



中国船级社
CHINA CLASSIFICATION SOCIETY
工厂认可证书

证书编号/Certificate No.
QH25PWA00033

CERTIFICATE OF WORKS APPROVAL

兹证明本证书所述制造厂具备按照下列标准的要求生产本证书所列产品的能力和条件。

This is to certify that the manufacturer stated in the certificate meets the requirements of the standards listed below and is available with the ability and conditions to produce the products described in the certificate.

制造厂/Manufacturer

林肯电气（唐山）焊接材料有限公司
Lincoln Electric (Tangshan) Welding Materials Co.,Ltd.

地址/Address

河北省唐山市滦县台商工业区内
Taiwan Industrial Zone, Luan County, Hebei, P.R.China

产品名称/Product

焊丝
Welding Wires

认可标准/Approval Standard

- 中国船级社《材料与焊接规范》第3篇第2章
Chapter 2, Part Three of China Classification Society Rules for Materials and Welding

用于/Intended for

船舶/Ships

产品明细/Product Description

船用焊接材料/Marine Welding Materials (M0001)

名称/Name	属性(值)/Value	单位/Unit
产品名称/Product Name	见附页 See additional page(s)	
牌号(型号)/Brand (Model)	见附页 See additional page(s)	
等级/Grade	见附页 See additional page(s)	
规格/Specification	见附页 See additional page(s)	
焊接位置/Welding Position	见附页 See additional page(s)	
电流极性/Current Polarity	见附页 See additional page(s)	
保护气体/Gas Shield	见附页 See additional page(s)	
配用焊剂/Combined With Flux	见附页 See additional page(s)	

批准的图纸/Approved Drawings

图纸批准号/Drawings Approval No.: 无 / Nil.

证书有效期至/This Certificate is valid until 2027年10月15日/Oct. 15,2027

发证机构 中国船级社秦皇岛分社 签发日期 2025年12月04日
Issued by CCS/QINHO Branch Date Dec. 04,2025

本证书根据中国船级社规范和相关规定签发。所有证书页为一个整体，必须同时使用。纸质证书每页均须由本社盖章方为有效，电子证书含数字签名方为有效，本证书复印件无效。任何单位和个人均不应摘录或节选本证书的部分内容。有关方对所持证书的真实性有疑问时，可向本社检验机构咨询。本证书凡是未注明版本的规范，其（发证时）最新版本适用于本证书。
This Certificate is issued pursuant to the Rules of the Society and related regulation. All pages of the certificate are taken as a whole and are used simultaneously. No paper certificate page is valid without bearing the stamp of the Society, no electronic certificates is valid without the digital signature, and no copied form of the certificate is regarded as valid. Any part of the certificate is not to be extracted or abridged by any unit or individual in any form. Related parties who are doubted about the authenticity of the certificate may inquire of the Society or its offices. For Rules with no version indication, their latest version (at the time of issuance of the certificate) applies to this certificate.



Form No: W01.

联系方式/Contact Us, 见本社官方网站/See official web site of the Society (<http://www.ccs.org.cn>)

UTN:P025-43390979

产品认可试验报告/ Approval Test Report

试验报告编号/ Test Report No. : 2023102501, 2023102503, 2023102505, 2023102512, 2023102513

试验报告日期/ Test Report Date : 2023-10-25

试验报告编号/ Test Report No. : 2025022601

试验报告日期/ Test Report Date : 2025-03-10

试验报告编号/ Test Report No. : 2025102201

试验报告日期/ Test Report Date : 2025-10-22

认可后的产品检验方式/Method of Product Inspection after Approval

按规范只认可不进行产品检验的产品/The product approved only in term of the rules:

认可后的产品由制造厂检验合格后签发合格证明, 并连同该产品的本社认可证书复印件一并交付用户, 制造厂对产品符合公约、法规、本社规范和本社认可的标准规定负责。

After approval, product inspection should be carried out by the Manufacturer. Upon satisfactory inspection, and the Quality Certificate issued by the Manufacturer should be provided to the purchaser together with the copy of the approval certificate issued by the Society. The manufacturer should take responsibility for the product being in compliance with the convention, statutory regulation, the Society rules and the standard accepted by the Society.

认可保持条件/Maintenance Requirements of Approval

1. 工厂认可后, 如果图纸、技术文件、工艺规程有较大改变, 应征得本社同意。若改变涉及或影响到产品的设计、主要制造材料、关键工艺或产品的特性、特征, 则与特性有关的图纸和技术文件应经过本社审批, 并在检验机构认为必要时, 经本社检验人员到厂进行检查和见证有关试验, 其结果应能证实仍符合认可条件。

After works approval, if there are any major changes to the drawings, technical documents, specifications, prior consent should be obtained from the survey office of the Society. If the changes involve or affect product design, major construction materials, key workmanship or product characteristics and properties, drawings and technical documents related to properties are to be examined and approved by the Society and, where deemed necessary by the survey office, the surveyor to the Society will go to the manufacturer to inspect or witness relevant tests and the results of the tests should be able to demonstrate compliance with the approval conditions

2. 工厂的质量管理体系应保持有效运行, 并且与认可时一致。如果质量管理体系发生改变, 应经原体系认证机构审核并报本社批准。

The quality management system of the factory shall be ensure effective operation, and shall be the same as the situation of approval. If there are any changes to the quality management system, auditing of the original certification organization for quality management system and the society's approval shall be obtained.

3. 工厂认可证书获得者应接受本社每年一次的定期审核, 定期审核日为认可证书期满之日对应的每一周年日, 检查工作应在定期审核日的前后三个月内进行。

Those who have obtained the certificate of works approval shall receive periodical audit done by the Society on an annual basis. The date of periodical audit shall be each anniversary date which corresponds to the date of expiry of the relevant certificate and the periodical audit shall be done within a time span of three months before and after the annual surveillance date.

4. 在认可证书有效期内, 本社检验人员可在未经事先通知的情况下对工厂的产品制造过程进行审核, 以验证产品的生产是否符合业经本社批准的图纸和文件。工厂应予以配合。

Within the validity of the approval certificate, the surveyor to the Society may pay unannounced audit to the manufacturing process of the product in order to confirm whether it is in compliance with the drawings and documents approved by the Society. The factory should provide an active cooperation and necessary for the surveyor.

5. 认可证书有效期内, 如果出现可能导致本社暂停或撤销认可的情况, 工厂应及时采取有效的纠正措施。

Within the validity of the approval certificate, if cases occur that may cause the Society to suspend or withdraw the certificate, the manufacturer should take corrective actions in a prompt and effective manner.

备注/Remarks

本社已审核了产品厂无石棉声明, 但本社的审核不免除产品厂按照合同关系向订货方保证产品无石棉的责任。

The declaration of asbestos-free submitted by manufacturer has been reviewed by the Society. However, liability of the manufacturer to guarantee the products are asbestos-free to purchaser under contract will not be exempted.

本证书由原工厂认可证书 (No. QH25PWA00002) 变更并替代原证书。

This Certificate is modified from and supersedes the previous Works Approval Certificate No. QH25PWA00002.

中国船级社秦皇岛分社
CCS Qinhuangdao Branch

注: 本证书含有附页, 共2页

Note: The certificate is attached with additional 2 page(s)

产品明细/ Product Description

序号 /No.	产品名称 Product name	牌号 (型号) Brand (Model)	认可等级 Grade	规格 Specification (Φ /mm)	焊接位置 Welding position ^①	电流极性 Current polarity ^②	保护气体 Gas shield	认可试验用焊剂 Flux fitted for the approval test (牌号/ Brand) ^④
1	半自动、自动焊焊丝-气体 Wire-Gas Combinations for Semi-Automatic and Automatic Welding ^③	JM [®] -56 (MERIT [®] S-6)	4YSM	Φ 1.4, Φ 1.6	F	DCEP	CO ₂ (C1)	--
				Φ 0.8, Φ 0.9, Φ 1.0, Φ 1.2	F, H, Vu, Vd, OH			
2	埋弧自动焊焊丝 Wire for submerged arc automatic welding	JW [®] -1	4Y40M	Φ 1.6, Φ 2.0, Φ 2.4, Φ 3.2, Φ 4.0, Φ 4.8	F	DCEP	--	JF-B (SJ101) ^⑤
3	埋弧自动焊焊丝 Wire for submerged arc automatic welding	PREMIERWELD [®] Ni1K	5Y46MH5	Φ 1.6, Φ 2.0, Φ 2.4, Φ 3.2, Φ 4.0, Φ 4.8	F	DCEP	--	PREMIERWELD [®] BF-40H ^⑤
4	埋弧自动焊焊丝 (双丝埋 弧 焊焊丝) Wire for submerged arc automatic welding(Wire for series submerged arc welding)	PREMIERWELD [®] Ni1K	4Y42H5	Φ 1.6, Φ 2.0, Φ 2.4, Φ 3.2, Φ 4.0, Φ 4.8	F	DCEP+AC ^⑥	--	PREMIERWELD [®] BF-40H ^⑤

序号 /No.	产品名称 Product name	牌号 (型号) Brand (Model)	认可等级 Grade	规格 Specification (Φ/mm)	焊接位置 Welding position ①	电流极性 Current polarity ②	保护气体 Gas shield	认可试验用焊剂 Flux fitted for the approval test (牌号/ Brand) ④
5	埋弧自动焊焊丝 Wire for submerged arc automatic welding	JW®-1	4YM	Φ2.4, Φ3.2, Φ4.0, Φ4.8	F	DCEP	--	SJ101⑤
6	半自动、自动焊焊丝-气体 Wire-Gas Combinations for Semi-Automatic and Automatic Welding	ARCWELD ALU 5183⑦	WC	Φ1.0, Φ1.2, Φ1.6	F, H, Vu, Vd, OH	DCEP	100%Ar (I-1)	--
7	半自动、自动焊焊丝-气体 Wire-Gas Combinations for Semi-Automatic and Automatic Welding	MERIT®S-6	4Y40SM	Φ1.4, Φ1.6	F	DCEP	80%Ar+20%CO2 (M21)	--
				Φ1.0, Φ1.2	F, H, Vu, Vd, OH			

注/Note:

①焊接位置/Welding Position: F: 平焊位置/Flat position welding; H: 横焊位置/Horizontal welding; Vu: 立向上焊位置/Vertical-up position welding;

Vd: 立向下焊位置/Vertical-down position welding; OH: 仰焊位置/Overhead position welding.

②电流极性/Current polarity: DCEP-直流反接/Direct Current Electrode Positive; AC-交流/Alternating Current.

③兼用于多道半自动和多道自动焊的焊丝，具有相同焊接电流和热输入条件/The automatic multirun welding is performed in the same conditions of welding current and energy as semi automatic welding with the concerned wire-gas combination.

④埋弧自动焊焊丝认可试验配用的焊剂制造厂/The manufacturer of flux fitted for the Approval test of Wire for submerged arc automatic welding.

⑤山东泰山阳光焊接材料有限公司/ Shandong Taishan Sunlight Welding Materials Co., Ltd.

⑥双丝焊时电流极性一支为直流，一支为交流。/ There are two kinds of current polarity when double wires weld, one is DCEP, the other is AC.

⑦认可试验用铝合金母材牌号：5083。/ Aluminum alloy base material brand for the approval test: 5083.

--结束/The End--