joosh maye jey NDT

1753

آزمون فلز پارس(پتروپالایش کنگان)

Radiography TEST Report for Piping

Report No.	634	**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:	10/06/1405	**RT Instruction No.**	J-104-IN-33	**KV:**		**Sensitivity:**	1.2		…	0	یاور کریمی	1143
Radiography Date:	02/06/1405	**RT Technique:**		**Source Power:**	30 ci	**Film Type:**	MX125-NIF-10	50µsv	608	0	احد رئیسی	1216
Request No.	635	SWSI ☐ DWSI ☑ DWDI ☑		**Source Size:**	2-2	**Total Film Length:**	1,390CM	70µsv	528	0	محمد دیماد	1147
Page:	1/2	**IQI**	10 - 16 Fe DIN	**Exposure Time:**	120min	**Spoiled Film:**			…	…	…	

Number of locations:	58	**Total request (inch diameter/film sheet):**	192	**Number of radiographic lesions:**	26	**Total radiographed (inch diameter/film sheet):**		**(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	004	0.5-OG-10-01B01-B1P21	8351	0.5	4.78	15*3	ALL	LTCS	PW-013-1			BW	635		☑	☐	☐	☐	☐	
2	001	0.75-ETY-10-70A37-A3X21(P)	8032	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
3	010	0.75-ETY-10-70A37-A3X21(P)	8033	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
4	011	0.75-ETY-10-70A37-A3X21(P)	8034	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
5	012	0.75-ETY-10-70A37-A3X21(P)	8035	0.5	3.73	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
6	017	0.75-ETY-10-70A37-A3X21(P)	8040	0.5	3.73	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
7	018	0.75-ETY-10-70A37-A3X21(P)	8041	0.5	3.73	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
8	019	0.75-ETY-10-70A37-A3X21(P)	8042	0.5	3.73	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
9	002	0.75-ETY-10-70A37-A3X21(P)	8043	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
10	020	0.75-ETY-10-70A37-A3X21(P)	8044	0.5	3.73	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
11	021	0.75-ETY-10-70A37-A3X21(P)	8045	0.5	3.73	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
12	003	0.75-ETY-10-70A37-A3X21(P)	8052	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
13	004	0.75-ETY-10-70A37-A3X21(P)	8053	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
14	005	0.75-ETY-10-70A37-A3X21(P)	8054	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
15	006	0.75-ETY-10-70A37-A3X21(P)	8055	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
16	007	0.75-ETY-10-70A37-A3X21(P)	8056	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
17	008	0.75-ETY-10-70A37-A3X21(P)	8057	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
18	009	0.75-ETY-10-70A37-A3X21(P)	8058	0.75	3.91	15*3	ALL	CS	PW-051			BW	635		☑	☐	☐	☐	☐	
19	001	12-ETY-10-70A31-A3X21(H)	8061	12	9.53	40*3	ALL	CS	PW-012			BW	635		☑	☐	☐	☐	☐	
20	016	12-ETY-10-70A32-A3X21(H)	8073	12	9.53	40*3	ALL	CS	PW-012			BW	635		☑	☐	☐	☐	☐	

Number of radiographed welds: 20 **Total inch:** (inch) **Total number of film sheets:** 76

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: 10/06/1405	Date:	Date:
Sign:	Sign:	Sign:

Code: J-104-FO-09 **Revision:** 04 **Issue.Date:** 1400.11.02 **Rev.Date:** 1404.07.29