**超声波检测报告**

报告编号: ZJC019-ZQ-24-XC-UT-010

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| 委托单位 | | 江苏省交通工程集团有限公司 | | | 工程名称 | | | 312国道常州横林至湖塘东段工程G312-SG3标段 | | |
| 构件名称 | | L66-JD5 | | | 检测部位 | | | 对接焊缝 | | |
| 材质 | | Q345qD | | 坡口形式 | V型 | | | 检测数量 | 50.8 m | |
| 检测时机 | | 焊后24小时 | | 焊接方法 | CO2气体保护焊 | | | 检测比例 | 100% | |
| 热处理状态 | | TMCP | | 工件温度 | 15℃ | | | 表面状态 | 打磨光滑 | |
| 仪器型号/  编号 | | 超声波探伤仪 SZ-C40 | | 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 | | 单面双侧 | | 扫查方式 | L+T | | | 检测灵敏度 | Φ3×40 | |
| 采用标准/  级别 | | GB/T 11345-2023 检验等级 B  Q/CR 9211-2015 验收等级 Ⅱ | | | | | | 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 1 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 | 2024.12.22 |

**超声波检测结果**

报告编号: ZJC019-ZQ-24-XC-UT-010

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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 | L66-JD5-DB1-DJ1-1 | 20+20 | 0~3.4 | 3.4 | / | / | / | / | / | / | 合格 |
| 2 | L66-JD5-DB1-DJ1-2 | 20+20 | 0~3.4 | 3.4 | / | / | / | / | / | / | 合格 |
| 3 | L66-JD5-DB1-DJ1-3 | 20+20 | 0~3.4 | 3.4 | / | / | / | / | / | / | 合格 |
| 4 | L66-JD5-DB1-DJ1-4 | 20+20 | 0~3.4 | 3.4 | / | / | / | / | / | / | 合格 |
| 5 | L66-JD5-DB1-DJ1-5 | 20+20 | 0~11.8 | 11.8 | / | / | / | / | / | / | 合格 |
| 6 | L66-JD5-DB1-DJ1-6 | 20+20 | 0~11.8 | 11.8 | / | / | / | / | / | / | 合格 |
| 7 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级） |  | | | 检测日期 | | | 2024.12.21 | | | |
| 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: ZJC019-ZQ-24-XC-UT-010（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 | L66-JD5-BB1-DJ2-1 | 32+32 | 0~3.4 | 3.4 | / | / | / | / | / | / | 合格 |
| 2 | L66-JD5-BB1-DJ2-2 | 32+32 | 0~3.4 | 3.4 | / | / | / | / | / | / | 合格 |
| 3 | L66-JD5-BB1-DJ2-3 | 32+32 | 0~3.4 | 3.4 | F1 | SL+5.2 | 150 | 450 | -2 | 20~23 | 不合格 |
| 4 | L66-JD5-BB1-DJ2-4 | 32+32 | 0~3.4 | 3.4 | / | / | / | / | / | / | 合格 |
| 5 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级） |  | | | 检测日期 | | | 2024.12.22 | | | |
| 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 | | | | | | | | | | | |