joosh maye jey NDT

1753

آزمون فلز پارس(پتروپالایش کنگان)

Radiography TEST Report for Piping

Report No.	631	**Reference Standard:**	ASME B 31.3	**RT Device S/N:**	577	**Density:**	2-4	**Received Dose(µsv)**	**Geiger**	**Dosimeter**	**Radiographer Name**	**Personnel Code**
Report Date:	02/06/1405	**RT Instruction No.**	J-104-IN-33	**KV:**		**Sensitivity:**	1.2		…	0	یاور کریمی	1143
Radiography Date:	31/05/1405	**RT Technique:**		**Source Power:**	32 ci	**Film Type:**	MX125-NIF-10	70µsv	608	0	احد رئیسی	1216
Request No.	632	SWSI ☐ DWSI ☑ DWDI ☑		**Source Size:**	2-2	**Total Film Length:**	1,104CM	80µsv	528	0	محمد دیماد	1147
Page:	1/2	**IQI**	10 - 16 Fe DIN	**Exposure Time:**	120min	**Spoiled Film:**			…	…	…	

Number of locations:	54	**Total request (inch diameter/film sheet):**	228	**Number of radiographic lesions:**	27	**Total radiographed (inch diameter/film sheet):**	12(inch)	**Start time:**	20:00	**End time:**	4:00

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	021RWC	4-HX-10-74B01-A1P21	8339	4	6.02	18*3	ALL	CS	PW-013-1			BW	632		☑	☐	☐	☐	☐	
2	011	2-PRW-10-05007-A1P23-P(2)	0195RWP2-RS	2	3.91	15*2	ALL	CS	PW-100			BW	632		☑	☐	☐	☐	☐	
3	2RW2C	2-HC-10-30B03-A1P21-E	0569RW2C	2	3.91	15*2	ALL	CS	PW-122			BW	632		☑	☐	☐	☐	☐	
4	020RWC	4-HX-10-74B01-A1P21	1250P1RW	4	6.02	18*3	ALL	CS	PW-013-1			BW	632		☑	☐	☐	☐	☐	
5	016RWC	4-HX-10-74B01-A1P21	1273P2RW	4	6.02	18*3	ALL	CS	PW-012-1			BW	632		☑	☐	☐	☐	☐	
6	018RWC	1-HC-10-73C13-B6P21(RI)	1432RW	2	5.54	15*2	ALL	LTCS	PW-137			BW	632		☑	☐	☐	☐	☐	
7	008CO	3-PRO-10-73C03-B6P21	6198CO	0.5	3.73	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
8	094CO	3-PRO-10-73C03-B6P21	6212CO	1.5	3.68	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
9	001	1-HC-10-73C13-B6P21(RI)	6952	1	4.55	15*3	ALL	LTCS	PW-013-1			BW	632		☑	☐	☐	☐	☐	
10	019RWC	1-HC-10-73C13-B6P21(RI)	6953RW-RS	2	5.54	15*2	ALL	LTCS	PW-137			BW	632		☑	☐	☐	☐	☐	
11	026	1-HC-10-73C13-B6P21(RI)	6960-RS	1	4.55	15*3	ALL	LTCS	PW-013-1			BW	632		☑	☐	☐	☐	☐	
12	007	1-HC-10-73C15-B6P21(RI)	6971	2	5.54	15*2	ALL	LTCS	PW-012-1			BW	632		☑	☐	☐	☐	☐	
13	044CO	1-HC-10-73C10-B6P21	7649CO	1	4.55	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
14	056CO	1-HC-10-73C10-B6P21	7652CO	0.5	3.73	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
15	004CO	2-PRO-10-73B04-B6P21-P	7721CO	2	5.54	15*2	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
16	6CO2	3-PRO-10-73C02-B6P21	7814CO2	0.5	3.73	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
17	12CO2	3-PRO-10-73C11-B6P21	7817CO2	1	4.55	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
18	130CO	3-PRO-10-73C03-B6P21	7854CO	0.5	3.73	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
19	129CO	3-PRO-10-73C03-B6P21	7855CO	0.5	4.78	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	
20	135CO	3-PRO-10-73C03-B6P21	7961CO	0.5	3.73	15*3	ALL	LTCS	PW-119			BW	632		☑	☐	☐	☐	☐	

Number of radiographed welds: 20 **Total inch:** 6(inch) **Total number of film sheets:** 70

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: یاور کریمی	Name: سینا حاجی مقصودی	Name:
Date: 02/06/1405	Date:	Date:
Sign:	Sign:	Sign: