**超声波检测报告**

报告编号: ZJC018-PK1Z-24-UT-004

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| 委托单位 | | 宿迁大道(迎宾大道至杨舍路)快速化改造工程施工项目SODDSG1标段 | | | 工程名称 | | | 宿迁大道(迎宾大道至杨舍路)快速化改造工程施工项目 | | |
| 构件名称 | | PK1Z-L1 | | | 检测部位 | | | PK1Z-L1 熔透角焊缝 | | |
| 材质 | | Q345qD | | 坡口形式 | V型 | | | 检测数量 | 112.52 m | |
| 检测时机 | | 焊后24小时 | | 焊接方法 | CO2气体保护焊+埋弧自动焊 | | | 检测比例 | 100% | |
| 热处理状态 | | TMCP | | 工件温度 | 5℃ | | | 表面状态 | 打磨光滑 | |
| 仪器型号/  编号 | | 超声波探伤仪 SZ-C01 | | 探头规格 | 5P9X9 70° 2.5P9X9 60 | | | 耦合剂 | 化学浆糊 | |
| 表面补偿 | | 4dB | | 对比试块 | RB-2 | | | 标准试块 | CSK-IA | |
| 检测位置 | |  | | 扫查方式 |  | | | 检测灵敏度 | Φ3×40 | |
| 采用标准/  级别 | | GB/T 11345-2023 检验等级 B | | | | | | 母材检测  结果 | 无影响横波检测缺陷 | |
| 检测部位及缺欠示意图：    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，发现 2 处超标缺欠，其余焊缝检测结论合格，具体检测情况见下页检测结果表格。 | | | | | | | | | | |
| 编制 |  | | 审核 |  | | 批准 |  | | 日 期 | 2024.11.12 |

**超声波检测结果**

报告编号: ZJC018-PK1Z-24-UT-004

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| 序号 | 构件或焊缝  编号 | 板厚mm | 检测部位  (m) | 检测  长度  (m) | 缺欠  编号 | 缺欠当量  (dB) | L  mm | X  mm | Y  mm | H  mm | 结论 |
| 1 | FD1 | 12⊥45 | 0~11.767 | 11.767 | / | / | / | / | / | / | 合格 |
| 2 | FD2 | 12⊥45 | 0~11.726 | 11.726 | F1 | SL+7.2 | 400 | 6200 | -1 | 7~8 | 不合格 |
| 3 | FD3 | 12⊥45 | 0~11.723 | 11.723 | / | / | / | / | / | / | 合格 |
| 4 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.10.31 | | | |
| 说明：L：缺欠指示长度；X：距基准点距离；Y：缺欠距焊缝中心距离；H：缺欠深度距离；R1-一次返修，R2-两次返修 | | | | | | | | | | | |

**超声波检测结果**

报告编号: ZJC018-PK1Z-24-UT-004（续1）

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| 序号 | 构件或焊缝  编号 | 板厚mm | 检测部位  (m) | 检测  长度  (m) | 缺欠  编号 | 缺欠当量  (dB) | L  mm | X  mm | Y  mm | H  mm | 结论 |
| 1 | FM1 | 12⊥25 | 0~11.767 | 11.767 | F1 | SL+6.3 | 300 | 2500 | 0 | 7~8 | 不合格 |
| 2 | FM2 | 12⊥25 | 0~11.726 | 11.726 | / | / | / | / | / | / | 合格 |
| 3 | FM3 | 12⊥25 | 0~11.723 | 11.723 | / | / | / | / | / | / | 合格 |
| 4 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.11.10 | | | |
| 说明：L：缺欠指示长度；X：距基准点距离；Y：缺欠距焊缝中心距离；H：缺欠深度距离；R1-一次返修，R2-两次返修 | | | | | | | | | | | |

**超声波检测结果**

报告编号: ZJC018-PK1Z-24-UT-004（续2）

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| 序号 | 构件或焊缝  编号 | 板厚mm | 检测部位  (m) | 检测  长度  (m) | 缺欠  编号 | 缺欠当量  (dB) | L  mm | X  mm | Y  mm | H  mm | 结论 |
| 1 | ZG1-2-T1 | 28⊥25 | 0~2.397 | 2.397 | / | / | / | / | / | / | 合格 |
| 2 | ZG1-2-T2 | 28⊥12 | 0~1.396 | 1.396 | / | / | / | / | / | / | 合格 |
| 3 | ZG1-2-T3 | 28⊥12 | 0~2.058 | 2.058 | / | / | / | / | / | / | 合格 |
| 4 | ZG1-2-T4 | 28⊥45 | 0~1.36 | 1.36 | / | / | / | / | / | / | 合格 |
| 5 | ZG1-1-T1 | 28⊥25 | 0~2.375 | 2.375 | / | / | / | / | / | / | 合格 |
| 6 | ZG1-1-T2 | 28⊥12 | 0~1.36 | 1.36 | / | / | / | / | / | / | 合格 |
| 7 | ZG1-1-T3 | 28⊥12 | 0~2.033 | 2.033 | / | / | / | / | / | / | 合格 |
| 8 | ZG1-1-T4 | 28⊥45 | 0~1.409 | 1.409 | / | / | / | / | / | / | 合格 |
| 9 | ZG2-2-T1 | 28⊥25 | 0~2.41 | 2.41 | / | / | / | / | / | / | 合格 |
| 10 | ZG2-2-T2 | 28⊥12 | 0~1.375 | 1.375 | / | / | / | / | / | / | 合格 |
| 11 | ZG2-2-T3 | 28⊥12 | 0~2.077 | 2.077 | / | / | / | / | / | / | 合格 |
| 12 | ZG2-2-T4 | 28⊥45 | 0~1.34 | 1.34 | / | / | / | / | / | / | 合格 |
| 13 | ZG2-1-T1 | 28⊥25 | 0~2.369 | 2.369 | / | / | / | / | / | / | 合格 |
| 14 | ZG2-1-T2 | 28⊥12 | 0~1.34 | 1.34 | / | / | / | / | / | / | 合格 |
| 15 | ZG2-1-T3 | 28⊥12 | 0~2.032 | 2.032 | / | / | / | / | / | / | 合格 |
| 16 | ZG2-1-T4 | 28⊥45 | 0~1.389 | 1.389 | / | / | / | / | / | / | 合格 |
| 17 | ZJ1-1-T1 | 20⊥25 | 0~0.356 | 0.356 | / | / | / | / | / | / | 合格 |
| 18 | ZJ1-1-T2 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 19 | ZJ1-1-T3 | 20⊥45 | 0~0.356 | 0.356 | / | / | / | / | / | / | 合格 |
| 20 | ZJ1-1-T4 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 21 | ZJ1-2-T1 | 20⊥25 | 0~0.406 | 0.406 | / | / | / | / | / | / | 合格 |
| 22 | ZJ1-2-T2 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 23 | ZJ1-2-T3 | 20⊥45 | 0~0.406 | 0.406 | / | / | / | / | / | / | 合格 |
| 24 | ZJ1-2-T4 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 25 | ZJ1-3-T1 | 20⊥25 | 0~0.356 | 0.356 | / | / | / | / | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.11.12 | | | |
| 说明：L：缺欠指示长度；X：距基准点距离；Y：缺欠距焊缝中心距离；H：缺欠深度距离；R1-一次返修，R2-两次返修 | | | | | | | | | | | |

**超声波检测结果**

报告编号: ZJC018-PK1Z-24-UT-004（续3）

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| 序号 | 构件或焊缝  编号 | 板厚mm | 检测部位  (m) | 检测  长度  (m) | 缺欠  编号 | 缺欠当量  (dB) | L  mm | X  mm | Y  mm | H  mm | 结论 |
| 1 | ZJ1-3-T2 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 2 | ZJ1-3-T3 | 20⊥45 | 0~0.356 | 0.356 | / | / | / | / | / | / | 合格 |
| 3 | ZJ1-3-T4 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 4 | ZJ1-4-T1 | 20⊥25 | 0~0.406 | 0.406 | / | / | / | / | / | / | 合格 |
| 5 | ZJ1-4-T2 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 6 | ZJ1-4-T3 | 20⊥45 | 0~0.406 | 0.406 | / | / | / | / | / | / | 合格 |
| 7 | ZJ1-4-T4 | 20⊥12 | 0~1.29 | 1.29 | / | / | / | / | / | / | 合格 |
| 8 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.11.12 | | | |
| 说明：L：缺欠指示长度；X：距基准点距离；Y：缺欠距焊缝中心距离；H：缺欠深度距离；R1-一次返修，R2-两次返修 | | | | | | | | | | | |