**射线检测记录**

工程名称：内蒙古荣信化工有限公司年产80万吨烯烃三期项目40万吨/年聚丙烯装置

委托单位： 中油吉林化建工程有限公司

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| 操作指导书编号 | | | | | | EPKG-RXHG-2025-RT-001 | | | | | | | | | | | | | | | | | | 记录编号 | | | | | | | | EPKJ-NMRX3-04-JLHJ-GPS-RT- | | | | | | | | | | | | | | | | | |
| **检测对象** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 承包单位 | | | | | | | 中油吉林化建工程有限公司 | | | | | | | | | | | | | | | | | | | | 检件名称 | | | | | | | | | | □工艺管道□储罐□球罐  □长输管道☑给排水地管 | | | | | | | | | | | | |
| 承压设备类型/  管道等级 | | | | | | | / | | | | | | | | | | | 检测部位 | | | | | | | | | ☑对接接头  □承插焊缝  □ | | | | | | | | | | 坡口形式 | | | | | | | ☑V型  □X型  □ | | | | | |
| 焊接方法 | | | | | □GTAW □SMAW  □GTAW+SMAW  □GTAW+SAW | | | | | | 热处理状态 | | | | | | | ☑无  □ | | | | | | | 检测时机 | | | | | | | | ☑焊后  □热处理后  □ | | | | | | | 表面状态 | | | | | | ☑打磨  □ | | | |
| 技术等级 | | | | | ☑AB □B  □ | | | | | | 透照技术 | | | | | | | ☑单胶片法  □双胶片法 | | | | | | | 像质计型号 | | | | | | | | □10-FE-JB  □6-FE-JB  □ | | | | | | | 散射线防护 | | | | | | 1mm铅背屏屏蔽 | | | |
| 底片黑度 | | | | | ☑2.0～4.5  □ | | | | | | 检测比例 | | | | | | | □100% □50%  □20% □10%  □1% □5% | | | | | | | 检测标准 | | | | | | | | ☑NB/T47013.2-2015  □SY/T4109-2020  □ | | | | | | | 合格级别 | | | | | | □Ⅰ□Ⅱ  □Ⅲ□ | | | |
| **透照参数** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 设备型号/  射源种类 | | | | Mzt2805DK1  X射线 | | | | | | 设备编号 | | | | 209590 | | | | | 焦点尺寸(mm) | | | | | | | 2.5\*2.5mm | | | | | | | 铅增感屏(mm) | | | | | ☑0.03×2  □0.1×2 | | | | 胶片牌号/胶片等级 | | | | | 锐柯R400/C5 | | |
| 序号 | | | 检件规格  (mm×mm) | | | | | | 透照  方式 | | | | 焦距  (mm) | | | | | | | | 有效片长  (mm) | | | | | | | | 管电压  源能量 | | | | | | 管电流  源活度 | | | | | 曝光时间  （min） | | | | | | 材质 | | | |
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| **暗室处理** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 方式 | | ☑手工□机洗 | | | | | | 显影温度 | | | | 20℃ | | | | 显影时间 | | | | | | 5min | | | | | | 定影温度 | | | | | | 20℃ | | 定影时间 | | | 10min | | | | | | 水洗时间 | | | 25min | |
| **检测部位信息** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 序号 | 检件编号 | | | | | | | | | | | 焊缝  编号 | | | 焊工号 | | | | | 透照参数序号 | | | 备注 | | | | | | | 序号 | 检件编号 | | | | | | | | | | 焊缝  编号 | | 焊工号 | | | | 透照参数序号 | | 备注 |
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| 布片图： | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 备注：透照方式缩写：Z—纵（直）缝透照；ZS—纵（直）缝双壁透照；HW—环缝外透；HN—环缝内透；HZ—环缝中心透照；SD—双壁单影；SS—双壁双影椭圆透照；SSZ—双壁双影垂直透照。 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 洗片人（资格）：  RT-Ⅱ 2025年 月 日 | | | | | | | | | | | | | | | | | 拍片人（资格）：  RT-Ⅰ 2025年 月 日 | | | | | | | | | | | | | | | | | | | 审核人（资格）：  RT-Ⅱ 2025年 月 日 | | | | | | | | | | | | | |

**射线检测记录（续）**

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| 检件名称 | | □工艺管道 □储罐 □球罐  □长输管道 □给排水地管 | | | | | 记录编号 | | | EPKJ-NMRX3-04-JLHJ-GPS-RT- | | | | | |
| 序号 | 检件编号 | | 焊缝编号 | 焊工号 | | 透照参数序号 | 备注 | 序号 | 检件编号 | | | 焊缝编号 | 焊工号 | 透照参数序号 | 备注 |
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| 洗片人（资格）：  RT-Ⅱ 年 月 日 | | | | | 拍片人（资格）：  RT-Ⅰ 年 月 日 | | | | | | 审核人（资格）：  RT-Ⅱ 年 月 日 | | | | |

**射线检测记录（续）**

工程名称：内蒙古荣信化工有限公司年产80万吨烯烃三期项目40万吨/年聚丙烯装置 委托单位：中油吉林化建工程有限公司

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| 操作指导书编号 | | EPKG-RXHG-2025-RT-001 | | | 记录编号 | | | | EPKJ-NMRX3-04-JLHJ-GPS-RT- | | | | |
| 检测标准 | | ☑NB/T47013.2-2015  □SY/T4109-2020  □ | | | 底片观察技术 | | | | | ☑单胶片法  □双胶片法 | | | |
| 检测比例 | | □100% □50% □20%  □10% □5% □1% | | | 合格级别 | | | | | □Ⅰ□Ⅱ□Ⅲ□ | | | |
| 检件编号 | 焊缝  编号 | 片号 | 焊工号 | 规格 | 底片黑度 | | 像质计  灵敏度 | 缺陷  性质 | | 缺陷  定量 | 缺陷  定位 | 评定  级别 | 备注 |
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| 评片人（资格）：  RT-Ⅱ 2025年 月 日 | | | | | | 审核人（资格）  RT-Ⅱ 2025年 月 日 | | | | | | | |