCS	PW-012-1			BW	598		☑	☐	☐	☐	☐	
11	001	8-BDM-10-21A05-B1P21	7101	2	3.91	15*3	ALL	LTCS	PW-012-1			BW	598		☑	☐	☐	☐	☐	
12	003CO	TR-HC-10-30B02-A3X21-E(1)	7103CO	0.5	3.73	15*3	ALL	CS	PW-118			BW	598		☑	☐	☐	☐	☐	
13	036	12-BDM-10-07601-B1P21(RI)	7120	12	6.35	40*3	ALL	LTCS	PW-013-1			BW	598		☑	☐	☐	☐	☐	
14	037	12-BDM-10-07601-B1P21(RI)	7121	12	6.35	40*3	ALL	LTCS	PW-013-1			BW	598		☑	☐	☐	☐	☐	
15	012	0.5-BDM-10-72A07-B1P21	7135	0.5	4.78	15*3	ALL	LTCS	PW-012-1			BW	598		☑	☐	☐	☐	☐	
16	042	3-JWR-10-06416-A1U26	7337	3	5.49	15*3	ALL	CS	PW-118			BW	598		☑	☐	☐	☐	☐	
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Number of radiographed welds:	16	Total inch:	(inch)	Total number of film sheets:	42

Legend: **P:** Prosity **CP:** Cluster porosity **LOP, IP:**Lack Of Penetration, Inadequate Penetration **UC:**UnderCut **SI:** Slag Inclusion **HB:** Hollow Bead **EP:** Excess Penetration **WH:** Worm Hole **C:** Crack **CC:** Crater Crack **LOF, IF:**Lack Of Fusion, Incomplete Fusion **BT:** Burn Through **CL:** Cold Lap **MA:** MisAlignment **IC:** Internal Concavity **FM:** Film Mark

Sub-Contractor (NDT Contractor)

Operator (Level II)	Technical Manager		Owner
Name: باور کریمی	Name: سینا حاجی مقصودی		Name:
Date: 30/04/1405	Date:		Date:
Sign:	Sign:		Sign:

به دلیل پراکندگی زیاد و یکنیج بودن سرجوشها وکمبود زمان تعدادی از سرجوش ها رادیوگرافی نشدند