河北丰宁抽水蓄能电站工程

压力钢管制作焊接过程记录表

合同编号：{ContractCode}

编号：{JJCode}

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 单位工程名称  (及编码) | | | {DWName} {DWCode} | | | | 焊接方法 | | | | | | | {input\_gcl} | | | | | |
| 分部工程名称  (及编码) | | | {FBName} {FBCode} | | | | 施工单位 | | | | | | | {Constructor} | | | | | |
| 单元工程名称、部位  (及编码) | | | {DYName} {JYPName} {DYCode} | | | | 材质 | {input\_1} | | | | | | 内径（mm） | | | | {input\_2} | |
| 板厚（mm） | | | | {input\_3} | |
| 施工依据 | | | {BuildBase} | | | | | | | | | | | | | | | | |
| 焊接负责人 | | | {input\_4} | | | 环境温度 | | | {input\_5} | | | | | | 湿度 | | {input\_6} | | |
| 焊前控制 | 焊材种类 | | {input\_7} | | | 烘干时间 | | | {input\_8} | | | | | | 保温时间 | | {input\_9} | | |
| 焊缝类型 | | {input\_10} | | | 组装间隙 | | | {input\_11} | | | | | | 错牙记录 | | {input\_12} | | |
| 正面焊缝清洁度 | | {input\_13} | | | 背缝清根 | | | {input\_14} | | | | | | 探伤检查 | | 正缝 | | {input\_15} |
| 背缝 | | {input\_16} |
| 焊接过程控制 | 预热温度  时间 | | 正缝 | {input\_17} | | 层间温度  时间 | | | 正  缝 | | | {input\_18} | | | 后热温度  时间 | | 正缝 | | {input\_19} |
| 背缝 | {input\_20} | | 背  缝 | | | {input\_21} | | | 背缝 | | {input\_22} |
| 焊接电流  (A) | | SAW:{input\_hgl\_1}  SMAW:{input\_hgl\_2}  MAG:{input\_hgl\_13} | | | 焊接电压  (V) | | | SAW:{input\_hgl\_3}  SMAW:{input\_hgl\_4}  MAG:{input\_hgl\_14} | | | | | | 焊接速度  (cm/min) | | SAW:{input\_hgl\_5}  SMAW:{input\_hgl\_6}  MAG:{input\_hgl\_15} | | |
| 焊接线能量  (kj/cm) | | SAW:{input\_hgl\_7}  SMAW:{input\_hgl\_8}  MAG:{input\_hgl\_16} | | | 焊接时间 | | | 正缝 | | 起始时间：{input\_hgl\_9} | | | | | 背缝 | 起始时间：{input\_hgl\_11} | | |
| 结束时间：{input\_hgl\_10} | | | | | 结束时间：{input\_hgl\_12} | | |
| 焊后检验 | 焊缝外观 | | 正缝 | | {input\_23} | | | | 焊缝长度 | | | | | | {input\_24} | | | | |
| 背缝 | | {input\_25} | | | | 超标长度 | | | | | | {input\_26} | | | | |
| 超声波 | | {input\_27} | | | | | | TOFD | | | | | | {input\_28} | | | | |
| 缺陷处理 | {input\_29} | | | | | | | | 复  检 | 外观 | | | | | {input\_30} | | | | |
| 超声波 | | | | | {input\_31} | | | | |
| TOFD | | | | | {input\_32} | | | | |
| 施工单位 | 初检： |  | | | | | | | 监理单位 | | | | 验收意见：{input\_33} | | | | | | |
|  | {input\_date\_1} | | | | | | |
| 复检： |  | | | | | | |  | | | | | | |
|  | {input\_date\_2} | | | | | | |
| 终检： |  | | | | | | | {input\_date\_4} | | | | | | |
|  | {input\_date\_3} | | | | | | |

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合同编号：{ContractCode}

编号：{JJCode}

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 单位工程名称  (及编码) | | | {DWName} {DWCode} | | | | 焊接方法 | | | | | | | {input\_2\_gcl} | | | | | |
| 分部工程名称  (及编码) | | | {FBName} {FBCode} | | | | 施工单位 | | | | | | | {Constructor} | | | | | |
| 单元工程名称、部位  (及编码) | | | {DYName} {JYPName} {DYCode} | | | | 材质 | {input\_2\_1} | | | | | | 内径（mm） | | | | {input\_2\_2} | |
| 板厚（mm） | | | | {input\_2\_3} | |
| 施工依据 | | | {BuildBase} | | | | | | | | | | | | | | | | |
| 焊接负责人 | | | {input\_2\_4} | | | 环境温度 | | | {input\_2\_5} | | | | | | 湿度 | | {input\_2\_6} | | |
| 焊前控制 | 焊材种类 | | {input\_2\_7} | | | 烘干时间 | | | {input\_2\_8} | | | | | | 保温时间 | | {input\_2\_9} | | |
| 焊缝类型 | | {input\_2\_10} | | | 组装间隙 | | | {input\_2\_11} | | | | | | 错牙记录 | | {input\_2\_12} | | |
| 正面焊缝清洁度 | | {input\_2\_13} | | | 背缝清根 | | | {input\_2\_14} | | | | | | 探伤检查 | | 正缝 | | {input\_2\_15} |
| 背缝 | | {input\_2\_16} |
| 焊接过程控制 | 预热温度  时间 | | 正缝 | {input\_2\_17} | | 层间温度  时间 | | | 正  缝 | | | {input\_2\_18} | | | 后热温度  时间 | | 正缝 | | {input\_2\_19} |
| 背缝 | {input\_2\_20} | | 背  缝 | | | {input\_2\_21} | | | 背缝 | | {input\_2\_22} |
| 焊接电流  (A) | | SAW:{input\_2\_hgl\_1}  SMAW:{input\_2\_hgl\_2}  MAG:{input\_2\_hgl\_13} | | | 焊接电压  (V) | | | SAW:{input\_2\_hgl\_3}  SMAW:{input\_2\_hgl\_4}  MAG:{input\_2\_hgl\_14} | | | | | | 焊接速度  (cm/min) | | SAW:{input\_2\_hgl\_5}  SMAW:{input\_2\_hgl\_6}  MAG:{input\_2\_hgl\_15} | | |
| 焊接线能量  (kj/cm) | | SAW:{input\_2\_hgl\_7}  SMAW:{input\_2\_hgl\_8}  MAG:{input\_2\_hgl\_16} | | | 焊接时间 | | | 正缝 | | 起始时间：{input\_2\_hgl\_9} | | | | | 背缝 | 起始时间：{input\_2\_hgl\_11} | | |
| 结束时间：{input\_2\_hgl\_10} | | | | | 结束时间：{input\_2\_hgl\_12} | | |
| 焊后检验 | 焊缝外观 | | 正缝 | | {input\_2\_23} | | | | 焊缝长度 | | | | | | {input\_2\_24} | | | | |
| 背缝 | | {input\_2\_25} | | | | 超标长度 | | | | | | {input\_2\_26} | | | | |
| 超声波 | | {input\_2\_27} | | | | | | TOFD | | | | | | {input\_2\_28} | | | | |
| 缺陷处理 | {input\_2\_29} | | | | | | | | 复  检 | 外观 | | | | | {input\_2\_30} | | | | |
| 超声波 | | | | | {input\_2\_31} | | | | |
| TOFD | | | | | {input\_2\_32} | | | | |
| 施工单位 | 初检： |  | | | | | | | 监理单位 | | | | 验收意见：{input\_2\_33} | | | | | | |
|  | {input\_2\_date\_1} | | | | | | |
| 复检： |  | | | | | | |  | | | | | | |
|  | {input\_2\_date\_2} | | | | | | |
| 终检： |  | | | | | | | {input\_2\_date\_4} | | | | | | |
|  | {input\_2\_date\_3} | | | | | | |