



中国船级社
CHINA CLASSIFICATION SOCIETY

证书格式号/Form: W01.01-
HQ000120

工厂认可证书
CERTIFICATE OF WORKS APPROVAL

证书编号/Certificate No. SH10W00045

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 as described in the certificate.

制造厂/Manufacturer

宝山钢铁股份有限公司

Baoshan Iron & Steel Co.,Ltd.

宝山区富锦路

Fujin Road, Baoshan District

认可产品/ Product Approved

钢板

STEEL PLATE

焊接结构用高强度淬火回火钢

High Strength Quenched and Tempered Steels for Welded Structures

认可标准/ Approval Standard

- 1.中国船级社《材料与焊接规范》(2009)及其修改通报第1篇第3章
Chapter3,Part1 of CCS for MATERIALS AND WELDING(2009) and Revision of the Rules
- 2.工厂技术标准
Technical standard of the work

证书有效期至/ This Certificate is valid until

2014年9月6日 / Sep. 6, 2014

发证机构 中国船级社上海分社
Issued by CCS Shanghai Branch

签发日期 2011年12月5日
Date Dec. 5, 2011

本证书根据中国船级社《钢质海船入级规范》及有关程序规定签发。关于证书的有关规定见本证书背面的说明。当本证书包括多页纸张时，则所有证书页为一个整体，必须同时使用。每一页证书均须由本社盖章方为有效。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。本认可证书不代表本社对个体产品质量的检验。有关各方对所持证书的真实性有疑问时，可以向本社检验机构咨询。
This Certificate is issued pursuant to the Rules for Classification of Sea-going Steel Ships and related procedures of the Society. Refer to the back of the certificate for detailed requirements of the certificate. When the certificate consists of more than one page, all pages of the certificate are taken as a whole and are used simultaneously. No certificate page is valid without bearing the stamp of the Society 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. This approval certificate does not constitute the inspection of the Society about the quality of the unit/batch product. Related parties who are doubted about the authenticity of the certificate may inquire of the Society or its offices.

CCS
中国船级社



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CCS Mansion, 9 Dongzhimen Nan Da Jie, Beijing 100007, China 网址/Web Site: http://www.ccs.org.cn
本地检验机构/CCS local Office: 中国船级社上海分社 CCS Shanghai Branch 电话/Tel: +86(21)58851234 传真/Fax: +86(21)58852626



SH86940195
No. 12271273

产品明细/ Product Description

焊接结构用高强度淬火回火钢/High Strength Quenched and Tempered Steels for Welded Structures	: A420~A690 (Z25/Z35)
钢级/Grade	: D420~D690 (Z25/Z35)
	: E420~E690 (Z25/Z35)
规格/Dimension	: 见附页 see appendix mm
冶炼方式/Steel Making	: 转炉 LF
浇铸方式/Casting	: 见附页 see appendix
脱氧方式/Deoxidation Method	: 镇静和细晶处理 Killed and Fine grain treated
细化晶粒元素/Grain Refining Elements	: 见附页 see appendix
交货状态/Condition of Supply	: 见附页 see appendix

批准的图纸和设计计算书/ Approved Drawings and Design Calculations

图纸批准号/ Drawings Approval No. : ----

产品认可试验报告/ Approval Test Report

试验报告编号/Test Report No. : SH10W00045
 试验报告日期/Test Report Date : 2011-10-30
 试验单位/ Laboratory : 宝山钢铁股份有限公司
 Baoshan Iron & Steel Co., Ltd.
 试验单位地址/ Test Address : 上海市宝山区富锦路
 Fujin Road, Baoshan District Shanghai

产品适用范围/ Application of the Product

船舶/海洋工程 Shipping/Offshore installations

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. 工厂的专业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 professional 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年度复查, 年度复查日为认可证书的签发日起的每一周年日, 检查工作可在年度复查日的前后三个月内进行。

Those who have obtained the certificate of works approval shall receive surveillance done by the Society on an annual basis. The date of surveillance shall be each anniversary date of the approval certificate since the date of issuance and the surveillance may 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取消认可的情况, 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 withdraw the certificate, the manufacturer should take corrective actions in a prompt and effective manner.

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

产品认可后的单件/单批检验应由本社验船师按批准的产品检验计划进行, 经检验合格后由本社签署等效证明文件。After product approval, UNIT/BATCH INSPECTIONS should be carried out by the surveyor of the society in accordance with the approved Product Inspection Scheme, and the equivalent document will be issued by the Society upon satisfactory inspection.

对于原材料和零部件的检验要求/ Inspection Requirements for Materials and Components

产品如下原材料和零部件应由本社认可的制造厂生产/The following materials and components of the product should be manufactured by the factory approved by the Society:
具体见工厂合格供方清单/Detail refer to list of manufacturer qualified suppliers.

产品如下原材料和零部件应经本社检验, 持有本社产品证书/The following materials and components of the product should be inspected and certificated by the Society:
Nil

产品如下原材料和零部件的制造厂清单, 经本社批准方可变更/The list of manufacturer for the following materials and components of the product should not be changed without the Society's approval:
具体见工厂合格供方清单/Detail refer to list of manufacturer qualified suppliers.

责任声明/Statement of Responsibility

本社的认可不影响、替代与本社授权或检验无关的各方对上述工厂的认可和发证, 并且不对与本社授权或检验无关的各方负责, 不承担其未经应允而承认、接受本社认可所导致的法律和经济责任。

The approval of the Society does not affect and replace any approval and certification of the manufacturer by any parties that bear no relation with this Society's authorization or survey and therefore takes no responsibility for these parties. The Society does not undertake any legal and economic liabilities arising from accepting this Society's certificate without prior permission from this Society.

其他/Others

本证书由原SH10W00091证书变更, 原证书SH10W00091仍然有效。
This certificate is changed from the original certificate of SH10W00091, and the original certificate of SH10W00091 is kept valid.

中国船级社上海分社

CCS Shanghai Branch



*****本证书正文完/ End of Text*****

注: 本证书含有附页, 共1页

Note: The certificate is attached with 1 additional page(s)



钢级 Grade	细化晶粒元素 Grain refining elements	钢板最大厚度,mm Max. thickness	交货状态 Supply condition	浇铸方式 Casting
A420~A690; D420~D690; E420~E690 (Z25/Z35)	A1+Ti+V	88	QT	连铸/CC
	A1+Nb+Ti+V	178	QT	模铸/IC

注 Note: 规格 Spec. 宽度 Width $\leq 4800\text{mm}$ 、长度 Length $\leq 25000\text{mm}$

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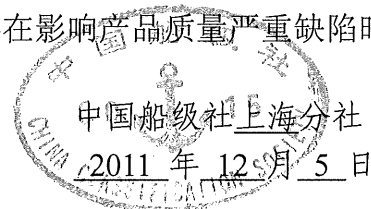


中国船级社

产品检验计划

根据中国船级社《钢质海船入级规范》的有关要求，下述申请方生产的船用产品业经 CCS 认可，根据产品的规范标准和申请方的产品专业质量体系，CCS 将依据下述产品检验计划实施产品检验和发证工作。

1. 申请方：宝山钢铁股份有限公司
2. 认可证书号：SH10W00045
3. 认可船用产品：焊接结构用高强度淬火回火钢
4. 产品检验依据：CCS《材料与焊接规范》(2009) 其修改通报第 1 篇第 3 章
5. 产品检验要求：
 - 5.1 产品检验项目
 - 5.1.1 CCS 需见证的试验项目：
 - 5.1.2 提交试验报告供 CCS 审核的试验项目：化学成分、力学性能和 Z 向钢 UT 检测
 - 5.1.3 需提交 CCS 检验的重要原材料(需提供 CCS 产品证书)：
 - 5.1.4 产品制造过程中 CCS 需见证的控制点：力学性能试验
 - 5.2 质量体系审核项目
 - 5.2.1 专业质量体系运行有效性，重要节点控制记录；
 - 5.2.2 原材料及零部件采购、分包控制的有效性；
 - 5.2.3 原材料及零部件的型号、规格、来源与本社认可时批准的文件一致性；
 - 5.2.4 原材料及零部件采购、分包验收记录。
6. 产品证书形式
 - 6.1 船用产品证书
 - 6.2 签署等效证明文件
 - 6.3 制造厂证明（要求工厂认可和/或型式认可而不要求持有产品证书的产品）
并随附认可证书复印件
7. 船用产品申请检验程序
8. 责任、分歧与仲裁
双方的责任、分歧与仲裁见本社《钢质海船入级规范》第 1 篇第 2 章第 14 节。
9. 其它说明
10. 产品检验计划的实施期限和失效
 - 10.1 本计划有效期为从 2011-12-5 至 2014-9-6
 - 10.2 当申请方获得的认可证书失效时，本检验计划自动失效
 - 10.3 当本社发现申请方产品专业质量体系中有存在影响产品质量严重缺陷时，将调整产品检验计划并书面通知申请方





中国船级社

关于颁发船用产品认可证书的函

工作控制号: SH10W00045宝山钢铁股份有限公司(申请方):

应贵公司申请,中国船级社按照本社规范和有关程序的要求,于2010年5月至2011年12月,对贵公司涉及所申请产品的设计、采购、生产和检验等有关的质量体系进行了审核;同时对焊接结构用高强度淬火回火钢船用产品进行了技术文件及图纸的审查和型式试验;上述审核及试验等结果表明,贵公司质量体系满足本社专业质量体系要求,具备生产上述产品的能力和条件,产品满足CCS《材料与焊接规范》(2009)及其修改通报第1篇第3章有关要求,特此颁发~~重新换发~~工厂认可证书。现将我社认可证书一份(编号为:SH10W00045)及经本社批准/备查的文件资料一套随函寄贵公司,请查收。

认可后贵公司应遵循如下要求,否则认可证书将被暂停或取消:

1. 在认可证书有效期内,公司每年度(工厂认可),申请我社进行认可的定期审核工作;定期审核应在定期审核到期日(工厂认可证书签发的周年日)前后三个月内完成。

2. 贵公司应确保专业质量体系持续有效运行,对体系中涉及的重要节点应保持运行记录,并对认可后产品的质量负责。

3. 对于原材料及零部件采购、分包等重要环节应有效控制;原材料及零部件采购、分包应在认可时经本社审批的分包方清单中选择,如需要更改应报本社审批;原材料及零部件采购、分包验收记录应保存,以便提供本社验船师审核。

4. 贵公司应确保认可后生产的产品与型式试验时的产品工艺、原材料和零部件保持一致,如有变化应通知本社确认,本社认为必要时应重新进行型式试验。

5. 如果图纸、技术文件、工艺规程或专业质量体系有较大改变,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，并在本社认为必要时，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。

6. 产品如出现质量异议，应积极协助客户解决，及时通知本社，认真分析原因和提出改进措施，并配合本社调查。

7. 认可后，本社将按照批准的检验计划对贵公司产品进行检验。

8. 认可证书有效期自 2011 年 12 月 5 日至 2014 年 9 月 6 日止，在此期间，将执行本社《钢质海船入级规范》的有关规定。

本认可不影响、不替代与本社授权、检验无关的各方对该厂的认可、检验与发证。本社按规范、相关标准与质量体系的要求，对该产品进行认可和检验，不对与本社授权、检验无关的各方负责，不承担其未经本社应允承认、接受本社认可和检验而由此产生的法律与经济责任。



- 附件：1、认可证书；
2、产品检验计划

