

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-000109**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Apr-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0106**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: SP-359-01
Procedural	Procedural	Descriptor:	OBG Side Panel

Reference Description:**Description of Non-Conformance:**

The Contractor did not properly perform in-process cleaning while performing welding. The Contractor welded over previously deposited metal without stopping to remove slag from or brushing clean the previously deposited weld. This occurred during the performance of critical weld repair CWR-061 on weld #002 of OBG side panel SP-359-01-002.

Applicable reference:

AWS D1.5, Section 3.11.1: "In-Process Cleaning. Before welding over previously deposited metal, all slag shall be removed and the weld and adjacent base metal shall be brushed clean."

Who discovered the problem: QA Inspector Sherri Brannon**Name of individual from Contractor notified:** ABFJV QC Inspector Kevin Carpenter**Time and method of notification:** Verbal (phone) notification at 15:45 on 04-04-2008**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** Verbal notification at 11:00 on 04-05-2008**QC Inspector's Name:** ZPMC CWI Huang Wei Pang**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 - District 4 Toll Bridge
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 95607

Date: 11-Apr-2008

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000086

Subject: NCR No. ZPMC-0106

Reference Description: The Contractor did not properly perform in-process cleaning while performing welding.

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

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved - No Response Required.

Material Location: OBG **Lift:**

Remarks:

The Contractor welded over previously deposited metal without stopping to remove slag from or brushing clean the previously deposited weld. This occurred during the performance of critical weld repair CWR-061 on weld #002 of OBG side panel SP-359-01-002.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0106

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000086

Subject: NCR No. ZPMC-0106

Dated: 09-Jul-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000041 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC QC has increased training of welders and confirmed repair by NDT method.

Please see attached response from ZPMC. ABFJV has reviewed and concurs with this response and considers this issue resolved.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000041R00;

Caltrans' comments:

Status: CLO

Date: 25-Aug-2008

The Contractor has generated an internal NCR to address this issue. Also, the welder has received training, and the weld in question was accepted by Ultrasonic Testing. The Department concurs that Non-Conformance ZPMC-0106 is closed.

Submitted by: Wright, Doug

Attachment(s):

Date: 25-Aug-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: 07-03-2008

From: Ady Velasco, Structural Materials Representative

Contract No.: 04-0120F4

Date/Time Submittal Received: 06-05-2008/

China Standard Time
(GMT+08:00)

Contractor's Transmittal #: TL-08-1339 **Rev. #** 0

<input checked="" type="checkbox"/> substantially complies with contract requirements and is approved			
<input type="checkbox"/> substantially complies with contract requirements and is approved as noted.			
<input type="checkbox"/> Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmital			
Verbal Notification		<input checked="" type="checkbox"/> No <input type="checkbox"/> 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>NCR close out documents</u>	
Submitting Contractor: <u>ABF</u>			
ITEMS REVIEWED	COMPLIES		COMMENTS
1. NCR No. ZPMC-0106, For Closure	<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	
Add more items here.....# - Item - Complies (Yes or No)-Comments			

Remarks:

Reviewer: Ady Velasco *AV*

Date: 07-03-2008

Construction Concurrence: Se Initial 7/4/08 Date

Received by (ABFJV): _____ Date: _____ Time: _____

Page 1 of 1

Date: 4 June 2008

To: Gary Pursell

From: Steve Lawton

Contract No. 04-0120F4

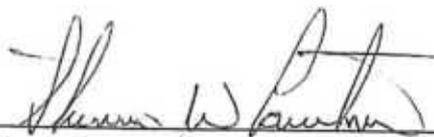
Dear Gary Pursell

This letter is issued to provide formal response addressing the proposed resolution to NCR ZPMC-0106 for Engineer's review and approval.

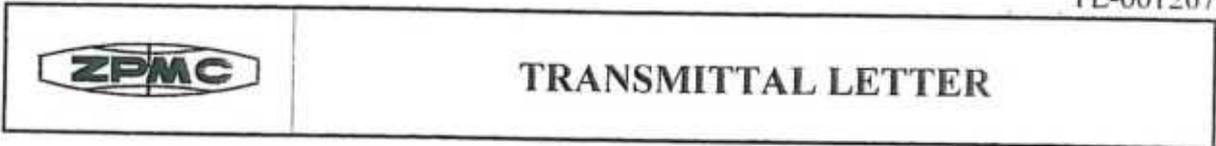
ZPMC has summarized the above listed NCR's and has generated an internal NCR for each occurrence.

ABFJV considers the NCR's mentioned as closed.

If further clarifications are needed, please contact me.



Steve Lawton
Foreign Quality Assurance Manager
American Bridge Fluor Joint Venture



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 05/27/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000109 FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-261 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000109 (ZPMC-0106)
- (3) COPY OF ZPMC INTERNAL NCR NCR-B-038
- (4) COPY OF CWR B-CWR061REV.0
- (5) COPY OF VT REPORT B-VT1229
- (6) COPY OF MT REPORT B787-UT-247R3

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



 PLAN HOLDER

RECEIVED 27 MAY 2008
 1126

 DATE



 COMPANY

 PHONE NO.

PLAN NUMBER: N/A
 #R787-QCP-102



No. B-261

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-5-27

REGARDING: NCR-000109 (ZPMC-0106)

With this letter of response, ZPMC requests closure for Caltrans NCR-000109 (ZPMC-0106). We agree the description in non-conformance. And ZPMC have trained the welders and confirmed the repair area by NDT method. Next time the welder will remove the defects completely before welding.

So ZPMC considers NCR-000109 can be closed.

Please reference attached documentation for acceptance and closure the NCR-000109.

ATTACHMENT:

NCR-000109 (ZPMC-0106)
ZPMC internal NCR
CWR documents for closure

Zhao Shuang Bao
5-27

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial *VB* Date: 7/4/08

REVIEWED
[Signature]
ABF Qcm
4 JUNE 08



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-000109 (ZPMC-0106) NCR 编号: NCR-B-038	
Item: weld over previously deposited metal without removing slag or cleaning 名称描述: 返修前未清理焊缝位置		Item Number: SP-359-01-002 件号:	Drawing Number: 图号:
Location: 2#焊缝 位置:		Date: 2008-4-4 日期:	

Description of Nonconformance:
不符合项状态描述:
the contractor did not properly perform in-process cleaning while performing welding. The contractor welded over previously deposited metal without stopping to remove slag from or brushing clean the previously deposited weld .this occurred during the performance of critical weld repair CWR-061 on weld #002 of OBG side panel SP-359-01-002.
ZPMC 在执行关键返修 (CWR-061) 时, 没对原来焊缝中的夹杂等缺陷进行清除和表面清理干净, 就直接在上面进行了烧焊覆盖。

Work By: liuhajian Prepared by: Wangli Reviewed by QCE: Zhuoshuang Bao
施工方: 准备: rock. 4.18 质量工程师批准: 2008.4.18.

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: Clear weld passes completely before welding per WPS.
建议: 严格按照 WPS 进行焊接 把焊道进行清除并清理干净后焊接

Prepared by: liujian Approved by QCA: HuGang
准备 质量经理批准

Reason for Nonconformance:
不符合原因: 焊缝两端包后焊道未清理干净
The weld pass wasn't cleaned completely after gouging.

Prevention of Re-occurrence:
预防措施: 以后把焊道中的夹杂缺陷进行清理
Remove all the defects completely before welding.

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
回用或返修的技术依据: 根据合同要求对焊道进行附件 无附件
NDI 检查, 若焊缝质量满足要求, 则回用; 若有缺陷时, 需知相应返修报告电话通知, 并应严格按照
加强控制. Perform NDT of the weld according to the contract. If the welding quality
meets the requirement, use as is. If there are any defects, existing, issue relevant welding repair report
we shall strengthen the control of process. Reviewed/批准: Tang Yongho 08.4.23

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

Verified by QCI/质检确认: Shi Peng-wu Reviewed by QCA/质检主任审核: HuGang
#R787-QCP-1300 Date: 7/4/08

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications

2008.5.21



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 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 95607

Date: 11-Apr-2008
 Contract No: 04-0120F4
 04-SF-80-13.2 / 13.9
 Job Name: SAS Superstructure
 Document No: 05.03.06-000086

Dear: Mr. Charles Kanapicki
 Attention: Mr. Dave Williams Consultant
 Subject: NCR No. ZPMC-0106

Reference Description: The Contractor did not properly perform in-process cleaning while performing welding.

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

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved - No Response Required.

Material Location: OBG

Lift:

Remarks:

The Contractor welded over previously deposited metal without stopping to remove slag from or brushing clean the previously deposited weld. This occurred during the performance of critical weld repair CWR-061 on weld #002 of OBG side panel SP-359-01-002.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer
 Attachments: ZPMC-0106

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom
 File: 05.03.06

This document is: APPROVED
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant Section 5-1.02 of the
 Standard Specifications
 Initial 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 #: 04-0120F4

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-000109

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Apr-2008

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

NCR #: ZPMC-0106

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: SP-359-01
 Procedural Procedural Descriptor: OBG Side Panel

Reference Description:

Description of Non-Conformance:

The Contractor did not properly perform in-process cleaning while performing welding. The Contractor welded over previously deposited metal without stopping to remove slag from or brushing clean the previously deposited weld. This occurred during the performance of critical weld repair CWR-061 on weld #002 of OBG side panel SP-359-01-002.

Applicable reference:

AWS D1.5, Section 3.11.1: "In-Process Cleaning. Before welding over previously deposited metal, all slag shall be removed and the weld and adjacent base metal shall be brushed clean."

Who discovered the problem: QA Inspector Sherri Brannon

Name of individual from Contractor notified: ABFJV QC Inspector Kevin Carpenter

Time and method of notification: Verbal (phone) notification at 15:45 on 04-04-2008

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: Verbal notification at 11:00 on 04-05-2008

QC Inspector's Name: ZPMC CWI Huang Wei Pang

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



关键焊缝返修报告

版本 Rev. N

Critical Welding Repair Report(CWR)

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	SP359	报告编号 Report No.	B-CWR061
合同号 Contract No.:	04-0120F4	部件名称 Items Name	5# T-RIB	NDT报告编号 Report No.of NDT	B787-UT-247F
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

Rejected indication found by ultrasonic inspection at third time.
(UT探伤返修第三次。) SP359-01-002

Weld No.(焊工编号):053609

Position:(焊接位置): 3G

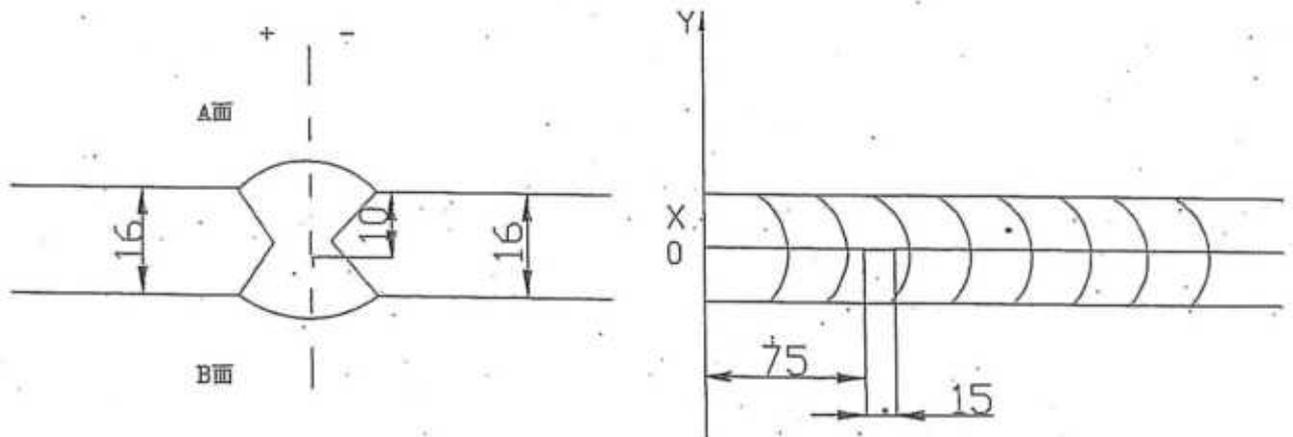
Welder ID

② 4-1-08

检验员 (Inspector): Li Liming 日期(Date): 2008.03.27

焊缝返修位置示意图:

Draft of welding discontinuity:



WELD NUMBER: SP359-01-002

REVIEWED
J. Miller
ABE QCM
1 APRIL 08

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial GJE Date: 4/3/2008

产生原因:

Caused:

- 1、焊工操作不当 Welders did not weld correctly.
- 2、焊道未清理干净 Clean Weld pass inadequately.

车间负责人(Foreman): *Liu Jian* 日期(Date): *2008.03.31*

处理意见

Disposition :

1. 从B面采用碳刨或打磨的方法去除焊缝缺陷;
 2. 准备一个正确得接头型式, 具体参照相应的返修WPS;
 3. 采用MT或其它无损检测方法保证缺陷完全被清除;
 4. 预热及焊接要求参照已批准的返修WPS执行;
 5. 将焊缝打磨与相邻焊缝平齐;
 6. 根据批准的车间图纸检查焊缝.
-
1. Gouge or grind to remove all the defects from the Face B.
 2. Prepare excavation according to the relevant repair WPS;
 3. Perform MT or other NDT methods of the area to ensure removal of the defects;
 4. Preheat and weld according to the relevant repair WPS;
 5. Grind the weld flush with the adjacent weld;
 6. Check the welds according to the working drawings.

This document is: APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial *SJE* Date: *4/8/2008*

工艺: *Niu Biefeng*
Technical engineer:

审核: *HuGang*
Approved by

日期: *3/31/08*
Date:



关键焊缝返修报告

版本 Rev. No.

Critical Welding Repair Report(CWR)

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	SP359	报告编号 Report No.	B-CWR081
合同号 Contract No.:	04-0120F4	部件名称 Items Name	5# T-RIB	NDT报告编号 Report No. of NDT	B787-UT-247R2
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

- 1 对焊工加强培训。Train the welders to master more knowledge.
- 2 认真清理焊道。Clean the weld pass more carefully.

车间负责人(Foreman): Liu Jian 日期(Date): 2008.03.31

参照的WPS编号 Repair WPS No.	WPS-345-FCAW-3 G(3F)-Repair WPS-345-SMAW-3 G(3F)-Repair	工艺员 technologist	
返修(碳刨)前预热温度 Preheat temperature before gouging	83°C	返修的缺陷 Description of discontinuity	Nin tiefeng rejected of discontinuity
焊前处理检查 Inspection before welding	ACC	焊前预热温度 Preheat temperature before welding	97°C
最大碳刨深度 Max. depth of gouging	9	碳刨总长 Total length of gouging	56 mm
焊工 welder	wang zhonghua 053753	焊接类型 welding type	SMAW
		焊接位置 position	3G
焊接电流 Current	156 A	焊接电压 Voltage	25.4 V
		焊接速度 Speed	98 mm/min

返修后检查
Inspection After repairing:

外观检查 VT result	AC	检验员 Inspector	Xu Xianping 07/07/2007	日期 Date	2008.04.05
NDT复检 NDT result	ACC	探伤员 NDT person	Ma Jizhong	日期 Date	2008.04.05

见证:
Witness/Review:备注:
Remark:

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 6.4.02 of the
Standard Specifications
Initial SJE Date: 4/3/2008

#R787-QCP-900

B-V11229



周数 22#		日期 2008.04.05	
Visual Weld Inspection Report 焊缝目视检查报告			
Caltrans Contract No. 加州合同编号	04-0120F4	Girder/梁:	OBG "H" RIBS
Project No.: 项目名称	San Francisco Oakland Bay Bridge 美国海湾大桥	Tower/塔:	NA
Project No.: 项目编号:	ZP06-787	Quality Control Representative:	Liu Jianhua
Welder I.D.# 焊工识别号	053753	CWI: 检验员:	Xu Xianping 07/02/07
Weld No. 焊缝编号	SP359-001-002	Quality Assurance Manager ~Approval 质量控制经理:	Hu Guang
Location 位置	3G	Crater 弧坑	√
Welding consumables 焊接材料	TL-508 (Φ4.0)	Over lap 焊瘤	√
Undercut 咬边	√	Arc strike 电弧擦伤	√
Porosity 气孔	√	Spatters 飞溅	√
Crack 裂纹	√	Accept or Reject 接受或拒收	ACC
Repair 返修	NA	Accept or Reject after repair 返修后接受或拒收	NA
<input type="checkbox"/> After root weld <input checked="" type="checkbox"/> After CWR or WRR No.: B-CWR 061 <input type="checkbox"/> After cover pass <input type="checkbox"/> After HSR No.: <input type="checkbox"/> Others			

B787-4T-247R3

#R787-QCP-603



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-247R3

DATE 2008.04.05

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: OBG BOTTOM PLATE

DRAWING NO.: SP359

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 "T" STEEL

图号

加州工程编号

REFERENCING CODE 参考规范

ACCEPTANCE STANDARD 接受标准

PROCEDURE NO. 程序编号

AWS D1.5-2002

AWS D1.5-2002(Table 6.3)

ZPQC-UT-01

WELDING PROCESS 焊接方法

JOINT TYPE 焊缝类型

CALIBRATION DUE DATE 仪器校正有效期

FCAW

BUTT-JOINT

Dec. 28, 2008

EQUIPMENT 设备

MANUFACTURER 制造商

MODEL NO. 样式编号

SERIAL NO. 序列编号

UT SCOPE

PANAMETRICS

EPOCH-4B

051392712

CALIBRATION BLOCK 试块

COUPLANT 耦合剂

MATERIAL/THICKNESS 材料厚度

AWS IIV BLOCK TYPE II

C.M.C

A709-GR50 / 16/10 mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70 °	2.5 MHz	18x18 mm				
Changchao	0 °	2.5 MHz	20 mm	Reference Level 参考灵敏度			20dB

Base metal inspected per AWS D1.5-2002 Section 6.19.5

0 ° UT OK.

WELD IDENTIFICATION 焊缝编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY							
									不连续位置(mm)							
a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 从X	From Y 从Y								
SP359-01-001	1R3	69.2					34								ACC.	
SP359-01-002	1R3	69.2					34								ACC.	
BLANK																

EXAMINED BY 主探

REVIEWED BY 审核:

Ma Ji Long 2008.04.05Li Liming 2008.04.05

LEVEL - II SIGN / DATE

LEVEL - II SIGN / DATE

质量经理 / QCM

用户 CUSTOMER

Hu Gang 2008.4.9

签字 SIGN / 日期 DATE

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-000171**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 31-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0106**Type of problem:**

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

Date the Non-Conformance Report was written: 04-Apr-2008**Description of Non-Conformance:**

The Contractor did not properly perform in-process cleaning while performing welding. The Contractor welded over previously deposited metal without stopping to remove slag from or brushing clean the previously deposited weld. This occurred during the performance of critical weld repair CWR-061 on weld #002 of OBG side panel SP-359-01-002.

Contractor's proposal to correct the problem:

ZPMC has retrained the worker and provided documentation of the repair.

Corrective action taken:

ZPMC wrote its internal NCR. The welder received additional training. The welds have been accepted per NDT results.

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 Eric Tsang, +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**