**超声波检测报告**

报告编号: ZJC018-Z2-24-UT-033

|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 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 | | Z2-L1-3 | | | 检测部位 | | | 熔透角焊缝 | | |
| 材质 | | Q345qD | | 坡口形式 | V型 | | | 检测数量 | 106.947 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 | | 单侧双面 | | 扫查方式 | L+N+T | | | 检测灵敏度 | Φ3×40 | |
| 采用标准/  级别 | | GB/T 11345-2023 检验等级 B  GB/T 29712-2023 验收等级 2 | | | | | | 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，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 | 2024.11.19 |

**超声波检测结果**

报告编号: ZJC018-Z2-24-UT-033

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 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 | FM1a | 20⊥25 | 0~9.023 | 9.023 | / | / | / | / | / | / | 合格 |
| 2 | FM1b | 16⊥35 | 0~11.057 | 11.057 | / | / | / | / | / | / | 合格 |
| 3 | FM2a | 20⊥25 | 0~9.017 | 9.017 | / | / | / | / | / | / | 合格 |
| 4 | FM2b | 16⊥35 | 0~11.049 | 11.049 | / | / | / | / | / | / | 合格 |
| 5 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
| 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 | | | 2024.10.28 | | | |
| 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-Z2-24-UT-033（续1）

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 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 | FD1a | 20⊥20 | 0~9.055 | 9.055 | / | / | / | / | / | / | 合格 |
| 2 | FD1b | 16⊥25 | 0~11.057 | 11.057 | / | / | / | / | / | / | 合格 |
| 3 | FD2a | 20⊥20 | 0~9.048 | 9.048 | / | / | / | / | / | / | 合格 |
| 4 | FD2b | 16⊥25 | 0~11.049 | 11.049 | / | / | / | / | / | / | 合格 |
| 5 | ZG1-5-T1 | 20⊥25 | 0~3.351 | 3.351 | / | / | / | / | / | / | 合格 |
| 6 | ZG1-5-T2 | 20⊥20 | 0~1.28 | 1.28 | / | / | / | / | / | / | 合格 |
| 7 | ZG1-5-T3 | 20⊥20 | 0~3.351 | 3.351 | / | / | / | / | / | / | 合格 |
| 8 | ZG1-5-T4 | 20⊥20 | 0~1.28 | 1.28 | / | / | / | / | / | / | 合格 |
| 9 | ZJ1-1-T1-1 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 10 | ZJ1-1-T1-2 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 11 | ZJ1-1-T1-3 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 12 | ZJ1-1-T1-4 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 13 | ZJ1-1-T2-1 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 14 | ZJ1-1-T2-2 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 15 | ZJ1-1-T2-3 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 16 | ZJ1-1-T2-4 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 17 | ZJ1-1-T3-1 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 18 | ZJ1-1-T3-2 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 19 | ZJ1-1-T3-3 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 20 | ZJ1-1-T3-4 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 21 | ZJ1-2-T1-1 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 22 | ZJ1-2-T1-2 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 23 | ZJ1-2-T1-3 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 24 | ZJ1-2-T1-4 | 20⊥25 | 0~0.105 | 0.105 | / | / | / | / | / | / | 合格 |
| 25 | ZJ1-2-T2-1 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.11.19 | | | |
| 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-Z2-24-UT-033（续2）

|  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 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 | ZJ1-2-T2-2 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 2 | ZJ1-2-T2-3 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 3 | ZJ1-2-T2-4 | 20⊥20 | 0~1.21 | 1.21 | / | / | / | / | / | / | 合格 |
| 4 | ZJ1-2-T3-1 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 5 | ZJ1-2-T3-2 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 6 | ZJ1-2-T3-3 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 7 | ZJ1-2-T3-4 | 20⊥20 | 0~0.31 | 0.31 | / | / | / | / | / | / | 合格 |
| 8 | ZGM1-5-T1 | 25+25 | 0~0.965 | 0.965 | / | / | / | / | / | / | 合格 |
| 9 | ZGM1-5-T2 | 25+25 | 0~0.965 | 0.965 | / | / | / | / | / | / | 合格 |
| 10 | HLM1-5-T1-1 | 20+35 | 0~0.4 | 0.4 | / | / | / | / | / | / | 合格 |
| 11 | HLM1-5-T1-2 | 20+35 | 0~0.4 | 0.4 | / | / | / | / | / | / | 合格 |
| 12 | HLM1-5-T1-3 | 20+35 | 0~0.4 | 0.4 | / | / | / | / | / | / | 合格 |
| 13 | HLM1-5-T2-1 | 20+35 | 0~0.4 | 0.4 | / | / | / | / | / | / | 合格 |
| 14 | HLM1-5-T2-2 | 20+35 | 0~0.4 | 0.4 | / | / | / | / | / | / | 合格 |
| 15 | HLM1-5-T2-3 | 20+35 | 0~0.4 | 0.4 | / | / | / | / | / | / | 合格 |
| 16 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
| 17 |  |  |  |  |  |  |  |  |  |  |  |
| 18 |  |  |  |  |  |  |  |  |  |  |  |
| 19 |  |  |  |  |  |  |  |  |  |  |  |
| 20 |  |  |  |  |  |  |  |  |  |  |  |
| 21 |  |  |  |  |  |  |  |  |  |  |  |
| 22 |  |  |  |  |  |  |  |  |  |  |  |
| 23 |  |  |  |  |  |  |  |  |  |  |  |
| 24 |  |  |  |  |  |  |  |  |  |  |  |
| 25 |  |  |  |  |  |  |  |  |  |  |  |
| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.11.19 | | | |
| 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 | | | | | | | | | | | |