



工程指示 / 要求簡箋(E.I.)

工程指示編號：EI/ 9499 /18 修改版次：  
 工程編號：J836 工程名稱：日出康城7期平台  
 工程項目：Welding Procedure 測試用鐵件。  
 收件人：Maggie Lor 發件人：李耀輝 日期：2018/7/11

要求提供 /  確認 事項：

- |                                    |                                     |                               |
|------------------------------------|-------------------------------------|-------------------------------|
| <input type="checkbox"/> 初步鋁料 B.M. | <input type="checkbox"/> 加工拆圖，然後生產  | <input type="checkbox"/> 尺寸表  |
| <input type="checkbox"/> 正式鋁料 B.M. | <input type="checkbox"/> 技術上資料 / 指示 | <input type="checkbox"/> 報價   |
| <input type="checkbox"/> 配件 B.M.   | <input type="checkbox"/> 樣辦或貨品說明書   | <input type="checkbox"/> 分判合約 |
| <input type="checkbox"/> 其他：_____  |                                     |                               |

內容：

煙筒密排備鐵件，供 Welding Procedure 測試用：  
 150 X 100 X 3mm(t) X 200mm (L) 鐵翅 4件  
 300 X 300 X 3mm(t) 鐵板 4件。

請在 2018/7/18 前完成上列要求。

附有關圖紙 / 文件：

3頁

以上項目為：

- 原合約工程包                       原合約工程加 / 減賬                       新工程報價

原因：-

分發東莞各部門：

- ( ) 生產技術總監  連附件    ( ) 技術部     連附件    ( ) 生產部     連附件    ( ) 機械設計部  連附件  
 ( ) 採購部     連附件    ( ) 生產統籌部  連附件  
 ( ) 質檢部     連附件    ( ) 會計部     連附件    ( ) 報關組     連附件    ( ) 其他 \_\_\_\_\_  連附件

分發香港各部門：

- ( ) 行政部  連附件    ( ) 會計部  連附件    ( ) 統籌部  連附件    ( ) 工程部地盤科文  連附件  
 ( ) 採購部  連附件    ( ) QS 部  連附件    ( ) 維修部  連附件    ( ) 其他 \_\_\_\_\_  連附件

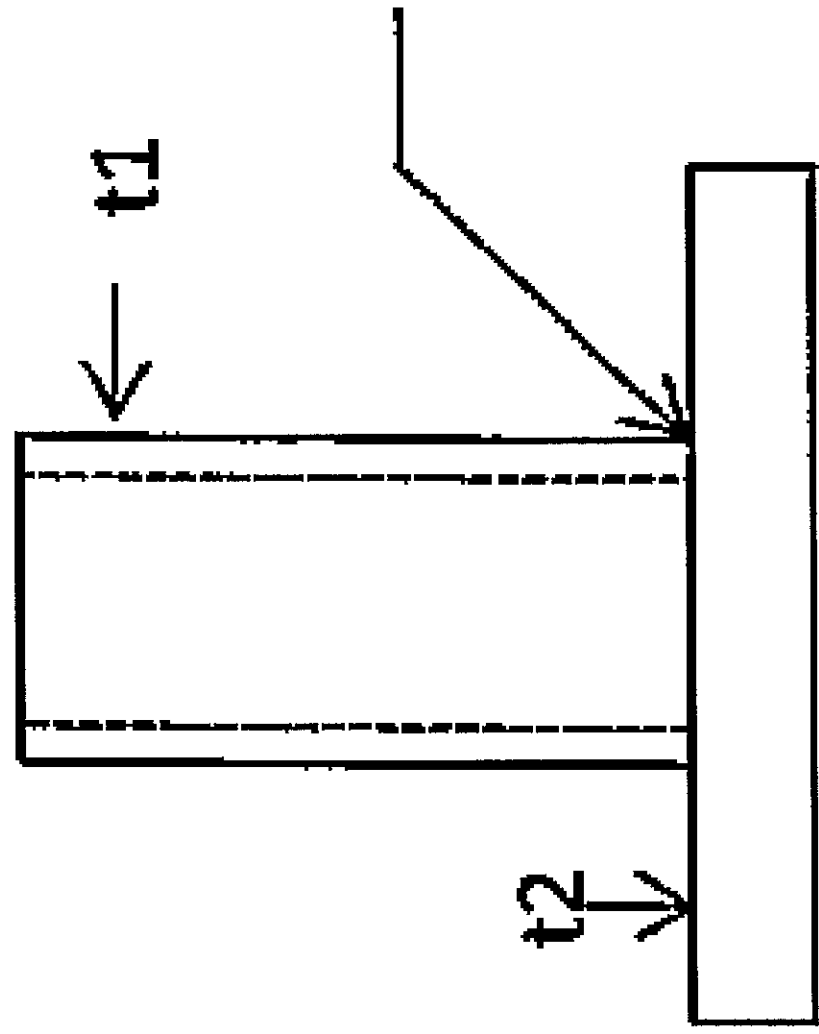
傳遞編號：

發件人簽署：

項目經理簽署：

不浸的水浦.

4套.



Gap max. 2

mm

(Referred to EN  
ISO 9692-

1:2003 Table 3)

t1 : 150 x 100 x 8mm thk. x 200mm long RHS (4件)

t2 : 300 x 300 x 30mm thk. Steel Plate (4件)



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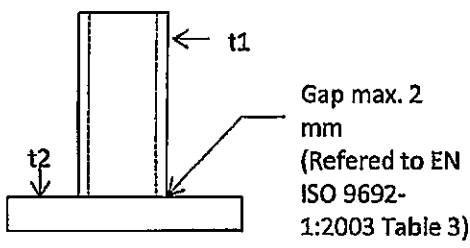
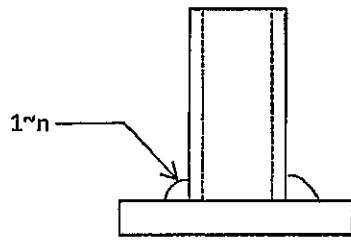
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## PRELIMINARY WELDING PROCEDURE SPECIFICATION (pWPS)

Report No.:	1808353-1	Rev.:	0	Amd.:	0	Issued Date:	10 July, 2018	Page	1 of 2	Pages
Application Standard:	BSENISO 15609-1:2004									
pWPS no.:	1808353-1R0A0									
Manufacturer:	China Overseas Building Construction Ltd. (Main Contractor) / Midi Aluminium Fabricator Ltd.									
Project:	Proposed Site C1, Development at Area 86, TKOTL 70 RP, Tseung Kwan O, New Territories									
Joint type and weld type:	Fillet weld in pipe to plate									
Welding positions:	Vertical up (PF)							Material thickness (mm): t1: 8; t2: 30		
Parent material specification:	BSEN 10210-1:2006 Designation S275J0H (1.1)							Outside diameter (mm): 100		
	BSEN 10025-2:2004 Designation S275J0 (1.1)									
Method of preparation and cleaning:	Flame cut followed by mechanical grinding							Mode of metal transfer: --		
<i>Weld preparation details (Sketch)*:</i>										
Joint preparation (mm)						Run sequence				
 <p>Gap max. 2 mm (Referred to EN ISO 9692-1:2003 Table 3)</p>						 <p>1~n</p>				
t1 : 150 x 100 x 8mm thk. x 200mm long RHS						8 mm leg length fillet weld				
t2 : 300 x 300 x 30mm thk. Steel Plate										
<i>Welding details:</i>										
Run no.	process	Size of Filler Metal	Current (A) Ave.	Voltage (V) Ave.	Type of current	Wire Feed Speed	Travel Speed mm / sec.	Heat input kJ / mm		
1~n	MMA	3.2 mm	80 ~ 110	20 ~ 25	DCEP	--	Approx. 1 ~ 3	0.43 ~ 2.20		
Filler metal classification and trade name: Kobelco LB-52 BSEN ISO 2560 : 2009-A-E 42 3 B 1 2 H10/ AWS A5.1 E7016										
Any special baking or drying: Dry the electrodes at 300~350°C for 30~60 minutes before use										
Gas / Flux	Shielding:	N/A			Gas flow rate:	Shielding:	N/A			
	Backing:	N/A				Backing:	N/A			
Tungsten electrode type / size: N/A										
Detail of backing / gouging: N/A										
Preheat temperature: N/A						Interpass temperature: Max. 250 °C				
Post-heating: N/A										
Post weld heat treatment and / or ageing: N/A						Pre-heat maintenance temperature: N/A				
<i>Other information:</i>										
Weaving (maximum width of run):						Approx. 9 mm				
Oscillation: amplitude, frequency, dwell time:						N/A				
Pulse welding details:						N/A				
Distance contact tube / work piece:						N/A				
Plasma welding details:						N/A				
Torch angle:						N/A				
Stick out length:						N/A				
Nozzle size:						N/A				



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### PRELIMINARY WELDING PROCEDURE SPECIFICATION (pWPS)

Report No.:	1808353-1	Rev.:	0	Amd.:	0	Issued Date:	10 July, 2018	Page	2 of 2	Pages
<b>Extent of Approval :-</b>										
Qualification Standard:	BSENISO 15614-1:2004+A2:2012									
Welding process(es):	Metal arc welding with covered electrode (111) (DCEP)									
Type of joint and weld:	Fillet weld qualifies fillet welding only.  It is not permitted to change a multi-run deposit into a single run (or single run on each side) or vice versa for a given process.  Same as the test.									
Parent metal group(s) and sub group(s):	PD CEN ISO TR 15608 : 2005 Group 1.1 welded to Group 1									
Parent metal thickness (mm):	t1 = 4 mm ~ 16 mm ; t2 ≥ 5 mm									
Weld metal thickness(mm) and filler weld size(mm):	No restriction for multi-run									
Outside diameter (mm):	≥ 50 mm									
Electrode identification:	Type used in welding condition									
Gas/Flux:	--									
Gas flow rate :-	--									
Mode of metal transfer:	--									
Heat input:	The lower limit of heat input qualified is 25% lower than that used in welding test piece.									
Welding position:	All positions except vertical down									
Preheat:	--									
Post weld heat treatment and/or ageing:	--									
<b>Test for qualification tests:</b>										
<b>Non-destructive tests:</b>		Visual Test Magnetic Particle Test								
<b>Destructive tests:</b>		Macroscopic Examination Hardness Test								
<b>Remark:</b>										
1. If all required weld test were accepted, a final welding procedure certification (Welding Procedure Approval Record) will be issued. 2. The welder who undertake and satisfied this welding procedure, relevant part of welder certificate will also be issued. 3. This procedure defines the limitation and the range of welding condition which is stated in extend of approval. 4. This document is prepared and based on customer information.										
Prepared by examining body:						Confirmed by manufacturer:				
 Tang Siu Man						 on behalf of				
Qualification: CSWIP 3.1 Welding Inspector										