

工程指示 / 要求簡箋(E.I.)

工程指示編號：EI / 5013 / 22

修改版次： -

工程編號： J - 858

工程名稱：將軍澳日出康城 11

工程項目：Welding procedure 和 welder cert 公証行 驗焊安排

收件人：Maggie

發件人：Ant Yeung

日期：19/08/2022

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 BD 要求進行 Welding procedure 和 welder cert 公証行 驗焊安排。

BD 入則 1 份。(趟門已入幕牆則)

判頭 3 個。 T1 T2 CW 預 師父 4 人

T3 CW 預 師父 2 人

趟門 預 師父 6 人

開工前要出 Welder cert 牌謝謝

共 2 人

請在 2022.08.31 前完成上列要求。

附： 頁

原合約工程包

原合約工程加 / 減賬

新工程報價

分發東莞各部門：貴司速速已於昨日取票。謝謝留意

- |                                 |                              |                                |                              |                               |                              |                                 |                              |
|---------------------------------|------------------------------|--------------------------------|------------------------------|-------------------------------|------------------------------|---------------------------------|------------------------------|
| <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 楊榮輝 | <input type="checkbox"/> 連附件 |
| <input type="checkbox"/> BUN    | <input type="checkbox"/> 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 | <input type="checkbox"/> 工程部地盤科文 | <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 / 22

發件人簽署：

項目經理簽署：

Ref : BD 3/7192/97/11(C2)

Address : Tseung Kwan O Area 86, Site C2, Tseung Kwan O, N.T. - TKOTL 70 R.P.

Appendix III to approval dated 2 December 2020

### **Curtain Wall Works**

In giving this approval of plans, I hereby impose the following conditions under item 6 in section 17(1) of the Buildings Ordinance:

- (a) Safety test on a representative portion of the proposed curtain wall system should be carried out in accordance with the Practice Note for Authorized Persons, Registered Structural Engineers and Registered Geotechnical Engineers (PNAP) APP-37 and the Code of Practice for the Structural Use of Glass 2018. The test should be carried out by an independent laboratory\* accredited by the Hong Kong Laboratory Accreditation Scheme (HOKLAS) or by other laboratory accreditation bodies which have reached mutual recognition agreements/arrangements with HOKLAS. The test results<sup>@</sup> should be appended with a statement signed by the Registered Structural Engineer and submitted prior to the application of occupation permit or the submission of Form BA14 as appropriate to confirm that the acceptance criteria appropriate to the test have been complied with.

- (b) Where steel welding is used for the connection of the curtain wall supports, welding procedures and welders should be assessed/tested in accordance with the appropriate provisions of the Annex A to the Code of Practice for the Structural Use of Steel 2011.

2. The following conditions in respect of qualified supervision of works are imposed under item 6 in section 17(1) of the Buildings Ordinance:

- (a) Qualified site supervision of the curtain wall works, including fabrication, erection and examination of the structural elements/fixings, by experienced and competent persons as defined in (b) and (c), should be provided to ensure that the works are carried out in accordance with the plans approved and that the required standards are complied with.
- (b) The Registered Structural Engineer should assign a quality control supervisor to supervise the works, determine the necessary frequency of inspection by the quality control supervisor which should not be less than once a week, and devise inspection check lists. The minimum qualifications and experience of the quality control supervisor is to be the same as the Technically Competent Person of grade T3 under the Registered Structural Engineer's stream, as stipulated in the Code of Practice for Site Supervision 2009.
- (c) The Registered General Building Contractor should assign a quality control co-ordinator to provide full time on site supervision of the works and devise inspection check lists. The minimum qualifications and experience of the quality control co-ordinator is to be the same as the Technically Competent Person of grade T1 under the Registered General Building



# Qualitech Testing & Consultancy Limited

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Tel : (852) 2185-0900 Fax : (852) 2687-6752 Website : www.qtc-hk.com E-mail : qtc@qtc-hk.com

*Handwritten notes:*  
 2009  
 參考  
 2009  
 2009

## 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):					
	BSEN 10025-2:2004 Designation S355J0 (1.2)						70					
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>												
t1 : 70 x 70 x 6.3 thk. x 200L S.H.S.						6 mm leg length fillet weld						
t2 : 300 x 300 x 32 thk. Steel Plate												
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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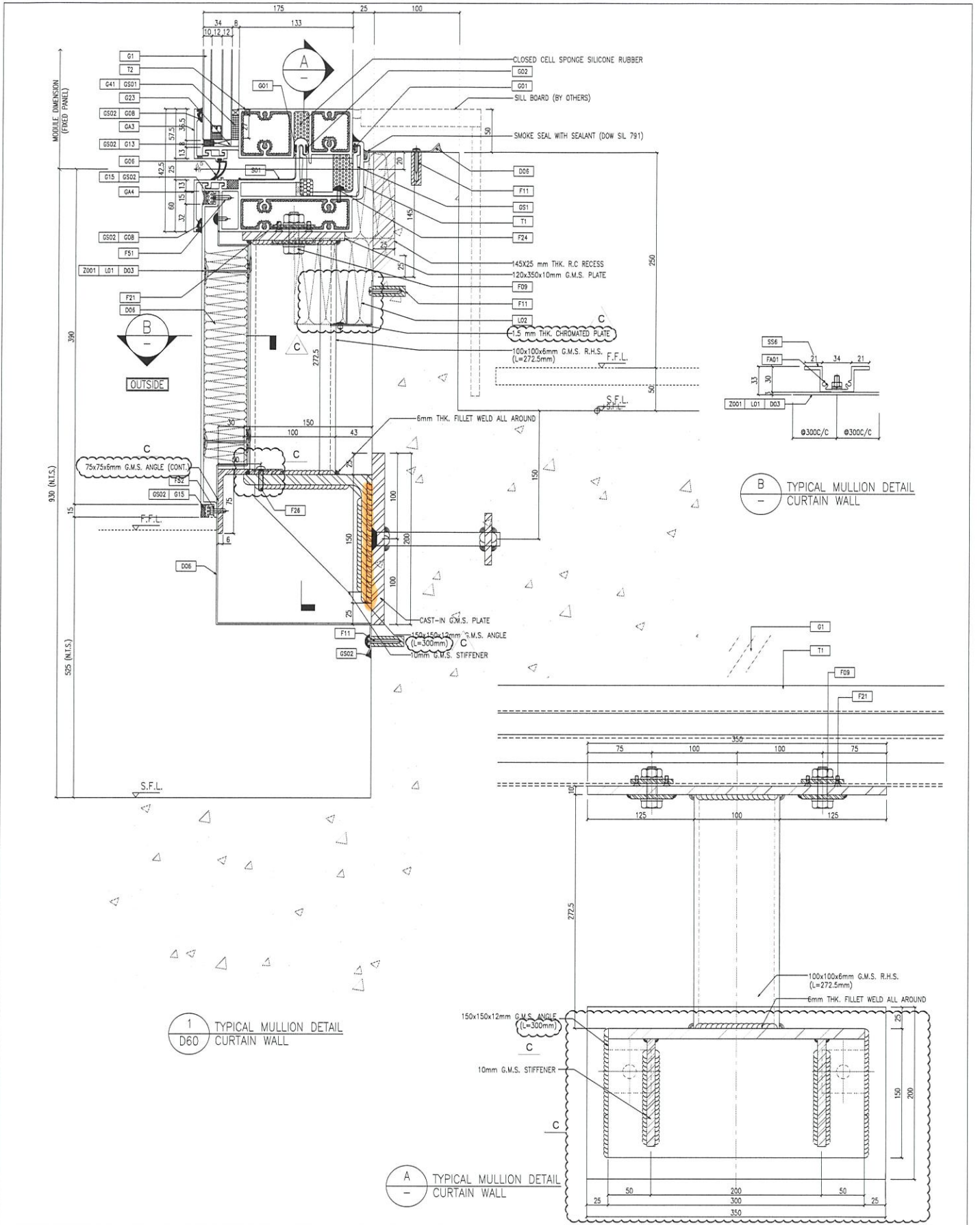
新界火炭山尾街19-25號宇宙工業中心B座9樓E&F室

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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	
<b>Extent of Approval :-</b>											
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:	--										
<b>Test for qualification tests:</b>											
<i>Non-destructive tests:</i>	Visual Test Magnetic Particle Test										
<i>Destructive tests:</i>	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 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					





1 D60 TYPICAL MULLION DETAIL CURTAIN WALL

B TYPICAL MULLION DETAIL CURTAIN WALL

A TYPICAL MULLION DETAIL CURTAIN WALL

BLD. REF. : ARCHITECT : <b>ronald lu &amp; partners</b> Ronald Lu & Partners (HK) Ltd. 呂元仲建築師事務所 (香港) 有限公司 MAIN CONTRIBUTOR : CLIENT : <b>信和置業有限公司</b> Sino Land Company Limited	STRUCTURAL ENGINEER : <b>Gammon</b> AECOM HEADLINE CONSULTANT: <b>AECOM</b>	PROJECT : PROPOSED RESIDENTIAL DEVELOPMENT AT HOUL TONG PHASE 11, LOHAS PARK TSEUNG KWAN O, N.T.	JOB NO. : J-858	DATE : 22-OCT-21	DRAWN BY : <b>黃特銘</b> Checked by : DATE : 22-OCT-21 SCALE : 1:2(A1)	C 22/07/21 REVISION AS PER COMMENTS U.S.	B 25/07/21 REVISION AS PER COMMENTS U.S.	A 22/12/21 REVISION AS PER COMMENTS U.S.	NO. DATE REVISION BY
						1. ALL DIMENSIONS ARE IN mm. 2. ALL EXTENSIONS ARE VIEWED FROM OUTSIDE. 3. BETTER FABRICATION.	LEGEND: (X1) DETAIL MARK NO. (RND) REFER SHEET NO. 1. F.F.L. -- FINISHED FLOOR LEVEL 2. S.F.L. -- STRUCTURAL FLOOR LEVEL 3. (R) -- REVERSED DETAIL		



