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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 标志 | | | | | | **东方电气（广州）重型机器有限公司** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 版本Revision | | | | | | | | | | | | | | | 3 | | | | | | | |
| **DONGFANG (GUANG ZHOU) HEAVY MACHINERY CO., LTD** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 页码Page | | | | | | | | | | | | | | | / | | | | | | | |
| **液 体 渗 透 检 验 报 告** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 报告编号 Report No. | | | | | | | | | | | | | | | | | | | | | | |
| **LIQUID PENETRANT EXAMINATION REPORT** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | |
| 用 户 | | | | | | |  | | | | | | | | | | | | 订 单 | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | 项目名称 | | | | | | | | | | | | |  | | | | | | | | | |
| Customer | | | | | | | Order | | | | | | | | | | | | Project | | | | | | | | | | | | |
| 部 件 名 称 | | | | | | |  | | | | | | | | | | | | 材 质 | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | 规 格 | | | | | | | | | | | | |  | | | | | | | | | |
| Sub Assembly | | | | | | | Material | | | | | | | | | | | | Size | | | | | | | | | | | | |
| 坡口型式 | | | | | | |  | | | | | | | | | | | | 图号 | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Chamfer Type | | | | | | | Drawing No. | | | | | | | | | | | |
| 检验规程 | | | | |  | | | | | | | | | | | | | | 检 验 内 容 | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Procedure | | | | | Designation Oper. | | | | | | | | | | | | | |
| 检验时机 | | | | | |  | | | | | | | | | | | | | 流转卡号 | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | 工序号 | | | | | | | | | | | | |  | | | | | | | | | |
| Exam Stage | | | | | | ST No. | | | | | | | Oper. No. | | | | | | | | | | | | |
| 制 造 工 艺 | | | | | | | | 锻 | | | | □ | | | | | 轧 | | | | | □ | | | | 铸 | | | | | | □ | | | | 焊 | | | | □ | | | | 其他 | | | | | | |  | | | | | | 焊 接 方 法 | | | | | | | | | | |  | | |
| Manufacture Process | | | | | | | | Forged | | | | Rolled | | | | | Cast | | | | | | Weld | | | | Other | | | | | | | Weld Process | | | | | | | | | | |
| 试  剂 | PENETRATANT MATERIAL |  | | | | | | 类别Type | | | | | | | | | | | | | | | | | | 商标Trademark | | | | | | | | | | | | | | 型号Type | | | | | | | | | | | | | | | | | | | | | 批号Reference No. | | | | | | | | | |
| 渗 透 剂 | | | | | | 着色Colored | | | | | | | | | | | | □ | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | |
| Penetrant | | | | | | 荧光Fluorescent | | | | | | | | | | | | □ | | | | | |
| 清 洗 剂 | | | | | | 类别Type | | | | | | | | | | | | | | | | | | 商标Trademark | | | | | | | | | | | | | | 型号Type | | | | | | | | | | | | | | | | | | | | | 批号Reference No. | | | | | | | | | |
| Cleaning | | | | | | 水洗Water | | | | | | | | | | | | □ | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | |
| Agent | | | | | | 溶剂Solvent | | | | | | | | | | | | □ | | | | | |
|  | | | | | | 类别Type | | | | | | | | | | | | | | | | | | 商标Trademark | | | | | | | | | | | | | | 型号Type | | | | | | | | | | | | | | | | | | | | | 批号Reference No. | | | | | | | | | |
| 显 像 剂 | | | | | | 湿粉Wet | | | | | | | | | | | | □ | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | |
| Developer | | | | | | 干粉Dry | | | | | | | | | | | | □ | | | | | |
| 试块 | | | | JB/T6064-2006 | | | | □ | | JB/T6064-2006 | | | | | | | | | | □ | | | GB/T18851（II型） | | | | | | | | | | | | | | | | | □ | | | ASME对比试块 | | | | | | | | | | | | | | | | | | | | □ | | | | | | | |
| Block | | | | A型Type A | | | | B型Type B | | | | | | | | | | ISO3452-3（Type II） | | | | | | | | | | | | | | | | | ASME Comparator Block | | | | | | | | | | | | | | | | | | | |
| 仪器 | | | | | | 测温仪型号 | | | |  | | | | | | | | | | 编号 | | | | | |  | | | | | | | | | 照度计/黑光强度计 | | | | | | | | | | | | | | |  | | | | | | | | | | | 编号 | | | |  | | | | | |
| Instrument | | | | | | Thermometer | | | | No. | | | | | | (Black) Light Meter | | | | | | | | | | | | | | | No. | | | |
|  | | | | | | 焊态 | | | | □ | 打磨 | | | | | | | | | □ | | | | | | 钢刷 | | | | | | | | | □ | | | | 抛光 | | | | | | | | □ | | | | | 机加 | | | | | | | | | | □ | | | 其他 | | | | |  |
| 表面状态 | | | | | | As Welded | | | | Ground | | | | | | | | | Brushed | | | | | | | | | Polished | | | | | | | | Machined | | | | | | | | | | Other | | | | |
| Surface | | | | | | 粗糙度 | | | | | Ra≤ | | | | | |  | | | | | μm | | | | 受检件温度 | | | | | | | | | | | | | | |  | | | | | | | | | | | | | ℃ | | | | | | | | | | | | | | | | |
| Condition | | | | | | Roughness | | | | | Part Temperature | | | | | | | | | | | | | | |
| 检  验  条  件 | E X A M I N A T I O N C O N D I T I O N | |  | | | | | 已做 □ | | | | | 未做 □ | | | | | | | | | | | | | 清洗剂 | | | | | | | | | | | | | 丙酮 □ | | | | | | | | | | 威第尔 □ | | | | | | | | | | 其它 | | | | | |  | | | | | |
| 预 清 洗 | | | | | Yes | | | | | No | | | | | | | | | | | | | Products Used | | | | | | | | | | | | | Acetone | | | | | | | | | | Votile | | | | | | | | | | Other | | | | | |
| Pre-Cleaning | | | | | 干燥方法 | | | | | | | | | | | 自然蒸发 □ | | | | | | | | | | | | | | | | 强制热或冷空气蒸发 □ | | | | | | | | | | | | | | | | | | | | 干燥时间 | | | | | | | | | |  | | | | 分钟 | |
|  | | | | | Drying Method | | | | | | | | | | | Natural Evaporation | | | | | | | | | | | | | | | | Forced Hot or Cold Air | | | | | | | | | | | | | | | | | | | | Drying Time | | | | | | | | | | Minutes | |
| 渗透剂施加 | | | | | 施加方法 | | | | | |  | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Penetrant | | | | | Method of | | | | | | 刷涂 | | | | | | □ | | | | 喷涂 | | | | | | □ | | | | | 渗透时间 | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | 分钟 | | | | | |
| Application | | | | | Application | | | | | | Brush | | | | | | Spray | | | | | | Dwell Time | | | | | | | | | | | Minutes | | | | | |
| 多余渗透剂 | | | | | 方法 | | | | | | 不起毛的布 □ | | | | | | | | | | | | | | | | | | | | 吸水纸 □ | | | | | | | | | | | | | | | | | | | | 水 □ | | | | | | | | | | | 溶剂 □ | | | | | |
| 的去除 | | | | | Method | | | | | | Lint-free Cloth | | | | | | | | | | | | | | | | | | | | Absorbent Paper | | | | | | | | | | | | | | | | | | | | Water | | | | | | | | | | | Solvent | | | | | |
| Excess Penetrant | | | | | 干燥方法 | | | | | | | | | | | 干净的材料吸干 □ | | | | | | | | | | | | | | | | | | 自然蒸发 □ | | | | | | | | | | | | | | | | | | | 干燥时间 | | | | | | | | | |  | | | 分钟 | |
| Removal | | | | | Drying Method | | | | | | | | | | | Blot with Clean Material | | | | | | | | | | | | | | | | | | Natural Evaporation | | | | | | | | | | | | | | | | | | | Drying Time | | | | | | | | | | Minutes | |
|  | | | | | 施加方法 | | | | | | | 喷涂 | | | | | | | | | | | | | | | □ | | | | | 干燥方法 | | | | | | | | | | | | | | | | | | | | | 自然蒸发 □ | | | | | | | | | | | | | | |
| 显像剂施加 | | | | | Method | | | | | | | Spray | | | | | | | | | | | | | | | Dry Method | | | | | | | | | | | | | | | | | | | | | Natural Evaporation | | | | | | | | | | | | | | |
| Developer | | | | | 干燥时间 | | | | | | | | | | | |  | | | | | | | | | | 分钟 | | | | | 最终评定时间 | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | 分钟 | |
| Application | | | | | Drying Time | | | | | | | | | | | | Minutes | | | | | Final Interpretation Time | | | | | | | | | | | | | | | | | | | | | Minutes | |
| 照明 | | | | | 自然光 □ | | | | | | | | 行灯 □ | | | | | | | | | | | | | | 手电筒 □ | | | | | | | | 黑光 □ | | | | | | | | | 照度 | | | | | | | | | | | | |  | | | | | | | | | Lux | |
| Light Condition | | | | | Natural | | | | | | | | Portable Lamp | | | | | | | | | | | | | | Torch | | | | | | | | Black | | | | | | | | | Light Intensity | | | | | | | | | | | | |  | | | | | | | | | μW/cm2 | |
| 后清洗 | | | | | 已做 □ | | | | | | | | 清 洗 剂 | | | | | | | | | | | | | | 水 □ | | | | | | | | 丙酮 □ | | | | | | | | | 威第尔 □ | | | | | | | | | | | | | 其他 | | | | | | |  | | | |
| Post-Cleaning | | | | | Yes | | | | | | | | Product used | | | | | | | | | | | | | | Water | | | | | | | | Acetone | | | | | | | | | Votile | | | | | | | | | | | | | Other | | | | | | |
| 评 定 结 果 | | | | | | | | 合格Acceptable | | | | | | | | | | | | | □ | | | | | | 不符合项报告号 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Result of Evaluation | | | | | | | | 不合格Unacceptable | | | | | | | | | | | | | □ | | | | | | Non Conformance Report No. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 备注 | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Remark | | | | | | | |
| 检 验 日 期 | | | | | | | | |  | | | | | | | | | | | | | | | | | | | 附 图 | | | | | | | | | | | | | | 有 | | | □ | | | | | | | | 无 | | | | | □ | | | | | | | | | | | | |
| Date of Examination | | | | | | | | | Sketch Attached | | | | | | | | | | | | | | Yes | | | No | | | | |
| 检验者/日期 | | | | | | | | | | | | | | | | | | 级别 | | | | | | |  | | | | 审核/日期 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 级别 | | | | | |  | | | | | | |
| Examiner/Date | | | | | | | | | | | | | | | | | | Level | | | | | | | Reviewed By/Date | | | | | | | | | | | | | | | | | | | | | | | | | | | | | Level | | | | | |
| 批准/日期 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 授权检验师/日期 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Approval By/Date | | | | | | | | | | | | | | | | | | | | | | | | | | | | | ANI or AI/Date | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |