



Quality Assurance Plan for off-site Steel H-Pile Fabrication

Guangzhou KYH Metal Co., Ltd.

Revision: 1.0

Date: March 2026

Prepared by: Mr. Yao Jiangtao / IWE Welding Engineer

Approved by: Mr. He Jianjun/Production Manager & Management Representative

廣州金源行金屬有限公司
Guangzhou KYH Metal Co., Ltd.



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1. Introduction

This Quality Assurance Plan (QAP) covers the off-site fabrication of steel H-pile with strengthening plates and/or shear studs Welding. It is prepared in accordance with the contract specifications and the Code of Practice for the Structural Use of Steel. The plan integrates internal quality-control system with independent acceptance inspections to ensure that all materials, processes, and personnel meet specified quality levels. All welding procedures and welder qualifications will comply with COP requirements; NDT tests are certified by a HOKLAS-accredited body as required by the Code.

2. Organization and Responsibilities

- Production Manager (Management Representative): Overall authority for implementing this QAP and ensuring compliance with all quality standards. Oversees production, assigns resources, and interfaces with the Registered Engineer (IWE) and client. Reports quality issues to senior management.
- International Welding Engineer (IWE): Develops and approves welding procedures (WPS) and qualifications. Reviews applicable welding codes and ensures our WPS meet AWS/EN and Hong Kong COP requirements. Verifies that welding equipment is properly set up and that welding consumables are certified.
- Certified Welding Inspector (CWI): Conducts visual inspections during and after welding. Witnesses all weld procedure qualification (WPQR) tests and welder qualification tests. Verifies that welds meet acceptance criteria and that NDT is performed by qualified personnel. Reports findings to the Quality Manager.
- Welders: Perform welding and stud attachment according to approved WPS and qualified processes. Only certified welders (qualified per COP Annex A) are permitted to weld structural H-pile components.
- Quality Manager: Manages the QAP on a daily basis. Develops inspection and testing plans, coordinates audits, and maintains quality records. Chairs internal quality meetings and ensures corrective actions are carried out for any non-conformances.
- QC Inspectors: Perform in-process dimensional checks (length, straightness, hole alignment), verify material identification, and inspect fit-up and tack welds. Carry out final visual (VT) and NDT inspections according to the QAP. Coordinate with third-party inspectors to ensure all checks are completed before shipment.

3. Fabrication Process and Equipment

- 3.1 The fabrication flow follows approved shop drawings and procedures. Key steps include material marking, cutting, end-preparation, assembly, welding, and finishing of H-pile members.
- 3.2 Stud Welding: We use Nelson Nelweld 6000 machines for stud welding. Stud attachments are performed by trained operators using qualified settings. All stud welds are visually inspected upon completion.
- 3.3 Robotic Welding: Automated arc welding is performed with four Fanuc robotic stations. Two stations use Lincoln Power Wave AC/DC 1000SD power sources fitted with LSO (Long Stick-Out) submerged-arc welding torches. LSO technology extends the stick-out length (up to about 160 mm) and preheats the wire, which significantly increases the melt-off rate. In practice, LSO can nearly double the deposition rate compared to conventional SAW setups. The other two stations use standard Lincoln Power Wave R450 sources.
- 3.4 All welding equipment (robots, studs, torches) and accessories are maintained and calibrated per manufacturer guidelines. Consumables (wire, flux, studs) are verified against approved specifications and lot traceability is maintained.

4. Welding Procedures and Qualifications

- 4.1 Procedure Qualification: Welding procedure specifications (WPS) are developed based on applicable codes (e.g. AWS D1.1) and project requirements. Each WPS is verified by a Procedure Qualification Record (PQR) test on representative joint configurations. PQR tests are witnessed by the CWI and documented. Per Hong Kong practice, all WPQR results are approved by the IWE and copies of qualified procedures are submitted to the Responsible Engineer as required.
- 4.2 Welder Qualification: All welders are qualified by performance testing in accordance with COP Annex A. Qualification tests are carried out under the supervision of a qualified welding inspector and accredited by a HOKLAS-certified third party. Test coupons cover the required positions and material thickness ranges. Certificates of welder qualification are issued for successful candidates. Only certified welders with valid qualifications are permitted to weld the structural H-pile sections.
- 4.3 Consumables and Equipment: All welding consumables (electrodes, wires, fluxes) are approved for the specified steel grades and certified by the manufacturers. Welding machines are checked daily for proper

operation, and key parameters (voltage, current, etc.) are logged to ensure consistency.

5. Inspection and Testing

- 5.1 In-Process Inspection: QC inspectors verify dimensions (length, straightness, hole positions) at major fabrication stages. Joint fit-up, tack welds, and general assembly quality are checked before welding. Any discrepancies are corrected immediately.
- 5.2 Weld Inspection: Every weld receives 100% visual inspection (VE). For critical welds (such as butt and fillet welds joining pile sections and plates), 100% nondestructive testing is performed. This includes Magnetic Particle (MT) or Liquid Penetrant Testing (PT) for surface defects and Ultrasonic Testing (UT) for internal defects as specified. Inspection personnel are qualified (at least Level II) in the relevant NDT methods.
- 5.3 Third-Party Inspection: A HOKLAS-accredited third-party inspection agency independently verifies finished products. They perform overall visual audits of weld quality and witness selected NDT. All NDT is performed per the COP requirements and by HOKLAS-certified laboratories. Inspection reports are endorsed by the Registered Engineer and retained in the quality records.
- 5.4 Acceptance Criteria: All inspections follow acceptance criteria in the Hong Kong COP and contract documents. Welds must meet specified weld profile, penetration, and be free of rejectable discontinuities. Components are released for shipment only after passing all inspection criteria.

6. Material Control and Traceability

- 6.1 All steel H-pile sections and strengthening plates are procured with mill test certificates. Upon receipt, materials are inspected for correct grade, heat number, and condition. Each piece is labeled or tagged so that it can be traced throughout fabrication.
- 6.2 Completed members carry identification marking to trace back to original certificates. Welding history (WPS used and welder identity) is documented for each component.
- 6.3 Any nonconforming material (e.g. wrong grade, excessive damage) is segregated. A disposition (repair, return, or scrap) is decided by engineering or quality management and recorded.



7. Document Control

- 7.1 All quality documents (WPS, PQR, welder certificates, inspection records, NCRs, equipment calibration logs) are controlled. Documents are uniquely identified, dated, and revision-controlled. Superseded documents are archived.
- 7.2 Shop personnel work only from the latest approved drawings and procedures. Any revisions are issued through formal change notices.
- 7.3 Calibration certificates for instruments (UT equipment, gauges, welders) are maintained. Equipment is calibrated or checked at scheduled intervals.

8. Quality Records and Approval

- 8.1 Upon completion, all inspection reports, test certificates, and quality records are compiled into the project's Quality Record Pack. These records are available for review by the client or regulatory authorities.
- 8.2 Final acceptance of each fabrication batch occurs only after both internal QC and third-party inspections are passed. The Production manager (management rep) and Quality Manager sign off on the release. A third-party CWI also certifies that the items meet COP standards. Shipment is authorized only after this final approval.

9. Non-Conformance and Corrective Action

- 9.1 Any defect found during inspection or testing is recorded in a Non-Conformance Report (NCR). The NCR specifies the nature of the defect, its location, and its severity.
- 9.2 Corrective actions (e.g. weld repair, additional weld passes) are performed by certified personnel following approved methods. The repaired area is re-inspected and retested as required.
- 9.3 Completed NCRs are reviewed by the Quality Manager and Production manager to verify that corrective measures were effective. Preventive actions (such as retraining or procedure revisions) are implemented to avoid recurrence.

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Appendix A

Certificate CN11/31167

SGS

The management system of

Guangzhou KYH Metal Co., Ltd.

Unified Social Credit Code: 91440116766135435J

Business Registration Address: No. 16, Lianyun Road, East Zone, Guangzhou Economic & Technological Development District, Guangzhou City, Guangdong Province, P.R. China

Business Operation Address: No. 16, Lianyun Road, East Zone, Guangzhou Economic & Technological Development District, Guangzhou City, Guangdong Province, P.R. China

has been assessed and certified as meeting the requirements of
ISO 9001:2015

For the following activities

Cutting and sales of steel and aluminum products

This certificate is valid from 09 October 2023 until 08 October 2026 and remains valid subject to satisfactory surveillance audits.
Issue 5. Certified since 08 October 2011

Authorised by
Jonathan Hall
Global Head - Certification Services

SGS United Kingdom Ltd
Rosemore Business Park, Ellesmere Port, Cheshire, CH65 3EN, UK
t +44 (0)151 350-6866 - www.sgs.com

The certification information can be verified on the web site of Certification and Accreditation Administration of the People's Republic of China
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Appendix B

Certificate IATF 0469430

Certificate CN20/30310

The management system of

Guangzhou KYH Metal Co., Ltd.

No. 16, Lianyun Road, East Area, Guangzhou Economic & Technological Development District, Guangzhou City,
Guangdong Province, P. R. China

has been assessed and certified as meeting the requirements of

IATF 16949:2016

Edition 1

For the following Scope
Bilting and shearing of steel coils

EXCLUSIONS : 8.3 Product Design

3 Year certification is valid from 26 February 2023 until 25 February 2026 and remains valid subject to satisfactory surveillance audits.

Version no. 2. Current version updated 26 February 2023

Authorized by
Norman SHENG
Veto Power Authority

Contracted Office : SGS United Kingdom Ltd, Station Road, Oldbury, B89 4LN, UK.

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Appendix C



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Appendix C



廣州金源行金屬有限公司 Guangzhou KYH Metal Co., Ltd.



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Appendix D



Composite beams Welding Procedure Specification Lsit 焊接工艺规程矩阵表
Guangzhou KYH Metal Co.,Ltd

Item No. 序号	WPS No.	WPQR No. 支撑的WPQR	Wedling Process 焊接方法	Material Grade 材料级别	Range of Thickness (mm) 厚度范围	Type of Joint 接头类型	Welding Position 焊接位置	Testing Standard 应用标准	Remark 备注												
1	KYH-WPS-001	WIA50294	783	S460M and lower	≥4.75	Stud welding	PA	ISO14555:2017	For Ø19mm stud welding.												
2	KYH-WPS-002	WIA50299	783	S460M and lower	≥6.25	Stud welding	PA	ISO14555:2017	For Ø25mm stud welding.												
3	KYH-WPS-003	WIA50304	135 (semi-auto.)	S460M and lower	Plate: ≥5 Stud dia.: ≥19	FW	PB	ISO15613:2004	Could be used for Stud seam repair.												
4	KYH-WPS-004	WIA50306	135 (semi-auto.)	S460M and lower	Plate: ≥5 Stud dia.: ≥25	FW	PB	ISO15613:2004	Could be used for Stud seam repair.												
5	KYH-WPS-005	WIA50294	783	S460M and lower	≥5.5	Stud welding	PA	ISO14555:2017	For ø22mm stud welding.												
		WIA50299																			
6	KYH-WPS-006	WIA60059	135 (semi-auto.)	S460M and lower	t≥5	FW	PB	BS EN ISO 15614-1-2017													
7	KYH-WPS-007	WIA60064	135 (Mechanical)	S460M and lower	t≥5	FW	PB	BS EN ISO 15614-1-2017													
8	KYH-WPS-008	WIA60066	135 (auto.)	S460M and lower	t≥5	FW	PB	BS EN ISO 15614-1-2017													
9	KYH-WPS-009	WIA60069	121(auto.)	S460M and lower	t≥5	FW	PA	BS EN ISO 15614-1-2017													
10	KYH-WPS-010	WIA60072	136 (semi-auto.)	S460M and lower	15≤t≤60	BW	PA	BS EN ISO 15614-1-2017													
11	KYH-WPS-011	WIA60077	136 (Mechanical)	S460M and lower	15≤t≤60	BW	PA	BS EN ISO 15614-1-2017													
12	KYH-WPS-012	WIA60080	135 (auto.)+ 121(auto.)	S460M and lower	135: t≤20 121: t≤40	BW	PA	BS EN ISO 15614-1-2017													
13	KYH-WPS-013	WIA60083	136 (semi-auto.)+ 121(Mechanical)	S460M and lower	136: t≤20 121: t≤40	BW	PA	BS EN ISO 15614-1-2017													
14	KYH-WPS-014	WIA60088	135 (semi-auto.)	S460M+ B500B and lower	Rebar dia. 3-40 15≤t≤60	Flare+Fillet	PB	ISO15613:2004	Rebar longitudinal seam welding.												
Abbrev. <table style="width: 100%; border: none;"> <tr> <td style="width: 150px;">121</td> <td style="width: 20px;">=</td> <td>Submerged arc welding with solid wire electrode</td> </tr> <tr> <td>135</td> <td>=</td> <td>Metal active gas welding with solid wire electrode</td> </tr> <tr> <td>136</td> <td>=</td> <td>Metal active gas welding with flux cored electrode</td> </tr> <tr> <td>783</td> <td>=</td> <td>Drawn arc stud welding with ceramic ferrule</td> </tr> </table>										121	=	Submerged arc welding with solid wire electrode	135	=	Metal active gas welding with solid wire electrode	136	=	Metal active gas welding with flux cored electrode	783	=	Drawn arc stud welding with ceramic ferrule
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Appendix E



Welder Qualification Cert. Register
 Guangzhou KYH Metal Co., Ltd

Item No. 序号	Welder name 焊工姓名	Welder No. 焊工号	ID No. 身份证号	Process 焊接方法	Welder Cert. No. 焊工证书号	Date of Expired 有效期	Testing Standard 考证标准	Testing Authority 检验机构	Range of Qualification					Remark 备注
									Type of Weld 焊接类型	Welding Position 焊接位置	Material Grade per ISO 15608 材料类别	Filler material group 焊材类别	Range of Thickness and diameter (mm) 厚度及直径范围	
1	薛水城 Xue Shuicheng	0842	440106197711250367	783	WIA50295	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥4.75	Stud Dia. 19mm
2	薛水城 Xue Shuicheng	0842	440106197711250367	783	WIA50300	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥6.25	Stud Dia. 25mm
3	王岗 Wang Gang	1006	533221199710214514	783	WIA50296	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥4.75	Stud Dia. 19mm
4	王岗 Wang Gang	1006	533221199710214514	783	WIA50301	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥6.25	Stud Dia. 25mm
5	雷文彬 Lei Wenbo	1035	622722198404193815	783	WIA50297	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥4.75	Stud Dia. 19mm
6	邓明军 Deng Mingjun	1036	431021198911283953	783	WIA50303	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥6.25	Stud Dia. 25mm
7	邓明军 Deng Mingjun	1036	431021198911283953	783	WIA50298	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥4.75	Stud Dia. 19mm
8	雷文彬 Lei Wenbo	1035	622722198404193815	783	WIA50302	20 Oct. 2031	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥6.25	Stud Dia. 25mm
9	雷文彬 Lei Wenbo	1035	622722198404193815	135	WIA50307	20 Oct. 2031	ISO9606-1:2017	ETS	FW	PA,PB	1 to 11	NA	Stud Dia.: 25 to 50 Plate: ≥3	
10	雷文彬 Lei Wenbo	1035	622722198404193815	135	WIA50305	20 Oct. 2031	ISO9606-1:2017	ETS	FW	PA,PB	1 to 11	NA	Stud Dia.: 19 to 38 Plate: ≥3	
11	雷文彬 Lei Wenbo	1035	622722198404193815	135	WIA60060	14 Jan. 2029	ISO9606-1:2017	ETS	FW	PA,PB	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
12	姜子宇 Jiang Ziyu	1050	620402199903101330	135	WIA60061	14 Jan. 2029	ISO9606-1:2017	ETS	FW	PA,PB	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
13	杨志翔 Yang Zhihuang	1043	452122199211294513	135	WIA60062	14 Jan. 2029	ISO9606-1:2017	ETS	FW	PA,PB	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
14	莫方仁 Mo Fangren	1004	440882198905293917	135	WIA60063	14 Jan. 2029	ISO9606-1:2017	ETS	FW	PA,PB	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
15	姜子宇 Jiang Ziyu	1050	620402199903101330	135 (Mechanical)	WIA60065	14 Jan. 2032	ISO14732:2013	ETS	FW	PA,PB	1 to 11	NA	Plate: ≥3	
16	王岗 Wang Gang	1006	533221199710214514	135 (Automatic)	WIA60067	14 Jan. 2032	ISO14732:2013	ETS	FW	PA,PB	1 to 11	NA	Plate: ≥3	
17	文武 Wen Wu	0968	431121198804145235	135 (Automatic)	WIA60068	14 Jan. 2032	ISO14732:2013	ETS	FW	PA,PB	1 to 11	NA	Plate: ≥3	
18	王岗 Wang Gang	1006	533221199710214514	121 (Automatic)	WIA60070	14 Jan. 2032	ISO14732:2013	ETS	FW	PA,PB	1 to 11	NA	Plate: ≥3	
19	文武 Wen Wu	0968	431121198804145235	121 (Automatic)	WIA60071	14 Jan. 2032	ISO14732:2013	ETS	FW	PA,PB	1 to 11	NA	Plate: ≥3	
20	雷文彬 Lei Wenbo	1035	622722198404193815	136	WIA60073	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
21	薛水城 Xue Shuicheng	0842	440106197711250367	136	WIA60074	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
22	莫方仁 Mo Fangren	1004	440882198905293917	136	WIA60075	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
23	杨志翔 Yang Zhihuang	1043	452122199211294513	136	WIA60076	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Pipe dia.: 500 (Fixed) Pipe dia.: 75 (Rotating) Plate: ≥3	
24	姜子宇 Jiang Ziyu	1050	620402199903101330	136 (Mechanical)	WIA60078	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
25	薛水城 Xue Shuicheng	0842	440106197711250367	136 (Mechanical)	WIA60079	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
26	王岗 Wang Gang	1006	533221199710214514	135(Auto.)+ 121(Auto.)	WIA60081	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
27	文武 Wen Wu	0968	431121198804145235	135(Auto.)+ 121(Auto.)	WIA60082	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
28	雷文彬 Lei Wenbo	1035	622722198404193815	136+121 (Mechanical)	WIA60084	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
29	杨志翔 Yang Zhihuang	1043	452122199211294513	121 (Mechanical)	WIA60085	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
30	莫方仁 Mo Fangren	1004	440882198905293917	121 (Mechanical)	WIA60086	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
31	薛水城 Xue Shuicheng	0842	440106197711250367	121 (Mechanical)	WIA60087	14 Jan. 2032	ISO14732:2013	ETS	BW	PA	1 to 11	NA	Plate: ≥3	
32	雷文彬 Lei Wenbo	1035	622722198404193815	135	WIA60089	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Rebar dia.: ≥3 Plate: ≥3	Rebar for longitudinal seam weld only
33	莫方仁 Mo Fangren	1004	440882198905293917	135	WIA60090	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Rebar dia.: ≥3 Plate: ≥3	Rebar for longitudinal seam weld only
34	杨志翔 Yang Zhihuang	1043	452122199211294513	135	WIA60091	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Rebar dia.: ≥3 Plate: ≥3	Rebar for longitudinal seam weld only
35	姜子宇 Jiang Ziyu	1050	620402199903101330	135	WIA60092	14 Jan. 2029	ISO9606-1:2017	ETS	BW	PA	1 to 11	FM1,FM2	Rebar dia.: ≥3 Plate: ≥3	Rebar for longitudinal seam weld only
36	杨志翔 Yang Zhihuang	1043	452122199211294513	783	WIA60093	14 Jan. 2032	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥6.25	Stud Dia. 25mm
37	姜子宇 Jiang Ziyu	1050	620402199903101330	783	WIA60094	14 Jan. 2032	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥4.75	Stud Dia. 19mm
38	杨志翔 Yang Zhihuang	1043	452122199211294513	783	WIA60095	14 Jan. 2032	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥6.25	Stud Dia. 25mm
39	姜子宇 Jiang Ziyu	1050	620402199903101330	783	WIA60096	14 Jan. 2032	ISO14732:2013	ETS	Stud welding	PA	NA	NA	≥4.75	Stud Dia. 19mm

Abbrev.
 121 = Submerged arc welding with solid wire electrode
 135 = Metal active gas welding with solid wire electrode
 136 = Metal active gas welding with flux cored electrode
 783 = Drawn arc stud welding with ceramic ferrule

廣州金源行金屬有限公司
Guangzhou KYH Metal Co., Ltd.



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 廣州經濟技術開發區東區連雲路16號 郵遞區號/ZIP: 510760 電話/Tel: (020) 3202 0980 傳真/Fax: (020) 3202 0981

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Category	Equipment Name	Model	Quantity	Manufacturer
SAW	Submerged Arc Welder	Power Wave AC/DC 1000 SD	2	Lincoln Electric
GMAW	CO2/MIG/MAG Welder	Power Wave R450	2	Lincoln Electric
Stud Welding	Stud Welding Machine	Nelweld 6000	2	Nelson
Robotic Welding	Robotic Welding System	M10i/D/M710iC	4	FUNUC
CNC	CNC Plasma/Flame Cutter	XPR300/XPR400	2	Messer/ Hypertherm
CNC	Vertical CNC Drilling Machine	MYNX 6500	1	DOOSAN

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Appendix G

中厚板、型材、管材仓库进料核收报告检查结果明细																
收料单号: 250-C06376		船运单号: SH0023945		采购单号: PCD-260095		供应商: 马钢钢材加工		质保书审核: 打印核收报告								
建单日期: 2026-02-23		采购单号: PCD-260095		供应商: 马钢钢材加工		状态: 品保已审核		检查地点: 外勤								
总卷数(包数): 3		总重量(吨): 75.456		不合格卷/包明细和处置方案		检查项目①内容: 核对品种、材质、规格、炉号、板/支号、数量/重量; 检查项目②内容: 测量公称尺寸、外形/扁差; 检查项目③内容: 检查外观、表面质量、锈蚀; 检查项目④内容: 检查产品标签/标识/标牌; 检查项目⑤内容: 核对材质书列出的化学成分和力学性能;										
序号	钢厂	材质	货品(大类)	钢材描述	重量 (t)	张/支数	炉号	板/支号	检查日期	判定	检查结果					
											项目①	项目②	项目③	项目④	项目⑤	备注
001	马钢	EN 1002...	H型钢	H-BEAM 356mm x 406mm x 393kg/...	23.580	5	A26200946	826020713	2026/2/23	合格	正确	符合	良好	良好	符合	
002	马钢	EN 1002...	H型钢	H-BEAM 356mm x 406mm x 393kg/...	37.728	8	A26200946	826020714	2026/2/23	合格	正确	符合	良好	良好	符合	
003	马钢	EN 1002...	H型钢	H-BEAM 356mm x 406mm x 393kg/...	14.148	3	A26200946	826020885	2026/2/23	合格	正确	符合	良好	良好	符合	

总记录笔数: 3 已检查记录笔数: 3 不合格记录笔数: 0

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Product Inspection Report

Report No.(报告编号): KYH-XXX-001

Project Name (项目名称)	XXXX			Project No. (项目编号)	XXX	
Product Name/ No. (产品名称/编号)	SOCKETED STEEL H-PILE WITH STIFFENING PLATE/001			Drawing No. (参考图纸号)	KYH-XXX-XXX	
Production Date (生产日期)	8/5 2025	Inspection Date (检验日期)	8/6 2025	Shipment Date (装运日期)	8/19 2025	
Part Name/No. (零件名称/零件号)	Material No. (材料编号)	Batch No. (批次号)	Heat No. (炉号)	Grade (牌号)	Mill (钢厂)	Remark (备注)
UBP 305×305×223	001	125061244	B25407742	S450J0	MAANSHAN	
STIFFENING PLATE-01	030	332409345	222406956	S460M	BAOSTEEL	
STIFFENING PLATE-02	031	332409345	222406956	S460M	BAOSTEEL	
<div style="border: 1px solid black; padding: 5px; display: inline-block; background-color: #e0e0e0;"> 仅供参考 </div>						
Inspection Items 检验项目				Result 检验结果		
Document 文件				Pass		合格
Appearance and Dimensions 外形及尺寸				Pass		合格
Visual 目视				Pass		合格
焊缝尺寸				Pass		合格
焊缝UT				Pass		合格
焊缝MT				Pass		合格
Final Conclusion: Pass – All items inspected meet the requirement.						
最终检验结论: 所有检验项目均符合要求						
Prepared By/Date: 检验员/日期				Checked By/Date: 审核/日期:		



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Appendix G

质量异常报告

我的桌面 新建报告

保存 发送 撤回 部门意见 QE判定 品质审核 审批 处理结果 重工验证 收藏 刷新

报告信息 | 查看报告 |

报告类型: MDR-加工异常 报告编号: MDR 自动生成 加工单号/料件编号/船号: [输入框] 供应商: [输入框] 钢厂: [输入框]

发生日期: 2026-03-11 机组: [下拉菜单] 客户: [输入框]

船号: [输入框] 机长: [下拉菜单] 下一加工单: [输入框] 保险备案号: [输入框]

加工类型: [下拉菜单] 不合格来源: 原材料不良 运输不良 作业不良 库存变质 退货 设备故障 其它

材料/成品信息 | 异常描述 |

选择料件 删除

料件编号	卷号	炉号	材质	进料日期	厚度	宽度	长度	不良卷数/片	不良重量(吨)	不良长度(米)	送货日期	客户名称

报告进度信息

- 质量异常报告建立
- 报告人:
- 品质判定
- 评审人:
- 品质审核
- 相关部门意见
- 审批
- 处理结果

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ISO 文件瀏覽

- F-P004 供方質量系統評鑑報告.pdf
- F-P005 低價易耗品申購單.pdf
- F-P006 認供供應商名單.pdf
- F-P007 供方質量體系開發請求.pdf
- F-P008 供方質量體系開發計劃.pdf
- F-Q001 倉庫薄板進料核收報告.pdf
- F-Q001_1 倉庫核收報告-中厚板.pdf
- F-Q002 原材料品質異常報告.pdf
- F-Q003 品質異常處理報告.pdf
- F-Q004 鑄料檢驗記錄.pdf
- F-Q005 質檢檢核表.pdf
- F-Q006 康守使用申請單.pdf
- F-Q007 粗糙度測試記錄.pdf
- F-Q008 硬度測試記錄.pdf
- F-Q009 量規儀器一覽表.pdf
- F-Q010 量規儀器管理卡.pdf
- F-Q011 客戶品質檔案_2024版.pdf
- F-Q012 客戶規格資料表.pdf
- F-Q013 客戶投訴檔案_11_27.pdf
- F-Q014 客戶產品跟進報告.pdf
- F-Q015 客戶投訴跟進報告.pdf
- F-Q016 外來文件登記表.pdf
- F-Q017 廢料商品品質處理報告.pdf
- F-Q018 樣品抽驗記錄表.pdf
- F-Q019 工程變更申請單.pdf
- F-Q020 工程變更通知.pdf
- F-Q021 測量系統分析計劃.pdf
- F-Q022 量具量衡性和同源性數據表.pdf
- F-Q023 量具量衡性和同源性分析報告.pdf
- F-Q024 量具穩定性分析報告.pdf
- F-Q025 量具偏向分析報告.pdf
- F-Q026 量具線性分析報告.pdf
- F-Q027 變更通知單 (PCN).pdf
- F-Q028 實驗室溫度記錄.pdf
- F-Q029 顧客特殊要求識別清單.pdf
- F-Q030 過程潛在失效模式及後果分析表 (PFMEA).pdf
- F-Q032 產品審核年度計劃.pdf
- F-Q033 產品審核檢查表和記錄.pdf
- F-Q034 產品審核報告.pdf
- F-Q035 產品審核糾正措施單.pdf
- F-Q036 中厚板 不合格品處理單.pdf
- F-S001 樣品審批申請表.pdf
- F-S002 客戶滿意度調查表.pdf
- F-S004 業務需求表.pdf
- F-S003 訂單詳詢表.pdf
- F-S004 成品裝貨明細表.pdf
- F-S005 成品審批處理單.pdf
- F-S006 結賬運費記錄表.pdf
- 記錄與標準 一覽表_2024.pdf
- 質量管理體系標準
- 質量管理

Guangzhou KYH Metal Co., Ltd.

不合格品處理單

(中厚板部)

MRB No: _____

外銷 內銷 受托

加工單號:	開料工作單號:
鋼廠:	
材質:	
板號:	
加工規格:	
加工公差:	
實測尺寸:	
不良件數:	
處理方式: <input type="checkbox"/> 入庫改用(可用方形計: _____)	
<input type="checkbox"/> 報廢 <input type="checkbox"/> 需要補料 <input type="checkbox"/> 让步放行 <input type="checkbox"/> 返工 <input type="checkbox"/> 其它	