



凯鑫钢业有限公司
KAYSEN STEEL INDUSTRY CO., LTD.

着色渗透检测报告

Report of dye penetrant inspection

编号: KS/R11-01

客户 Client				合同号 Contract No.	KS2016051401	报告编号 Report No.	PT16GN1212-04	页码 Page No.	1 of 1
探伤方法 Test Method	Type II-C		环境温度 Environment Temp	28℃		观察 Observation	≥1000Lx	表面状态 Surface Condition	光洁 smooth and clean
渗透剂型号 Penetrant Type	HP-ST		清洗剂型号 Cleaner Type	HR-ST		显像剂型号 Developer Type	HD-ST	检测比例 checking proportion	100%
渗透剂施加方法 Penetrant method	喷涂法 Spraying		清洗方式 Cleaning Method	溶剂擦除 Solvent wipe		显像方法 Imaging modality	喷法 Spraying	检测标准 Test standard	ASTM E165-2012
渗透时间 Penetrant Time	10min.		显像时间 Developing Time	7min		灵敏度 Sensitivity	3 point display B-III	验收标准 Acc. Standard	ASME VIII div. 1 appendix 8

序号 NO.	品名 Description	规格(mm) Dimension(mm)	材质 Material	数量 Quantity(PCS)	抽样比 Ratio	检测部位 Inspection area	表面状况 Surface Condition	评定等级 Judgement Level	检测结果 Test Result	备注 Remarks
31	偏心大小头	60.3*26.7*5.54*5.56	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
32	同心大小头	114.3*60.3*13.49*5.54	304-S	3	100%	All surface	NI■ RI□ UI□	--	ACC.	--
33	同心大小头	114.3*48.3*13.49*5.08	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
34	偏心大小头	33.4*26.7*6.35*5.56	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
35	同心大小头	26.7*21.3*5.56*4.78	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
36	异径三通	33.4*26.7*6.35*5.56	304-S	7	100%	All surface	NI■ RI□ UI□	--	ACC.	--
37	异径三通	26.7*21.3*5.56*4.78	304-S	7	100%	All surface	NI■ RI□ UI□	--	ACC.	--
38	异径三通	114.3*48.3*13.49*5.08	304-S	2	100%	All surface	NI■ RI□ UI□	--	ACC.	--
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NI: 无应记录缺陷, RI: 有应记录缺陷, UI: 有应返修缺陷。

NI: There is no defect shall be recorded ; RI: There is defect (are defects) should be recorded; UI: There is defect (are defects) should be repaired.

检测人(II级): Inspector(Level II)	日期: Date	2016.06.12	审核(II级): Reviewer (Gr.II)	日期: Date	2016.06.12	检验部门 Stamp of Quality Dept.
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Report of dye penetrant inspection

编号: KS/R11-01

客户 Client				合同号 Contract No.	KS2016051401	报告编号 Report No.	PT16GN1212-03	页码 Page No.	1 of 1
探伤方法 Test Method	Type II-C		环境温度 Environment Temp	28°C		观察 Observation	≥1000Lx	表面状态 Surface Condition	光洁 smooth and clean
渗透剂型号 Penetrant Type	HP-ST		清洗剂型号 Cleaner Type	HR-ST		显像剂型号 Developer Type	HD-ST	检测比例 checking proportion	100%
渗透剂施加方法 Penetrant method	喷涂法 Spraying		清洗方式 Cleaning Method	溶剂擦除 Solvent wipe		显像方法 Imaging modality	喷法 Spraying	检测标准 Test standard	ASTM E165-2012
渗透时间 Penetrant Time	10min.		显像时间 Developing Time	7min		灵敏度 Sensitivity	3 point display B-III	验收标准 Acc. Standard	ASME VIII div. 1 appendix 8

序号 NO.	品名 Description	规格(mm) Dimension(mm)	材质 Material	数量 Quantity(PCS)	抽样比 Ratio	检测部位 Inspection area	表面状况 Surface Condition	评定等级 Judgement Level	检测结果 Test Result	备注 Remarks
21	等径三通	114.3*13.49	304-S	8	100%	All surface	NI■ RI□ UI□	--	ACC.	--
22	偏心大小头	60.3*33.4*5.54*6.35	304-S	3	100%	All surface	NI■ RI□ UI□	--	ACC.	--
23	偏心大小头	48.3*26.7*5.08*5.56	304-S	2	100%	All surface	NI■ RI□ UI□	--	ACC.	--
24	偏心大小头	114.3*60.3*13.49*5.54	304-S	8	100%	All surface	NI■ RI□ UI□	--	ACC.	--
25	偏心大小头	114.3*73.0*13.49*7.01	304-S	2	100%	All surface	NI■ RI□ UI□	--	ACC.	--
26	偏心大小头	73.0*48.3*7.01*5.08	304-S	2	100%	All surface	NI■ RI□ UI□	--	ACC.	--
27	偏心大小头	88.9*48.3*7.62*5.08	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
28	同心大小头	88.9*48.3*7.62*5.08	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
29	90°弯头 LR	21.3*4.78	304-S	28	100%	All surface	NI■ RI□ UI□	--	ACC.	--
30	偏心大小头	114.3*48.3*13.49*5.08	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--

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探伤方法 Test Method	Type II-C			环境温度 Environment Temp	28℃	观察 Observation	≥1000Lx	表面状态 Surface Condition	光洁 smooth and clean
渗透剂型号 Penetrant Type	HP-ST			清洗剂型号 Cleaner Type	HR-ST	显像剂型号 Developer Type	HD-ST	检测比例 checking proportion	100%
渗透剂施加方法 Penetrant method	喷涂法 Spraying			清洗方式 Cleaning Method	溶剂擦除 Solvent wipe	显像方法 Imaging modality	喷法 Spraying	检测标准 Test standard	ASTM E165-2012
渗透时间 Penetrant Time	10min.			显像时间 Developing Time	7min	灵敏度 Sensitivity	3 point display B-III	验收标准 Acc. Standard	ASME VIII div. 1 appendix 8

序号 NO.	品名 Description	规格(mm) Dimension(mm)	材质 Material	数量 Quantity(PCS)	抽样比 Ratio	检测部位 Inspection area	表面状况 Surface Condition	评定等级 Judgement Level	检测结果 Test Result	备注 Remarks
1	异径三通	60.3*33.4*5.54*6.35	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
2	异径三通	48.3*42.2*5.08*6.35	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
3	异径三通	48.3*33.4*5.08*6.35	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
4	异径三通	114.3*60.3*13.49*5.54	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
5	异径三通	88.9*48.3*7.62*5.08	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
6	异径三通	60.3*26.7*5.54*5.56	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
7	异径三通	60.3*48.3*5.54*5.08	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
8	异径三通	73.0*60.3*7.01*5.54	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
9	异径三通	114.3*88.9*13.49*7.62	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--
10	异径三通	73.0*48.3*7.01*5.08	304-S	1	100%	All surface	NI■ RI□ UI□	--	ACC.	--

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客户 Client				合同号 Contract No.	KS2016051401	报告编号 Report No.	PT16GN1212-02	页码 Page No.	1 of 1
探伤方法 Test Method	Type II-C		环境温度 Environment Temp	28°C		观察 Observation	≥1000Lx	表面状态 Surface Condition	光洁 smooth and clean
渗透剂型号 Penetrant Type	HP-ST		清洗剂型号 Cleaner Type	HR-ST		显像剂型号 Developer Type	HD-ST	检测比例 checking proportion	100%
渗透剂施加方法 Penetrant method	喷涂法 Spraying		清洗方式 Cleaning Method	溶剂擦除 Solvent wipe		显像方法 Imaging modality	喷法 Spraying	检测标准 Test standard	ASTM E165-2012
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11	90°弯头 LR	60.3*33.4*5.54*6.35	304-S	65	100%	All surface	NI■ RI□ UI□	--	ACC.	--
12	90°弯头 LR	48.3*42.2*5.08*6.35	304-S	24	100%	All surface	NI■ RI□ UI□	--	ACC.	--
13	90°弯头 LR	48.3*33.4*5.08*6.35	304-S	75	100%	All surface	NI■ RI□ UI□	--	ACC.	--
14	90°弯头 LR	114.3*60.3*13.49*5.54	304-S	43	100%	All surface	NI■ RI□ UI□	--	ACC.	--
15	90°弯头 LR	88.9*48.3*7.62*5.08	304-S	50	100%	All surface	NI■ RI□ UI□	--	ACC.	--
16	90°弯头 LR	60.3*26.7*5.54*5.56	304-S	65	100%	All surface	NI■ RI□ UI□	--	ACC.	--
17	90°弯头 LR	60.3*48.3*5.54*5.08	304-S	7	100%	All surface	NI■ RI□ UI□	--	ACC.	--
18	90°弯头 LR	73.0*60.3*7.01*5.54	304-S	20	100%	All surface	NI■ RI□ UI□	--	ACC.	--
19	等径三通	114.3*88.9*13.49*7.62	304-S	4	100%	All surface	NI■ RI□ UI□	--	ACC.	--
20	等径三通	73.0*48.3*7.01*5.08	304-S	4	100%	All surface	NI■ RI□ UI□	--	ACC.	--

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