



磁粉探伤报告 MAGNETIC PARTICLE TESTING REPORT

报告号:

Report No: MMEC-7353-212-MT-001

PHASE 2 SPLICE 1 LINE 2

委托单位 Consignment Company	玛顿模块化工程建造(苏州)有限公司 Modern Modular Engineering&Construction CO.,LTD	检测单位 Test Contractor	特灵顿(上海)检测认证服务有限公司 TUV Thuringen Shanghai Co.,Ltd	检测地点 Test place	玛顿模块化工程建造(苏州)有限公司 Modern Modular Engineering&Construction CO.,LTD
委托内容 Consignment Contents	磁粉探伤 MT	主体材料 Member Material	As Drawing	焊接方法 Mode of welding	FCAW+SAW
程序 Procedure	MHI-7353-QA-002	检测部位 Test Position	焊缝和热影响区 Welding and HAZ	热处理状态 Heat Treatment Status	/
检测比例(%) Percentage	Fillet weld 30%& T<8mmCJP weld 100%& lug weld 100%& PJP weld depth>12mm 20%& TKY weld 100%	检测时机 Test Occasion	冷至环境温度 Cooled to ambient temperature	仪器型号 Model of Instrument	MP-A2L
磁化方法 Magnetization Method	磁轭 Yoke	磁化电流 Current of Magnetization	交流 Alternating Current	提升力 Lift Power	$\geq 45N, > 3s$
磁化时间 Magnetization Time	1—3秒(second)	表面状态 Surface Status	砂轮打磨 Grinding Wheel Polishing	标准试块 Test Piece	Magnetic field indicator A-30/100
磁粉类型 Type of Magnetic Particle	黑磁粉 Black Magnetic Particle	喷洒方法 Spray Manner	喷涂 Spraying	测试标准 Test Standard	EN ISO17638-2016
温度 Temperature	环境温度 Ambient Temperature	验收标准 Acceptance Standard	ISO 23278:2015 Level 2X	检测时间 Date of Test	2022.11.17~2023.02.04

检测结论Testing result:

该检验项目依据ITP。依据 ISO 23278:2015 Level 2X 标准的质量要求, 评定合格。

This test was requested by ITP. All the workpieces listed on attachments have been tested by MT, and qualified in accordance with ISO 23278:2015 Level 2X.

*DIGITAL LIGHT METER:>1000 lux



审核/等级 Reviewed by/ Level		检验/等级 Inspector/ Level	
日期 Date	2023.2.4	日期 Date	2023.2.4



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工程名称 Project Name		SIWMF Structure Project		构件名称 Structure Name		As below			
序号	工件或焊缝编号	检测位置	缺陷编号	缺陷尺寸	评定（Assess）		返修(Repair)		备注
S/N	Workpiece and Number of Welding Joint	Test Position(mm)	Number of Defect	Size of Defect	合格	不合格	合格	不合格	Remarks:
					Accept	Not Accept	Accept	Not Accept	
1	BP2-1-1-F1	Weld & HAZ	-	-	Acc.	-	-	-	
2	BP2-1-1-F2	Weld & HAZ	-	-	Acc.	-	-	-	
3	BP2-1-1-F3	Weld & HAZ	-	-	Acc.	-	-	-	
4	BP2-1-1-F4	Weld & HAZ	-	-	Acc.	-	-	-	
5	BP2-1-2-F1	Weld & HAZ	-	-	Acc.	-	-	-	
6	BP2-1-2-F2	Weld & HAZ	-	-	Acc.	-	-	-	
7	BP2-1-2-F3	Weld & HAZ	-	-	Acc.	-	-	-	
8	BP2-1-2-F4	Weld & HAZ	-	-	Acc.	-	-	-	
9	BP2-1-3-F1	Weld & HAZ	-	-	Acc.	-	-	-	
10	BP2-1-3-F2	Weld & HAZ	-	-	Acc.	-	-	-	
11	BP2-1-3-F3	Weld & HAZ	-	-	Acc.	-	-	-	
12	BP2-1-3-F4	Weld & HAZ	-	-	Acc.	-	-	-	
13	BP2-1-4-F1	Weld & HAZ	-	-	Acc.	-	-	-	
14	BP2-1-4-F2	Weld & HAZ	-	-	Acc.	-	-	-	
15	BP2-1-4-F3	Weld & HAZ	-	-	Acc.	-	-	-	
16	BP2-1-4-F4	Weld & HAZ	-	-	Acc.	-	-	-	
17	BP2-2-1-F1	Weld & HAZ	-	-	Acc.	-	-	-	
18	BP2-2-1-F2	Weld & HAZ	-	-	Acc.	-	-	-	
19	BP2-2-1-F3	Weld & HAZ	-	-	Acc.	-	-	-	
20	BP2-2-1-F4	Weld & HAZ	-	-	Acc.	-	-	-	
21	BP2-2-2-F1	Weld & HAZ	-	-	Acc.	-	-	-	
22	BP2-2-2-F2	Weld & HAZ	-	-	Acc.	-	-	-	
23	BP2-2-2-F3	Weld & HAZ	-	-	Acc.	-	-	-	
24	BP2-2-2-F4	Weld & HAZ	-	-	Acc.	-	-	-	
25	BP2-2-3-F1	Weld & HAZ	-	-	Acc.	-	-	-	