joosh maye jey NDT

1753

آزمون فلز پارس(پتروپالایش کنگان)

Radiography TEST Report for Piping

Report No.	598	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:	31/04/1405	RT Instruction No.	J-104-IN-33	KV:		Sensitivity:	1/2		...	0	باور کریمی	1143
Radiography Date:	29/04/1405	RT Technique:		Source Power:	16 ci	Film Type:	MX125-NIF-10	100µsv	1226	0	رضا عیلی	1179
Request No.	599	SWSI ☐ DWSI ☑	DWDI ☑	Source Size:	2-2	Total Film Length:	1,035CM	80µsv	1190	0	عرامت اله صالحی	1123
Page:	1/2	IQI	10 - 16 Fe DIN	Exposure Time:	150min	Spoiled Film:			...	...	...	

Number of locations:	49	Total request (inch diameter/film sheet):	91	Number of radiographic lesions:	24	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	Reshot	Retake	Cut-Out	Remark
1	060	3-PRO-10-73C03-B6P21	6183-RP	3	5.49	15*1	22~23	LTCS	PW-122			BW	599		☑	☐	☐	☐	☐	
2	001	1.5-PRO-10-07829-B6P21(2)	6625	1.5	5.08	15*3	ALL	LTCS	PW-137			BW	599		☑	☐	☐	☐	☐	
3	004	1.5-PRO-10-07829-B6P21(2)	6634	1.5	5.08	15*3	ALL	LTCS	PW-137			BW	599		☑	☐	☐	☐	☐	
4	005	1.5-PRO-10-07829-B6P21(2)	6640	1.5	5.08	15*3	ALL	LTCS	PW-137			BW	599		☑	☐	☐	☐	☐	
5	011	1-HC-10-72D01-B3X21-P	6650	1.5	5.08	15*3	ALL	LTCS	PW-071			BW	599		☑	☐	☐	☐	☐	
6	013RWC	1-HC-10-72D01-B3X21-P	6651	1.5	5.08	15*3	ALL	LTCS	PW-102			BW	599		☑	☐	☐	☐	☐	
7	014	1-HC-10-72D01-B3X21-P	6652	1.5	5.08	15*3	ALL	LTCS	PW-071			BW	599		☑	☐	☐	☐	☐	
8	016RWC	1-HC-10-72D01-B3X21-P	6653	1	4.55	15*3	ALL	LTCS	PW-102			BW	599		☑	☐	☐	☐	☐	
9	017	1-HC-10-72D01-B3X21-P	6654	1	4.55	15*3	ALL	LTCS	PW-102			BW	599		☑	☐	☐	☐	☐	
10	024	1-HC-10-72D01-B3X21-P	6658	1	4.55	15*3	ALL	LTCS	PW-051			BW	599		☑	☐	☐	☐	☐	
11	021	1.5-PRO-10-72D08-B6P21-JP	6751	1.5	5.08	15*3	ALL	LTCS	PW-028			BW	599		☑	☐	☐	☐	☐	
12	022	1.5-PRO-10-72D08-B6P21-JP	6752	1.5	5.08	15*3	ALL	LTCS	PW-137			BW	599		☑	☐	☐	☐	☐	
13	026	1.5-PRO-10-72D08-B6P21-JP	6755	1.5	5.08	15*3	ALL	LTCS	PW-077			BW	599		☑	☐	☐	☐	☐	
14	027	1.5-PRO-10-72D08-B6P21-JP	6756	1.5	5.08	15*3	ALL	LTCS	PW-109			BW	599		☑	☐	☐	☐	☐	
15	030	1.5-PRO-10-72D08-B6P21-JP	6757	1.5	5.08	15*3	ALL	LTCS	PW-119			BW	599		☑	☐	☐	☐	☐	
16	031	1.5-PRO-10-72D08-B6P21-JP	6758	1.5	5.08	15*3	ALL	LTCS	PW-118			BW	599		☑	☐	☐	☐	☐	
17	036	16-BDM-10-60B01-B1P21(RI)	7061	2	3.91	15*3	ALL	LTCS	PW-012-1			BW	599		☑	☐	☐	☐	☐	
18	005	2-BDM-10-01704-B1P21	7065	0.5	2.77	15*3	ALL	LTCS	PW-012-1			BW	599		☑	☐	☐	☐	☐	
19	027	2-BDM-10-01803-B1P21	7066	2	3.91	15*3	ALL	LTCS	PW-012-1			BW	599		☑	☐	☐	☐	☐	
20	29-1	8-BDM-10-60B06-B1P21	7116-RS	8	6.35	30*1	20~45	LTCS	PW-012-1			BW	599		☑	☐	☐	☐	☐	

Number of radiographed welds:	20	Total inch:	(inch)	Total number of film sheets:	68

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: 31/04/1405	Date:	Date:
Sign:	Sign:	Sign:

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