

	Doc. No:	D99110M-C-XXX	 <b>Qingdao Wuchuan Heavy Industry Co., Ltd</b>	
	Doc. Title:	BSR 项目热喷铝承包方初步检测计划		
	Project:	GUARA and LULA-NE Projects		
	Subject:	BUOYS SUPPLY	Sheets:	1 / 3

## BSR 项目热喷铝承包方初步检测计划

1、本项目对热喷铝有严格的技术要求，为了保证外包队的施工质量，在技术协议签订之前需要对外包方设备进行初步检测，具体检测项目如下：

1)、Dry Film Thickness Measurement 干膜厚度测试

DFT 要求：225 $\mu$ m-400 $\mu$ m，详细要求见附件 1 ‘Thermal Sprayer Qualification Test’.

2)、Bend Test 弯曲测试，

弯曲测试要求：弯曲测试所用设备心轴为 13mm.详细要求见附件 1‘Thermal Sprayer Qualification Test’.

3)、Adhesion Test 结合力测试

结合力测试要求单点最低结合力不低于 7MPa，平均结合力不低于 10MPa.详细要求见附件 1‘Thermal Sprayer Qualification Test’.

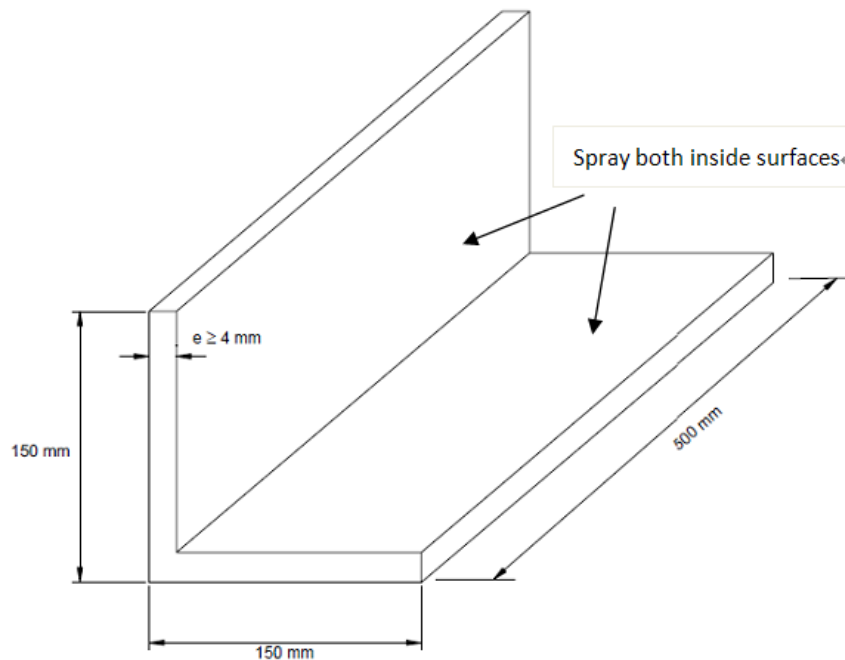



Figure 1: Angle Bar Sample for DFT

A. 角钢测试试板如图 1 所示，必须取本项目所用角钢余料制作，尺寸可以适当更改，满足图 2 中所示的检测取点要求即可

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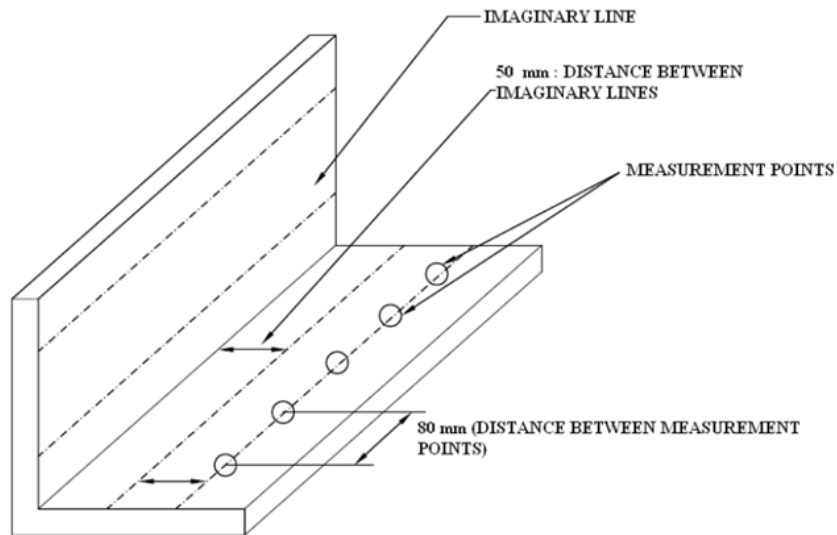


Figure 2 Thickness measures for Angle Bar

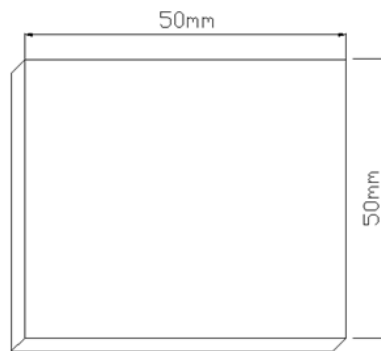


Figure 3: Square Sample for DFT, Bend & Adhesion Test

B.图 3 所示试样要首先进行膜厚测试；检测合格之后，进行结合力测试。尺寸可以适当更改，要满足图 4 及图 5 的测试取点范围。

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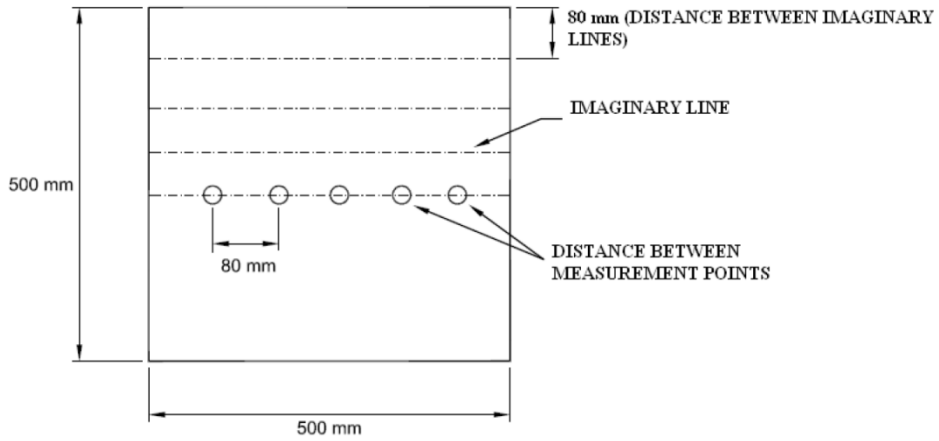


Figure 4: Square Sample DFT measurement

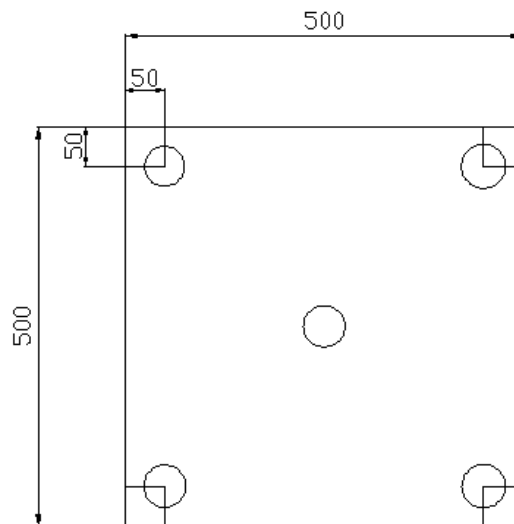


Figure 4: Square Sample Adhesion Test

C. 弯曲试验试样尺寸:

50mm × (100—200) mm × (1.25 × 1.35) mm

试验方法见附件 2.