

PMI REPORT

PROJECT: WORPAR

ITEM: 621B.2

1、WELD MAP

Weld Map
焊缝分布图

文件编号 Doc No: WZA21-26 Rev. 0

WXZC		焊缝分布图 Weld Map				第 1 页 共 4 页 PAGE 1 OF 4			
产品名称 JOB NAME	油蒸汽换热器 OIL/STEAM HEAT EXCHANGER	产品图号/版本号 DWG. No./Rev.	WXZC21A19-00		生产令号 JOB NO.	WZA21-26			

更改标记 REV.ID.	数量 QTY	文件号码 DOC.No.	签字 SIGN	日期 DATE	更改标记 REV.ID.	数量 QTY	文件号码 DOC.No.	签字 SIGN	日期 DATE
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志成装备

ZHICHENG

2、PMI Report

无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

PMI REQUEST BY: LUWEI			PURCHASE ORDER NUMBER		
SIGNATURE: LUWEI			P0619006		
DATE: 21.8.7					
PMI PERFORMED BY: PUJINBIAO			PMI WILL BE/WAS PERFORMED AT:		
SIGNATURE: PUJINBIAO			Materials to the factory		
DATE: 21.8.7					
ITEM OR TAG NUMBER	SAMPLE SIZE	MATERIAL	MILL CERT. NUMBER	HEAT NUMBER	DESCRIPTION
1	/	SA-240 304	200229015	1910365	Shell (include head and expansion)
2	/	SA-240 304	200229015	1910365	Channel shell
3	/	SA-240 304	6144956108740562	A2101374	tubesheet
4	/	SA-213 TP304L	2021-08-0806	NY210413AS03	tubes
5	/	SA-182 F304	IC-ZLFL-2021A1302-2-1	J210122-6	Channel flange
6	/	SA-312 TP304	2021-05-20-001	YX2006-2001	Nozzle $\phi 114.3 \times 6.02$
7	/	SA-312 TP304	2021-7-26-002	YX2006-2121	Nozzle $\phi 21.3 \times 2.77$
8	/	SA-312 TP304	2021-7-26-002	YX2006-2163	Nozzle $\phi 168.3 \times 7.11$
9	/	SA-312 TP304	2021-7-26-002	YX2006-2121	Nozzle $\phi 33.4 \times 3.38$
EXAMINATION RESULTS					
ITEM OR TAG NUMBER	NO. OF PIECES EXAM.	NO. OF PIECES ACCEPT.	NO. OF PIECES REJ.	MATERIAL IDENTIFIED AS	Chemical Composition Percentage
					Cr Mo Ni C Ti Cb Cu Fe V
1	shell	ACC	/	SA-240 304	18.14 8.06
2	Channel shell	ACC	/	SA-240 304	18.16 8.12
3	tubesheet	ACC	/	SA-240 304	18.05 8.35
4	tubes	ACC	/	SA-213 TP304L	18.23 8.13
5	Channel flange	ACC	/	SA-182 F304	18.15 8.01
6	nozzle	ACC	/	SA-312 TP304	18.30 8.17
7	nozzle	ACC	/	SA-312 TP304	18.34 8.17
8	nozzle	ACC	/	SA-312 TP304	18.06 8.13
9	nozzle	ACC	/	SA-312 TP304	18.04 8.13
ADDRESS OF SELLER RESPONSIBLE FOR REJECTION(S): NA					
ADDITIONAL INFORMATION : NA					
MANHOURS AND LOSS INCURRED FROM REJECTIONS, ETC. : NA					
PMI Supervisor <u>LUWEI 21.8.7</u> Signature/Date					



无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

PMI REQUEST BY: LULEI			PURCHASE ORDER NUMBER			
SIGNATURE: LULEI			P0619006			
DATE: 21.7.28						
PMI PERFORMED BY: PUJINBIAO			PMI WILL BE/WAS PERFORMED AT:			
SIGNATURE: PUJINBIAO			After welding			
DATE: 21.7.28						

ITEM OR TAG NUMBER	SAMPLE SIZE	MATERIAL	MILL CERT. NUMBER	HEAT NUMBER	DESCRIPTION
1	/	ER308L	200198331-02	486212	A1
2	/	ER308L	200198331-02	486212	A2
3	/	ER308L	200198331-02	486212	A3
4	/	ER308L	200198331-02	486212	A4
5	/	ER308	W200169	20-99013	A1 (expansion)
6	/	ER308	W200169	20-99013	B1
7	/	ER308	W200169	20-99013	B2
8	/	ER308L	200198331-02	486212	B3
9	/	ER308L	200198331-02	486212	B4

EXAMINATION RESULTS													
ITEM OR TAG NUMBER	NO. OF PIECES EXAM.	NO. OF PIECES ACCEPT.	NO. OF PIECES REJ.	MATERIAL IDENTIFIED AS	Chemical Composition Percentage								
					Cr	Mo	Ni	C	Ti	Cb	Cu	Fe	V
1	A1	ACC	/	ER308L	18.02		8.27						
2	A2	ACC	/	ER308L	18.17		8.20						
3	A3	ACC	/	ER308L	18.03		8.26						
4	A4	ACC	/	ER308L	18.04		8.46						
5	A1	ACC	/	ER308	19.44		8.79						
6	B1	ACC	/	ER308	19.65		8.61						
7	B2	ACC	/	ER308	19.31		9.10						
8	B3	ACC	/	ER308L	18.02		8.17						
9	B4	ACC	/	ER308L	18.01		8.45						

ADDRESS OF SELLER RESPONSIBLE FOR REJECTION(S): NA													
ADDITIONAL INFORMATION: NA													
MANHOURS AND LOSS INCURRED FROM REJECTIONS, ETC. NA													
PMI Supervisor <u>LUWEI 21.7.28</u> Signature/Date													



无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

PMI REQUEST BY: LULEI			PURCHASE ORDER NUMBER			
SIGNATURE: LULEI			P0619006			
DATE: 21.8.1						
PMI PERFORMED BY: PUJINBIAO			PMI WILL BE/WAS PERFORMED AT:			
SIGNATURE: PUJINBIAO			After welding			
DATE: 21.8.1						

ITEM OR TAG NUMBER	SAMPLE SIZE	MATERIAL	MILL CERT. NUMBER	HEAT NUMBER	DESCRIPTION
1	/	ER308	W200169	20-99013	C1
2	/	ER308	W200169	20-99013	C2
3	/	ER308	W200169	20-99013	C3
4	/	ER308	W200169	20-99013	C4
5	/	ER308	W200169	20-99013	C5
6	/	ER308	W200169	20-99013	C6
7	/	ER308	W200169	20-99013	C7
8	/	ER308	W200169	20-99013	C8

EXAMINATION RESULTS													
ITEM OR TAG NUMBER	NO. OF PIECES EXAM.	NO. OF PIECES ACCEPT.	NO. OF PIECES REJ.	MATERIAL IDENTIFIED AS	Chemical Composition Percentage								
					Cr	Mo	Ni	C	Ti	Cb	Cu	Fe	V
1	C1	ACC	/	ER308	19.50		9.12						
2	C2	ACC	/	ER308	18.95		9.72						
3	C3	ACC	/	ER308	19.13		9.19						
4	C4	ACC	/	ER308	19.13		9.55						
5	C5	ACC	/	ER308	19.62		8.99						
6	C6	ACC	/	ER308	19.19		9.02						
7	C7	ACC	/	ER308	18.88		9.09						
8	C8	ACC	/	ER308	18.87		9.15						

ADDRESS OF SELLER RESPONSIBLE FOR REJECTION(S): NA													
ADDITIONAL INFORMATION: NA													
MANHOURS AND LOSS INCURRED FROM REJECTIONS, ETC. NA													
PMI Supervisor <u>LUWEI 21.8.1</u> Signature/Date													



无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

PMI REQUEST BY: LULEI			PURCHASE ORDER NUMBER			
SIGNATURE: LULEI			P0619006			
DATE: 21.8.1						
PMI PERFORMED BY: PUJINBIAO			PMI WILL BE/WAS PERFORMED AT:			
SIGNATURE: PUJINBIAO			After welding			
DATE: 21.8.1						

ITEM OR TAG NUMBER	SAMPLE SIZE	MATERIAL	MILL CERT. NUMBER	HEAT NUMBER	DESCRIPTION
1	/	ER308	W200169	20-99013	C9
2	/	ER308	W200169	20-99013	C10
3	/	ER308	W200169	20-99013	C11
4	/	ER308	W200169	20-99013	C12
5	/	ER308	W200169	20-99013	C13
6	/	ER308	W200169	20-99013	C14
7	/	ER308	W200169	20-99013	C15
8	/	ER308	W200169	20-99013	D1

EXAMINATION RESULTS													
ITEM OR TAG NUMBER	NO. OF PIECES EXAM.	NO. OF PIECES ACCEPT.	NO. OF PIECES REJ.	MATERIAL IDENTIFIED AS	Chemical Composition Percentage								
					Cr	Mo	Ni	C	Ti	Cb	Cu	Fe	V
1	C9	ACC	/	ER308	19.28		9.32						
2	C10	ACC	/	ER308	19.20		8.94						
3	C11	ACC	/	ER308	19.34		9.27						
4	C12	ACC	/	ER308	19.59		9.11						
5	C13	ACC	/	ER308	19.15		9.60						
6	C14	ACC	/	ER308	19.19		9.39						
7	C15	ACC	/	ER308	19.10		9.26						
8	D1	ACC	/	ER308	19.72		9.59						

ADDRESS OF SELLER RESPONSIBLE FOR REJECTION(S): NA													
ADDITIONAL INFORMATION: NA													
MANHOURS AND LOSS INCURRED FROM REJECTIONS, ETC. NA													
PMI Supervisor <u>LUWEI 21.8.1</u> Signature/Date													



无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

PMI REQUEST BY: LULEI			PURCHASE ORDER NUMBER			
SIGNATURE: LULEI			P0619006			
DATE: 21.9.20						
PMI PERFORMED BY: PUJINBIAO			PMI WILL BE/WAS PERFORMED AT:			
SIGNATURE: PUJINBIAO			After welding			
DATE: 21.9.20						

ITEM OR TAG NUMBER	SAMPLE SIZE	MATERIAL	MILL CERT. NUMBER	HEAT NUMBER	DESCRIPTION
1	/	ER308	W200169	20-99013	D2
2	/	ER308	W200169	20-99013	D3
3	/	ER308	W200169	20-99013	D4
4	/	ER308	W200169	20-99013	D5
5	/	ER308	W200169	20-99013	D6
6	/	ER308	W200169	20-99013	D7
7	/	ER308	W200169	20-99013	D8
8	/	ER308	W200169	20-99013	D9

EXAMINATION RESULTS													
ITEM OR TAG NUMBER	NO. OF PIECES EXAM.	NO. OF PIECES ACCEPT.	NO. OF PIECES REJ.	MATERIAL IDENTIFIED AS	Chemical Composition Percentage								
					Cr	Mo	Ni	C	Ti	Cb	Cu	Fe	V
1	D2	ACC	/	ER308	19.57		9.39						
2	D3	ACC	/	ER308	19.05		9.65						
3	D4	ACC	/	ER308	19.03		8.89						
4	D5	ACC	/	ER308	18.75		9.12						
5	D6	ACC	/	ER308	19.04		9.00						
6	D7	ACC	/	ER308	19.02		8.71						
7	D8	ACC	/	ER308	19.05		9.53						
8	D9	ACC	/	ER308	19.34		9.37						

ADDRESS OF SELLER RESPONSIBLE FOR REJECTION(S): NA													
ADDITIONAL INFORMATION: NA													
MANHOURS AND LOSS INCURRED FROM REJECTIONS, ETC. NA													
PMI Supervisor <u>LUWEI 21.9.20</u> Signature/Date													



无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

PMI REQUEST BY: LULEI			PURCHASE ORDER NUMBER									
SIGNATURE: LULEI			P0619006									
DATE: 21.9.20												
PMI PERFORMED BY: PUJINBIAO			PMI WILL BE/WAS PERFORMED AT:									
SIGNATURE: PUJINBIAO			After welding									
DATE: 21.9.20												

ITEM OR TAG NUMBER	SAMPLE SIZE	MATERIAL	MILL CERT. NUMBER	HEAT NUMBER	DESCRIPTION
1	/	ER308	W200169	20-99013	D10
2	/	ER308	W200169	20-99013	D11
3	/	ER308	W200169	20-99013	E1
4	/	ER308	W200169	20-99013	E2
5	/	ER308	W200169	20-99013	E3
6	/	ER308	W200169	20-99013	E4
7	/	ER308	W200169	20-99013	E5
8	/	ER308	W200169	20-99013	E6

EXAMINATION RESULTS													
ITEM OR TAG NUMBER	NO. OF PIECES EXAM.	NO. OF PIECES ACCEPT.	NO. OF PIECES REJ.	MATERIAL IDENTIFIED AS	Chemical Composition Percentage								
					Cr	Mo	Ni	C	Ti	Cb	Cu	Fe	V
1	D10	ACC	/	ER308	19.07		9.46						
2	D11	ACC	/	ER308	19.74		9.42						
3	E1	ACC	/	ER308	19.23		9.33						
4	E2	ACC	/	ER308	19.31		9.16						
5	E3	ACC	/	ER308	18.55		8.55						
6	E4	ACC	/	ER308	18.71		9.45						
7	E5	ACC	/	ER308	19.00		9.32						
8	E6	ACC	/	ER308	19.06		9.19						

ADDRESS OF SELLER RESPONSIBLE FOR REJECTION(S): NA													
ADDITIONAL INFORMATION: NA													
MANHOURS AND LOSS INCURRED FROM REJECTIONS, ETC. NA													
PMI Supervisor <u>LUWEI</u> <u>21.9.20</u> Signature/Date													



无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

PMI REQUEST BY: LULEI			PURCHASE ORDER NUMBER			
SIGNATURE: LULEI			P0619006			
DATE: 21.9.20						
PMI PERFORMED BY: PUJINBIAO			PMI WILL BE/WAS PERFORMED AT:			
SIGNATURE: PUJINBIAO			After welding			
DATE: 21.9.20						

ITEM OR TAG NUMBER	SAMPLE SIZE	MATERIAL	MILL CERT. NUMBER	HEAT NUMBER	DESCRIPTION
1	/	ER308	W200169	20-99013	E7
2	/	ER308	W200169	20-99013	E8
3	/	ER308	W200169	20-99013	E9
4	/	ER308	W200169	20-99013	E10
5	/	ER308	W200169	20-99013	E11
6	/	ER308	W200169	20-99013	E12

EXAMINATION RESULTS													
ITEM OR TAG NUMBER	NO. OF PIECES EXAM.	NO. OF PIECES ACCEPT.	NO. OF PIECES REJ.	MATERIAL IDENTIFIED AS	Chemical Composition Percentage								
					Cr	Mo	Ni	C	Ti	Cb	Cu	Fe	V
1	E7	ACC	/	ER308	18.61		8.70						
2	E8	ACC	/	ER308	19.04		9.11						
3	E9	ACC	/	ER308	19.04		8.91						
4	E10	ACC	/	ER308	19.40		8.90						
5	E11	ACC	/	ER308	18.85		8.81						
6	E12	ACC	/	ER308	19.60		8.25						

ADDRESS OF SELLER RESPONSIBLE FOR REJECTION(S): NA													
ADDITIONAL INFORMATION: NA													
MANHOURS AND LOSS INCURRED FROM REJECTIONS, ETC. NA													
PMI Supervisor <u>LUWEI 21.9.20</u> Signature/Date													



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无锡市志成生化工程装备有限公司
Wuxi Zhicheng Biochemical Engineering Equipment Co.,Ltd.

3、PMI 检测照片



PLATE 304/4mm

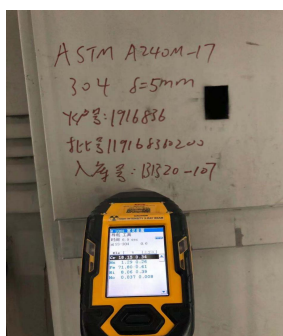


PLATE 304/5mm

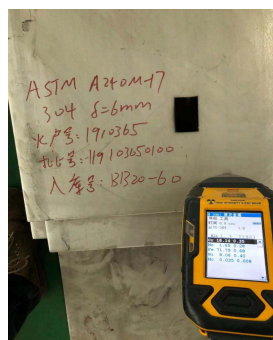


PLATE 304/6mm

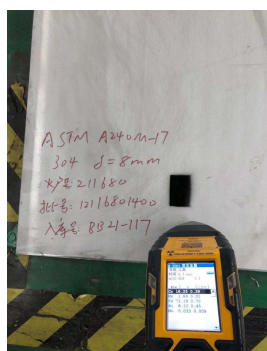


PLATE 304/8mm



PLATE 304/10mm



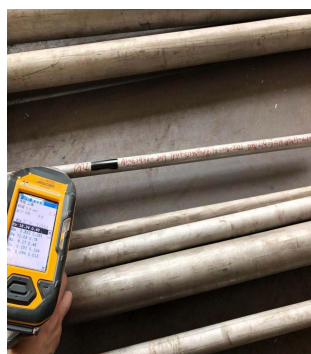
TUBES



TUBESHEET



CHANNEL FLANGE



NOZZLE 304 φ 21.3



NOZZLE 304 φ 33



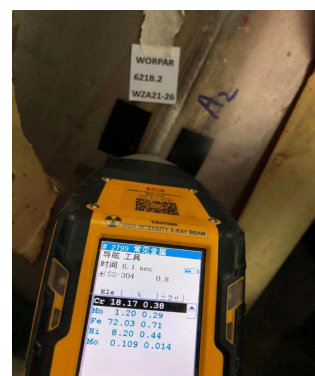
NOZZLE 304 φ 114



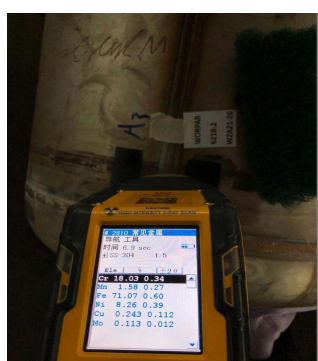
NOZZLE 304 φ 168



WELD A1



WELD A2



WELD A3



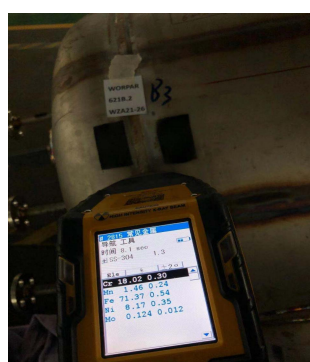
WELD A4



WELD B1



WELD B2



WELD B3



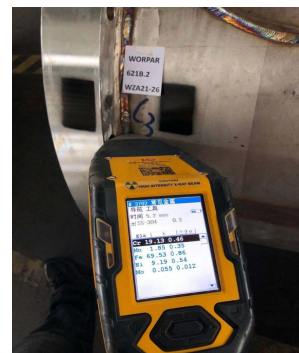
WELD B4



WELD C1



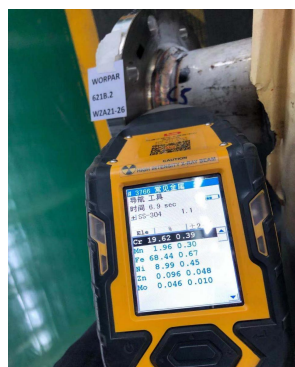
WELD C2



WELD C3



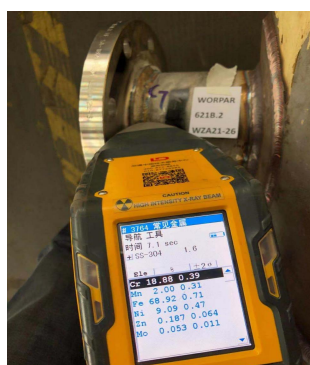
WELD C4



WELD C5



WELD C6



WELD C7



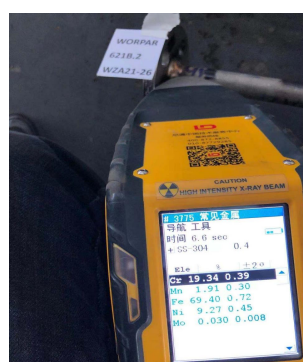
WELD C8



WELD C9



WELD C10



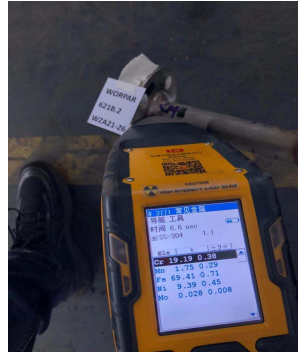
WELD C11



WELD C12



WELD C13



WELD C14



WELD C15



WELD D1



WELD D2



WELD D3



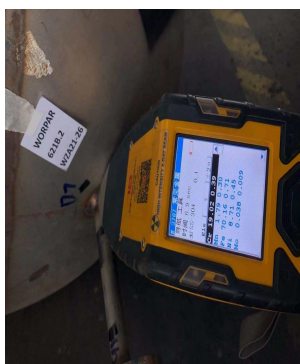
WELD D4



WELD D5



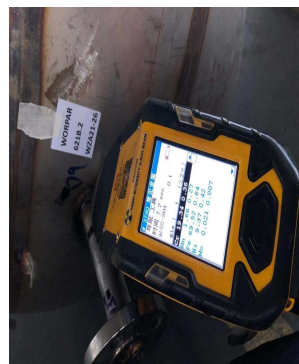
WELD D6



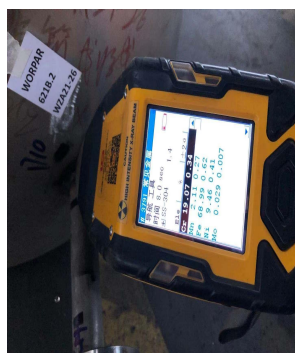
WELD D7



WELD D8



WELD D9



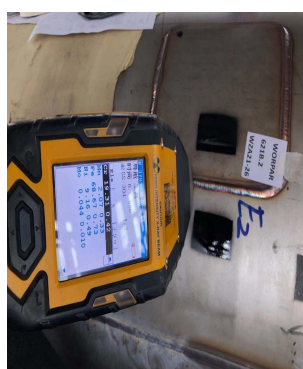
WELD D10



WELD D11



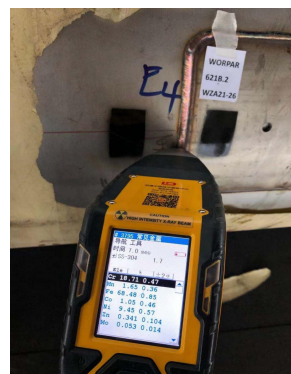
WELD E1



WELD E2



WELD E3



WELD E4



WELD E5



WELD E6



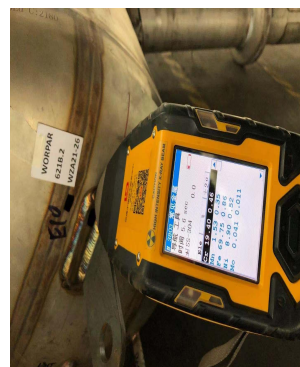
WELD E7



WELD E8



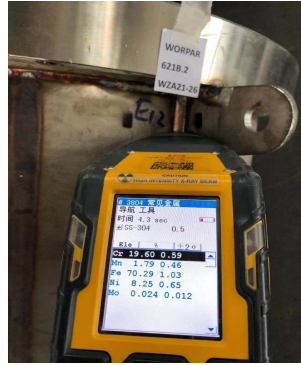
WELD E9



WELD E10



WELD E11



WELD E12



A1 (expansion)