joosh maye jey NDT

1555

انهار (ایستگاه گاز هما)

Radiography TEST Report for Piping

Report No.	HOMA-238	**Reference Standard:**	ASME B 31.3	**RT Device S/N:**	12689	**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	علی دلیخون	1230
Radiography Date:	05/06/1405	**RT Technique:**		**Source Power:**	30 ci	**Film Type:**	FUJI50-PB-10	120µsv	1122	0	ابوذر تاجمرادی	1110
Request No.	511	SWSI ☐ DWSI ☑ DWDI ☐		**Source Size:**	2-2	**Total Film Length:**	1,124CM	120µsv	262	0	ناصر قاسمی	1284
Page:	1/2	**IQI**	10 - 16 Fe DIN	**Exposure Time:**	200min	**Spoiled Film:**		…	…	…	…	

Number of locations:	37	**Total request (inch diameter/film sheet):**	142	**Number of radiographic lesions:**	23	**Total radiographed (inch diameter/film sheet):**	110(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	103	CHM-1127001-HS18-2-N	6579	2	8.74	15*3	ALL	CS	66			BW	511		☑	☐	☐	☐	☐	
2	101	CHM-1127001-HS18-2-N	6586	2	8.74	15*3	ALL	CS	44			BW	511		☑	☐	☐	☐	☐	
3	102	CHM-1127001-HS18-2-N	6588	2	8.74	15*3	ALL	CS	44			BW	511		☑	☐	☐	☐	☑	
4	105	CHM-1127001-HS18-2-N	6577PD1	2	8.74	15*3	ALL	CS	99			BW	511		☑	☐	☐	☐	☐	
5	106	CHM-1127001-HS18-2-N	6578PD2	2	8.74	15*3	ALL	CS	99			BW	511		☑	☐	☐	☐	☐	
6	92	CHM-1127002-HS18-2-N	6587	2	8.74	15*3	ALL	CS	44			BW	511		☑	☐	☐	☐	☐	
7	93	CHM-1127002-HS18-2-N	6589	2	#REF!	15*3	ALL	CS	44			BW	511		☑	☐	☐	☐	☐	
8	94	CHM-1127002-HS18-2-N	6590	2	8.74	15*3	ALL	CS	66			BW	511		☑	☐	☐	☐	☐	
9	95	CHM-1127002-HS18-2-N	6591	2	8.74	15*3	ALL	CS	44			BW	511		☑	☐	☐	☐	☐	
10	96	CHM-1127002-HS18-2-N	6592	2	8.74	15*3	ALL	CS	44			BW	511		☑	☐	☐	☐	☐	
11	23RW	GAS-1134073-CN28-2-P	2625CO	4	6.02	18*3	ALL	CS	125			BW	511		☑	☐	☐	☐	☐	
12	10C	GAS-1150079-FN27-8-P	4385RT	8	8.18	30*1	30-40	CS	7	-		BW	511		☑	☐	☐	☐	☐	
13	17A	GAS-1150085-FN27-16-P	6183RSH	2	5.54	15*3	ALL	CS	07	-		BW	511		☑	☐	☐	☐	☐	
14	58	GAS-1204035-GN28-12-P	6575	12	14.27	40*3	ALL	CS	119	-		BW	511		☑	☐	☐	☐	☐	
15	58A	GAS-1204035-GN28-12-P	6576	12	14.27	40*3	ALL	CS	122	119		BW	511		☑	☐	☐	☐	☐	
16	1	GAS-1205175-HN28-6-IS	1063RT	6	10.97	24*1	20-35	CS	2	-		BW	511		☑	☐	☐	☐	☐	
17	4	GAS-1205176-HN28-6-IS	1066RT	6	10.97	24*1	20-35	CS	2	-		BW	511		☑	☐	☐	☐	☐	
18	9	GAS-1205176-HN28-6-IS	2114RT/RSH	6	10.97	24*1	20-30	CS	21	-		BW	511		☑	☐	☐	☐	☐	
19	8	GAS-1205179-HN28-4-IS	6420RP	10	15.09	35*1	32-42	CS	104	-		BW	511		☑	☐	☐	☐	☐	
20	2B	GAS-1205189-HN28-4-IS	5789RP	4	13.49	18*2	2--8	CS	104	-		BW	511		☑	☐	☐	☐	☐	

Number of radiographed welds: 20 **Total inch:** 90(inch) **Total number of film sheets:** 55

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: علی دلیخون	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