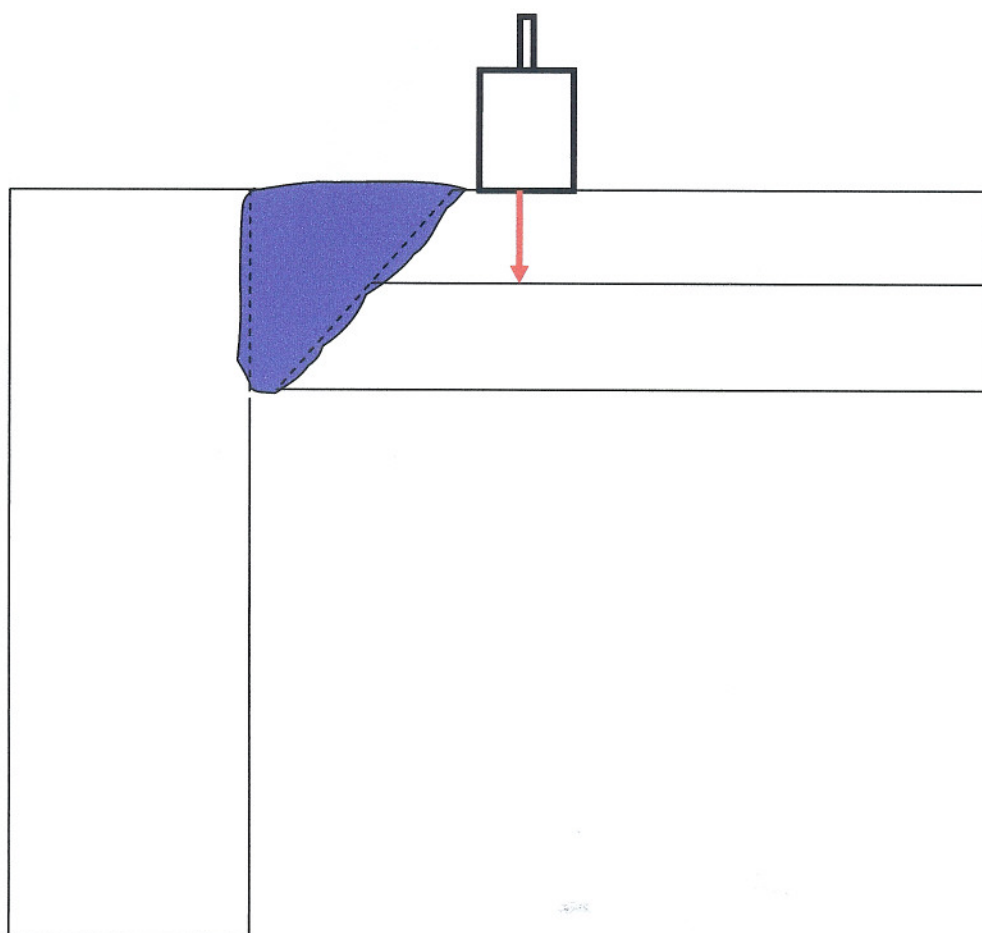
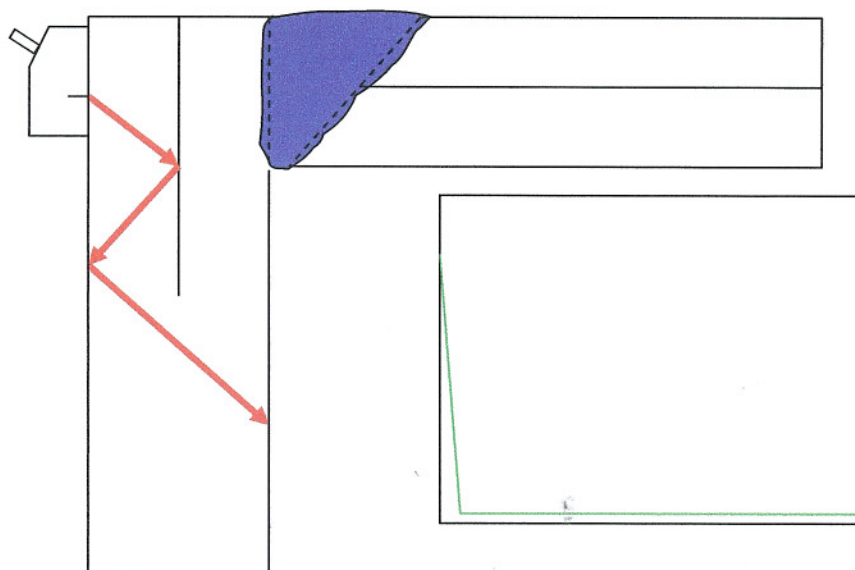


➤ (换位置)

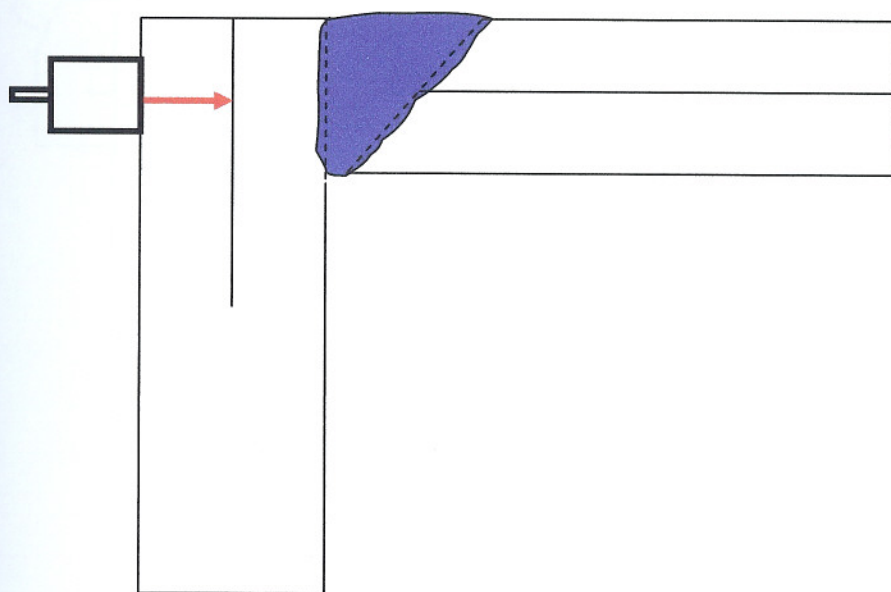


➤ 看不见的 (不能检出 non-detectable)

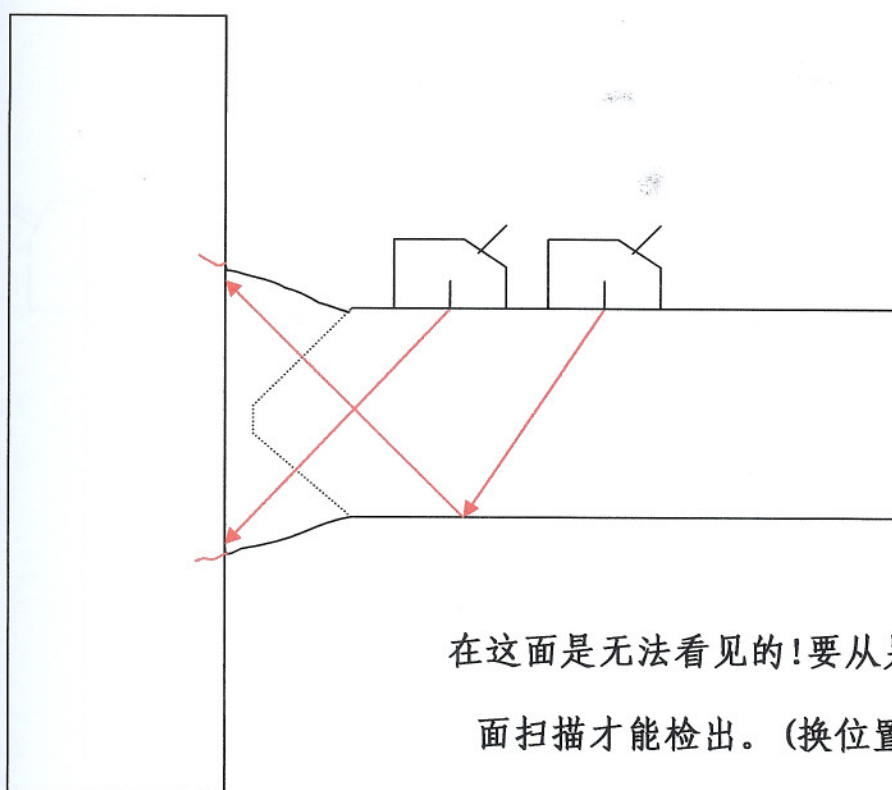


夹层无法检出 (沒有回波)

➤ (换角度)

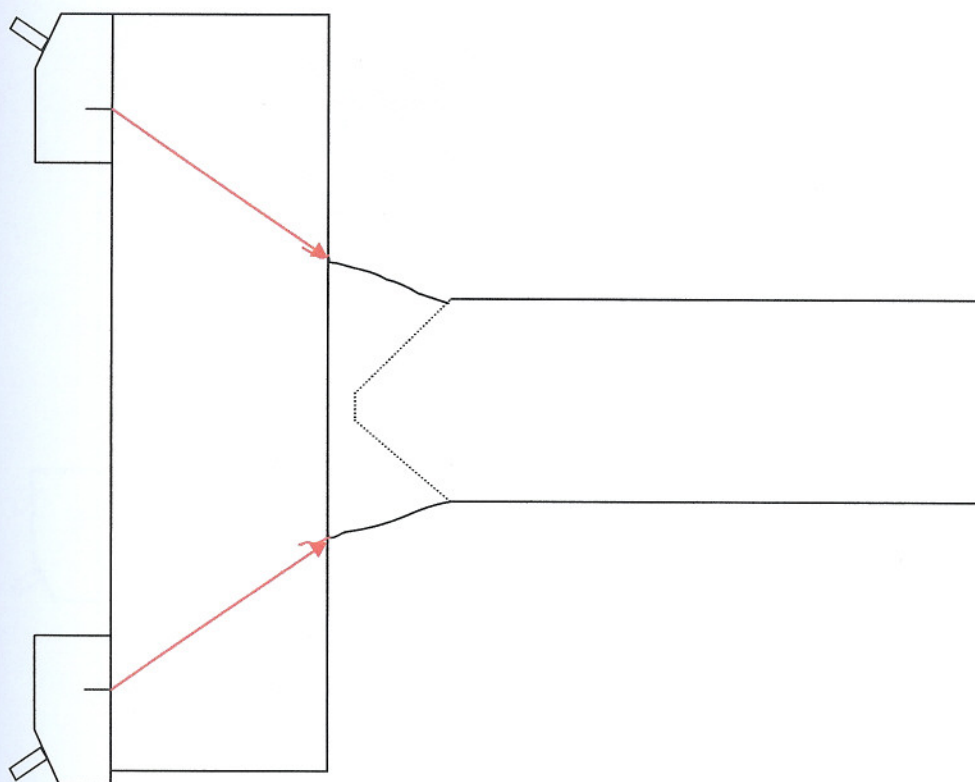


➤ 看不见的 (不能检出 non-detectable)

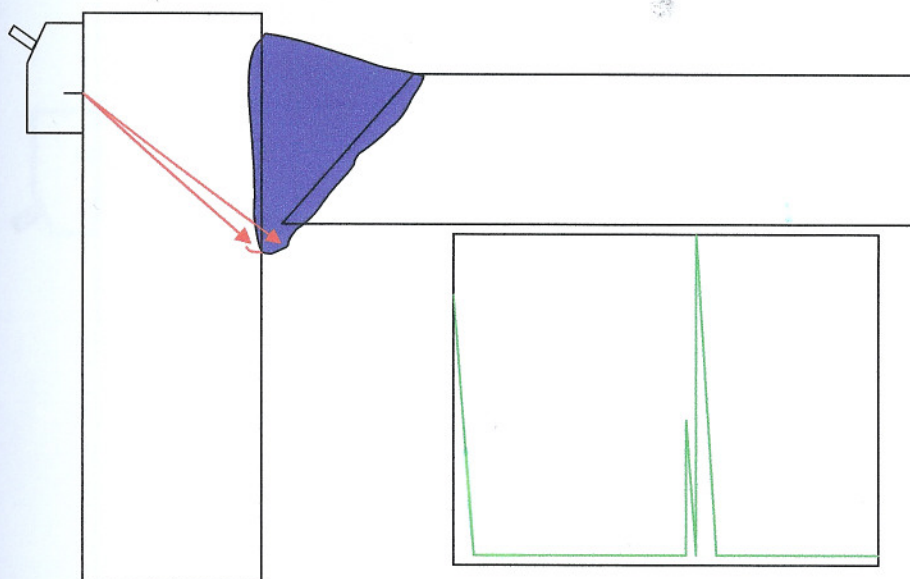


在这面是无法看见的!要从另一面扫描才能检出。(换位置)

➤ (换位置、换方向)

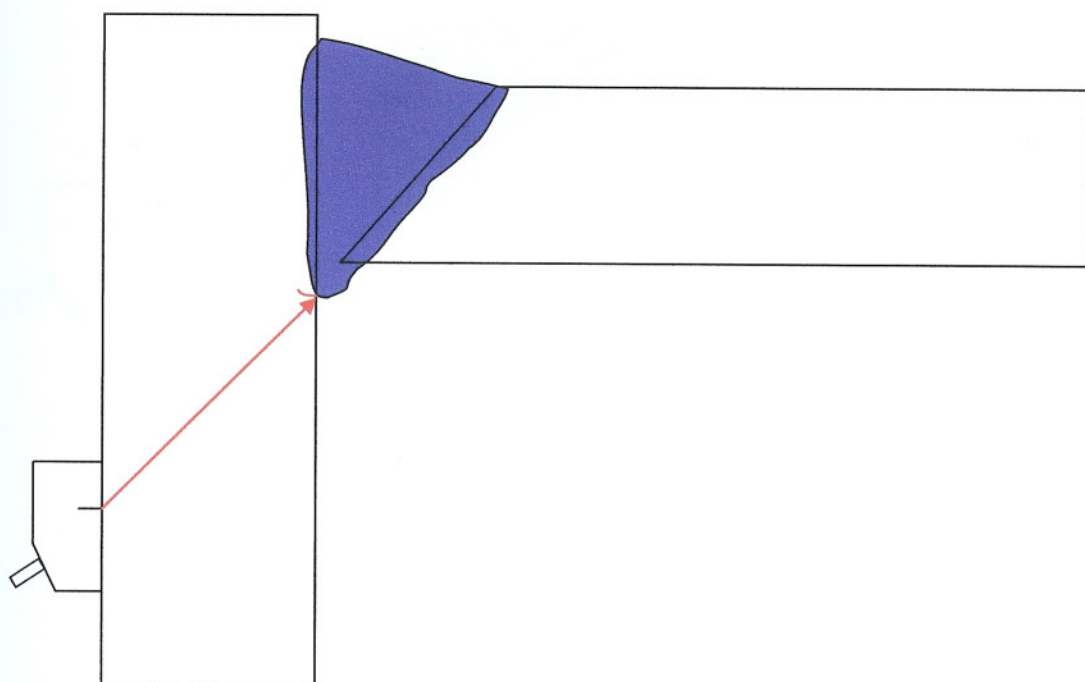


➤ 看不清的 (Confused)

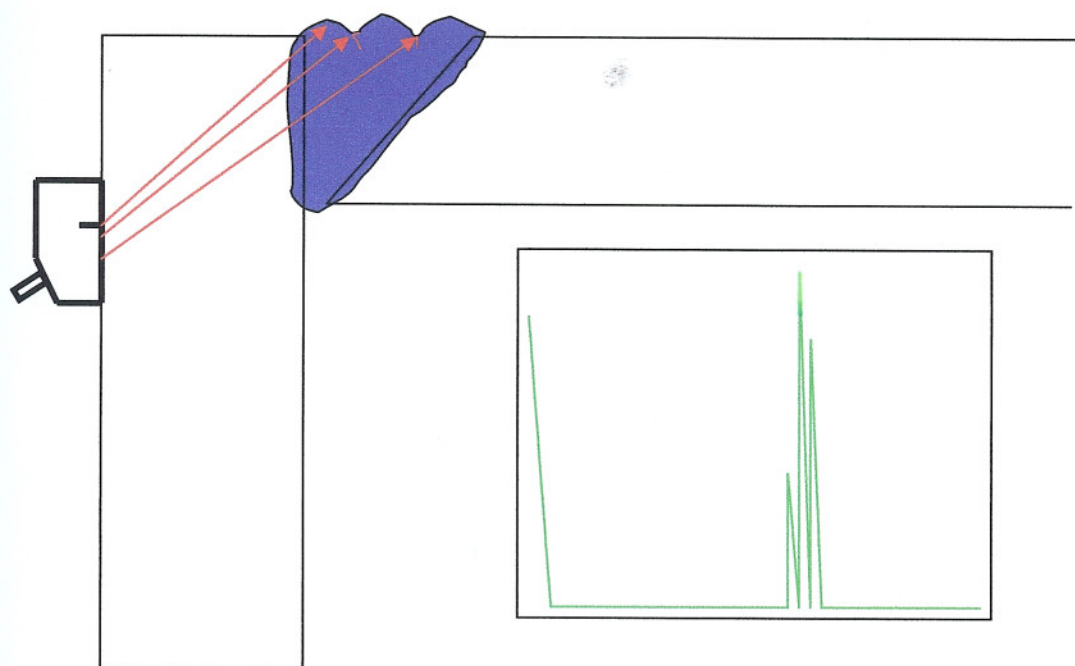


裂纹与根部焊瘤回波混淆看不清楚

➤ 换方向

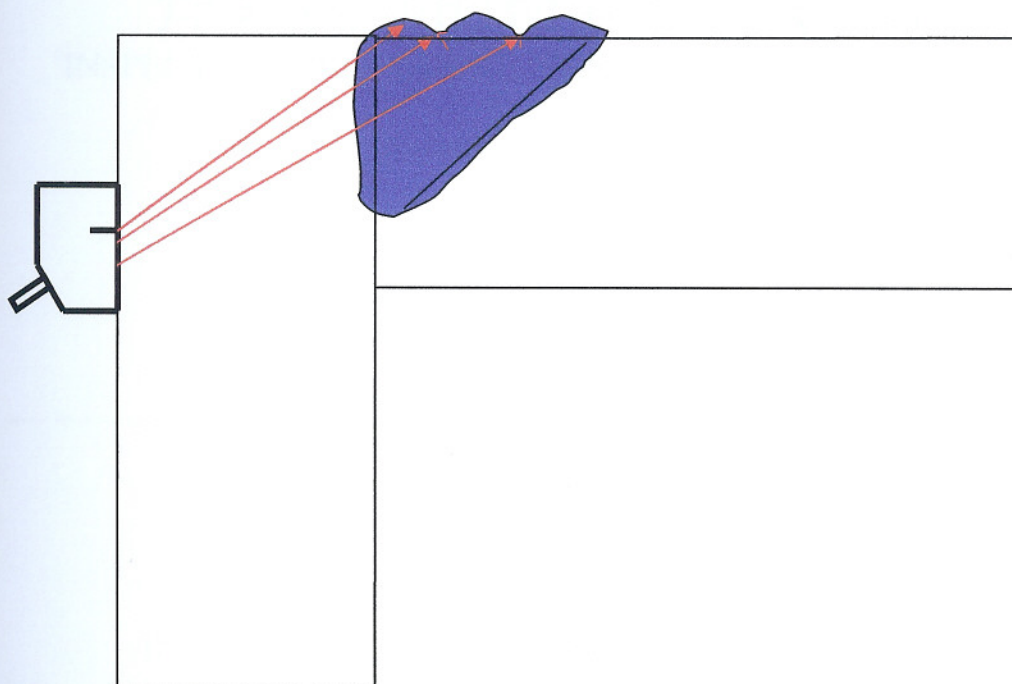


➤ 看不清的 (Confused)

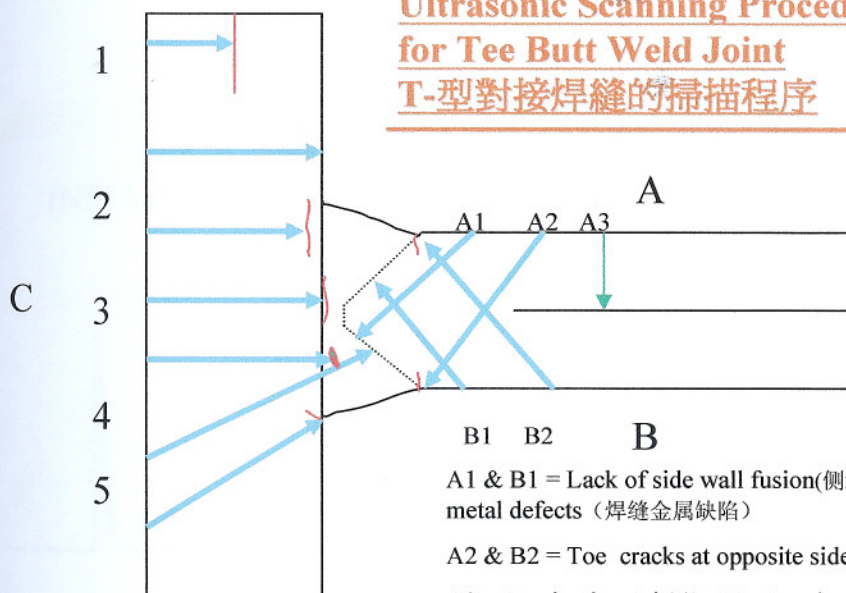


裂纹与焊瘤回波混淆看不清楚

➤ 换方法用磁粉/渗透 (Change Method Used MT or PT)



**Ultrasonic Scanning Procedure
for Tee Butt Weld Joint**
T-型对接焊缝的扫描程序



A1 & B1 = Lack of side wall fusion (侧边未熔合), & Weld metal defects (焊缝金属缺陷)

A2 & B2 = Toe cracks at opposite side (相对面根部裂纹)

A3 = Lamination (夹层) C1 = Lamination (夹层)

C5 = Weld metal defects (焊缝金属缺陷)

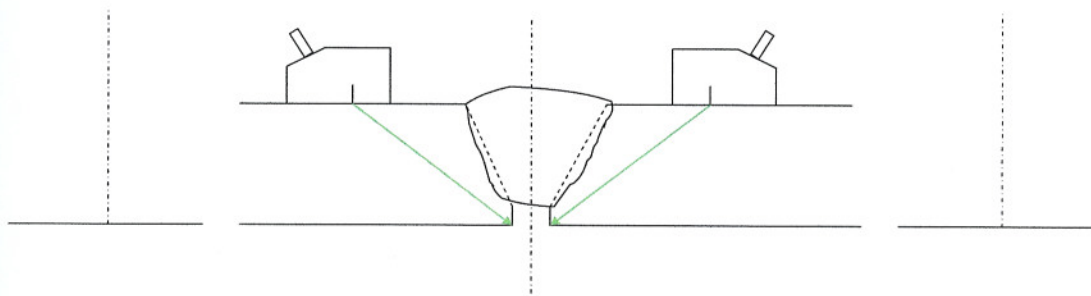
C2 = Plate thickness (板厚) C6 = Lack of side wall fusion (侧边未熔合)

C3 = Lameller Tearing (裂纹)

C7 = Toe cracks (根部裂纹) C4 = Lack of fusion (未熔合)

焊缝根部的检验程序 (1Q)

INSPECTION PROCEDURE FOR THE WELD ROOT (1Q)

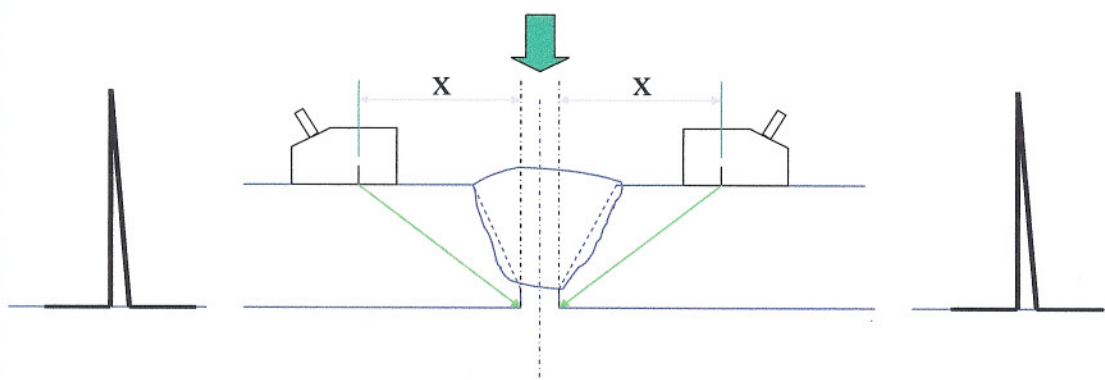


根部未焊透有间隙的情况

INCOMPLETE PENETRATION AT WELD ROOT
(WITH ROOT OPENING)

焊缝根部的检验程序 (1)

INSPECTION PROCEDURE FOR THE WELD ROOT (1)

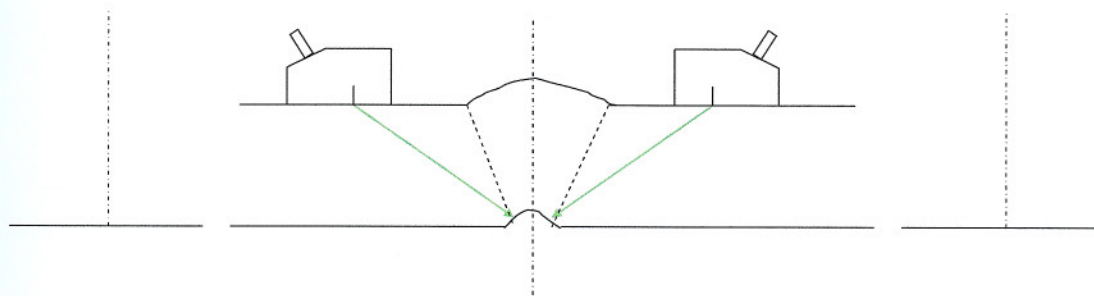


根部未焊透有间隙的情况

INCOMPLETE PENETRATION AT WELD ROOT
(WITH ROOT OPENING)

焊缝根部的检验程序 (2Q)

INSPECTION PROCEDURE FOR THE WELD ROOT (2Q)

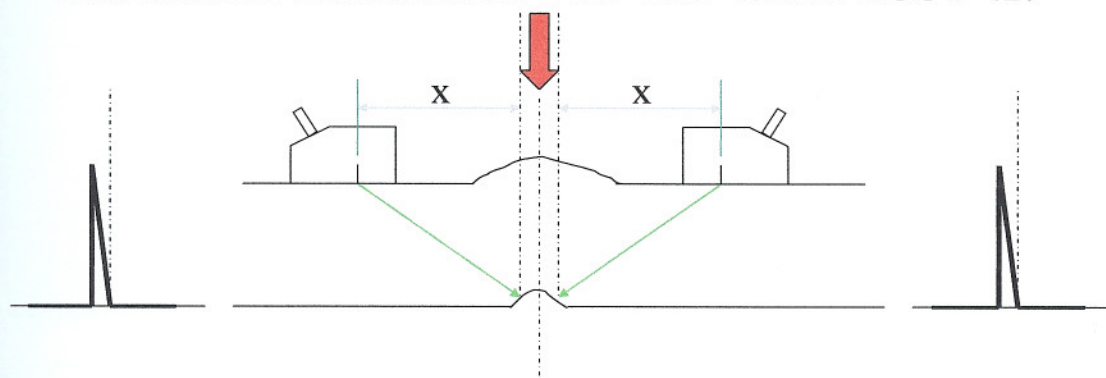


根部凹陷的情况

ROOT CONCAVITY

焊缝根部的检验程序 (2)

INSPECTION PROCEDURE FOR THE WELD ROOT (2)

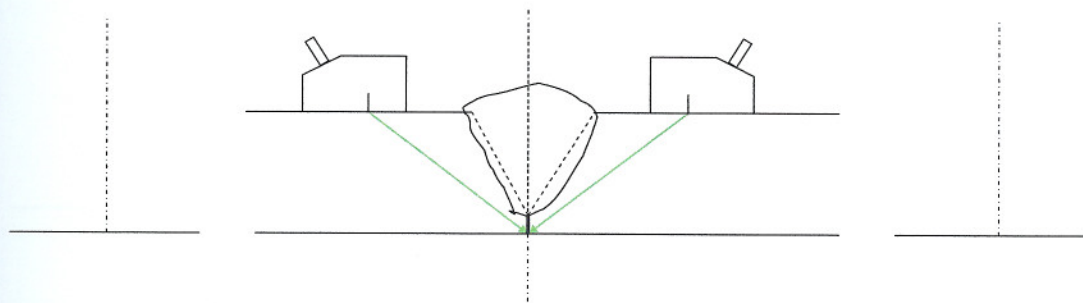


根部凹陷的情况

ROOT CONCAVITY

焊缝根部的检验程序 (3Q)

INSPECTION PROCEDURE FOR THE WELD ROOT (3Q)

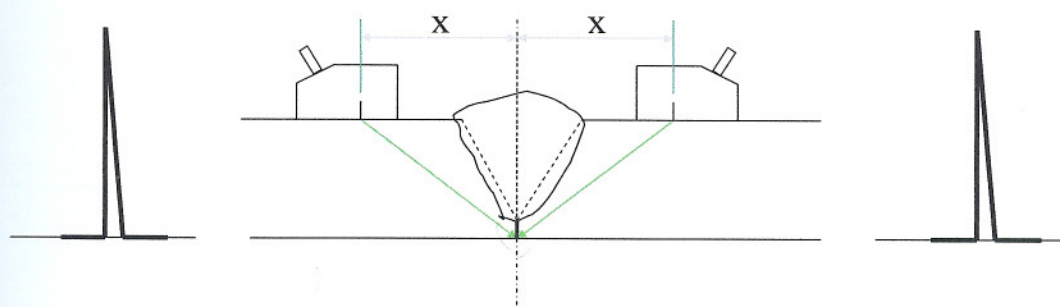


根部未焊透没有间隙的情况

INCOMPLETE PENETRATION AT WELD ROOT
(WITHOUT ROOT OPENING)

焊缝根部的检验程序 (3)

INSPECTION PROCEDURE FOR THE WELD ROOT (3)



根部未焊透没有间隙的情况

INCOMPLETE PENETRATION AT WELD ROOT
(WITHOUT ROOT OPENING)