



中国船级社

CHINA CLASSIFICATION SOCIETY

(证书分社)

焊接工艺认可报告

REPORT OF WELDING PROCEDURES

工作证号: J40-100-2238A31

兹证明应泰兴市华申船舶设备有限公司的申请,下列署名的检验师于2018年12月27日及以后诸日,对该公司所申请的焊接工艺进行了确认。

THIS IS TO CERTIFY that at request of Taixing Expansion Marine Equipments Co., Ltd. the undersigned did attend the approval test for the welding procedure on Dec.27.2018 and subsequent dates.

试验依据

Rules and regulations

1. 中国船级社《材料与焊接规范》(2018)及其修改通报

CCS (RULES FOR MATERIALS AND WELDING) (2018) as amended

2. 中国船级社《船舶焊接检验指南》(2017)

CCS (GUIDELINES FOR INSPECTION OF HULL WELDS) (2017)

二、认可试验项目

Test items

序号 No.	试验编号 Test No.	焊接方法 Welding Procedure	钢材等级 Steel Grade	厚度 Thickness (mm)	接头形式 Joint Type	焊接材料 Welding Material	焊接位置 Welding Position
1	YKP-2018-WPS-CCS-001	FCM		14	butt	CE71T-1/ 1.2/2Y	平角焊
2	YKP-2018-WPS-CCS-002	FCM	DH6	14	butt	CE71T-1/ 1.2/2Y	横焊 II
3	YKP-2018-WPS-CCS-003	FCM	DH6		butt	CE71T-1/ 1.2/2Y	平角焊
4	YKP-2018-WPS-CCS-004	FCM	DH6		butt	CE71T-1/ 1.2/2Y	横焊 II
5	YKP-2018-WPS-CCS-005	FCM	DH6	14	fillet	CE71T-1/ 1.2/2Y	平角横焊
6	YKP-2018-WPS-CCS-006	FCM	DH6	14	Fillet	CE71T-1/ 1.2/2Y	立位上角横焊 II

三、认可焊接工艺的适用范围

Application of approved welding procedure

按照 CCS《材料与焊接规范》(2018)第3篇第3章第3.1.4条及其修改通报确定。

According to the Section 3.1.4, Chapter 3, Part Three of CCS (RULES FOR MATERIALS AND WELDING) (2018), as amended

四、结论

Conclusion

上述焊接工艺认可项目符合 CCS《材料与焊接规范》(2018)及其修改通报的要求,予以认可。

The foregoing welding procedures are in accordance with the requirements of CCS (RULES FOR MATERIALS AND WELDING) (2018) as amended and the welding procedures are approved.

五、本报告附录

Appendices of the report include

1. 《焊接工艺规程》(WPS)

(Welding procedure specification) (WPS)

编号: YKP-2018-WPS-CCS-001~YKP-2018-WPS-CCS-006

2. 《焊接工艺评定报告》(WPQR)

(Welding procedure qualification report) (WPQR)

编号: YKP-2018-WPS-CCS-001~YKP-2018-WPS-CCS-006

签发日期

Issued at

签发日期

Issued on



2019年07月31日

(Yiu yu)

中国船级社检验师

Surveyor to CCS