

工程指示 / 要求簡箋(E.I.)

工程指示編號：EI / 3009 / 21

修改版次：-

工程編號：J - 852

工程名稱：亞皆老街中電

工程項目：驗焊 Welding Procedure 用鐵件

收件人：Maggie

發件人：Ant Yeung

日期：28/01/2021

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 |

內容：

請按加工圖訂購鐵件 送地盤驗焊 不用浸鉛水

1. 70x70x6.3 鐵通 S355J0H 5 件

2. 300x300x32 鐵通 S355J0 5 件

林賢仁 羅汝光 王建聰 馮振朗 謝謝

請在 2021.02.05 前完成上列要求。

附：1 頁 BM

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：

- | | | | |
|--|---|--|---|
| <input type="checkbox"/> 生產技術總監 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 技術部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 生產部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 機械設計部 <input type="checkbox"/> 連附件 |
| <input type="checkbox"/> 採購部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 生產統籌部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 小羅&清 <input type="checkbox"/> 連附件 | |
| <input type="checkbox"/> 質檢部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 會計部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 報關組 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 其他 <u>楊榮輝</u> <input type="checkbox"/> 連附件 |

分發其他分判：

- (v) 水洪 連附件

分發香港各部門：

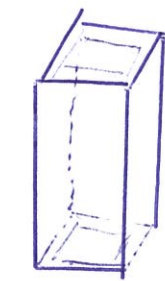
- | | | | | | |
|---|--|---|--|--|--|
| <input type="checkbox"/> 行政部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 會計部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 統籌部 <input type="checkbox"/> 連附件 | <u>林哥</u> <input type="checkbox"/> 連附件 | <input type="checkbox"/> 工程地盤科文 <input type="checkbox"/> 連附件 | <u>祥哥</u> <input type="checkbox"/> 連附件 |
| <input type="checkbox"/> 採購部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> QS 部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 維修部 <input type="checkbox"/> 連附件 | <input type="checkbox"/> 其他 _____ <input type="checkbox"/> 連附件 | | |

傳遞編號：

HK / 21

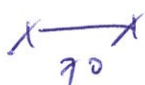
發件人簽署：

項目經理簽署：



200長

S355 J04

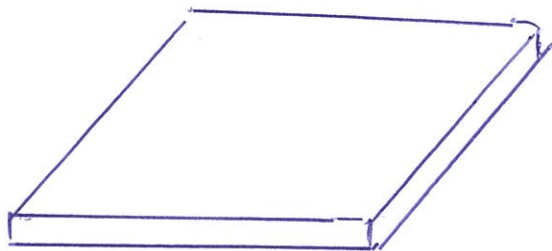


70 x 70 x 6.3

全長 L = 200長

5件

32 厚



S355 J0



300

300 x 300 x 32厚

5件

共 54 件

不用焊接



Qualitech Testing & Consultancy Limited

匯駿檢測及顧問有限公司

Flat E & F, 9/F, Block B, Universal Industrial Centre, 19-25 Shan Mei Street, Sha Tin, Hong Kong.

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ei 3009

PRELIMINARY WELDING PROCEDURE SPECIFICATION (pWPS)

Report No.:	2101218-1	Rev.:	0	Amd.:	0	Issued Date:	27 January, 2021	Page	1 of 2	Pages
Application Standard:	BS EN ISO 15609-1:2004									
pWPS no.:	2101218-1R0A0									
Manufacturer:	Gammon Engineering & Construction Company Limited (Main Contractor) / Midi Aluminium Fabricator Ltd.									
Project:	Proposed Residential Development at 139-147 Argyle Street, Kowloon - K.I.L. 6038 R.P., K.I.L. 6037 R.P., K.I.L. 6036 R.P., K.I.L. 6035 R.P. and K.I.L. 6005									
Joint type and weld type:	T joint fillet weld in pipe to plate									
Welding positions:	Vertical up (PF)					Material thickness (mm): t1: 6.3; t2: 32				
Parent material specification:	BSEN 10210-1:2006 Designation S355J0H (1.2)					Outside diameter (mm): 70				
	BSEN 10025-2:2004 Designation S355J0 (1.2)									
Method of preparation and cleaning:	Flame cut followed by mechanical grinding					Mode of metal transfer: --				
Weld preparation details (Sketch)*:										
Joint preparation (mm)					Run sequence					
<p>Gap max. 2 mm (Referred to EN ISO 9692-1:2003 Table 3)</p>					<p>6 mm leg length fillet weld</p>					
t1 : 70 x 70 x 6.3 thk. x 200L S.H.S. t2 : 300 x 300 x 32 thk. Steel Plate					S355J0H S355J0					
Welding details:										
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 ~ 120	20 ~ 25	AC	--	Approx. 1 ~ 3	0.43 ~ 2.40		
Filler metal classification and trade name: Kobelco LB-52 BS EN 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					
Other information:										
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. :	2101218-1	Rev.:	0	Amd.:	0	Issued Date:	27 January, 2021	Page	2 of 2	Pages
Extent of Approval :-										
Qualification Standard:	BS EN ISO 15614-1:2004+A2:2012									
Welding process(es) :	Metal arc welding with covered electrode (111) (AC) (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, 1.2 welded to Group 1									
Parent metal thickness (mm) :	t1: 3.15 mm ~ 12.6 mm & t2: ≥5mm									
Weld metal thickness(mm) and filler weld size(mm) :	No restriction for multi- run									
Outside diameter (mm) :	≥ 35 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 :	--									
Test for qualification tests :										
<i>Non-destructive tests :</i>	Visual Test Magnetic Particle Test									
<i>Destructive tests :</i>	Macroscopic Examination Hardness Test									
Remark :										
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 extent of approval.										
4. This document is prepared and based on customer information.										
Prepared by examining body:						Confirmed by manufacturer:				
										
Tang Siu Man										
Qualification : CSWIP 3.1 Welding Inspector						on behalf of				



CONSTRUCTION
INDUSTRY COUNCIL
建造業議會

建造業工人註冊證
Construction Workers Registration Card

註冊編號
Registration No. CWR06064039

林賢仁
Lam Yin Yan

簽發日期
Issue Date 03-07-2020
有效日期
Expiry Date 02-07-2025



此證是根據《建造業工人註冊條例》(第583章)發出。非法使用他人註冊證屬嚴重刑事罪行。 This card is issued under the Construction Workers Registration Ordinance (Cap. 583). Unlawful use of another person's registration card is a serious criminal offence.



建造業安全訓練證明書
Construction Industry Safety Training Certificate

工廠及工業經營條例第6BA(2)條

Section 6BA(2) of the Factories and Industrial Undertakings Ordinance

持證人姓名 Holder's Name

(中文): 林賢仁
(English): Lam Yin Yan

編號 Reference No.: HRKT0215346R

完成課程日期 Date of Course Completion: 10/07/2020
(日/月/年) (dd/mm/yyyy)

有效期限 Validity Period: from 25/10/2020
(日/月/年) (dd/mm/yyyy)

to 24/10/2023



本證明書由香港人力資源有限公司簽發 Issued by Hong Kong Human Resources Ltd.
此證明書須由持證人擁有及保存。 This certificate is owned and should be kept by the certificate holder.

香港永久性居民身份證

HONG KONG PERMANENT IDENTITY CARD

林賢仁
LAM, Yin Yan

P435927

2651 6343 0088

出生日期 Date of Birth
25-03-1962 男 M

***AX

簽發日期 Date of Issue
(11-94)

03-10-20 P435927(9)



中級工藝測試證明書
Intermediate Trade Test Certificate

持証人姓名 Holder's Name :

(中文 Chinese) : 王建聰

(英文 English) : WONG, Kin Chung

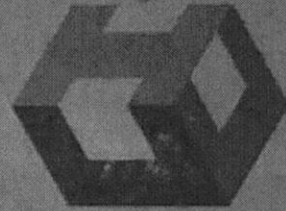
編號 Reference No. : B113024

工種及頒授年份 Trade and Year of Certification :

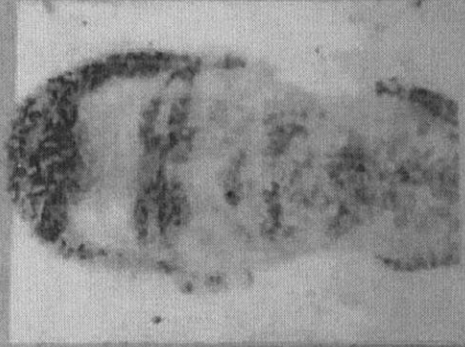
請參閱背頁

Please turn overleaf to read the information

本證書發給由 Issued by:



CONSTRUCTION
INDUSTRY COUNCIL
建造業議會



Lee Shing See

李承仕 金紫荊星章, OBE, 太平紳士, 主席
LEE Shing See, GBS, OBE, JP, Chairman



CONSTRUCTION
INDUSTRY COUNCIL
建造業議會

建造業工人註冊證

Construction Workers Registration Card

註冊編號
Registration No. CWR06101184

馮振郎
Fung Zhen Luang

簽發日期
Issue Date 09-11-2018
有效日期
Expiry Date 29-05-2021



此證是根據《建造業工人註冊條例》(第583章)發出。非法使用他人註冊證屬嚴重刑事罪行。 This card is issued under the Construction Workers Registration Ordinance (Cap. 583). Unlawful use of another person's registration card is a serious criminal offence.



建造業安全訓練證明書

Construction Industry Safety Training Certificate

工廠及工業經營條例第6BA(2)條

Section 6BA(2) of the Factories and Industrial Undertakings Ordinance

持證人姓名 Holder's Name

(中文): 馮振郎
(English): Fung Zhen Luang

編號 Reference No.: HRJD0467342R

完成課程日期 Date of Course Completion: 14/12/2020
(日日/月月/年年年年) (dd/mm/yyyy)

有效期限 Validity Period: 由 from 31/12/2020
(日日/月月/年年年年) (dd/mm/yyyy)

至 to 30/12/2023 止



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