joosh maye jey NDT

1644

سینا صنعت احمدپور

Radiography TEST Report for Piping

شرکت سینا صنعت احمدپور ثبت: ۳۱۱۸۵ سهامی خاص
SINA SANAT-E AHMADPOUR CO.

Report No.	KSM-ASU-979	**Reference Standard:**	ASME B 31.3	**RT Device S/N:**	275	**Density:**	2-4	**Received Dose(µsv)**	**Geiger**	**Dosimeter**	**Radiographer Name**	**Personnel Code**
Report Date:	03/07/1405	**RT Instruction No.**	J-104-IN-33	**KV:**		**Sensitivity:**	1/2		…	0	رضا خادم پیر	1111
Radiography Date:	25/06/1405	**RT Technique:**		**Source Power:**	54 ci	**Film Type:**	MX125- PB-10	120µsv	PC-527	0	احمد عیباوی فر	1229
Request No.	SSA-RQ-548	SWSI ☐ DWSI ☐ DWDI ☑		**Source Size:**	2 mm	**Total Film Length:**	870CM	120µsv	PC-521	0	شجاع خسرویان	1109
Page:	1/2	**IQI**	10 - 16 Fe EN	**Exposure Time:**	130min	**Spoiled Film:**	30CM		…	…	…	

Number of locations:	28	**Total request (inch diameter/film sheet):**	52	**Number of radiographic lesions:**	26	**Total radiographed (inch diameter/film sheet):**	48(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	30	LO-701404	ASU-2134	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
2	10	LO-711401	ASU-2135	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
3	12	LO-711401	ASU-2137	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
4	13	LO-711401	ASU-2138	1	3.38	15*3		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
5	14	LO-711401	ASU-2160	1	3.38	15*3		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
6	15	LO-711401	ASU-2161	0.75	2.87	15*3		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
7	16	LO-711401	ASU-2139	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
8	18	LO-711401	ASU-2141	1	3.38	15*3		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
9	19	LO-711401	ASU-2142	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
10	21	LO-711401	ASU-2143	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
11	22	LO-711401	ASU-2144	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
12	23	LO-711401	ASU-2145	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
13	24	LO-711401	ASU-2146	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
14	25	LO-711401	ASU-2147	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
15	26	LO-711401	ASU-2148	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
16	27	LO-711401	ASU-2149	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
17	28	LO-711401	ASU-2150	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
18	29	LO-711401	ASU-2151	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
19	30	LO-711401	ASU-2152	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	
20	31	LO-711401	ASU-2153	2	3.91	15*2		SS	GWC-16				SSA-RQ-54		☑	☐	☐	☐	☐	

Number of radiographed welds: 26 **Total inch:** 48(inch) **Total number of film sheets:** 56

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)

Name: رضا خادم پیر
Date: 03/07/1405
Sign:

سرجوش 2136 و 2140 ریشوت و از ریپورت حذف گردید

Technical Manager

Name: سینا حاجی مقصودی
Date:
Sign:

Owner

Name:
Date:
Sign:

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