

**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-000132**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0126**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> SEG-717A, SEG-014A, SEG-019A, SEG-0717A
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	OBG Segment Assemblies

**Reference Description:** Base metal repairs without following approved procedures**Description of Non-Conformance:**

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

**Applicable reference:**

ZPMC WPS# WPS-345-SMAW-1G (1F)-FCM-REPAIR

**Who discovered the problem:** QA Inspector Steve Hall**Name of individual from Contractor notified:** ABFJV QC Inspector Mr. Li Jing Bo**Time and method of notification:** 5/09/08 2100hrs**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** 5/16/08 10:15 telephone**QC Inspector's Name:** ZPMC QC Inspector Mr. Chen Xi**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

SMR

**Reviewed By:** Lowry,Patrick

SMR



**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, A JV  
375 BURMA ROAD  
OAKLAND CA 95607

**Date:** 19-May-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:** 05.03.06-000107

**Subject:** NCR No. ZPMC-0126

**Reference Description:** Base metal repairs without following approved procedures

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.

**Material Location:** OBG **Lift:**

### Remarks:

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-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-0126

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

**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000107

**Subject:** NCR No. ZPMC-0126

**Dated:** 26-Aug-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000108 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC has identified this nonconformance of not performing MT to verify complete removal of defects and have generated an internal NCR to prevent future occurrences

See attached documents

**Submitted by:** Kanapicki, Charles

**Attachment(s):** ABF-NPR-000108R00

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**Caltrans' comments:**

**Status:** REJ

**Date:** 25-Sep-2008

The Contractor's response is not acceptable. The proposed resolution states "see attached documents", but none are attached. Please provide documentation of the repair performed, and documentation that the required Non-Destructive Testing of the repaired area is acceptable.

**Submitted by:** Wright, Doug

**Attachment(s):**

**Date:** 25-Sep-2008

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000107

**Subject:** NCR No. ZPMC-0126

**Dated:** 08-Sep-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000108 Rev: 01

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC has identified this nonconformance of not performing MT to verify complete removal of defects and have generated an internal NCR to prevent future occurrences.

Please see attached.

**Submitted by:**

**Attachment(s):** ABF-NPR-000108R01;

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**Caltrans' comments:**

**Status:** AAP

**Date:** 25-Sep-2008

The response is acceptable, but the Non-Conformance is not closed.

Please provide documentation that the weld repairs were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0126 at that time.

**Submitted by:** Wright, Doug

**Date:** 25-Sep-2008

**Attachment(s):**



## TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 08/25/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000132(ZPMC-0126)FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-293 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000132 (ZPMC-0126)
- (3) COPY OF INTERNAL NCR-B-057
- (4) COPY OF NDT REPORTS.

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

PLAN HOLDER

*July Li*

DATE

RECEIVED 25 AUG 2008

*1107*



COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No: B-293

## LETTER OF RESPONSE

**TO: American Bridge/Flour JV**

**DATE: 2008-8-25**

**REGARDING: NCR-000132**

With this letter of response, ZPMC apply to closure the caltrans **NCR-000132** (**ZPMC-0126**) . We agree what describe in the nonconformance report, and have trained the operator that must follow the procedure and WPS during the course of repair. in case of there are some repair we must perform in the future, we should prior MT check to confirm remove the defects completely, then just can perform the welding repair in later.

We attaché the NDT reports for the weld repair point to make sure that the good quality of the welds , please check and revise these documents.

So ZPMC considers the **NCR-000132** (**ZPMC-0126**) can be closed.

Please reference attached documentation for acceptance and close the **NCR-000132** (**ZPMC-0126**) .

**ATTACHMENT:**

**NCR-000132 (ZPMC-0126)**

**ZPMC internal NCR**

**The NDT reports**

*Zhao Shuangbao*

*2008.8.25*



# Nonconformance Report

## 不符合项报告

Project Name: <b>S.F.O.B.B</b> 项目名称: 美国加州海湾大桥		NCR Number: <b>NCR-000132 (ZPMC-0126)</b> NCR 编号: <b>NCR-B-057</b>	
Item: <b>base metal weld repairs without following approved repair procedure</b> 名称描述: 未按照批准的返修工艺进行母材和焊缝返修		Item Number: 件号:	Drawing Number: 图号: <b>SEG-717A, SEG-014A, SEG-019A, SEG-017A</b>

Location: <b>OBG assembly shop</b> 位置: 桥面拼装车间	Date: <b>2008-5-9</b> 日期:
--	------------------------------

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

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

ZPMC 没有按照批准的返修工艺移除临时工装并进行母材和焊缝的返修。ZPMC 没有按照批准的返修工艺在返修前对碳刨区域进行磁粉检测。这发生在焊缝 SEG-717A-006, SEG-014A-019, SEG-019A-002 和 SEG-017A-002 上。

Work By: Hu Qiang Prepared by: Lu Guang Bin Reviewed by QCE: Zhao Shuang Bao  
施工方: S.L.W 准备: 2008.5.09 质量工程师批准: 5.30

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 严格按照批准的返修工艺及对返修进行返修。  
Repair according to the approved repair procedure and associated WPs.

Prepared by: Lu Guang Bin                      Approved by QCA: Hu Gang  
准备                      质量经理批准

**Reason for Nonconformance:**  
不符合原因: 卡马割除后未进行MT检测,就对缺陷清除返修。  
After we removed temporary fit-up aids, we performed base metal weld repairs without performing MT.

预防措施 1. 对施焊人操作工批评指正。                      1. Help operators realize their mistakes and then correct them.  
2. 加强现场监控。                      2. Enhance inspection in the shop.

Approved by/批准: Lu Guang Bin

**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

加强返修过程中的现场监控,对操作人员进行指导与教育,避免此种情况再次发生。  
Strengthen the supervision and control of shop working and training to the relevant personal to avoid the thing appearing again.

Reviewed /批准: Zhao Shuang Bao

Verification:     Acceptable                       Unacceptable  
确认:                      可接受                      不可接受

Verified by QCI/质检确认: Liu Zhao gang                      Reviewed by QCA/质检主任审核: Hu Gang



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, A JV  
375 BURMA ROAD  
OAKLAND CA 95607

Date: 19-May-2008

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

Dear: Mr. Charles Kanapicki  
Attention: Mr. Dave Williams Consultant

Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0126

Document No: 05.03.06-000107

Reference Description: Base metal repairs without following approved procedures

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.

Material Location: OBG

Lift:

### Remarks:

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-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-0126

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

File: 05.03.06

**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-000132

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 09-May-2008

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

NCR #: ZPMC-0126

## Type of problem:

Welding  Concrete  Other Welding  Curing  Procedural  Bridge No: 34-0006Joint fit-up  Coating  Other  Component: SEG-717A, SEG-014A, SEG-019A, SEG-0717AProcedural  Procedural  Descriptor: OBG Segment Assemblies

Reference Description: Base metal repairs without following approved procedures

## Description of Non-Conformance:

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

## Applicable reference:

ZPMC WPS# WPS-345-SMAW-1G (1F)-FCM-REPAIR

Who discovered the problem: QA Inspector Steve Hall

Name of individual from Contractor notified: ABFJV QC Inspector Mr. Li Jing Bo

Time and method of notification: 5/09/08 2100hrs

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 5/16/08. 10:15 telephone

QC Inspector's Name: ZPMC QC Inspector Mr. Chen Xi

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

SMR

Reviewed By: Lowry, Patrick

SMR





# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-1309	DATE日期 2008.05.18	PAGE OF页码 1/1	Revision No: 0
PROJECT NO. 工程编号: ZP06-787	CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SEG14A PLATE PANEL SPLICE	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 Dec. 28 <sup>ST</sup> , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395
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-345F2-X 16mm
WELDING PROCESS 焊接方法	N/A	TYPE OF JOINT 焊缝类型	BUTT

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			
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING
SEG014A-019				ACC.		AFTER GOUGING

BLANK


EXAMINED BY 主探 <u>Bo Tinmi</u> LEVEL - II SIGN 签名 / DATE日期 2008-05-18	REVIEWED BY 审核 <u>[Signature]</u> 2008.05.18 LEVEL-II SIGN / DATE日期
质量经理 / QCM <u>HuGang</u> 2008.8.18 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE







# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-1397

DATE日期 2008.05.24

PAGE OF页码 1/1

Revision No: 0

PROJECT NO.

工程编号:

ZP06-787

CONTRACTOR:

用户:

CALTRANS

DRAWING NO.

图号:

 SEG17A  
C5 PLATE PANEL SPLICE

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  
Dec. 28<sup>ST</sup>, 2008

 EQUIPMENT 设备  
MT YOKE

 MANUFACTURER 制造商  
PARKER

 MODEL NO. 样式编号  
B310S

 SERIAL NO. 连续编号  
5620 5395 5617

 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

 WELDING 焊接件  
 CASTING 铸件  
 FORGING 锻造

 Material & thickness  
母材, 厚度

 A709M-345T2-X  
22mm

 WELDING PROCESS  
焊接方法

N/A

 TYPE OF JOINT  
焊缝类型

BUTT

 WELD I.D.  
焊缝编号

DISCONTINUITY不连续性

 INDICATION  
指示

 TYPE  
类型

 LENGTH IN  
mm  
长度

 ACCEPT  
接受

 REJECT  
拒收

 REMARKS  
备注

SEG017A-002

ACC.

AFTER GOUGING

BLANK

EXAMINED BY主操

Bo Timm

LEVEL-II SIGN 签名 / DATE日期 2008.05.24

质量经理 / QCM

Hu Gang 2008.5.24

签字 SIGN / 日期 DATE

REVIEWED BY 审核

L. L. L. 2008.05.24

LEVEL-II SIGN / DATE日期

用户CUSTOMER

签字 SIGN / 日期 DATE

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000107

**Subject:** NCR No. ZPMC-0126

**Dated:** 18-Nov-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000108 Rev: 02

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC requests closure of this NCR based on the attached documentation.  
Please see attached.

**Submitted by:**

**Attachment(s):** ABF-NPR-000108R02; Close-out documents.

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**Caltrans' comments:**

**Status:** REJ

**Date:** 20-Nov-2008

The proposed resolution is not acceptable. The attached documents do not include all five of the locations listed in the NCR. Please submit documents for weld joint SEG-014A-003, which was listed in the NCR. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0126 at that time.

**Submitted by:** Wright, Doug

**Date:** 20-Nov-2008

**Attachment(s):**



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 11/18/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: CALTRANS NCR FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-293R1 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000132(ZPMC-0126).
- (3) COPY OF MT REPORTS FOR CORRESPONDING 4 WELDS

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

A handwritten signature in blue ink, appearing to read "Ruby".

\_\_\_\_\_  
PLAN HOLDER



\_\_\_\_\_  
COMPANY

RECEIVED 18 NOV 2008

1345

\_\_\_\_\_  
DATE

\_\_\_\_\_  
PHONE NO.

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



No. B-293R1

## LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-11-18

REGARDING: NCR-000132 (ZPMC-0126)

With this letter of response, ZPMC requests closure for Caltrans NCR-000132 (ZPMC-0126). As the comments from caltrans: please provide documentation that the weld repairs were performed and that the repairs were acceptable. So we submit the documentation as follow.

So ZPMC considers NCR-000132 (ZPMC-0126) can be closed.

Please check the attached documentation for acceptance and close the NCR-000132 (ZPMC-0126).

ATTACHMENT:

NCR-000132 (ZPMC-0126)

The MT reports for corresponding 4 welds

*zhao shuangbao*

*2008.11.18.*

*Thomas W. [Signature]*  
ABF QCM  
18 Nov 08



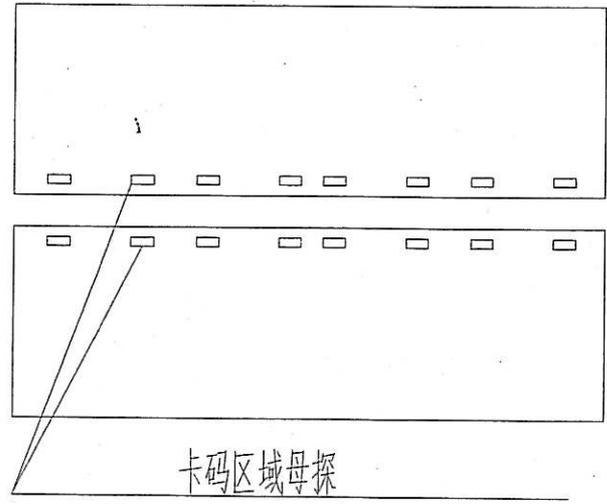
# 母材探伤申请表

SHANGHAI ZHENHUA PORT MACHINERY CO LTD

APPLICATION FORM FOR BASE MATERIAL NDT

产品名称 Project Name		美国海湾大桥		探伤类别 NDT type		数量 Quantity			
序号 No.	零部件图号 Drawing No.	零部件名称 Items	件号 Item No.	数量 Quantity	板厚/尺寸 Thickness/Dimension	炉批号 Batch No.	材料 Material	结论 Result	
	SEG-014A	SP40A			16 x 50A <sup>2</sup>				✓
	SEG-014A	SP50A			16 x 50A <sup>2</sup>				✓

探伤位置图  
Scheme showing the test part



SEG014A-019

卡码区域母探

申请人 Applicant		日期 Date	..	主探者 Inspected by		日期 Date	2008.5.27
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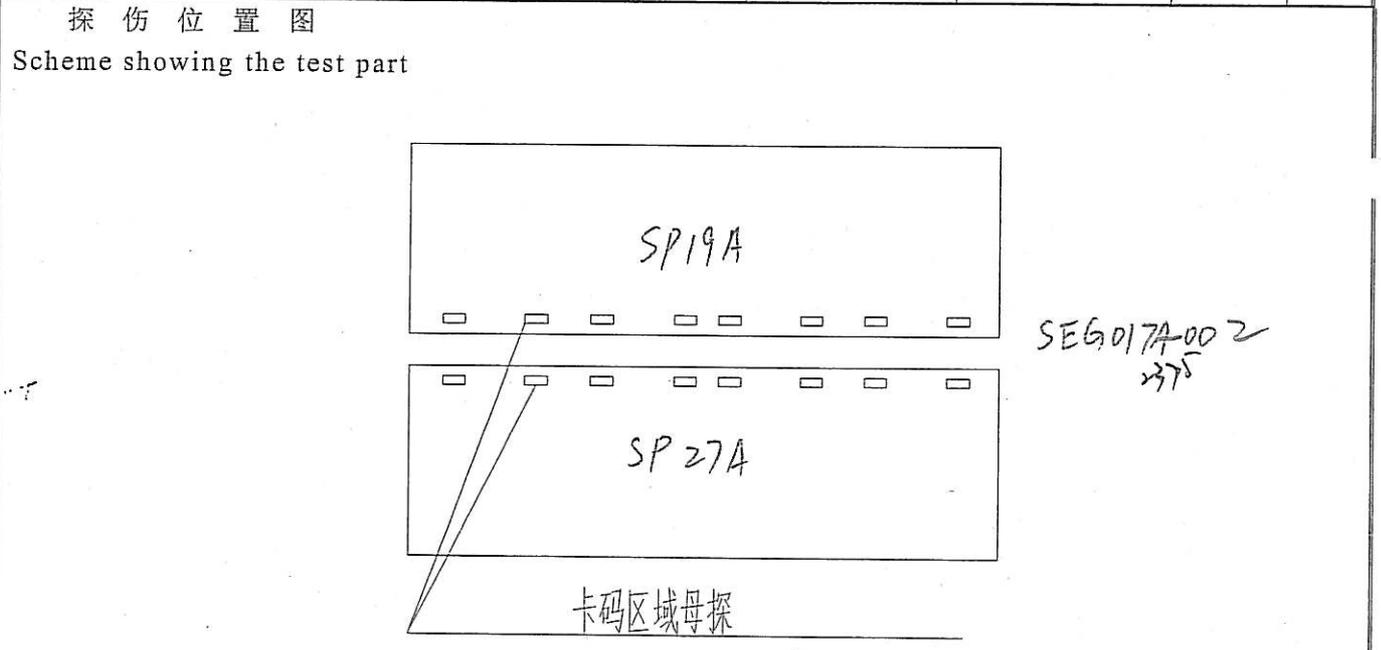


# 母材探伤申请表

SHANGHAI ZHENHUA PORT MACHINERY CO LTD

APPLICATION FORM FOR BASE MATERIAL NDT

产品名称 Project Name		美国海湾大桥		探伤类别 NDT type		数量 Quantity			
序号 No.	零部件图号 Drawing No.	零部件名称 Items	件号 Item No.	数量 Quantity	板厚/尺寸 Thickness/Dimension	炉批号 Batch No.	材料 Material	结论 Result	
1	SP19A	SP19A		1	16X10006		A709M-345T2-X	✓	
2	SP27A	SP27A		1	16X10006		A709M-345T2-X	✓	



申请人 Applicant	沈付友 胡国兴	日期 Date	..	主探者 Inspected by		日期 Date	2008.7.1
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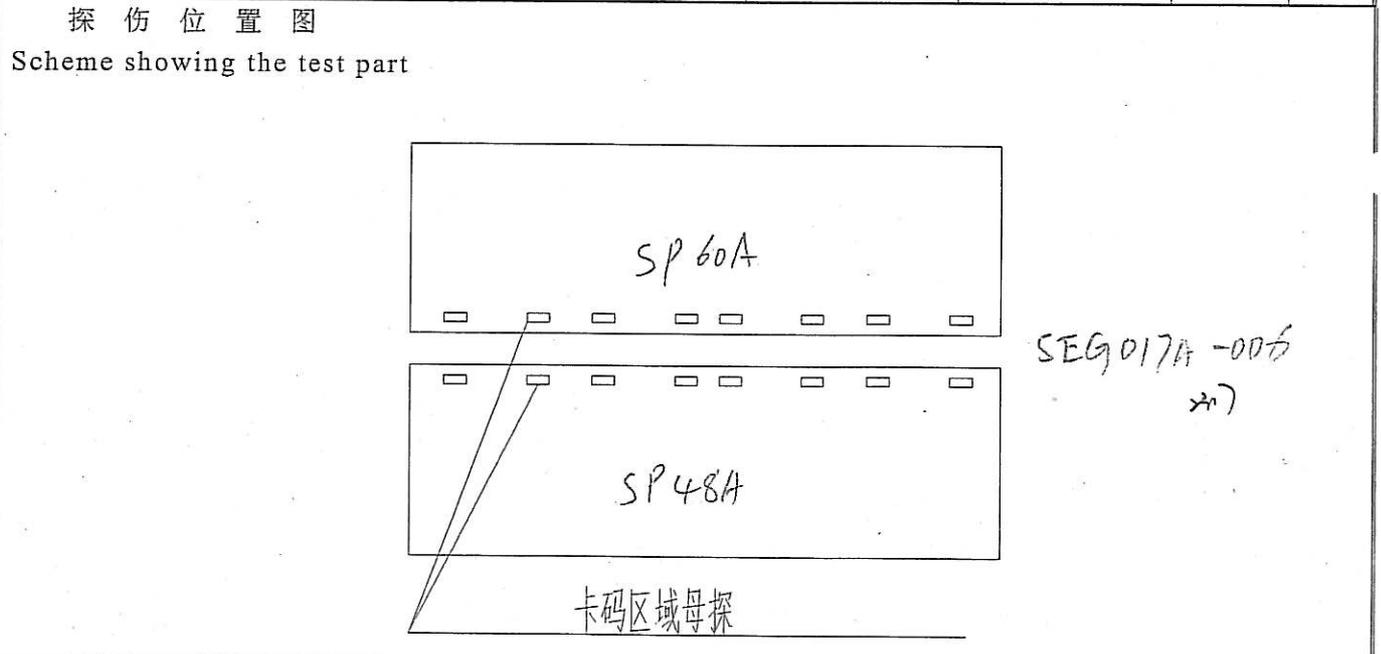


# 母材探伤申请表

SHANGHAI ZHENHUA PORT MACHINERY CO LTD

APPLICATION FORM FOR BASE MATERIAL NDT

产品名称 Project Name		美国海湾大桥		探伤类别 NDT type	数量 Quantity			
序号 No.	零部件图号 Drawing No.	零部件名称 Items	件号 Item No.	数量 Quantity	板厚/尺寸 Thickness/Dimension	炉批号 Batch No.	材料 Material	结论 Result
1	SP60A	SP60A		1	16 X 10006		A709M-24 T2-X	✓
2	SP48A	SP48A		1	16 X 10006		A709M-24 T2-X	✓



申请人 Applicant	沈付友 胡国兴	日期 Date	..	主探者 Inspected by		日期 Date	2028.07.20
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480



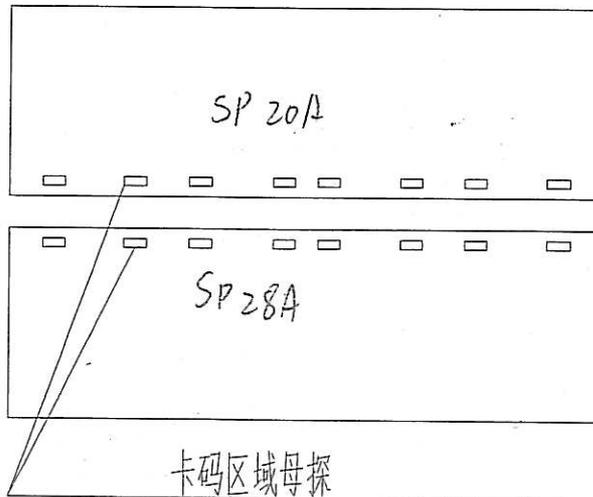
# 母材探伤申请表

SHANGHAI ZHENHUA PORT MACHINERY CO LTD

APPLICATION FORM FOR BASE MATERIAL NDT

产品名称 Project Name		美国海湾大桥		探伤类别 NDT type	数量 Quantity			
序号 No.	零部件图号 Drawing No.	零部件名称 Items	件号 Item No.	数量 Quantity	板厚/尺寸 Thickness/Dimension	炉批号 Batch No.	材料 Material	结论 Result
1	SP20A	SP20A		1	16X15007		A709M-345 T2-X	✓
2	SP28A	SP28A		1	16X15007		A709M-345 T2-X	✓

探伤位置图  
Scheme showing the test part



SEG019A-002  
1229

卡码区域母探

申请人 Applicant	沈付友 胡国兴	日期 Date	..	主探者 Inspected by	王威	日期 Date	2008.5.21
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REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4807      DATE日期 2008.05.21      PAGE OF页码 1/1      Revision No: 0

PROJECT NO. 工程编号: ZP06-787      CONTRACTOR: 用户: CALTRANS

DRAWING NO. 图号: SEG019A OBG PLATE,PANEL SPLICE      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 Dec. 28<sup>ST</sup>, 2008

EQUIPMENT 设备 MT YOKE      MANUFACTURER 制造商 PARKER      MODEL NO. 样式编号 B310S      SERIAL NO. 连续编号 5395 5617 5620

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  WELDING 焊接件  CASTING 铸件  FORGING 锻造      Material & thickness 母材,厚度 A709M-345T2-X 16mm

WELDING PROCESS 焊接方法 NA      TYPE OF JOINT 焊缝类型 material

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			
SP20A				ACC.		100%MT
SP28A				ACC.		100%MT

BLANK

EXAMINED BY主探 Wang Wei 2008.05.21      REVIEWED BY审核 C. C. Liming 2008.05.21

LEVEL - II SIGN 签名 / DATE日期      LEVEL-II SIGN / DATE日期

质量经理 / QCM      用户CUSTOMER

签字 SIGN / 日期 DATE      签字 SIGN / 日期 DATE



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 08/25/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000132(ZPMC-0126)FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-293 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000132 (ZPMC-0126)
- (3) COPY OF INTERNAL NCR-B-057
- (4) COPY OF NDT REPORTS.

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

*Ruby Li*

PLAN HOLDER

RECEIVED 25 AUG 2008  
1107

DATE



COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. B-293

## LETTER OF RESPONSE

**TO:** American Bridge/Flour JV

**DATE:** 2008-8-25

**REGARDING:** NCR-000132

With this letter of response, ZPMC apply to closure the caltrans NCR-000132 (ZPMC-0126) . We agree what describe in the nonconformance report, and have trained the operator that must follow the procedure and WPS during the course of repair. in case of there are some repair we must perform in the future, we should prior MT check to confirm remove the defects completely, then just can perform the welding repair in later.

We attaché the NDT reports for the weld repair point to make sure that the good quality of the welds , please check and revise these documents.

So ZPMC considers the NCR-000132 (ZPMC-0126) can be closed.

Please reference attached documentation for acceptance and close the NCR-000132 (ZPMC-0126) .

**ATTACHMENT:**

NCR-000132 (ZPMC-0126)

ZPMC internal NCR

The NDT reports

*Zhao Shuangbao*

*2008. 8. 25*



# 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-000132 (ZPMC-0126) NCR 编号: NCR-B-057	
Item: base metal weld repairs without following approved repair procedure 名称描述: 未按照批准的返修工艺进行母材和焊缝返修		Item Number: 件号:	Drawing Number: 图号: SEG-717A, SEG-014A, SEG-019A, SEG-017A
Location: OBG assembly shop 位置: 桥面拼装车间		Date: 2008-5-9 日期:	

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

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

ZPMC 没有按照批准的返修工艺移除临时工装并进行母材和焊缝的返修。ZPMC 没有按照批准的返修工艺在返修前对碳刨区域进行磁粉检测。这发生在焊缝 SEG-717A-006, SEG-014A-019, SEG-019A-002 和 SEG-017A-002 上。

Work By: Hu Qiang Prepared by: Lu Guang Bin Reviewed by QCE: Zhao Shuangbao  
 施工方: S.W 准备: 2008.5.09 质量工程师批准: 5.30

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 严格按照批准的返修工艺及对应WPS进行返修。  
Repair according to the approved repair procedure and associated WPS.

Prepared by: Lu Guang Bin                      Approved by QCA: Hu Gang  
 准备                      质量经理批准

**Reason for Nonconformance:**  
不符合原因: 卡马割除后未进行MT检测,就对缺陷清除返修。  
After we removed temporary fit-up aids, we performed base metal weld repairs without performing MT.  
 预防措施 1. 对施焊人操作工批评指正。  
2. 加强现场监控。  
1. Help operators realize their mistake and then correct them.  
2. Enhance inspection in the shop.

Approved by/批准: Lu Guang Bin

**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

加强对返修过程中的现场监控,对操作人员进行了指导与教育,避免此种情况再次发生。  
Strengthen the supervision and control of shop working and training to the relevant personal to avoid the thing appearing again.

Reviewed /批准: Zhao Shuangbao

**Verification:**     Acceptable                       Unacceptable  
 确认:                      可接受                      不可接受

Verified by QCI/质检确认: Liu Zhaoyang                      Reviewed by QCA/质检主任审核: Hu Gang



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, A JV Date: 19-May-2008  
 375 BURMA ROAD Contract No: 04-0120F4  
 OAKLAND CA 95607 Contract No: 04-SF-80-13.2 / 13.9  
 Dear: Mr. Charles Kanapicki Job Name: SAS Superstructure  
 Attention: Mr. Dave Williams Consultant Document No: 05.03.06-000107  
 Subject: NCR No. ZPMC-0126

Reference Description: Base metal repairs without following approved procedures

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.

Material Location: OBG Lift:

**Remarks:**

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure.

ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-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-0126

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

File: 05.03.06

**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

City: 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-000132

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 09-May-2008

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

NCR #: ZPMC-0126

**Type of problem:**Welding  Concrete  Other Welding  Curing  Procedural  Bridge No: 34-0006Joint fit-up  Coating  Other  Component: SEG-717A, SEG-014A, SEG-019A, SEG-0717.Procedural  Procedural  Descriptor: OBG Segment Assemblies

Reference Description: Base metal repairs without following approved procedures

**Description of Non-Conformance:**

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

**Applicable reference:**

ZPMC WPS# WPS-345-SMAW-1G (1F)-FCM-REPAIR

Who discovered the problem: QA Inspector Steve Hall

Name of individual from Contractor notified: ABFJV QC Inspector Mr. Li Jing Bo

Time and method of notification: 5/09/08 2100hrs

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 5/16/08 10:15 telephone

QC Inspector's Name: ZPMC QC Inspector Mr. Chen Xi

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

SMR

Reviewed By: Lowry, Patrick

SMR

## NCR PROPOSED RESOLUTION

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

**Dated:** 10-Dec-2008

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

**Attention:** Pursell, Gary  
Resident Engineer

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000108 **Rev:** 03

**Ref:** 05.03.06-000107

**Subject:** NCR No. ZPMC-0126

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC requests closure of this NCR based on the attached documentation.

Please see attached.

**Submitted by:**

**Attachment(s):** ABF-NPR-000108R03; docs to close this NCR

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**Caltrans' comments:**

**Status:** CLO

**Date:** 21-Dec-2008

The proposed resolution is acceptable. The documents requested in Rev 2 of NPR-0108 have been provided. The Department concurs that Non-Conformance ZPMC-0126 is closed.

**Submitted by:** Wright, Doug

**Date:** 22-Dec-2008

**Attachment(s):**



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 12/05/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: CALTRANS NCR FOR CLOSURE

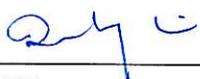
SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

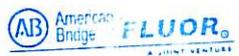
- (1) COPY OF LETTER OF RESPONSE WITH NO.B-293R2 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000132(ZPMC-0126).
- (3) COPY OF MT REPORTS FOR CORRESPONDING 5 WELDS

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

  
 \_\_\_\_\_  
 PLAN HOLDER

RECEIVED 05 DEC 2008  
  
 \_\_\_\_\_  
 DATE

  
 \_\_\_\_\_  
 COMPANY

\_\_\_\_\_  
 PHONE NO.

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



No. B-293R2

## LETTER OF RESPONSE

**TO: American Bridge/Flour JV**

**DATE: 2008-12-5**

**REGARDING: NCR-000132 (ZPMC-0126)**

With this letter of response, ZPMC requests closure for Caltrans **NCR-000132 (ZPMC-0126)**. As the comments from caltrans: please provide documentation that the weld SEG014A-003 repairs were performed and that the repairs were acceptable. So we submit the documentation as follow.

So ZPMC considers **NCR-000132 (ZPMC-0126)** can be closed.

Please check the attached documentation for acceptance and close the **NCR-000132 (ZPMC-0126)**.

**ATTACHMENT:**

**NCR-000132 (ZPMC-0126)**

**The MT reports for corresponding 5 welds**

*Zhuo Shuangbao*

*2008.12.5*

*Thomas W. Lambert  
ABE QCM  
10 DEC. 08*





# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-5406      DATE日期 2008.05.27      PAGE OF页码 1/1      Revision No: 0

PROJECT NO. 工程编号: ZP06-787	CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SEG014A Bottom plate	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
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 <sup>ST</sup> , 2008
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	MODEL NO. 样式编号 B310S
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	SERIAL NO. 连续编号 5395 5617 5620
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	CURRENT 电流 AC
WELDING PROCESS 焊接方法	NA	YOKE SPACING 磁轭间距 70~150mm
		Material & thickness 母材,厚度 A709M-345T2-X 16 mm
		TYPE OF JOINT 焊缝类型 MATERIAL

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			
BP5				ACC.		MATERIAL
BP6				ACC.		MATERIAL
BLANK						

Xu Hai <u>Xu Hai</u> LEVEL - II SIGN 签名 / DATE日期 08.5.27	 LEVEL-II SIGN / DATE日期
质量经理 / QCM <u>Hu Guang</u> 签字 SIGN / 日期 DATE 12.5	用户CUSTOMER _____ 签字 SIGN / 日期 DATE



No. B-293R1

## LETTER OF RESPONSE

**TO: American Bridge/Flour JV**

**DATE: 2008-11-18**

**REGARDING: NCR-000132 (ZPMC-0126)**

With this letter of response, ZPMC requests closure for Caltrans **NCR-000132 (ZPMC-0126)**. As the comments from caltrans: please provide documentation that the weld repairs were performed and that the repairs were acceptable. So we submit the documentation as follow.

So ZPMC considers **NCR-000132 (ZPMC-0126)** can be closed.

Please check the attached documentation for acceptance and close the **NCR-000132 (ZPMC-0126)**.

**ATTACHMENT:**

**NCR-000132 (ZPMC-0126)**

**The MT reports for corresponding 4 welds**

*zhaoshuangbao*

*2008.11.18.*

探伤报告编号 B78 MT-4804

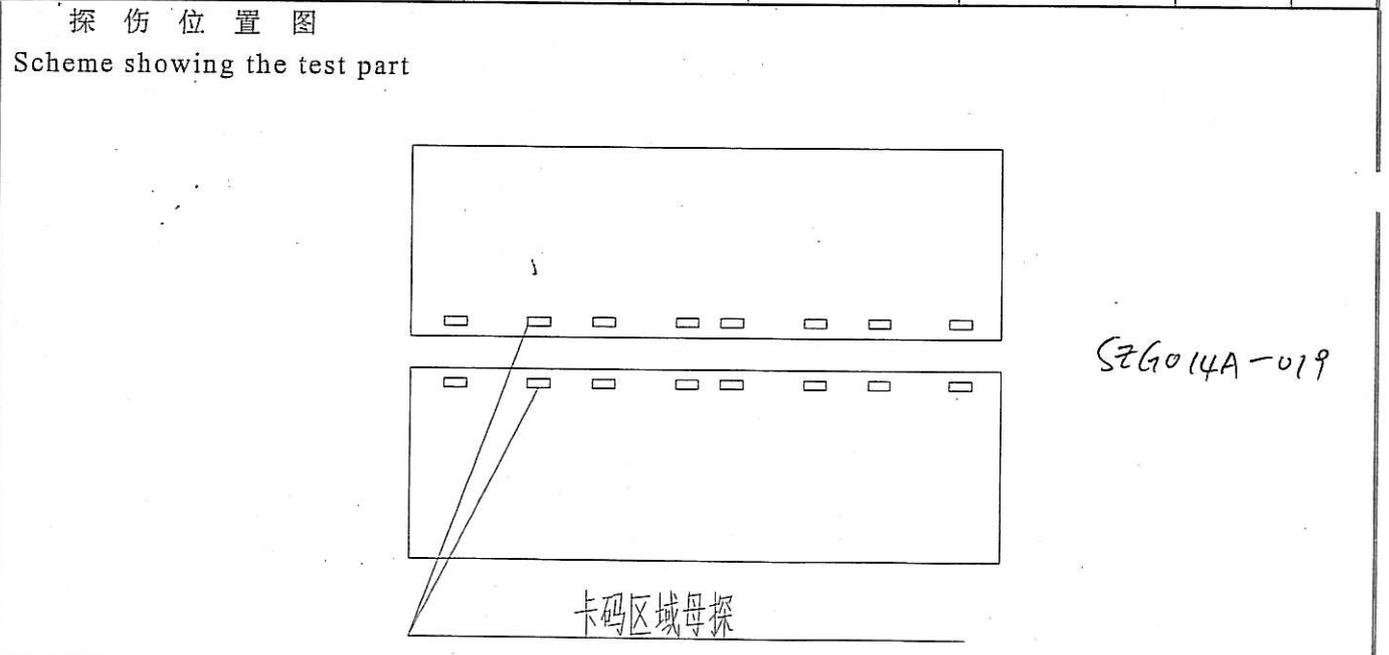


# 母材探伤申请表

SHANGHAI ZHENHUA PORT MACHINERY CO LTD

APPLICATION FORM FOR BASE MATERIAL NDT

产品名称 Project Name		美国海湾大桥		探伤类别 NDT type	数量 Quantity			
序号 No.	零部件图号 Drawing No.	零部件名称 Items	件号 Item No.	数量 Quantity	板厚/尺寸 Thickness/Dimension	炉批号 Batch No.	材料 Material	结论 Result
	SEG-014A	SP40A			16 x 504			✓
	SEG014A	SP52A			16 x 504			✓



申请人 Applicant		日期 Date	..	主探者 Inspected by		日期 Date	2008.5.27
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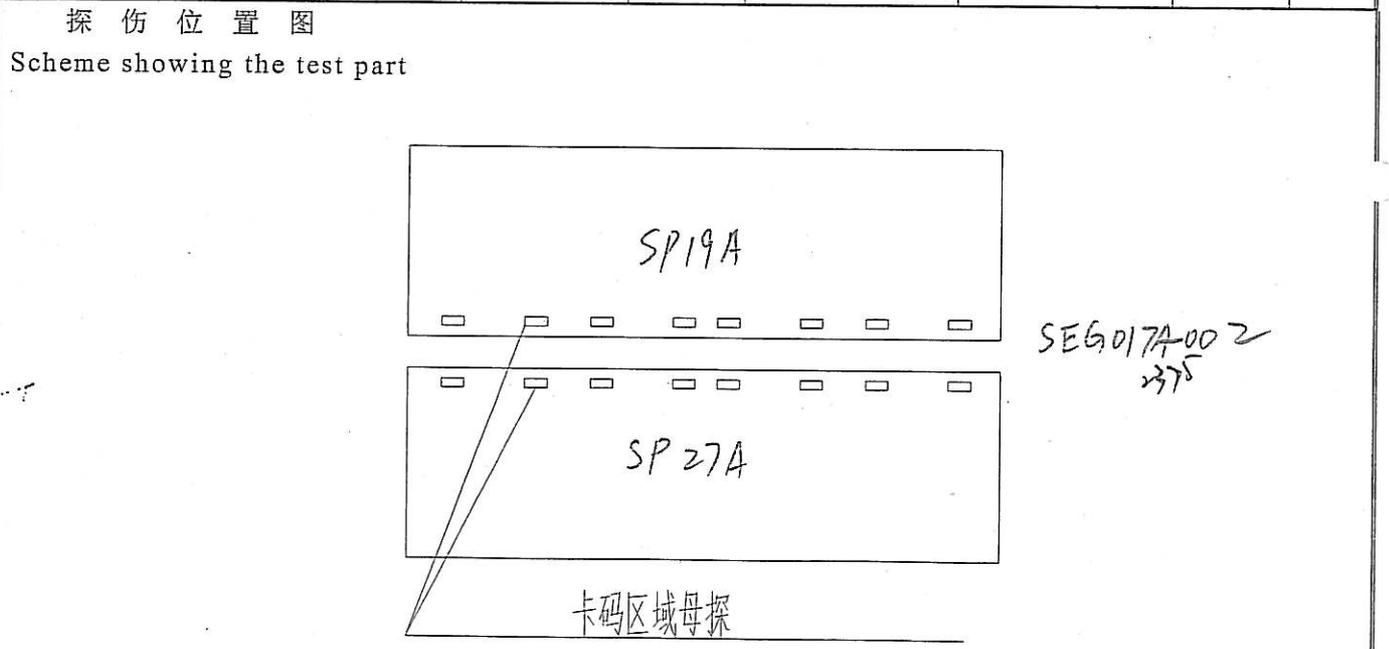


# 母材探伤申请表

SHANGHAI ZHENHUA PORT MACHINERY CO LTD

APPLICATION FORM FOR BASE MATERIAL NDT

产品名称 Project Name		美国海湾大桥		探伤类别 NDT type	数量 Quantity			
序号 No.	零部件图号 Drawing No.	零部件名称 Items	件号 Item No.	数量 Quantity	板厚/尺寸 Thickness/Dimension	炉批号 Batch No.	材料 Material	结论 Result
1	SP19A	SP19A		1	16x10006		A709M-345T2-X	✓
2	SP27A	SP27A		1	16x10006		A709M-345T2-X	✓



申请人 Applicant	沈付友 胡国兴	日期 Date	..	主探者 Inspected by		日期 Date	2008.7.1
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480

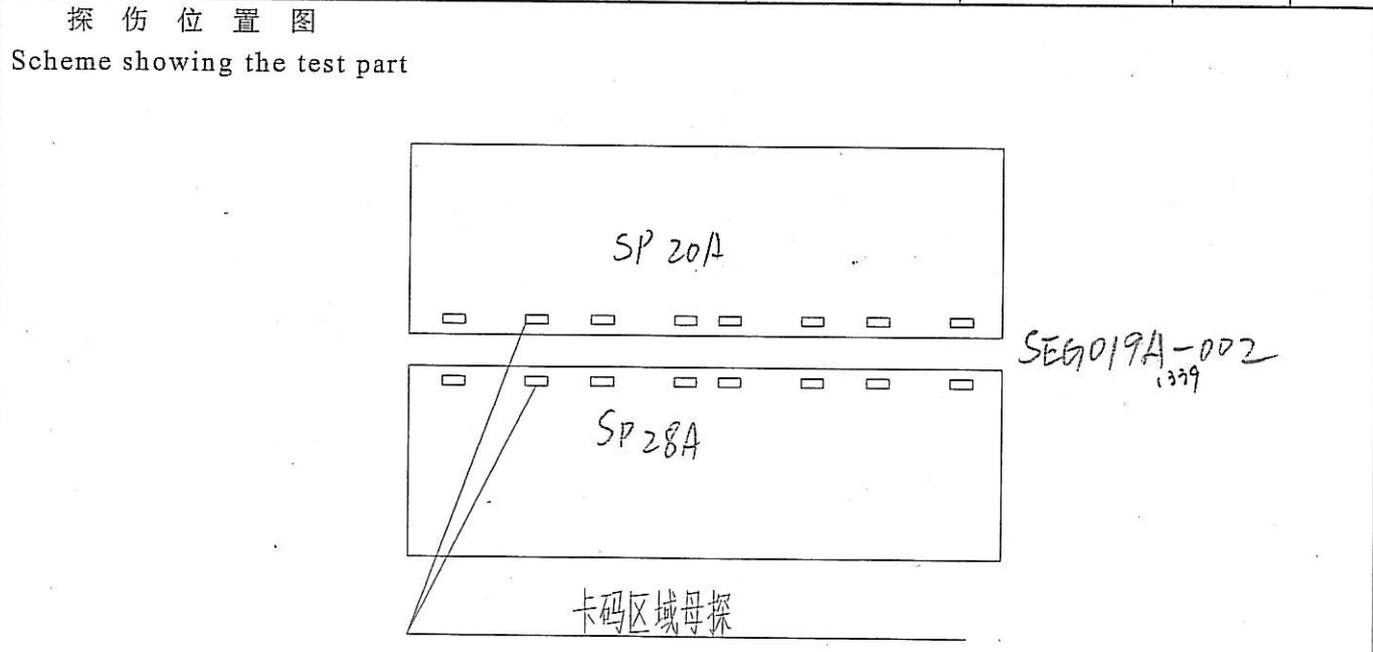


# 母材探伤申请表

SHANGHAI ZHENHUA PORT MACHINERY CO LTD

APPLICATION FORM FOR BASE MATERIAL NDT

产品名称 Project Name		美国海湾大桥		探伤类别 NDT type	数量 Quantity			
序号 No.	零部件图号 Drawing No.	零部件名称 Items	件号 Item No.	数量 Quantity	板厚/尺寸 Thickness/Dimension	炉批号 Batch No.	材料 Material	结论 Result
1	SP20A	SP20A		1	16X15007		A709M-345 T2-X	✓
2	SP28A	SP28A		1	16X15007		A709M-345 T2-X	✓



申请人 Applicant	沈付友 胡国兴	日期 Date	..	主探者 Inspected by	王威	日期 Date	2008.5.21
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TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 08/25/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000132(ZPMC-0126)FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-293 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000132 (ZPMC-0126)
- (3) COPY OF INTERNAL NCR-B-057
- (4) COPY OF NDT REPORTS.

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

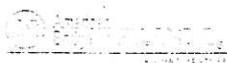
ACKNOWLEDGEMENT:

*Quily L.*

\_\_\_\_\_  
PLAN HOLDER

RECEIVED 25 AUG 2008  
1107

\_\_\_\_\_  
DATE



\_\_\_\_\_  
COMPANY

\_\_\_\_\_  
PHONE NO.

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



No. B-293

## LETTER OF RESPONSE

**TO:** American Bridge/Flour JV

**DATE:** 2008-8-25

**REGARDING:** NCR-000132

With this letter of response, ZPMC apply to closure the caltrans NCR-000132 (ZPMC-0126) . We agree what describe in the nonconformance report, and have trained the operator that must follow the procedure and WPS during the course of repair. in case of there are some repair we must perform in the future, we should prior MT check to confirm remove the defects completely, then just can perform the welding repair in later.

We attaché the NDT reports for the weld repair point to make sure that the good quality of the welds , please check and revise these documents.

So ZPMC considers the NCR-000132 (ZPMC-0126) can be closed.

Please reference attached documentation for acceptance and close the NCR-000132 (ZPMC-0126) .

**ATTACHMENT:**

NCR-000132 (ZPMC-0126)

ZPMC internal NCR

The NDT reports

*Zhao Shuangbo*

*2008.8.25*



# 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-000132 (ZPMC-0126) NCR 编号: NCR-B-057	
Item: base metal weld repairs without following approved repair procedure 名称描述: 未按照批准的返修工艺进行母材和焊缝返修		Item Number: 件号:	Drawing Number: 图号: SEG-717A, SEG-014A, SEG-019A, SEG-017A

Location: OBG assembly shop 位置: 桥面拼装车间	Date: 2008-5-9 日期:
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**Description of Nonconformance:**  
不符合项状态描述:

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

ZPMC 没有按照批准的返修工艺移除临时工装并进行母材和焊缝的返修。ZPMC 没有按照批准的返修工艺在返修前对碳刨区域进行磁粉检测。这发生在焊缝 SEG-717A-006, SEG-014A-019, SEG-019A-002 和 SEG-017A-002 上。

Work By: Hu Qiang Prepared by: Lu Yuhong Reviewed by QCE: Zhuo Shuangbao  
施工方: SJW 准备: 2008.5.29 质量工程师批准: 5.30

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: 严格按照批准的返修工艺及对应WPS进行返修。  
Repair according to the approved repair procedure and associated WPS.

Prepared by: Lu Guang Bin    Approved by QCA: Hu Gang  
准备:    质量经理批准

**Reason for Nonconformance:**  
不符合原因: 卡马割除后未进行MT检测,就对缺陷清除返修。  
After we removed temporary fit-up aids, we performed base metal weld repairs without performing MT.

预防措施: 1. 对拖焊人操作工批评指正。  
2. 加强现场监控。  
1. Help operators realize their mistake and then correct them.  
2. Enhance inspection in the shop.

Approved by/批准: Lu Guang Bin

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

加强对返修过程中的现场监控,对操作人员进行指导与教育,避免此种情况再次发生。  
Strengthen the supervision and control of shop working and training to the relevant personal to avoid the thing appearing again.

Reviewed/批准: Zhuo Shuangbao

Verification:  Acceptable     Unacceptable  
确认:                      可接受                      不可接受

Verified by QCI/质检确认: Liu Zhao gang    Reviewed by QCA/质检主任审核: Hu Gang



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, A JV Date: 19-May-2008  
 375 BURMA ROAD Contract No: 04-0120F4  
 OAKLAND CA 95607 Contract No: 04-SF-80-13.2 / 13.9  
 Dear: Mr. Charles Kanapicki Job Name: SAS Superstructure  
 Attention: Mr. Dave Williams Consultant Document No: 05.03.06-000107  
 Subject: NCR No. ZPMC-0126

Reference Description: Base metal repairs without following approved procedures

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.

Material Location: OBG

Lift:

**Remarks:**

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-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-0126

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

File: 05.03.06

**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-000132

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 09-May-2008

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

**NCR #:** ZPMC-0126

**Type of problem:**

Welding  Concrete  Other   
 Welding  Curing  Procedural  **Bridge No:** 34-0006  
 Joint fit-up  Coating  Other  **Component:** SEG-717A, SEG-014A, SEG-019A, SEG-0717A  
 Procedural  Procedural  **Descriptor:** OBG Segment Assemblies

**Reference Description:** Base metal repairs without following approved procedures

**Description of Non-Conformance:**

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #'s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

**Applicable reference:**

ZPMC WPS# WPS-345-SMAW-1G (1F)-FCM-REPAIR

**Who discovered the problem:** QA Inspector Steve Hall

**Name of individual from Contractor notified:** ABFJV QC Inspector Mr. Li Jing Bo

**Time and method of notification:** 5/09/08 2100hrs

**Name of Caltrans Engineer notified:** Stanley Ku

**Time and method of notification:** 5/16/08 10:15 telephone

**QC Inspector's Name:** ZPMC QC Inspector Mr. Chen Xi

**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

SMR

**Reviewed By:** Lowry, Patrick

SMR

**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-000161**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jan-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0126**Type of problem:**

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

**Date the Non-Conformance Report was written:** 09-May-2008**Description of Non-Conformance:**

The Contractor removed temporary fit-up aids and performed base metal weld repairs without following the approved repair procedure. ZPMC did not perform magnetic particle examination of the excavated areas prior to repair welding as stated in the approved repair procedure. This occurred on weld joint #s SEG-717A-006, SEG-014A-003, SEG-014A-019, SEG-019A-002 and SEG-017A-002.

**Contractor's proposal to correct the problem:**

Reference: ZPMC Letter NCR-000132

**Corrective action taken:**

Repair is accepted as indicated by 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