

工程指示 / 要求簡箋 ENGINEER INSTRUCTIONS(E.I.)

工程指示編號:	EI- 5186	修改版本:	-
	HK-		
工程編號:	J 853	工程名稱:	大窩坪 (延坪道)
收件人:	Maggie Lor	發件人:	Edwin Ho
工程項目:	Welding Procedure & Welder's Qualification Test Cert. (Curtain Wall)用鐵件 (3套)	日期:	11/10/2022

<input type="checkbox"/> 原合約工程包	<input type="checkbox"/> 原合約工程加 / 減賬 QT-	<input type="checkbox"/> 新工程報價 QT-
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信件批核號碼/圖紙參考編號:	批核模具圖紙編號:
客戶指示附件:	管理內部批簽署:

<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:		

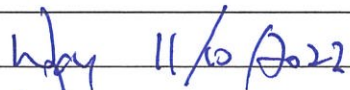

內容: 請附件訂購鐵件送QTC火炭公証行 驗焊, 不用浸鉛水。預3位師傅進行測試。 1. 80 x 80 x 6mm thk. x 200mm Long R.H.S. (3件) 2. 250 x 250 x 10mm thk. Steel Plate (3件) 送貨和考核場地: 火炭坳背灣街34-36號- 豐盛工業中心A座地下11號舖 (桂林街及穗禾路交界) 收貨人: 盧先生 6221 7812 完成上列要求日期: 18/10/2022

國內

<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"/> 採購部	<input type="checkbox"/> 連附件	<input checked="" type="checkbox"/> 生產統籌部	<input checked="" type="checkbox"/> 連附件	<input type="checkbox"/> 報關組	<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"/> 機械設計部	<input type="checkbox"/> 連附件
<input checked="" type="checkbox"/> 香港辦	<input checked="" type="checkbox"/> 連附件	<input type="checkbox"/> 其他:			

香港

<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	<input type="checkbox"/> 工程部	<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 checked="" type="checkbox"/> 地盤管理	<input checked="" type="checkbox"/> 連附件	<input type="checkbox"/> 維修部	<input type="checkbox"/> 連附件

*發件人簽署: Edwin Ho	*組別成員批核簽署: 
傳遞編號:	項目經理簽署: 



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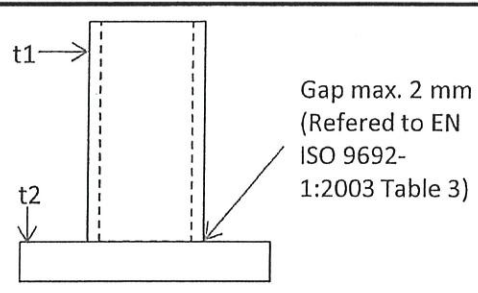
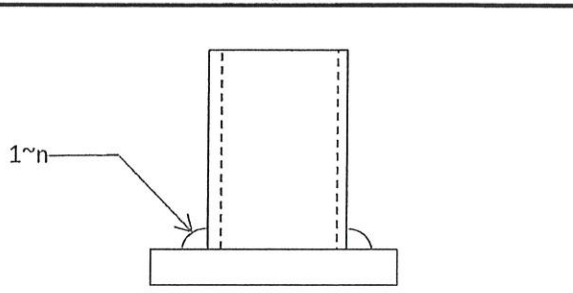
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E2/5166

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PRELIMINARY WELDING PROCEDURE SPECIFICATION (pWPS)

Report No. :	2209023-1	Rev.:	0	Amd.:	0	Issued Date:	07 October, 2022	Page	1 of 2	Pages
Application Standard:	BS EN ISO 15609-1:2004									
pWPS no.:	2209023-1R0A0									
Manufacturer:	Hip Hing Construction Co., Ltd (Main Contractor) / Midi Aluminium Fabricator Ltd.									
Project:	Proposed Residential Development at NKIL6542, Yin Ping Road, Tai Wo Ping, Kowloon, Hong Kong									
Joint type and weld type:	T joint fillet weld in pipe to plate									
Welding positions:	Vertical up (PF)					Material thickness (mm): t1: 6 ; t2: 10				
Parent material specification:	BSEN 10210-1:2006 Designation S275J0H (1.1)					Outside diameter (mm): 80				
	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>										
t1 : 80 x 80 x 6mm thk. x 200mm Long R.H.S.					6 mm leg length fillet weld					
t2 : 250 x 250 x 10mm 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	90 ~ 130	22 ~ 26	AC	--	Approx. 1 ~ 3	0.53 ~ 2.70		
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. 10mm					
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. :	2209023-1	Rev.:	0	Amd.:	0	Issued Date:	07 October, 2022	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 welded to Group 1									
Parent metal thickness (mm) :	t1: 3 mm ~ 12 mm & t2: 5 mm ~ 20 mm									
Weld metal thickness(mm) and filler weld size(mm) :	No restriction for multi- run									
Outside diameter (mm) :	≥ 40mm									
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 extend of approval.										
4. This document is prepared and based on customer information.										
Prepared by examining body:						Confirmed by manufacturer:				
										
Lo Chun Wing						on behalf of				
Qualification : CSWIP 3.1 Welding Inspector										