

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, PRC**Report No:** NCR-000081**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0079**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: PMT, DP031-001, DP063-001
Procedural	Procedural	Descriptor:	Closed rib weld PMT for OBD DP031-001

Description of Non-Conformance:

The Contractor's performance of a closed rib weld production monitoring test (PMT) does not conform to Contract requirements. The Contractor welded one rib at a time during performance of the PMT for equipment that was used to simultaneously weld multiple ribs in production. This has occurred on the PMT preceding fabrication of deck panels DP031-001 DP63-001.

Applicable reference:

Special Provisions, Section 10-1.59 Steel Structures, subsection Welding of the Closed Ribs to Box Shell Plate, paragraph C. Monitoring of Production Welds (p. 329): "If the equipment is used in production to simultaneously weld multiple ribs, then at least two ribs shall be welded during the test."

Who discovered the problem: Kenneth Riley**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** Verbal notification on 02-27-2008**QC Inspector's Name:** Chen Xi and Shen Xue Jun**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:****Comments:**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By: Lowry, Patrick

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer



DEPARTMENT OF TRANSPORTATION
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge /Fluor Enterprises, a JV
375 Burma Road
Oakland CA 94607

Date: 29-Feb-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000048

Subject: NCR No. ZPMC-0079

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Non-Conformance with quality control procedures. Please take appropriate corrective action. Recurrence may require further administrative action.
- Non-Conformance with quality control. Records indicate that this is a recurring issue and constitutes a systematic problem in quality control. Within fourteen (14) days, please submit a plan to correct the deficiency.
- Material or workmanship is not in compliance with contract requirements.

Enclosed please find the following items:

NCR No: ZPMC-0079

Remarks:

Please see attached Non-Conformance Report for details.

Transmitted by: Stanley Ku Sr. Bridge Engineer

cc: Rick Morrow, Gary Pursell, Stanley Ku, Brian Boal, Jason Tom, Dave Williams

File: 05.03.06

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000048

Subject: NCR No. ZPMC-0079

Dated: 05-Sep-2008

Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000115 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: We consider this NCR closed. Additional staff and training has been provided to ensure proper inspection techniques.

Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000115R00;

Caltrans' comments:

Status: CLO

Date: 08-Sep-2008

The Contractor's response is acceptable. The Department concurs that Non-Conformance ZPMC-0079 is closed.

Submitted by: Wright, Doug

Attachment(s):

Date: 08-Sep-2008

DEPARTMENT OF TRANSPORTATION

CHINA FABRICATION TEAM
 506 Shangcheng Rd., Pudong New District
 Shanghai 200120, PRC



REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Dave Williams, American Bridge – Fluor, a Joint Venture
Gary Pursell, Resident Engineer

Review Date: 04/15/08

From: Stanley Ku

Contract No.: 04-0120F4

Date/Time Submittal Received: 03/19/08 09:00

China Standard Time
 (GMT+08:00)

Contractor's Transmittal #: TL 08-0637 Rev. # 0

- substantially **complies** with contract requirements and is approved
- substantially **complies** with contract requirements and is approved as noted.
- Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmital

Verbal Notification No Yes Date: _____ Time: _____

Name of individual from Contractor Notified: _____

This submittal is a:	<input type="checkbox"/> Welding Report	<input type="checkbox"/> Critical Weld Repair
	<input type="checkbox"/> Request for Information	<input type="checkbox"/> Heat Straightening Request
	<input type="checkbox"/> Fabrication Procedures	<input checked="" type="checkbox"/> Other: <u>Response to NCR</u>

Submitting Contractor: American Bridge/Fluor

ITEMS REVIEWED	COMPLIES	COMMENTS
1. Closure for NCR No. ZPMC 0023 and ZPMC 0079	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	
2.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
3.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
4.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
5.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
6.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
7.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
8.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
9.	<input type="checkbox"/> Yes <input type="checkbox"/> No	

Remarks:

Reviewer: Stanley Ku

Date: 04/15/08

Construction Concurrence: SK Initial 4/15/08 Date

Received by: [Signature] Date: 4/15/08 Time: 1245

Page 1 of 2

Date: 18 March 2008

To: Gary Pursell

From: Steve Lawton

Contract No. 04-0120F4

Dear Gary Pursell

NCR's 23 & 79

This letter is issued to provide formal response addressing the proposed resolution to each of the mentioned NCR's for Engineer's review and approval.

NCR-000023 - ZPMC did not identify unacceptable Visual indications.

ZPMC accepted a weld based on Visual criteria that was later determined to be unacceptable as found during QA overcheck.

ZPMC has acknowledged that the unacceptable indications were overlooked by the inspector and determined the cause of the unacceptable indications. ZPMC has generated an internal NCR to document this Non-conformance.

Page 2 of 2

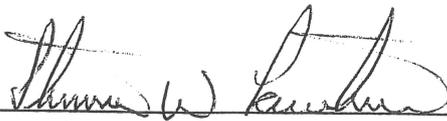
NCR-000079 - PMT welding not conforming to Special Provisions requirements

ZPMC welded 1 Rib on PMT then went on to run multiple ribs on the production panel contrary to Contract requirements.

ZPMC has informed personnel responsible for welding of PMT's and Production panels of the requirements set forth in the Special Provisions regarding number of ribs required on a PMT when multiple ribs are to be welded in production. ZPMC has generated an internal NCR to document this Non-Conformance.

With the above response, ABFJV considers the NCR's mentioned as closed.

If further clarifications are needed, please contact me.



Steve Lawton
Foreign Quality Assurance Manager



No. B-070

LETTER OF RESPONSE

DATE: 2008.03.12
To: AB/F Steve Lawton
From: ZPMC Sun Wei
Subject: Response to CT NCR-000081
Mr. Lawton,

ZPMC has generated internal NCR-B-019 in Response to CT NCR-000081. ZPMC welded one rib at a time during performance of the PMT for equipment that was used to simultaneously weld multiple ribs in production. This has occurred on the PMT preceding fabrication of deck panels DP031-001 DP063-001. ZPMC will organize special workers who are in charge of backward deformation, assemble PMT plates and improve checking welding, to ensure the number of the U-ribs and weld PMT plates at the same time.

Attached you will find a copy of ZPMC internal NCR-B-019.

If further information is needed, Please contact me.

Sincerely
Sun Wei

A handwritten signature in cursive script that reads 'Sun Wei'.

A handwritten date in cursive script that reads '2008-3-12'.



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B
 项目名称: 美国加州海湾大桥

NCR Number:
 NCR 编号: NCR-B-019 (NCR-000081)

Item: PMT does not conform requirement
 名称描述: 拖带试板的焊接不规范

Item Number:
 件号:

Drawing Number:
 图号: DP-031/063

Location: OBG Deck Plate
 位置: 钢箱梁顶板单元

Date:
 日期: 2008-2-27

Description of Nonconformance:

不符合项状态描述:

The contractor welded one rib at a time during performance of the PMT for equipment that was used to simultaneously weld multiple rib in production. This has occurred on the PMT preceding fabrication of deck panels DP031-001 DP063-001.

产品板单元焊接之前的 PMT 施焊过程中没有按照标书要求进行, 必须几块 PMT 试板的所有焊缝全部同时进行施焊。涉及的板单元为 DP031-001 DP063-001.

Work By: Zhao Yan Jun Prepared by: Fu Tubang Reviewed by QCE: Zhao Shuang Bao
 施工方: 2008.03.06 准备: 2008.03.07 质量工程师批准:

Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
 处理措施: 回用 返修 拒收

Recommendation:

建议:

施工队组织专人负责做返变形, 确认好当天要施焊的顶板单元 U 肋根数, 装配相应的 PMT 试板, PMT 试板同时施焊。

Labor boss organize special workers who is in charge of backward deformation, ensure the number of u-rib that will be weld about DP. Assemble PMT plates correspond to the u-ribs, weld PMT plates at the same time.

Prepared by: Liao Da Xue Approved by QCA: Hu Fang
 准备 质量经理批准

Reason for Nonconformance:

不符合原因:

PMT 试板未同时施焊, 标书要求 PMT 试板要同时施焊。

Not weld PMT plates as the same time, don't satisfy special provision requirement.

Prevention of Re-occurrence:

预防措施:

- 1、专人负责做返变形, 装 PMT 试板
 - 2、加强焊接前的检查
1. Organize special workers who is in charge of backward deformation, assemble PMT plates.
 2. Improve checking before welding.

Approved by/批准: Liao Da Xue

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment

回用或返修的技术依据: 附件 无附件

From now on, PMT welding will be performed together with plate panel welding.
 从今以后, PMT 焊接将与主梁板单元一起进行焊接。
 Reviewed /批准: Tang Yang bo. 08.2.8

Verification: Acceptable Unacceptable

确认: 可接受 不可接受

Verified by QCI/质检确认: Sun Wei 07051331 Reviewed by QCA/质检主任审核: Hu Fang 2008.3.11



DEPARTMENT OF TRANSPORTATION
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge /Fluor Enterprises, a JV
375 Burma Road
Oakland CA 94607

Date: 29-Feb-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Attention: Dave Williams Consultant
Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0079
Document No: 05.03.06-000048

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Non-Conformance with quality control procedures. Please take appropriate corrective action. Recurrence may require further administrative action.
- Non-Conformance with quality control. Records indicate that this is a recurring issue and constitutes a systematic problem in quality control. Within fourteen (14) days, please submit a plan to correct the deficiency.
- Material or workmanship is not in compliance with contract requirements.

Enclosed please find the following items:

NCR No: ZPMC-0079

Remarks:

Please see attached Non-Conformance Report for details.

Transmitted by: Stanley Ku Sr. Bridge Engineer

cc: Rick Morrow, Gary Pursell, Stanley Ku, Brian Boal, Jason Tom, Dave Williams

File: 05.03.06

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Bay Area Branch
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 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000081

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Feb-2008

Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

NCR #: ZPMC-007

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: PMT, DP031-001, DP063-001
 Procedural Procedural Descriptor: Closed rib weld PMT for OBD DP031-001

Description of Non-Conformance:

The Contractor's performance of a closed rib weld production monitoring test (PMT) does not conform to Contract requirements. The Contractor welded one rib at a time during performance of the PMT for equipment that was used to simultaneously weld multiple ribs in production. This has occurred on the PMT preceding fabrication of deck panels DP031-001 DP63-001.

Applicable reference:

Special Provisions, Section 10-1.59 Steel Structures, subsection Welding of the Closed Ribs to Box Shell Plate, paragraph C. Monitoring of Production Welds (p. 329): "If the equipment is used in production to simultaneously weld multiple ribs, then at least two ribs shall be welded during the test."

Who discovered the problem: Kenneth Riley

Name of individual from Contractor notified:

Time and method of notification:

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: Verbal notification on 02-27-2008

QC Inspector's Name: Chen Xi and Shen Xue Jun

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By: Lowry, Patrick

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 03/12/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR(NCR-000024) FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

(1) COPY OF LETTER OF RESPONSE WITH NO.B-069 FOR CLOSURE.

(2) COPY OF NCR WITH NUMBER NCR-000024 .

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

Ruby L.

PLAN HOLDER

3/18/08 10:40

DATE

AD/TU

COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. B-069

LETTER OF RESPONSE

DATE: 2008.03.12
To: AB/F Steve Lawton
From: ZPMC Xu Xianping
Subject: Response to CT NCR-000024
Mr. Lawton,

ZPMC has generated internal NCR-B-011 in response to CT NCR-000024, regarding that the undercut exceeded 1mm in depth and notches that were located on the fillet welds SP075-01-016 and SP075-01-027. The current and voltage fluctuated during the machine was operating, which resulted in the undercut. ZPMC will check the machine before welding and inspect the welds more strictly. SP075 has been finished welding and accepted by VT and MT, which can be shown by VT report B-VT210 and MT report B787-MT-055.

Attached you will find a copy of ZPMC internal NCR-B-011.
For further information, please contact me. Thank you.

Sincerely,
Xu Xianping

A handwritten signature in black ink, appearing to read 'Xu Xianping', with a date '2008-3-12' written below it.



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B
项目名称: 美国加州海湾大桥

NCR Number: NCR-B-011 (NCR-000024)
NCR 编号:

Item: Visual inspection unacceptable
名称描述: 目检不合格

Item Number:
件号:

Drawing Number: SP075-01
图号:

Location: Bottom Plate
位置: 钢箱梁底板

Date: 2008-2-22
日期:

Description of Nonconformance:

不符合项状态描述:

ZPMC NDE technician Zhou Dong Yun accepted T-stiffener fillet welds on SP075-01 #016 through #027 after visual inspection and MT. ZPMC did not identify locations where undercut exceeded 1mm in depth and notches that were located at the fillet weld transition into the weld access hole of the T-stiffeners.

ZPMC 的 NDE 人员周东运在通过目检的底板单元 SP075-01 的 T 型肋角焊缝#016 到#027 上做磁粉。ZPMC 没有把角焊缝上超过 1mm 深的咬边标识出来。

Work By: Lu Hai peng Prepared by: Du Wenling Reviewed by QCE: Fu Yidong
施工方: 2008.02.24 准备: 2008.02.22 质量工程师批准: 2008.02.22

- Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
处理措施: 回用 返修 拒收

Recommendation:

建议

Improve the strength of the inspection.

Prepared by: Xu Xian ping 2008.02.23 Approved by QCA: Hu Guang 2008.2.23
准备 质量经理批准

Reason for Nonconformance:

不符合原因:

The current and voltage fluctuated during the machine was operating, which resulted in the undercut.

Prevention of Re-occurrence:

预防措施:

Check the machine before the welding and improve the inspection strength.

Approved by/批准: Xu Xian ping 2008.2.23

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
回用或返修的技术依据: 附件 无附件

Repair the welds according to the repair WPS(WPS-345-SMAW-2G(2F)-FCM-Repair and WPS-345-FCAW-2G(2F)-FDM-Repair, and reference technology report GGL-JZGT-97(the repair technology of the San Francisco Oakland Bridge).

Reviewed /批准: Tang Yong bo

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

Verified by QCI/质检确认: Xu Xian ping Reviewed by QCA/质检主任审核: Hu Guang



DEPARTMENT OF TRANSPORTATION
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge/Fluor Enterprises, a JV
375 Burma Road
Oakland CA 94607

Date: 08-Feb-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0023

Document No: 05.03.06-000014

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Non-Conformance with quality control procedures. Please take appropriate corrective action. Recurrence may require further administrative action.
- Non-Conformance with quality control. Records indicate that this is a recurring issue and constitutes a systematic problem in quality control. Within fourteen (14) days, please submit a plan to correct the deficiency.
- Material or workmanship is not in compliance with contract requirements.

Enclosed please find the following items:

NCR No: ZPMC-0023

Remarks:

Please see attached Non-Conformance Report for details.

Transmitted by: Stanley Ku Sr. Bridge Engineer

cc: Rick Morrow, Gary Pursell, Stanley Ku, Brian Boal, Jason Tom, Dave Williams

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
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Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: ZPMC's fabrication shop, Changxing Island, China

Report No: NCR-000024

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 31-Dec-2007

Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

NCR #: ZPMC-0023

Type of problem:

Welding **Concrete** **Other**

Welding **Curing** **Procedural**

Bridge No: 34-0006

Joint fit-up **Coating** **Other**

Component: SP075-01, T-stiffener fillet welds

Procedural **Procedural** **Description:**

Description of Non-Conformance:

ZPMC NDE technician Zhou Dong Yun accepted T-stiffener fillet welds on SP075-01 #016 through #027 after visual inspection and MT. ZPMC did not identify locations where undercut exceeded 1 mm in depth and notches that were located at the fillet weld transitions into the weld access hole of the T-stiffeners.

Applicable reference:

AWS D1.5, 2002, section 6.26.1.5: "... Undercut shall be no more than 1.0mm deep ..." AWS D1.5, 2002, section 3.2.5: "Radii of beam copes and weld access holes shall provide a smooth transition, free of notches or cutting past the points of tangency between adjacent surfaces."

Who discovered the problem: Caltrans Mets QA Inspector Scott Croff

Name of individual from Contractor notified:

Time and method of notification: 1600, verbal

Name of Caltrans Engineer notified: Cheng Wen Liu

Time and method of notification:

QC Inspector's Name: Zhou Dong Yun

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Unknown at this time.

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By: Lowry, Patrick

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer

B-VT-210



Visual Weld Inspection Report
焊缝目视检查报告

周数

9#

日期

2007.12.31

Girder/梁: OBG Bottom plate

Tower/塔: NA

Caltrans Contract No.

加州合同编号

04-0120F4

Project No.:

项目名称

San Francisco Oakland Bay Bridge

海湾大桥

美国

Representative:

质检代表:

Lu Jianhua

CWI:

检验员:

M.K.Wu 2007/12/31
04082021

Project No.:

项目编号:

ZP06-787

Quality Assurance Manager

~Approval

质量控制经理:

Hu Gang

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 返修后接受
SP075-01-003/017	048810	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-002/016	048810	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-005/019	048810	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-004/018	048810	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-007/021	053742	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-006/020	053742	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-009/023	053742	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-008/022	053742	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-011/025	048801	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-010/024	048801	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-013/027	048801	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP075-01-012/026	048801	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA

After root weld

After CWR or WRR No.:

After cover pass

After HSR No. : HSR (B) -

Others

#R787-QCP-603

B787-MT-055

"✓" is no defects. "X" is defects. "NA" is not applicable.



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-055		DATE 日期 2008.01.01	PAGE 页码 1/1	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: EAST BOX SP75		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4		
REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Jan. 1 ST , 2009	
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5360 5362	
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC	
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm	
MATERIAL TO BE EXAMINED 检测材料	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 母材, 厚度	A709M-345T2-X 16/8mm	
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	CORNER JOINT	

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SP075-01-003/017				ACC.		*
SP075-01-002/016				ACC.		*
SP075-01-005/019				ACC.		*
SP075-01-004/018				ACC.		*
SP075-01-007/021				ACC.		*
SP075-01-006/020				ACC.		*
SP075-01-009/023				ACC.		*
SP075-01-008/022				ACC.		*
SP075-01-011/025				ACC.		*
SP075-01-010/024				ACC.		*
SP075-01-013/027				ACC.		*
SP075-01-012/026				ACC.		*

*All welding were 10% MT inspection and ACC.

*所有焊缝经10%MT检测合格。

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EXAMINED BY 主探 Zhou Dongyan LEVEL-II SIGN 签名 / DATE 日期 2008.01.01	REVIEWED BY 审核 Cai Xinxin LEVEL-II SIGN / DATE 日期 2008.01.01
质量经理 / QCM Hu Gang 签字 SIGN / 日期 DATE	用户 CUSTOMER 签字 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000036**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 19-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0079**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 27-Feb-2008**Description of Non-Conformance:**

The Contractor's performance of a closed rib weld production monitoring test (PMT) does not conform to Contract requirements. The Contractor welded one rib at a time during performance of the PMT for equipment that was used to simultaneously weld multiple ribs in production. This has occurred on the PMT preceding fabrication of deck panels DP031-001 DP63-001.

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

ZPMC has informed personnel responsible for welding of PMT's and Production panels of the requirements set forth in the Special Provisions regarding number of ribs required on a PMT when multiple ribs are to be welded in production. ZPMC has generated an internal NCR to document this Non-Conformance.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** **Date:****Is Engineer's approval attached?** Yes No**Comments:**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Liu, Chengwen

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer