



**Task – T2065425**  
**WPS & PQR Review**

Attention: Mr. Y. K. Jung, YMI CORPORATION (WCN : 465542)

The documents shown in the attached list are reviewed in accordance with the applicable requirements of the following:

- ABS MVR Part 2 for Materials and Welding (2020)

Please note our review is based on the following conditions:

- 1) The work is to be completed to the satisfaction of the attending ABS Surveyor.
- 2) This drawing was re-submitted for the approval of alternations made since the last submission which was approved by ABS Letter dated 26 Nov 2020 (Ref. No : T2063576).

For any clarifications, contact Mr. Tae-Ho Kim at 051-460-4029. ([thkim@eagle.org](mailto:thkim@eagle.org)).

Very truly yours,

Jang-Ho Yoon  
Director of Engineering

Electronically Signed by: Jae-Sung Park

Document List

Drawing No.	Rev. No.	Title	Status
-	-	Incoming Email	-
YMI-WPS-FC-01 YMI-PQ-FC-001(2G) YMI-PQ-FC-002(3G)	0	YMI-WPS-FC-01	Reviewed

Electronic copies of the documents, appropriately stamped are available in the ABS client Portal.



Work Order: 4531001-A  
First Visit Date: 19-Nov-2020  
Last Visit Date: 25-Nov-2020  
Survey Location: Gimhae, Korea

## Welding Procedure Report

Customer Name YMI CORPORATION  
WCN of Customer 465542  
Location Gimhae, Korea

This is to certify that the undersigned Surveyors to this Bureau did at the request of YMI CORPORATION, from 19-Nov-2020 to 25-Nov-2020, carry out the following Survey and report as follows:

### Welding Procedures

Welding Process	Type of Joint	Parent Metal and Thickness Range	Welding Position	Minimum pre-heat and maximum interpass temperature	Shielding Gas	Welding Parameters
FCAW	BUTT	DH36, 20 mmT and 3 - 40 mmT	2G and 3G	20 °C and 65 °C	CO2	SEE BELOW

### Statement of Work - Classification Service - Welding Procedure Survey

- Base Metal(s) is/are identified
- Test specimen locations are indicated
- Test weldment procedure is described
- Welding positions are indicated
- Results of Welding Procedure Test Data are included in facility/ shipyard/ Plant Procedure Qualification Report (PQR)
- Inspection methods are described
- Filler metal is specified
- Current is specified
- Shielding gas and flux is indicated
- Applicable Rules, Codes, Specifications are referenced
- Joint design is described
- Thermal data is indicated (preheat/ post heat/ inter-pass temperatures)
- Welding Process Description is available
- Parameter ranges are described
- Weld backing is specified as applicable
- This procedure is acceptable for this application and test results are satisfactory.

### Report Findings

#### Statement/Observation

Finding No	Asset	Survey Task	Date Created
2.0	-	Welding Procedure Survey YMI-PQ-FC-001/002	25-Nov-2020

#### Found

The two (2) welding procedure qualification tests were carried out in accordance with the ABS Rules, the preliminary Welding Procedure Specification (T2060036 dated 18 November 2020), examined, tested as required and considered satisfactory.

1 of 2

NOTE: This Report evidences that the survey reported herein was carried out in compliance with one or more of the Rules, guides, standards or other criteria of the American Bureau of Shipping and is issued solely for the use of the Bureau, its committees, its clients or other authorized entities. This Report is a representation only that the vessel, structure, item of material equipment, machinery or any other item covered by this Report has been examined for compliance with, or has met one or more of the Rules, guides, standards or other criteria of American Bureau of Shipping. The validity, applicability and interpretation of this Report is governed by the Rules and standards of American Bureau of Shipping who shall remain the sole judge thereof. Nothing contained in this Report or in any notation made in contemplation of this Report shall be deemed to relieve any designer, builder, owner, manufacturer, seller, supplier, repairer, operator or other entity of any warranty express or implied.



Work Order: 4531001-A  
First Visit Date: 19-Nov-2020  
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pWPS No.: YMI-WPS-FC-01

PQR Nos.: YMI-PQ-FC-001 (2G), YMI-PQ-FC-002 (3G)

Welding Process: FCAW

Welding Position: 2G and 3G

Type of Joint: Butt

Base Metal: Plate (DH36, 20 mmT)

Filler Metal: AWS A5.20-2005(R2015); E71T-1C (Kiswel, Dia 1.2 mm)

Shielding Gas: CO2 (99.8 %)

Preheat and Post Weld Heat Treatment: Dry out and N/A

### Attending Surveyor(s):

Park, Jung-Kyu

Signed-off Date: 26-Nov-2020

### Reviewing Surveyor(s)

Work Order Reviewer: Kim, Tae-Gyoo

Work Order Credit Date: 26-Nov-2020



Work Order: 4531001-B  
First Visit Date: 19-Nov-2020  
Last Visit Date: 25-Nov-2020  
Survey Location: Gimhae, Korea

## Welder Qualification Report

Customer Name YMI CORPORATION  
WCN of Customer 465542  
Location Gimhae, Korea

This is to certify that the undersigned Surveyors to this Bureau did at the request of YMI CORPORATION, from 19-Nov-2020 to 25-Nov-2020, carry out the following Survey and report as follows:

### Welder Qualifications

Welder Name	Welder ID Number	Welding Process	Type of welded joint	Plate thickness and Welding Positions	Welding Procedure Specification	Pass/Fail
SEE ATTACHMENT	SEE ATTACHMENT	FCAW	BUTT	20 *mm and 2G AND 3G	YMI-WPS-FC-01	Pass

### Statement of Work - Classification Service - Welders Qualification Survey

- The welder or welding operator's qualification test record was completed by the manufacturer.
- Testing carried out as required by approved procedure/specifications and as reported herein.
- Testing machines are maintained in a satisfactory condition and records of their recheck or calibration dates confirmed.
- The welder or operator followed the approved procedure/specification including positions.
- The welding consumables and the welding process were in accordance with approved ABS procedures or specifications.

### Report Findings

#### Statement/Observation

Finding No	Asset	Survey Task	Date Created
3.0	-	Welders Qualification Survey YMI-WPS-FC-01	25-Nov-2020

#### Found

The welder performance qualification tests for the following welders were carried out in accordance with the ABS Rules, preliminary approved welding procedure specifications (T2060036 dated 18 November 2020), examined, tested as required and considered satisfactory.

- Welder Nos.: 760207-1, 660622-1 and 830301-1

For details, refer to the attached three (3) manufacturer's welder's qualification certification Nos. YMI-W001/W002/W003 dated 25 November 2020.

### Attending Surveyor(s):

Park, Jung-Kyu  
Signed-off Date: 26-Nov-2020



Work Order: 4531001-B  
First Visit Date: 19-Nov-2020  
Last Visit Date: 25-Nov-2020  
Survey Location: Gimhae, Korea

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### Reviewing Surveyor(s)

Work Order Reviewer: Kim, Tae-Gyoo  
Work Order Credit Date: 26-Nov-2020