**磁粉检测报告**

报告编号: ZJC026-24-MT-075

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 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-10XT1 | | | | | 检测部位 | | 角焊缝 | | |
| 材质 | | Q345qD | | | 反差增强剂 | | FA-5 | | 检测数量 | | 58.538 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 | 2024.12.27 |

**磁粉检测结果**

报告编号: ZJC026-24-MT-075

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 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-10XT1-M/BL1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 2 | S-10XT1-M/BL1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 3 | S-10XT1-M/BL2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 4 | S-10XT1-M/BL2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 5 | S-10XT1-M/BL3-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 6 | S-10XT1-M/BL3-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 7 | S-10XT1-M/BL4-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 8 | S-10XT1-M/BL4-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 9 | S-10XT1-M/BL5-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 10 | S-10XT1-M/BL5-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 11 | S-10XT1-M/BL6-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 12 | S-10XT1-M/BL6-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 13 | S-10XT1-M/YL1 | 0~3.174 | 3.174 | / | A | / | / | 合格 |
| 14 | S-10XT1-M/YL2 | 0~4.4 | 4.4 | / | A | / | / | 合格 |
| 15 | S-10XT1-M/BL1-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 16 | S-10XT1-M/BL1-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 17 | S-10XT1-M/BL2-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 18 | S-10XT1-M/BL2-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 19 | S-10XT1-M/BL3-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 20 | S-10XT1-M/BL3-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 21 | S-10XT1-M/BL4-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 22 | S-10XT1-M/BL4-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 23 | S-10XT1-M/BL5-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 24 | S-10XT1-M/BL5-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 25 | S-10XT1-M/BL6-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.27 | |
| 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-075（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-10XT1-M/BL6-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 2 | S-10XT1-M/BL5-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 3 | S-10XT1-M/BL5-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 4 | S-10XT1-M/BL6-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 5 | S-10XT1-M/BL6-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 6 | S-10XT1-M/BL7-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 7 | S-10XT1-M/BL7-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 8 | S-10XT1-M/BL8-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 9 | S-10XT1-M/BL8-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 10 | S-10XT1-M/BL9-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 11 | S-10XT1-M/BL9-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 12 | S-10XT1-M/BL10-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 13 | S-10XT1-M/BL10-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 14 | S-10XT1-M/BL11-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 15 | S-10XT1-M/BL11-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 16 | S-10XT1-M/BL12-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 17 | S-10XT1-M/BL12-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 18 | S-10XT1-M/BL13-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 19 | S-10XT1-M/BL13-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 20 | S-10XT1-M/BL14-1 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 21 | S-10XT1-M/BL14-2 | 0~1 | 1.0 | / | A | / | / | 合格 |
| 22 | S-10XT1-M/YL1 | 0~2.42 | 2.42 | / | A | / | / | 合格 |
| 23 | S-10XT1-M/YL2 | 0~4.544 | 4.544 | / | A | / | / | 合格 |
| 24 | 以下空白 |  |  |  |  |  |  |  |
| 25 |  |  |  |  |  |  |  |  |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | 2024.12.27 | |
| 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 | | | | | | | | |