**磁粉检测报告**

报告编号: ZJC026-24-MT-071

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 委托单位 | | 中交一公局集团有限公司 | | | | | 工程名称 | | 钟园路对接强胜路道路工程 | | |
| 构件名称 | | S-9B | | | | | 检测部位 | | 角焊缝 | | |
| 材质 | | Q345qD | | | 反差增强剂 | | FA-5 | | 检测数量 | | 139.015 m |
| 检测时机 | | 焊后24小时 | | | 磁悬液类型 | | 黑色水悬液 | | 检测比例 | | 100% |
| 仪器型号和编号 | | 磁粉探伤仪 SZ-C04 | | | 施加方法 | | 喷罐 | | 磁化电流/  提升力 | | >45N |
| 表面状况 | | 打磨 | | | 磁化方法 | | 连续湿法 | | 磁化时间 | | 1~3S |
| 采用标准和级别 | | GB/T 26951-2011  GB/T 26952-2011 2X级 | | | 灵敏度试片 | | A1 30/100标准试片 | | 观察环境 | | 检测表面>1000Lx |
| 检测部位及缺陷示意图：    说明：焊缝坐标方向为纵向焊缝从小桩号到大桩号；环向焊缝从左到右；竖直焊缝从上到下。 | | | | | | | | | | | |
| 检测结果：  依据上述标准及合格级别，本公司按照上述比例对上述检测部位焊缝进行了检测，检测结论合格，具体检测情况见下页检测结果表格。 | | | | | | | | | | | |
| 编制 |  | | 审核 |  | | 批准 | |  | | 日 期 | 2024.12.26 |

**磁粉检测结果**

报告编号: ZJC026-24-MT-071

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 序号 | 构件或焊缝  编号 | 检测部位  (m) | 检测  长度  (m) | 缺陷  编号 | 缺陷  性质 | X  (mm) | 缺陷  尺寸  (mm) | 结论 |
| 1 | S-9B-M/UL1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 2 | S-9B-M/UL1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 3 | S-9B-M/UL1-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 4 | S-9B-M/UL1-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 5 | S-9B-M/UL2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 6 | S-9B-M/UL2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 7 | S-9B-M/UL2-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 8 | S-9B-M/UL2-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 9 | S-9B-M/UL3-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 10 | S-9B-M/UL3-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 11 | S-9B-M/UL3-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 12 | S-9B-M/UL3-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 13 | S-9B-M/UL4-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 14 | S-9B-M/UL4-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 15 | S-9B-M/UL4-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 16 | S-9B-M/UL4-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 17 | S-9B-M/UL5-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 18 | S-9B-M/UL5-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 19 | S-9B-M/UL5-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 20 | S-9B-M/UL5-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 21 | S-9B-M/UL6-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 22 | S-9B-M/UL6-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 23 | S-9B-M/UL6-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 24 | S-9B-M/UL6-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 25 | S-9B-D/BL1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.26 | |
| 缺陷性质代号:  A-无缺陷；S-夹渣；P-气孔；C-裂纹；U-咬边；L-未熔合；X：距基准点距离；R1-返修一`次，R2-返修两次 | | | | | | | | |

**磁粉检测结果**

报告编号: ZJC026-24-MT-071（续1）

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 序号 | 构件或焊缝  编号 | 检测部位  (m) | 检测  长度  (m) | 缺陷  编号 | 缺陷  性质 | X  (mm) | 缺陷  尺寸  (mm) | 结论 |
| 1 | S-9B-D/BL1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 2 | S-9B-D/BL2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 3 | S-9B-D/BL2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 4 | S-9B-D/TL1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 5 | S-9B-D/TL1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 6 | S-9B-D/TL1-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 7 | S-9B-D/TL1-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 8 | S-9B-D/TL2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 9 | S-9B-D/TL2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 10 | S-9B-D/TL2-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 11 | S-9B-D/TL2-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 12 | S-9B-D/TL3-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 13 | S-9B-D/TL3-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 14 | S-9B-D/TL3-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 15 | S-9B-D/TL3-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 16 | S-9B-D/TL4-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 17 | S-9B-D/TL4-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 18 | S-9B-D/TL4-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 19 | S-9B-D/TL4-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 20 | S-9B-D/TL5-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 21 | S-9B-D/TL5-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 22 | S-9B-D/TL5-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 23 | S-9B-D/TL5-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 24 | S-9B-D/TL6-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 25 | S-9B-D/TL6-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.26 | |
| 缺陷性质代号:  A-无缺陷；S-夹渣；P-气孔；C-裂纹；U-咬边；L-未熔合；X：距基准点距离；R1-返修一`次，R2-返修两次 | | | | | | | | |

**磁粉检测结果**

报告编号: ZJC026-24-MT-071（续2）

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 序号 | 构件或焊缝  编号 | 检测部位  (m) | 检测  长度  (m) | 缺陷  编号 | 缺陷  性质 | X  (mm) | 缺陷  尺寸  (mm) | 结论 |
| 1 | S-9B-D/TL6-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 2 | S-9B-D/TL6-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 3 | S-9B-D/TL7-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 4 | S-9B-D/TL7-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 5 | S-9B-D/TL7-3 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 6 | S-9B-D/TL7-4 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 7 | S-9B-F/BL1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 8 | S-9B-F/BL1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 9 | S-9B-F/BL2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 10 | S-9B-F/BL2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 11 | S-9B-F/BL3-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 12 | S-9B-F/BL3-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 13 | S-9B-1HG/GJ1-1 | 0~0.5 | 0.5 | / | A | / | / | 合格 |
| 14 | S-9B-1HG/GJ1-2 | 0~0.5 | 0.5 | / | A | / | / | 合格 |
| 15 | S-9B-1HG/GJ2-1 | 0~0.5 | 0.5 | / | A | / | / | 合格 |
| 16 | S-9B-1HG/GJ2-2 | 0~0.5 | 0.5 | / | A | / | / | 合格 |
| 17 | S-9B-M/HG1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 18 | S-9B-M/HG1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 19 | S-9B-M/HG2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 20 | S-9B-M/HG2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 21 | S-9B-M/HG3-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 22 | S-9B-M/HG3-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 23 | S-9B-M/HG4-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 24 | S-9B-M/HG4-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 25 | S-9B-M/HG5-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.26 | |
| 缺陷性质代号:  A-无缺陷；S-夹渣；P-气孔；C-裂纹；U-咬边；L-未熔合；X：距基准点距离；R1-返修一`次，R2-返修两次 | | | | | | | | |

**磁粉检测结果**

报告编号: ZJC026-24-MT-071（续3）

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 序号 | 构件或焊缝  编号 | 检测部位  (m) | 检测  长度  (m) | 缺陷  编号 | 缺陷  性质 | X  (mm) | 缺陷  尺寸  (mm) | 结论 |
| 1 | S-9B-M/HG5-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 2 | S-9B-M/HG6-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 3 | S-9B-M/HG6-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 4 | S-9B-M/HG7-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 5 | S-9B-M/HG7-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 6 | S-9B-M/HG8-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 7 | S-9B-M/HG8-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 8 | S-9B-M/HG9-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 9 | S-9B-M/HG9-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 10 | S-9B-M/HG10-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 11 | S-9B-M/HG10-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 12 | S-9B-M/HG11-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 13 | S-9B-M/HG11-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 14 | S-9B-M/HG12-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 15 | S-9B-M/HG12-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 16 | S-9B-D/HG1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 17 | S-9B-D/HG1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 18 | S-9B-D/HG2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 19 | S-9B-D/HG2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 20 | S-9B-D/HG3-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 21 | S-9B-D/HG3-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 22 | S-9B-D/HG4-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 23 | S-9B-D/HG4-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 24 | S-9B-D/HG5-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 25 | S-9B-D/HG5-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.26 | |
| 缺陷性质代号:  A-无缺陷；S-夹渣；P-气孔；C-裂纹；U-咬边；L-未熔合；X：距基准点距离；R1-返修一`次，R2-返修两次 | | | | | | | | |

**磁粉检测结果**

报告编号: ZJC026-24-MT-071（续4）

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 序号 | 构件或焊缝  编号 | 检测部位  (m) | 检测  长度  (m) | 缺陷  编号 | 缺陷  性质 | X  (mm) | 缺陷  尺寸  (mm) | 结论 |
| 1 | S-9B-D/HG6-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 2 | S-9B-D/HG6-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 3 | S-9B-D/HG7-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 4 | S-9B-D/HG7-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 5 | S-9B-D/HG8-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 6 | S-9B-D/HG8-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 7 | S-9B-D/HG9-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 8 | S-9B-D/HG9-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 9 | S-9B-D/HG10-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 10 | S-9B-D/HG10-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 11 | S-9B-D/HG11-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 12 | S-9B-D/HG11-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 13 | S-9B-D/HG12-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 14 | S-9B-D/HG12-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 15 | S-9B-F/HG1-1 | 0~2.27 | 2.27 | / | A | / | / | 合格 |
| 16 | S-9B-F/HG1-2 | 0~2.231 | 2.231 | / | A | / | / | 合格 |
| 17 | S-9B-F/HG1-3 | 0~2.269 | 2.269 | / | A | / | / | 合格 |
| 18 | S-9B-F/HG1-4 | 0~2.23 | 2.23 | / | A | / | / | 合格 |
| 19 | S-9B-F/HG1-5 | 0~2.271 | 2.271 | / | A | / | / | 合格 |
| 20 | S-9B-F/HG1-6 | 0~2.232 | 2.232 | / | A | / | / | 合格 |
| 21 | S-9B-F/HG1-7 | 0~2.272 | 2.272 | / | A | / | / | 合格 |
| 22 | S-9B-F/HG1-8 | 0~2.233 | 2.233 | / | A | / | / | 合格 |
| 23 | S-9B-F/HG1-9 | 0~2.271 | 2.271 | / | A | / | / | 合格 |
| 24 | S-9B-F/HG1-10 | 0~2.233 | 2.233 | / | A | / | / | 合格 |
| 25 | S-9B-F/HG1-11 | 0~2.271 | 2.271 | / | A | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.26 | |
| 缺陷性质代号:  A-无缺陷；S-夹渣；P-气孔；C-裂纹；U-咬边；L-未熔合；X：距基准点距离；R1-返修一`次，R2-返修两次 | | | | | | | | |

**磁粉检测结果**

报告编号: ZJC026-24-MT-071（续5）

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 序号 | 构件或焊缝  编号 | 检测部位  (m) | 检测  长度  (m) | 缺陷  编号 | 缺陷  性质 | X  (mm) | 缺陷  尺寸  (mm) | 结论 |
| 1 | S-9B-F/HG1-12 | 0~2.232 | 2.232 | / | A | / | / | 合格 |
| 2 | 以下空白 |  |  |  |  |  |  |  |
| 3 |  |  |  |  |  |  |  |  |
| 4 |  |  |  |  |  |  |  |  |
| 5 |  |  |  |  |  |  |  |  |
| 6 |  |  |  |  |  |  |  |  |
| 7 |  |  |  |  |  |  |  |  |
| 8 |  |  |  |  |  |  |  |  |
| 9 |  |  |  |  |  |  |  |  |
| 10 |  |  |  |  |  |  |  |  |
| 11 |  |  |  |  |  |  |  |  |
| 12 |  |  |  |  |  |  |  |  |
| 13 |  |  |  |  |  |  |  |  |
| 14 |  |  |  |  |  |  |  |  |
| 15 |  |  |  |  |  |  |  |  |
| 16 |  |  |  |  |  |  |  |  |
| 17 |  |  |  |  |  |  |  |  |
| 18 |  |  |  |  |  |  |  |  |
| 19 |  |  |  |  |  |  |  |  |
| 20 |  |  |  |  |  |  |  |  |
| 21 |  |  |  |  |  |  |  |  |
| 22 |  |  |  |  |  |  |  |  |
| 23 |  |  |  |  |  |  |  |  |
| 24 |  |  |  |  |  |  |  |  |
| 25 |  |  |  |  |  |  |  |  |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.26 | |
| 缺陷性质代号:  A-无缺陷；S-夹渣；P-气孔；C-裂纹；U-咬边；L-未熔合；X：距基准点距离；R1-返修一`次，R2-返修两次 | | | | | | | | |