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 #: 50.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC **Report No:** NCR-000117
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 09-Apr-2008
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0114

Type of problem:

Welding	☑	**Concrete**	☐	**Other**	☐		
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:**	34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:**	FB017, FB026, FB017, FB018, FB025
Procedural	☑	**Procedural**	☐	**Descripton:**	OBG Floorbeams		

Reference Description:

Description of Non-Conformance:

The Contractor performed complete joint penetration (CJP) welds without the use of weld tabs. AWS D1.5, Section 3.12.1, "Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done by use of weld tabs (extension bars and runoff plates) placed in a manner that will duplicate the joint detail being welded." This was observed on floorbeam weld joint numbers FB017-001-125, FB026-02-125, FB026-01-125, FB017-02-125, FB018-02-125, FB018-01-125, FB025-01-125, and FB025-02-125.

Applicable reference:

AWS D1.5, Section 3.12.1, "Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done by use of weld tabs (extension bars and runoff plates) placed in a manner that will duplicate the joint detail being welded."

Who discovered the problem: QA Inspector William Clifford
Name of individual from Contractor notified: ABFJV QA Inspector Art Peterson
Time and method of notification: 04/10/2008, 1300, Verbal
Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 04/14/2008, 1215, Verbal
QC Inspector's Name: ZPMC QC Inspector 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.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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:**	18-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:**	05.03.06-000095
Subject:	NCR No. ZPMC-0114		

Reference Description: The Contractor performed complete joint penetration (CJP) welds without the use of weld tabs.

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:

AWS D1.5, Section 3.12.1, "Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done by use of weld tabs (extension bars and runoff plates) placed in a manner that will duplicate the joint detail being welded." The non-conformance activity was observed on floorbeam weld joint numbers FB017-001-125, FB026-02-125, FB026-01-125, FB017-02-125, FB018-02-125, FB018-01-125, FB025-01-125, and FB025-02-125.

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-0114

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

File: 05.03.06

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV
P.O. BOX 23223 Oakland, CA 94623
Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000095

Subject: NCR No. ZPMC-0114

Dated: **26-Aug-2008**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000110 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution: ZPMC generated an internal NCR to document and inform the relevant personnel and to prevent future occurrences

ZPMC performed CJP welds without using run-off tabs thinking there was not sufficient accessibility to do so. Since this nonconformance was issued ZPMC has determined methods to use runn-off tabs in the areas in question. ZPMC generated an internal NCR to document and inform the relevant personnel and to prevent future occurrences. See attached documents.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000110R00; ZPMC 114 Attachment 1.pdf; ZPMC 114 Attachment 2.pdf

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Caltrans' comments:

Status: CLO

Date: 26-Sep-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0114 is closed.

Submitted by: Wright, Doug

Date: 26-Sep-2008

Attachment(s):

TL-001444

ZPMC

TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 07/28/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000117(ZPMC-0114)FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

(1) COPY OF LETTER OF RESPONSE WITH NO.B-281FOR CLOSURE.
(2) COPY OF NCR WITH NUMBER NCR-000117(ZPMC-0114).
(3) COPY OF INTERNAL NCR NCR-B-051
(4) COPY OF UT REPORTS FOR THE WELD AREAS BEFORE TIME INCLUDING B787-UT-713, B787-UT-438, B787-UT-438R1, B787-UT-438R2, B787-UT-829, B787-UT-851, B787-UT-693, B787-UT-432, B787-UT-432R1, B787-UT-432R2

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEGEMENT:

Rosemary
PLAN HOLDER

July 28th, 2008
DATE

ABFJV
COMPANY

PHONE NO.

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

ZPMC

No. B-281

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-7-28

REGARDING: NCR-000117

With this letter of response and the attached NCR, ZPMC requests closure for the NCR-**000117(ZPMC-0114)**. We have checked the weld location and realized that space is big enough to install the welding tab, and with the requirement of the AWS that " weld shall be terminated at the end of a joint in a manner that will ensure sound weld. Whenever possible, this shall be done by use of weld tabs(extension bars and runoff plates)placed in a manner tat will duplicate the joint detail being welded." So ZPMC will use the weld tabs on such similar CJP welds in the future.

So ZPMC considers the NCR-**000117(ZPMC-0114)** can be closed.

Please reference attached documentation for acceptance and closure of NCR-**000117(ZPMC-0114)**

ATTACHMENT:
ZPMC internal NCR
NCR-**000117(ZPMC-0114)**
All NDT reports for the weld areas before time

Zhewshuang bao
2008. 7. 28.

ZPMC

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-051

Item: CJP welding without tab 名称描述: 焊接过程中没加引熄弧板	Item Number: 件号: FB017/026/025/018	Drawing Number: 图号: FB017/026/025/018

Location: bay seven 位置: 隔板生产车间	Date: 日期: 2008-4-9

Description of Nonconformance:
不符合项状态描述:

The contractor performed complete joint penetration welds without the use of weld tabs. Whenever possible, this shall be done by use of weld tabs placed in a manner that will duplicate the joint detail being welded, this was observed on floorbeam weld joint numbers FB017-001-125,FB026-02-125,FB026-01-125,FB017-02-125,FB018-01-125,FB025-01-125,FB025-02-125.

ZPMC在生产过程中对CJP坡口焊缝并没有使用引熄弧板,与标书的要求严重不符, 发生的构件焊缝为横隔板 FB017-001-125,FB026-02-125,FB026-01-125,FB017-02-125,FB018-01-125,FB025-01-125,FB025-02-125.

Work By: Lin Jinfei Prepared by: Fu Yuhong 2008.5.27 Reviewed by QCE: Zhao Shuangbao 5.27
施工方: 准备: 质量工程师批准:

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

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

Recommendation:
建议 以上焊缝须做探伤. NDT检验确保无缺陷. 以后此类焊缝必须紧引熄弧板.

Prepared by: Fang Yuefa 6.3 Approved by QCA: Hu Gang 2008.6.3
准备 质量经理批准

Reason for Nonconformance:
不符合原因: 在部分CJP坡口焊缝处没有使用引熄弧板.
The contractor performed complete joint penetration welds without the use of weld tabs.

预防措施
以后同类CJP坡口焊缝必须采用引熄弧板.
Weld tabs shall be used on such similiar CJP welds.

Approved by/批准: Fang Yuefa 6.3

Technical Justification for Use-As-Is/Repair: ☐ Attachment 附件 ☑ Non-attachment 无附件
回用或返修的技术依据:
以后在焊接过程, 是否增加引熄弧板, 请参见AWS D1.5 3.12.1 规范要求进行.
For the use of weld tabs during welding, see AWS D1.5, section 3.12.1.

Reviewed /批准: Tang Yongbo 5.30/08

Verification: ☑ Acceptable 可接受 ☐ Unacceptable 不可接受
确认:

Verified by QCI/质检确认: Li Zhijiang 2008.7.22 Reviewed by QCA/质检主任审核: Hu Gang 2008.7.22

#R787-QCP-1300

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:	18-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:	05.03.06-000095
Subject:	NCR No. ZPMC-0114		

Reference Description: The Contractor performed complete joint penetration (CJP) welds without the use of weld tabs.

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:

AWS D1.5, Section 3.12.1, "Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done by use of weld tabs (extension bars and runoff plates) placed in a manner that will duplicate the joint detail being welded." The non-conformance activity was observed on floorbeam weld joint numbers FB017-001-125, FB026-02-125, FB026-01-125, FB017-02-125, FB018-02-125, FB018-01-125, FB025-01-125, and FB025-02-125.

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-0114

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

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY

Arnold Schwarzenegger, Governor

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 #: 50.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

Report No: NCR-000117
Date: 09-Apr-2008
NCR #: ZPMC-0114

Type of problem:

Welding	☑	Concrete	☐	Other	☐	
Welding	☐	Curing	☐	Procedural	☐	Bridge No: 34-0006
Joint fit-up	☐	Coating	☐	Other	☐	Component: FB017, FB026, FB017, FB018, FB025
Procedural	☑	Procedural	☐	Descripton: OBG Floorbeams		

Reference Description:

Description of Non-Conformance:

The Contractor performed complete joint penetration (CJP) welds without the use of weld tabs. AWS D1.5, Section 3.12.1, "Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done by use of weld tabs (extension bars and runoff plates) placed in a manner that will duplicate the joint detail being welded." This was observed on floorbeam weld joint numbers FB017-001-125, FB026-02-125, FB026-01-125, FB017-02-125, FB018-02-125, FB018-01-125, FB025-01-125, and FB025-02-125.

Applicable reference:

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Who discovered the problem: QA Inspector William Clifford
Name of individual from Contractor notified: ABFJV QA Inspector Art Peterson
Time and method of notification: 04/10/2008, 1300, Verbal
Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 04/14/2008, 1215, Verbal
QC Inspector's Name: ZPMC QC Inspector 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.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Inspected By:	Lowry,Patrick	Quality Assurance Inspector
Reviewed By:	Lowry,Patrick	QA Reviewer

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-713	DATE 2008.05.04	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB17 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311,061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 /S IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X/ A709M-345F2-X /14/18/30mm	

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 焊缝部件编号	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 距X	From'Y 距Y		
FB017-01-125		68.7				32								ACC.	
FB017-01-126		68.7				32								ACC.	
FB017-01-127		68.7				32								ACC.	
BLANK															

EXAMINED BY 主探 Ma Jialong 2008.05.04. LEVEL - II SIGN / DATE	REVIEWED BY 审核: Xue Haitong 2008.05.04 LEVEL- II SIGN / DATE
质量经理 / QCM HuGang 2008.5.6 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

ZPMC

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-438	DATE 2008.04.09	PAGE 1 OF 3	Revision No: 0

PROJECT NO. :工程编号 ZP06-787	CONTRACTOR : CALTRANS
ITEMS NAME: OBG Diaphragm	DRAWING NO.:FB26 图号
	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 CORNER-JOINT	CALIBRATION DUE DATE 仪器校正有效期. Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 051392712,061488510
CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345F2-X / 30/18/14 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 焊缝图件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB026-02-125	1	68.5	A	2	42	32	2	+8	8	56	8	-4	83	REJ.	
FB026-02-126	1	68.5	A	2	38	32	3	+3	8	62	13	-2	145	REJ.	
	2	68.5	A	2	45	32	3	+10	8	62	13	-6	255	REJ.	
	3	68.5	A	2	45	32	3	+10	10	61	13	-2	1370	REJ.	
	4	68.5	A	2	47	32	3	+12	10	63	13	-2	1740	REJ.	
FB026-02-127		68.5	A	1	45	32	1	+12	5	39	14	-4	375	ACC	
		68.5	A	1	48	32	1	+15	8	34	13	-2	602	ACC.	

EXAMINED BY 主探 [signature] 2008.04.09 LEVEL - II SIGN / DATE	REVIEWED BY 审核: Xuehaitong 2008.04.09 LEVEL- II SIGN / DATE
质量经理 / QCM HuGang 2008.4.17 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

Attachment-1. CONTINUED

ZPMC

REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 B787-UT-438 DATE 2008.04.09 PAGE 2 OF 3 Revision No: 0

WELD IDENTIFICATION 焊缝报告编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置 Length 长度	Sound Path 声程	Depth from Face'A' 到检测面深度	From'X 到X5	From'Y 到Y	Discontinuity Evaluation 缺陷评估 Remark 备注
FB026-02-127		68.5	A	2	47	32	2	-13	10	51	9	-6	695	ACC.
		68.5	A	2	46	32	2	-12	10	47	11	-1	845	ACC.
		68.5	A	2	47	32	2	-13	8	47	11	0	1055	ACC.
	1	68.5	A	2	42	32	3	-7	390	65	4	-4	1410	REJ.
		68.5	A	2	47	32	2	-13	10	49	10	-2	1550	ACC.
		68.5	A	1	44	32	1	-11	15	37	13	-8	1920	ACC.
		68.5	A	1	50	32	1	-17	18	41	15	-3	2065	ACC.
		68.5	A	2	46	32	2	-12	17	51	10	-4	2185	ACC.
		68.5	A	2	47	32	4	-11	10	74	1	-4	2240	ACC.
		68.5	A	1	47	32	1	-14	20	39	14	-2	2520	ACC.
		68.5	A	2	46	32	1	-13	14	36	5	-3	3200	ACC.
		68.5	A	2	46	32	4	-10	10	80	1	-5	3360	ACC.
	2	68.5	A	2	42	32	4	-6	35	75	2	-4	3550	REJ.
	3	68.5	A	2	46	32	3	-11	40	69	4	-4	3650	REJ.
		68.5	A	2	47	32	3	-12	10	58	3	-3	4285	ACC.
		68.5	A	1	47	32	2	-13	15	51	14	-2	4295	ACC.
	4	68.5	A	2	41	32	4	-5	12	72	2	-5	4400	REJ.
		68.5	A	2	48	32	2	-14	10	46	17	-4	5180	ACC.
		68.5	A	2	49	32	4	-13	10	73	1	-4	5270	ACC.

EXAMINED BY主探

LEVEL-II SIGN / DATE 2008.04.09

REVIEWED BY 审核:

LEVEL-II SIGN / DATE 2008.04.09

质量经理 / QCM

HuGang 2008.4.17

签字 SIGN / 日期 DATE

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(FORM# ZPQC-UT01-2)

Attachment-1. CONTINUED

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REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 B787-UT-438 DATE 2008.04.09 PAGE 3 OF 3 Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG（次数）	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置 Length 长度	Sound Path 声程	Depth from Face'A' 到表面深度	From'X 到X5	From'Y 到Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB026-02-127	5	68.5	A	2	41	32	3	-6	10	69	4	0	6235	REJ.	
		68.5	A	2	47	32	4	-11	8	70	2	-3	7130	ACC.	
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EXAMINED BY主探

Li Liming 2008.04.09

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xue Haitong 2008.04.09

LEVEL- II SIGN / DATE

质量经理 / QCM

HuGang 2008.4.17

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-438R1	DATE 2008.04.16	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB26 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 051392712,061488510
CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345F2-X / 30/18/14 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 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB026-02-125	1R1	68.4	A	1	41	32	3	+6	10	59	22	+3	80	REJ.	
FB026-02-126		68.4				32								ACC	
FB026-02-127		68.4				32								ACC	

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EXAMINED BY 主探 Li Liming 2008.04.16 LEVEL - II SIGN / DATE	REVIEWED BY 审核: Eshuiqin 2008.04.16 LEVEL- II SIGN / DATE
质量经理 / QCM HuGang 2008.4.23 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-438R2	DATE 2008.04.21	PAGE 1 OF 1	Revision No: 0
PROJECT NO. :工程编号 ZP06-787			
ITEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB26 图号	CONTRACTOR : CALTRANS	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01	
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 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	051392712,061488510
CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度	
AWS IIW BLOCK TYPE Ⅱ	C.M.C	A709M-345F2-X / 30/18/14 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 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB026-02-125		68.4				32								ACC	
BLANK															

EXAMINED BY 主探 Li Liuting 2008.04.21 LEVEL - II SIGN / DATE	REVIEWED BY 审核: Zhuqin LEVEL- II SIGN / DATE 2008-04-21
质量经理 / QCM HuGang 2008.5.1 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

:EPORT NO.报告编号 B787-UT-829	DATE 2008.05.13	PAGE 1 OF 2	Revision No: 0

'ROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
TEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB26 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW/SAW/SMAW	JOINT TYPE焊缝类型 T-JOINT/BUTT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311,061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345F2-X /14/18/30mm	

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 焊缝部件编号	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 距X	From'Y 距Y		
FB026-01-125		68.5				33								ACC.	
B026-01-126		68.5				33								ACC.	
FB026-01-127		68.5				33								ACC.	
FB026-01-021		68.5				33								ACC.	
FB026-01-081		68.5				33								ACC.	
FB026-01-108		68.5				33								ACC.	
FB026-02-021		68.5				33								ACC.	

EXAMINED BY 主探 XueHaifeng LEVEL - II SIGN / DATE 2008-05-13	REVIEWED BY 审核: Ma Jiliang LEVEL- II SIGN / DATE 2008-05-13
质量经理 / QCM Hu Gang 2008.5.21 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-851	DATE 2008.05.12	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB17 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311,061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345F2-X 14/18/30mm	

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 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB017-02-125		68.4				35								ACC.	
FB017-02-126		68.4				35								ACC.	
FB017-02-127		68.4				35								ACC.	
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EXAMINED BY 主探 Xue Haizong 2008.05.12 LEVEL - II SIGN / DATE	REVIEWED BY 审核: Ma Zhong 2008.05.12 LEVEL- II SIGN / DATE
质量经理 / QCM Hu Gang 2008.5.21 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-693	DATE 2008.05.02	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB18 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311,061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 WS IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X/ A709M-345F2-X /14/18/30mm	

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 焊缝部件编号	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 距X	From'Y 距Y		
FB018-01-125		68.7				32								ACC.	
FB018-01-126		68.7				32								ACC.	
FB018-01-127		68.7				32								ACC.	
BLANK															

EXAMINED BY 主探 Xue Haiyong 2008.05.02 LEVEL - II SIGN / DATE	REVIEWED BY 审核: Mao Zhong 2008.05.02. LEVEL- II SIGN / DATE
质量经理 / QCM Hu Guang 2008.5.6 签字 SIGN / 日期 DATE	用户CUSTOMER / 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

Attachment-1. CONTINUED

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REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 B787-UT-829	DATE 2008.05.13	PAGE 2 OF 2	Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG（次数）	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置 Length 长度	Sound Path 声程	Depth from Face'A' 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB026-02-081		68.5				33								ACC.	
FB026-02-125		68.5				33								ACC.	
FB026-02-126		68.5				33								ACC.	
FB026-02-127		68.5				33								ACC.	
FB026-01-078		68.5				33								ACC.	
FB026-01-079		68.5				33								ACC.	
FB026-01-080		68.5				33								ACC.	
FB026-01-122		68.5				33								ACC.	
FB026-02-078		68.5				33								ACC.	
FB026-02-079		68.5				33								ACC.	
FB026-02-080		68.5				33								ACC.	
FB026-02-122		68.5				33								ACC.	
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EXAMINED BY主探	REVIEWED BY 审核:
Xuellahrong 2008.05.13	Majilong 2008.05.13
LEVEL - II SIGN / DATE	LEVEL- II SIGN / DATE
质量经理 / QCM	用户CUSTOMER
HuGang 2008.5.21	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-432 | DATE 2008.04.08 | PAGE 1 OF 3 | Revision No: 0

PROJECT NO. :工程编号 ZP06-787

ITEMS NAME: OBG Diaphragm 部件名称 | DRAWING NO.:FB25 图号 | CONTRACTOR : CALTRANS | CALTRANS CONTRACT NO.: 04-0120F4 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	T-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	051392712,061488510
CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度	
AWS IIW BLOCK TYPE Ⅱ	C.M.C	A709M-345F2-X / 30/18/14 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				

Base metal inspected per AWS D1.5-2002 Section 6.19.5 | Reference Level 参考灵敏度 20dB | 0 ° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y	Discontinuity Evaluation 缺陷评估	Remark 备注
FB025-01-125	1	68.3	A	1	42	32	0	-10	20	29	11	-5	0	REJ.	
	2	68.3	A	1	41	32	4	-5	25	74	27	-2	60	REJ.	
	3	68.3	A	1	45	32	3	-10	35	63	23	-3	160	REJ.	
	4	68.3	A	1	42	32	0	-10	45	27	10	-7	290	REJ.	
FB025-01-126	1	68.3	A	1	43	32	1	-10	30	43	15	-1	170	REJ.	
	2	68.3	A	1	45	32	3	-10	37	61	22	-3	315	REJ.	
	3	68.3	A	1	46	32	3	-11	20	57	21	0	1035	REJ.	

EXAMINED BY 主探

Li Liming 2008.04.08

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xue Haiyong 2008.04.09

LEVEL - II SIGN / DATE

质量经理 / QCM

Hu Gang 2008.4.17

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

Attachment-1. CONTINUED

ZPMC

REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 B787-UT-432 DATE 2008.04.08 PAGE 2 OF 3 Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	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 缺陷评估	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Face'A' 表面深度	From'X' 距X	From'Y' 距Y		
FB025-01-126	4	68.3	A	1	42	32	1	+9	20	40	14	-3	1180	REJ.	
	5	68.3	A	1	43	32	1	+10	50	43	16	+8	1275	REJ	
	6	68.3	A	1	43	32	1	+10	25	42	15	0	1375	REJ.	
	7	68.3	A	1	44	32	2	+10	22	47	16	0	1455	REJ.	
	8	68.3	A	1	43	32	1	+10	40	39	14	0	1540	REJ.	
	9	68.3	A	1	44	32	1	+11	20	42	15	+3	1740	REJ.	
	10	68.3	A	1	43	32	1	+10	20	47	18	+7	1620	REJ.	
FB025-01-127	1	68.3	A	2	46	32	4	+10	25	71	2	+3	520	REJ.	
	2	68.3	A	2	45	32	3	+10	25	69	3	-5	660	REJ	
		68.3	A	1	45	32	1	+12	20	39	14	-2	900	ACC	
	3	68.3	A	2	42	32	4	+6	20	73	1	+3	1485	REJ.	
	4	68.3	A	1	44	32	2	+10	55	48	17	+5	1885	REJ.	
	5	68.3	A	1	43	32	1	+10	50	42	15	+3	2095	REJ.	
	6	68.3	A	1	44	32	2	+10	12	50	18	+8	2455	REJ.	
	7	68.3	A	1	36	32	1	+3	15	39	14	+4	2570	REJ.	
		68.3	A	1	46	32	1	+13	14	36	13	+5	2630	ACC.	
		68.3	A	1	46	32	1	+13	10	41	15	+2	2820	ACC.	
	8	68.3	A	1	40	32	1	+7	25	39	14	+5	2920	REJ.	
	9	68.3	A	1	43	32	1	+10	10	39	14	+5	2960	REJ.	

EXAMINED BY主探

LiLiang 2008.04.08

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

YueHaiRong 2008.04.08

LEVEL- II SIGN / DATE

质量经理 / QCM

HuGang 2008.4.17

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

Attachment-1. CONTINUED

ZPMC

REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 B787-UT-432 DATE 2008.04.08 PAGE 3 OF 3 Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG（次数）	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置 Length 长度	Sound Path 声程	Depth from Face'A' 距表面深度	From'X 到X	From'Y 到Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB025-01-127		68.3	A	1	45	32	1	+12	10	41	15	+5	3040	ACC.	
		68.3	A	1	49	32	1	+16	10	42	15	+5	3095	ACC.	
		68.3	A	1	47	32	1	+14	7	36	13	+3	3540	ACC.	
	10	68.3	A	1	39	32	1	+6	10	42	15	+7	3735	REJ.	
	11	68.3	A	2	42	32	4	+6	10	70	2	+7	3960	REJ.	
	12	68.3	A	1	42	32	2	+8	10	50	18	+3	4035	REJ.	
	13	68.3	A	2	38	32	4	+2	10	77	0	+3	4290	REJ.	
		68.3	A	1	48	32	0	+16	10	30	11	-7	4340	ACC.	
	14	68.3	A	1	43	32	1	+10	10	40	15	+5	4520	REJ.	
		68.3	A	1	46	32	2	+12	10	48	18	+5	4660	ACC.	
	15	68.3	A	1	43	32	2	+9	10	45	16	+2	5240	REJ.	
	16	68.3	A	1	42	32	1	+9	10	37	14	+4	5510	REJ.	
	17	68.3	A	2	40	32	3	+5	10	69	3	+4	6080	REJ.	
	18	68.3	A	1	42	32	1	+9	10	38	12	+2	6100	REJ.	
		68.3	A	1	46	32	2	+12	10	48	16	+7	6200	ACC.	
	19	68.3	A	1	41	32	1	+8	10	37	13	+3	6265	REJ.	
	20	68.3	A	1	42	32	1	+9	10	35	13	+2	6730	REJ.	
		68.3	A	1	44	32	1	+11	10	38	14	+2	6840	ACC.	
		68.3	A	1	46	32	1	+13	20	42	15	+2	7200	ACC.	

EXAMINED BY主探

Li Liuning 2008.04.08

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xue Hairong 2008.04.08

LEVEL- II SIGN / DATE

质量绝理 / QCM

HuGang 2008.4.17

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM#.ZPQC-L101-2)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-432R1 | DATE 2008.04.16 | PAGE 1 OF 2 | Revision No: 0

PROJECT NO. :工程编号 ZP06-787

CONTRACTOR : CALTRANS

ITEMS NAME: OBG FLOOR BEAM 部件名称

DRAWING NO.:FB25 图号

CALTRANS CONTRACT NO.: 04-0120F4 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	T-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	051392712,061488510
CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度	
AWS IIW BLOCK TYPE Ⅱ	C.M.C	A709M-345F2-X / 30/18/14 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 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y	Discontinuity Evaluation 缺陷评估	Remark 备注
FB025-01-125	1R1	68.4	A	1	41	32	3	-6	10	56	21	-2	210	REJ.	
FB025-01-126	1R1	68.4	A	1	44	32	2	-10	10	49	18	-4	1135	REJ.	
	2R1	68.4	A	1	43	32	1	-10	10	39	14	-4	1180	REJ.	
	3R1	68.4	A	1	43	32	1	-10	50	43	16	-8	1275	REJ.	
	4R1	68.4	A	1	43	32	1	-10	25	42	15	0	1375	REJ.	
	5R1	68.4	A	1	44	32	2	-10	22	47	16	0	1455	REJ.	
	6R1	68.4	A	1	43	32	1	-10	40	39	14	0	1540	REJ.	

EXAMINED BY 主察

Li Lin 2008.04.16

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

E Shuigen 2008.04.16

LEVEL- II SIGN / DATE

质量经理 / QCM

HuGang 2008.4.23

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

Attachment-1. CONTINUED

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REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 B787-UT-432R1 DATE 2008.04.16 PAGE 2 OF 2 Revision No: 0

WELD IDENTIFICATION 焊缝组件编号	INDICATION NO. 指示号	PROBE ANGLE 探头角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置 Length 长度	Sound Path 声程	Depth from Face'A' 离检测面深度	From'X' 到X	From'Y' 到Y	Discontinuity Evaluation 缺陷评定	Remark 备注
FB025-01-126	7R1	68.4	A	1	43	32	1	-10	20	47	18	-7	1620	REJ.	
FB025-01-127	1R1	68.4	A	1	45	32	1	-12	20	39	14	-4	900	REJ.	
	2R1	68.4	A	1	41	32	2	-7	10	48	17	-9	1925	REJ.	
	3R1	68.4	A	1	42	32	1	-9	12	41	15	-5	2035	REJ.	
	4R1	68.4	A	1	36	32	1	-3	7	37	14	-4	2570	REJ.	
	5R1	68.4	A	1	38	32	2	-4	8	49	18	-10	2960	REJ.	
	6R1	68.4	A	1	39	32	1	-6	10	42	15	-7	3735	REJ.	
	7R1	68.4	A	1	43	32	1	-10	10	40	15	-7	4520	REJ.	

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EXAMINED BY主探

Li Liming 2008.04.16

LEVEL-II SIGN / DATE

REVIEWED BY 审核:

E Shuqin 2008.04.16

LEVEL-II SIGN / DATE

质量经理 / QCM

HuGang 2008-4.23

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-432R2	DATE 2008.04.21	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB25 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 051392712,061488510
CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345F2-X / 30/18/14 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 焊缝部件编号	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 距X	From'Y 距Y		
FB025-01-125		68.4				32								ACC	
FB025-01-126		68.4				32								ACC	
FB025-01-127		68.4				32								ACC	
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EXAMINED BY 主探 Li Liming 2008.04.21 LEVEL - II SIGN / DATE	REVIEWED BY 审核: Zhuqin LEVEL- II SIGN / DATE 2008.04.21
质量经理 / QCM HuGang 2008.5.1 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 B787-UT-643	DATE 2008.04.26	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: OBG FLOOR BEAM 部件名称	DRAWING NO.:FB25 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS焊接方法 FCAW	JOINT TYPE焊缝类型 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311,061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345F2-X/ A709M-345T2-X /14/18/30 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 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
FB025-02-125		68.3				35								ACC.	
FB025-02-126		68.3				35								ACC.	
FB025-02-127		68.3				35								ACC.	
FB025-02-079		68.3				35								ACC.	
FB025-02-122		68.3				35								ACC.	
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EXAMINED BY 主探 XueHaiyong 2008.04.26 LEVEL - II SIGN / DATE	REVIEWED BY 审核: Li Liming 2008.04.26 LEVEL- II SIGN / DATE
质量经理 / QCM HuGang 2008.5.1 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

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 #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, PRC **Report No:** NCS-000075
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 23-Sep-2008
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0114

Type of problem:

Welding	☑	**Concrete**	☐	**Other**	☐	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:**
Procedural	☑	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 09-Apr-2008

Description of Non-Conformance:

The Contractor performed complete joint penetration (CJP) welds without the use of weld tabs. AWS D1.5, Section 3.12.1, "Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done by use of weld tabs (extension bars and runoff plates) placed in a manner that will duplicate the joint detail being welded." This was observed on floorbeam weld joint numbers FB017-001-125, FB026-02-125, FB026-01-125, FB017-02-125, FB018-02-125, FB018-01-125, FB025-01-125, and FB025-02-125.

Contractor's proposal to correct the problem:

Since this nonconformance was issued, the Contractor has determined methods to use run-off tabs in the areas in question.

Corrective action taken:

The Contractor generated an internal NCR to document and inform the relevant personnel and to prevent future occurrences.

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 Ady Velasco, 011-86-138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Liu,Chengwen	Quality Assurance Inspector
Reviewed By:	Velasco,Abifhiram	QA Reviewer