**超声波检测报告**

报告编号: ZJC022-24-UT-031

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| 委托单位 | | 江苏常鑫路桥集团有限公司北京路桥通国际工程咨询有限公司苏交科集团检测认证有限公司 | | | 工程名称 | | | 南京至盐城高速公路NY-YZ8标 | | |
| 构件名称 | | 6-JD3 | | | 检测部位 | | | 对接焊缝 | | |
| 材质 | | Q345qD | | 坡口形式 | V型 | | | 检测数量 | 288.718 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 | 15℃ | | | 表面状态 | 打磨光滑 | |
| 仪器型号/  编号 | | 超声波探伤仪 SZ-C02 | | 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  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，发现 5 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 | 2024.12.23 |

**超声波检测结果**

报告编号: ZJC022-24-UT-031

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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 | 6-JD3-D1-BC-1 | 16+32 | 0~1.908 | 1.908 | / | / | / | / | / | / | 合格 |
| 2 | 6-JD3-D2-BC-1 | 16+32 | 0~1.908 | 1.908 | / | / | / | / | / | / | 合格 |
| 3 | 6-JD3-D3-BC-1 | 16+32 | 0~2.557 | 2.557 | F1 | SL+2.4dB | 400 | 1200 | -3 | 8~10 | 不合格 |
| 4 | 6-JD3-D4-BC-1 | 16+32 | 0~1.976 | 1.976 | / | / | / | / | / | / | 合格 |
| 5 | 6-JD3-D5-BC-1 | 16+32 | 0~1.976 | 1.976 | / | / | / | / | / | / | 合格 |
| 6 | 6-JD3-D6-BC-1 | 16+32 | 0~2.342 | 2.342 | / | / | / | / | / | / | 合格 |
| 7 | 6-JD3-D7-BC-1 | 16+32 | 0~2.341 | 2.341 | / | / | / | / | / | / | 合格 |
| 8 | 6-JD3-D8-BC-1 | 16+32 | 0~2.341 | 2.341 | / | / | / | / | / | / | 合格 |
| 9 | 6-JD3-D9-BC-1 | 16+32 | 0~2.341 | 2.341 | / | / | / | / | / | / | 合格 |
| 10 | 6-JD3-D10-BC-1 | 16+32 | 0~2.341 | 2.341 | / | / | / | / | / | / | 合格 |
| 11 | 6-JD3-D11-BC-1 | 16+32 | 0~2.341 | 2.341 | / | / | / | / | / | / | 合格 |
| 12 | 6-JD3-D12-BC-1 | 16+32 | 0~1.951 | 1.951 | / | / | / | / | / | / | 合格 |
| 13 | 6-JD3-D13-BC-1 | 16+32 | 0~1.951 | 1.951 | F1 | SL+2.9dB | 200 | 0 | -3 | 8~10 | 不合格 |
| 14 | 6-JD3-D14-BC-1 | 16+32 | 0~1.951 | 1.951 | / | / | / | / | / | / | 合格 |
| 15 | 6-JD3-D15-BC-1 | 16+32 | 0~1.951 | 1.951 | / | / | / | / | / | / | 合格 |
| 16 | 6-JD3-D16-BC-1 | 16+32 | 0~1.966 | 1.966 | / | / | / | / | / | / | 合格 |
| 17 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.11.28 | | | |
| 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: ZJC022-24-UT-031（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 | 6-JD3-B1-BC-1 | 16+32 | 0~2.103 | 2.103 | / | / | / | / | / | / | 合格 |
| 2 | 6-JD3-B2-BC-1 | 16+32 | 0~2.171 | 2.171 | / | / | / | / | / | / | 合格 |
| 3 | 6-JD3-B3-BC-1 | 16+32 | 0~2.146 | 2.146 | F1 | SL+2.6dB | 200 | 700 | -3 | 5~7 | 不合格 |
| 4 | 6-JD3-B4-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 5 | 6-JD3-B5-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 6 | 6-JD3-B6-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 7 | 6-JD3-B7-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 8 | 6-JD3-B8-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 9 | 6-JD3-B9-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 10 | 6-JD3-B10-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 11 | 6-JD3-B11-BC-1 | 16+32 | 0~2.146 | 2.146 | / | / | / | / | / | / | 合格 |
| 12 | 6-JD3-B12-BC-1 | 16+32 | 0~2.146 | 2.146 | F1 | SL+2.5dB | 300 | 1200 | -3 | 5~7 | 不合格 |
| 13 | 6-JD3-B13-BC-1 | 16+32 | 0~2.171 | 2.171 | / | / | / | / | / | / | 合格 |
| 14 | 6-JD3-B14-BC-1 | 16+32 | 0~2.303 | 2.303 | / | / | / | / | / | / | 合格 |
| 15 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.12.03 | | | |
| 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: ZJC022-24-UT-031（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 | 6-JD3-DB-BC-1 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 2 | 6-JD3-DB-BC-2 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 3 | 6-JD3-DB-BC-3 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 4 | 6-JD3-DB-BC-4 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 5 | 6-JD3-DB-BC-5 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 6 | 6-JD3-DB-BC-6 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 7 | 6-JD3-DB-BC-7 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 8 | 6-JD3-DB-BC-8 | 16+16 | 0~16.367 | 16.367 | / | / | / | / | / | / | 合格 |
| 9 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.12.15 | | | |
| 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: ZJC022-24-UT-031（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 | 6-JD3-BB-BC-1 | 16+32 | 0~15.572 | 15.572 | / | / | / | / | / | / | 合格 |
| 2 | 6-JD3-BB-BC-2 | 16+32 | 0~15.572 | 15.572 | / | / | / | / | / | / | 合格 |
| 3 | 6-JD3-BB-BC-3 | 16+32 | 0~15.572 | 15.572 | F1 | SL+2.7dB | 250 | 11500 | -3 | 8~10 | 不合格 |
| 4 | 6-JD3-BB-BC-4 | 16+32 | 0~15.572 | 15.572 | / | / | / | / | / | / | 合格 |
| 5 | 6-JD3-BB-BC-5 | 16+32 | 0~15.572 | 15.572 | / | / | / | / | / | / | 合格 |
| 6 | 6-JD3-BB-BC-6 | 16+32 | 0~15.572 | 15.572 | / | / | / | / | / | / | 合格 |
| 7 | 以下空白 |  |  |  |  |  |  |  |  |  |  |
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| 26 | 检测人员  （资质等级 Ⅱ级） |  | | | 检测日期 | | | 2024.12.23 | | | |
| 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 | | | | | | | | | | | |