



工程指示 / 要求簡箋(E.I.)

工程指示編號：EI / 5082 / 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 公証行測試用鐵件
 收件人 : Maggie 木椅 發件人 : Ant Yeung 日期 : 08/09/2022

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 :

請訂購鐵件。送 OTC 火炭公証行，預 12 位師父進行測試

1. 350x150x12 mm ThK 2 件
2. 150x150x12 mm ThK 26 件 (22+4 後備)
 S275 J0 不熱浸，不需黑油 謝謝

請在 2022.09.16 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 | <u>楊榮輝</u> <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 checked="" type="checkbox"/> 統籌部 | <input checked="" type="checkbox"/> 連附件 | <input type="checkbox"/> 工程部地盤科文 | <input type="checkbox"/> 連附件 |
| <input checked="" type="checkbox"/> 採購部 | <input checked="" 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：

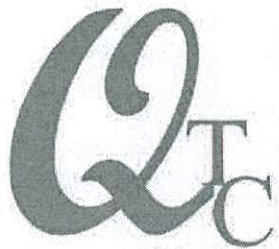
HK / 22

發件人簽署： 

項目經理簽署： 

地址: 尖沙咀: 桂地街24号丰盛工业中心地下

地舖



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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收貨和考核場地

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收貨人: 詹先生

PRELIMINARY WELDING PROCEDURE SPECIFICATION (pWPS) 62217812

Report No. :	2207585-1	Rev.:	0	Amd.:	0	Issued Date:	26 August, 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											

5

FI 5082

From: Lo Chun Wing <cw.lo@qtc-hk.com>
To: "midipur@midiltd.com.hk" <midipur@midiltd.com.hk>
Subject: RE: J-858 日出康街 : Welding Procedure
Date sent: Fri, 26 Aug 2022 10:50:10 +0000

156814

Dear Eva,

FYI, pWPS for Lohas Park, Tseung Kwan O

Test Piece for the test : 350x150x12mm steel plate 2pcs. (Welding Procedure Test)
150x150x12mm steel plate 22pcs. (Welder Qualification Test) 287-

Looking forward to entering into a business relationship with you. Please call me any time if you have any questions.

Sincerely,

Mr Lo

Tel: (+852) 62217812

Email: cw.lo@qtc-hk.com



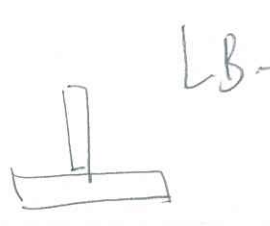
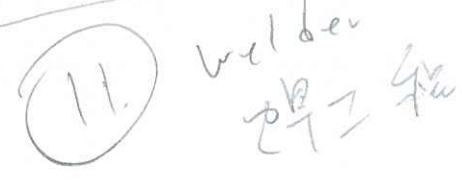
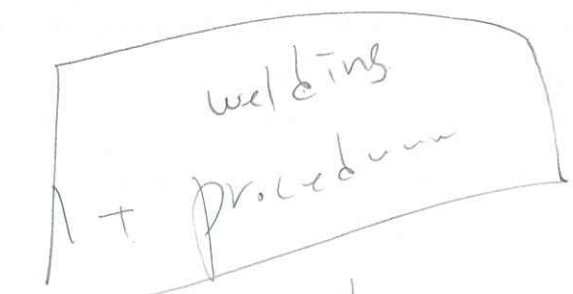
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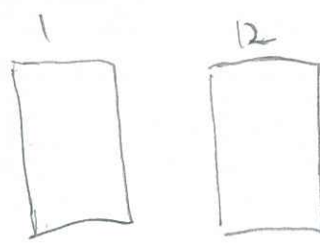


From: midipur@midiltd.com.hk <midipur@midiltd.com.hk>

Sent: Friday, August 26, 2022 12:38 PM

To: Lo Chun Wing <cw.lo@qtc-hk.com>

Subject: J-858 日出康街 : Welding Procedure



Dear Mr. Lo,

有關今早電話溝通, 資料如下:

鐵板 : S275J0

焊枝 : LB52, 直徑 : 3.2mm

共12套

謝!

Eva

MIDI Aluminium Fabricator Ltd., Tel:(852) 2348 9211, Fax:(852) 2772 7666

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PRELIMINARY WELDING PROCEDURE SPECIFICATION (pWPS)

Report No. : 2207585-1	Rev.: 0	Amd.: 0	Issued Date: 26 August, 2022	Page 1 of 2 Pages					
Application Standard:	BS EN ISO 15609-1:2004								
pWPS no.:	2207585-1R0A0								
Manufacturer:	Gammon Engineering & Construction Co., Ltd. (Main Contractor) / Midi Aluminium Fabricator Ltd.								
Project:	Proposed Residential Development at TKOTL 70RP, Phase 11, Lohas Park, Tseung Kwan O								
Joint type and weld type:	T joint fillet weld in plate								
Welding positions:	Horizontal overhead (PD)	Material thickness (mm): 12							
Parent material specification:	BS EN 10025-2:2004 Designation S275J0 (1.1)	Outside diameter (mm): --							
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>12mm(t1) 12mm(t2) Gap max. 2 mm (Referred to EN ISO 9692-1:2003 Table 3)</p>		<p>1~n 6 mm leg length fillet weld</p>							
t1 : 350L x 150W x 12mm thk. Steel Plate									
t2 : 350L x 150W x 12mm 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	90 ~ 130	22 ~ 26	AC	--	Approx. 1 ~ 3	0.53 ~ 2.70	
Filler metal classification and trade name:					Kobelco LB-52 / AWS A5.1 E7016 / BS EN ISO 2560:2009-A-E 42 3 B 1 2 H10				
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. 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				



Qualitech Testing & Consultancy Limited

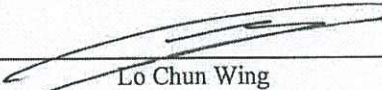
匯駿檢測及顧問有限公司

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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 & t2 : 6 mm ~ 24 mm									
Weld metal thickness(mm) and filler weld size(mm) :	No restriction for multi-run									
Outside diameter (mm) :	Plates also covers pipes when the outside diameter is > 500 mm or when the diameter is > 150 mm welded in the PA or PC rotated position									
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 :										
Non-destructive tests :		Visual Test Magnetic Particle Test								
Destructive tests :		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:				
						_____				
Qualification : CSWIP 3.1 Welding Inspector						on behalf of				