

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-000181**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0164**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Tower Double Diaphragms**Procedural****Procedural****Descriptor:** Shipping of Tower Diaphragms not completed**Reference Description:** 04-0120F4 Special Provisions, ABF/ZPMC Welding Quality Control Plan**Description of Non-Conformance:**

ZPMC shipped of five (5) Tower Double Diaphragms identified as ESD1-38m, ESD1-33m, SSD1-38m, SSD1-47.6m and SSD1-23m for machining with fabrication and testing not completed. The aforementioned double diaphragms were not accepted by ABF Quality Control (QC) at time of shipping to Nantong due to weld discontinuities in need of repair, required nondestructive testing not completed and weld terminations not acceptable to project specifications. Below is a digital photograph illustrating the loading in progress.

**Applicable reference:**

ABF-SUB-093R04 77-m (Type 3B) Mock-Up Fabrication Plan

Who discovered the problem: Greg Bertlesman, Quality Assurance Inspector**Name of individual from Contractor notified:** Don Walton**Time and method of notification:** 09/03/08; 1300; Verbal**Name of Caltrans Engineer notified:** Scott Kennedy, Structures Construction**Time and method of notification:** 09/03/08; 1400; Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: Fu Yuhong

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 Joshua Ishibashi, who represents the Office of Structural Materials for your project.

Inspected By:	Ishibashi,Josh	SMR
----------------------	----------------	-----

Reviewed By:	Smith,Ryan	SMR
---------------------	------------	-----



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 09-Sep-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: 05.03.06-000154

Subject: NCR No. ZPMC-0164

Reference Description: Failure to Follow Approved Procedure / Double Diaphragm Assembles / Second Shipment

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: Tower **Lift:** 01

Remarks:

ZPMC shipped of five (5) Tower Double Diaphragms identified as ESD1-38m, ESD1-33m, SSD1-38m, SSD1-47.6m and SSD1-23m for machining with fabrication and testing not completed. The aforementioned double diaphragms were not accepted by ABF Quality Control (QC) at time of shipping to Nantong due to weld discontinuities in need of repair, required nondestructive testing not completed and weld terminations not acceptable to project specifications.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with the approved procedures and the steps taken by the Quality Control Manager to prevent future failures to follow the submitted and approved procedures.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0164

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000154

Subject: NCR No. ZPMC-0164

Dated: 11-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000158 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC violated the sequence of the fabrication procedure at their own risk. ABF has instructed ZPMC to follow the fabrication procedure.

ZPMC violated the sequence of the fabrication procedure at their own risk. ABF has instructed ZPMC to follow the fabrication procedure. If the fabrication cannot be completed as written ZPMC shall revise the fabrication procedure prior to welding. Double Diaphragms, when returned will be completed. Contrary to the NCR, ABFJV does not have a hold point for acceptance of materials prior to shipping to the machine shop.

Submitted by:

Attachment(s): ABF-NPR-000158R00

Caltrans' comments:

Status: REJ

Date: 28-Sep-2008

The proposed resolution with the statement that "ABF has instructed ZPMC to follow the fabrication procedure. If the fabrication cannot be completed as written ZPMC shall revise the fabrication procedure prior to welding" would be an acceptable resolution. However it is unclear as to whether ABFJV is in agreement that ZPMC has violated the fabrication procedures due to ABFJV's assertion that there is not "a hold point for acceptance of the materials prior to shipping." It is the Department's position that Step 5 of the Diaphragm Fabrication Procedure FP-MUA-21, approved in Submittal 93R03, while not addressing acceptance of the materials does clearly indicate a hold point for inspection and correction prior to machining the diaphragms.

Therefore the proposed resolution as presented by ABFJV is not acceptable.

Submitted by: Wright, Doug

Date: 28-Sep-2008

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000154

Subject: NCR No. ZPMC-0164

Dated: 13-Feb-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000158 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC provided the requested inspection documents.

ZPMC has provided the inspection documents as requested. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000158R01;

Caltrans' comments:

Status: CLO

Date: 17-Feb-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0164 is closed.

Submitted by: Wright, Doug

Date: 17-Feb-2009

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 02/05/2009

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR FOR CLOSURE

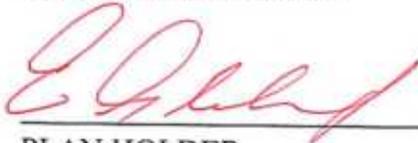
SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.T-024 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-181(ZPMC-164)
- (3) ~~COPY OF ABF-NPR-000179~~ *d.l. 2/9/09*
- (4) COPY OF NDT REPORTS

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



PLAN HOLDER

5-Feb-2009 (2:43)

DATE

ABFJV

COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. T-024

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-2-5

REGARDING: NCR-181 ZPMC-164

ZPMC received NCR-181(ZPMC-164), it mentioned that ZPMC was shipping five tower double diaphragms identified as ESD1-38m, ESD1-33m, SSD1-38, SSD1-47.6m and SSD1-23m for machining, with fabrication and testing not completed.

ZPMC had verified and acknowledged this problem. Due to the tight schedule, ZPMC decided to send these five diaphragms to Nantong Base for machining. Before ZPMC sent out, most of the work was finished including welding, grinding, repairing and part of NDT. So ZPMC thought the diaphragm state at that time were already satisfied with machining condition. After all five diaphragms getting back, the technician finished all the required NDT and these five diaphragms had gotten Caltrans' green tag.

So ZPMC request to close this NCR basing on AB/F NCR Proposed Solution ABF-NPR-000179 and here provided all the NDT reports, hoped Caltrans can take a review and close NCR ZPMC-164.

ATTACHMENT:

NCR-000181 (ZPMC-0164)

ABF-NPR-000179

ESD1-38M NDT reports:

Upper diaphragm plate butt welding: T787-UT-063 & T787-MT-090

Lower diaphragm plate butt welding: T787-UT-215 & T787-MT-315

Welds between upper and lower diaphragm plates with web plates: T787-MT-558

Welds between upper diaphragm plate with flange ring: T787-MT-731

Welds between lower diaphragm plate with flange ring: T787-MT-732

Upper diaphragm flange ring butt welding: T787-UT-284

Lower diaphragm flange ring butt welding: T787-UT-276

ESD1-33M NDT reports:

Upper diaphragm plate butt welding: T787-UT-142 & T787-MT-545

Lower diaphragm plate butt welding: T787-UT-360 & T787-MT-008

Welds between upper and lower diaphragm plates with web plates:

T787-MT-550 & T787-MT-523

Welds between upper diaphragm plate with flange ring: T787-MT-549

Welds between lower diaphragm plate with flange ring: T787-MT-327

Lower diaphragm flange ring butt welding: T787-UT-217

SSDI-38M NDT reports:

Upper diaphragm plate butt welding: T787-UT-041 & T787-MT-051

Lower diaphragm plate butt welding: T787-UT-013, 013R1, 013R2 & T787-MT-108

Welds between upper and lower diaphragm plates with web plates: T787-MT-532

Welds between upper diaphragm plate with flange ring: T787-MT-531

Welds between lower diaphragm plate with flange ring: T787-MT-530

Upper diaphragm flange ring butt welding: T787-UT-275

Lower diaphragm flange ring butt welding: T787-UT-274

SSDI-47.6M NDT reports:

Upper diaphragm plate butt welding: T787-UT-151 & T787-MT-286

Lower diaphragm plate butt welding: T787-UT-008 & T787-MT-009

Welds between upper and lower diaphragm plates with web plates: T787-MT-527

Welds between upper diaphragm plate with flange ring: T787-MT-526

Welds between lower diaphragm plate with flange ring: T787-MT-525

Upper diaphragm flange ring butt welding: T787-UT-295

Lower diaphragm flange ring butt welding: T787-UT-193

SSDI-23M NDT reports:

Upper diaphragm plate butt welding: T787-UT-178 & T787-MT-264

Lower diaphragm plate butt welding: T787-UT-173 & T787-MT-251

Welds between upper and lower diaphragm plates with web plates:

T787-MT-539 & T787-MT-540

Welds between upper diaphragm plate with flange ring: T787-MT-538

Welds between lower diaphragm plate with flange ring: T787-MT-537

Upper diaphragm flange ring butt welding: T787-UT-286

Lower diaphragm flange ring butt welding: T787-UT-270


2009-2-5



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94612
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR. A. S. Date: 09-Sep-2006
375 BURMA ROAD
OAKLAND CA 95607 Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki Job Name: SAS Superstructure
Attention: Mr. Dave Williams Document No: 05.03.06-000154
Consultant
Subject: NCR No. ZPMC-0164

Reference Description: Failure to Follow Approved Procedure / Double Diaphragm Assembles / Second Shipment

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: Tower

Lift: 01

Remarks:

ZPMC shipped of five (5) Tower Double Diaphragms identified as ESD1-38m, ESD1-33m, SSD1-38m, SSD1-47.6m and SSD1-23m for machining with fabrication and testing not completed. The aforementioned double diaphragms were not accepted by ABF Quality Control (QC) at time of shipping to Nantong due to weld discontinuities in need of repair, required nondestructive testing not completed and weld terminations not acceptable to project specifications.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with the approved procedures and the steps taken by the Quality Control Manager to prevent future failures to follow the submitted and approved procedures.

Transmitted by: Scott Kennedy Sr. Bridge Engineer
Attachments: ZPMC-0164

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe
File: 05.03.06

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICE
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. Ste. 12
 Vallejo, CA 94592-1132
 (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-000181

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 02-Sep-2008

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

NCR #: ZPMC-0164

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Tower Double Diaphragms
 Procedural Procedural Description: Shipping of Tower Diaphragms not completed
 Reference Description: 04-0120F4 Special Provisions, ABF/ZPMC Welding Quality Control Plan

Description of Non-Conformance:

ZPMC shipped of five (5) Tower Double Diaphragms identified as ESD1-38m, ESD1-33m, SSD1-38m, SSD1-47.6m and SSD1-23m for machining with fabrication and testing not completed. The aforementioned double diaphragms were not accepted by ABF Quality Control (QC) at time of shipping to Nantong due to weld discontinuities in need of repair, required nondestructive testing not completed and weld terminations not acceptable to project specifications. Below is a digital photograph illustrating the loading in progress.



Applicable reference:

ABF-SUB-093R04 77-m (Type 3B) Mock-Up Fabrication Plan

Who discovered the problem: Greg Bertlesman, Quality Assurance Inspector

Name of individual from Contractor notified: Don Walton

Time and method of notification: 09/03/08; 1300; Verbal

Name of Caltrans Engineer notified: Scott Kennedy, Structures Construction

Time and method of notification: 09/03/08; 1400; Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: Fu Yuhong

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 Joshua Ishibashi, who represents the Office of Structural Materials for your project.

Inspected By: Ishibashi, Josh

SMR

Reviewed By: Smith, Ryan

SMR



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-063

DATE 2008.05.06

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 38M UPPER DIAPHRAGM
部件名称

DRAWING NO.: SA371(E)+P965(E)
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
SAW

JOINT TYPE 焊缝类型
BUTT

CALIBRATION DUE DATE 仪器校正有效期
DEC. 28th, 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 IIV BLOCK TYPE II

COUPLANT 耦合剂
C.M.C

MATERIAL/THICKNESS 材料厚度
A709M-HPS-485WT2-Z/ 75mm

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	45 °	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)						
ESD1-SA371A/B-8A/8B		68.7			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	ACC.	
		44.6												ACC.	

BLANK

EXAMINED BY 主探

Xu Huiyong 2008.05.06
LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Li Chunying 2008.05.06
LEVEL - II SIGN / DATE

质量经理 / QCM

Hu Gang 2008.5.15
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 T787-MT-558		DATE 日期 2008.08.27		PAGE OF 页码 1/2	Revision No: 0	
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SA371+SA348 TOWER(E) 38M DIAPHRAGM			CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4			
REFERENCING CODE 参考规范编号 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 th , 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 5517			
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 锻件	Material & thickness 母材, 厚度	A709M-HPS-485WT2			
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT			
WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
ESD1-SA371B/B-3				ACC.		
ESD1-SA371B/B-4				ACC.		
ESD1-SA371B/B-7				ACC.		
ESD1-SA371B/B-8				ACC.		
ESD1-SA371B/B-11				ACC.		
ESD1-SA371B/B-12				ACC.		
ESD1-SA371B/B-15				ACC.		
ESD1-SA371B/B-16				ACC.		
ESD1-SA371B/B-1				ACC.		
ESD1-SA371B/B-2				ACC.		
ESD1-SA371B/B-5				ACC.		
ESD1-SA371B/B-6				ACC.		
ESD1-SA371B/B-9				ACC.		
ESD1-SA371B/B-10				ACC.		
EXAMINED BY 主操 <i>Zhou Donglin</i>			REVIEWED BY 审核 <i>Cai Xinlin</i>			
LEVEL - II SIGN 签名 / DATE 日期 <i>2008.8.27</i>			LEVEL-II SIGN / DATE 日期 <i>08-08-27</i>			
质量经理 / QCM <i>Hu Chen</i> <i>2008.08.27</i>			用户 CUSTOMER			
签字 SIGN / 日期 DATE			签字 SIGN / 日期 DATE			



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-558 DATE日期 2008.08.27 PAGE OF 页码 2/2 Revision No: 0

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

DRAWING NO. 图号: SA371+SA348 TOWER(E) 38M DIAPHRAGM CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4

REFERENCING CODE 参考规范编号: 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. 28th, 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 锻件 Material & thickness 母材, 厚度: A709M-HPS-485WT2 75/60/40mm

WELDING PROCESS 焊接方法: SMAW TYPE OF JOINT 焊缝类型: T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
ESD1-SA371B/B-13				ACC.		
ESD1-SA371B/B-14				ACC.		
ESD1-SA348-11				ACC.		
ESD1-SA348-12				ACC.		
ESD1-SA348-13				ACC.		
ESD1-SA348-14				ACC.		
ESD1-SA348-15				ACC.		
ESD1-SA348-16				ACC.		

BLANK

EXAMINED BY 主操: Zhou Dongfeng REVIEWED BY 审核: Cai Xinmin

LEVEL-II SIGN 签名 / DATE 日期: 2008-8-27 LEVEL-II SIGN 签名 / DATE 日期: 08-08-27

质量经理 / QCM: Huibang 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 T787-MT-732		DATE 日期 2008.09.20		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: ESD1-SA348 TOWER(E) 38M LOWER DIAPHRAGM			CALTRANS CONTRACT NO.: 杭州工程编号 04-0120F4				
REFERENCING CODE 参考规范编号: 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 th , 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 锻件		Material & thickness 母材, 厚度		A709M-345T2 /A709M-HPS-455WT2 75/60 mm	
WELDING PROCESS 焊接方法		FCAW		TYPE OF JOINT 焊缝类型 T-JOINT			
WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注	
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度				
ESD1-SA348-1				ACC.			
ESD1-SA348-2				ACC.			
BLANK							
EXAMINED BY 主检 <u>Su.wei</u>				REVIEWED BY 审核 <u>Xutai</u>			
LEVEL-II SIGN 签名 / DATE 日期 <u>2008/09/20</u>				LEVEL-II SIGN / DATE 日期 <u>08.9.20</u>			
质量经理 / QCM <u>Huqiang</u> <u>2008.9.20</u>				用户 CUSTOMER			
签字 SIGN / 日期 DATE				签字 SIGN / 日期 DATE			



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-284

DATE 2008.08.03

PAGE 1 OF 2

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 38M LOWER DIAPHRAGM

DRAWING NO.: ESD1-SA373

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 EDGE PLATE

页号

加州工程编号

REFERENCING CODE 参考规范

ACCEPTANCE STANDARD 接受标准

PROCEDURE NO. 程序编号

AWS D1.5-2002

AWS D1.5-2002(Table 6.3)

ZPQC-UT-01

WELDING PROCESS 焊接方法

JOINT TYPE 焊缝类型

CALIBRATION DUE DATE 仪器校正有效期

FCAW

BUTT

DEC. 28th, 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

071565311,061488510,

CALIBRATION BLOCK 试块

COUPLANT 耦合剂

MATERIAL/THICKNESS 材料厚度

061495811, 070152011,

AWS IIW BLOCK TYPE II

C.M.C

A709M-345T2-Z

60mm

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	18*18 mm	Changchao	60°	2.5 MHz	18*18 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 _y (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		
ESD1-SA371A/B-3A(3B)															*
ESD1-SA371A/B-4A(4B)															*
ESD1-SA371A/B-5A(5B)		68.8				32								ACC.	
		58.6				32								ACC.	
ESD1-SA371A/B-7A(7B)															*
ESD1-SA371A/B-8A(8B)															*

EXAMINED BY 主探

REVIEWED BY 审核:

Xuekaiyong 2008.08.03

Li Liming 2008.08.03

LEVEL - II SIGN / DATE

LEVEL - II SIGN / DATE

质量经理 / QCM

用户 CUSTOMER

Huobang 2008.08.03

主探 SIGN / 日期 DATE

主探 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-276

DATE 2008.07.30

PAGE 1 OF 2

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 38M LOWER DIAPHRAGM

DRAWING NO.: ESD1-SA374

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 EDGE PLATE

型号

加州工程编号

REFERENCING CODE 参考规范

ACCEPTANCE STANDARD 接受标准

PROCEDURE NO. 程序编号

AWS D1.5-2002

AWS D1.5-2002(Table 6.3)

ZPQC-UT-01

WELDING PROCESS 焊接方法

JOINT TYPE 焊缝类型

CALIBRATION DUE DATE 仪器校正有效期

FCAW

BUTT

DEC. 28th, 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

071565311,061488510,

061495811, 070152011,

CALIBRATION BLOCK 试块

COUPLANT 耦合剂

MATERIAL/THICKNESS 材料厚度

AWS IIW BLOCK TYPE II

C.M.C

A709M-345T2

60mm

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	18*18 mm	Changchao.	60 °	2.5 MHz	18*18 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		
ESD1-SA348-3A(3B)															*
ESD1-SA348-4A(4B)															*
ESD1-SA348-5A(5B)															*
ESD1-SA348-6A(6B)															*
ESD1-SA348-7A(7B)															*
ESD1-SA348-8A(8B)		69.2				33									ACC..

EXAMINED BY 主探

REVIEWED BY 审核:

Xue Hong 2008.07.30
LEVEL - II SIGN 1 DATE

Zhuang Lin
LEVEL - II SIGN 1 / 1 DATE 2008.07.30

质量经理 / QCM

用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-360

DATE 2008.08.27

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: THE FIRST LIFTING
部件名称DRAWING NO.: SA317(E), P831(E)
图号CALTRANS CONTRACT NO.: 04-0120F4
加州工程编号REFERENCING CODE 参考标准
AWS D1.5-2002ACCEPTANCE STANDARD 接受标准
AWS D1.5-2002 (Table 6.3)PROCEDURE NO. 程序编号
ZPQC-UT-01WELDING PROCESS 焊接方法
SAWJOINT TYPE 焊缝类型
BUTTCALIBRATION DUE DATE 仪器校正有效期
DEC. 28th, 2008EQUIPMENT 设备
UT SCOPEMANUFACTURER 制造商
PANAMETRICSMODEL NO. 样式编号
EPOCH-4BSERIAL NO. 序列编号
071565311, 061488510,
061495811, 070152011,CALIBRATION BLOCK 试块
AWS IIW BLOCK TYPE IICOUPLANT 耦合剂
C.M.CMATERIAL/THICKNESS 材料厚度
A709M-HPS-485WT2-Z 75mm

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	18*18 mm	Changchao	45°	2.5 MHz	18*18 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 不连续体					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
ESD1-SA317-3A(3B)		68.3				33									ACC.	
		44.8				33									ACC.	
ESD1-SA317-4A(4B)		68.3				33									ACC.	
		44.8				33									ACC.	
BLANK																

EXAMINED BY 主操

REVIEWED BY 审核:

LEVEL-II SIGN / DATE

LEVEL-II SIGN / DATE

质量经理 / QCM

用户 CUSTOMER

主操 SIGN / 日期 DATE

主操 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-550		DATE日期 2008.08.26	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: SA317(E) TOWER(E) 33M DIAPHRAGM		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 th , 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	<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-HPS-485WT2-Z 75/60/40mm	
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT	

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
ESD1-SA318B/B-3				ACC.		
ESD1-SA318B/B-4				ACC.		
ESD1-SA318B/B-5				ACC.		
ESD1-SA318B/B-6				ACC.		
ESD1-SA318B/B-10				ACC.		
ESD1-SA318B/B-12				ACC.		
ESD1-SA318B/B-14				ACC.		
ESD1-SA318B/B-15				ACC.		
BLANK						

EXAMINED BY 主操 <u>Cai Xin Min</u> LEVEL-II SIGN 签名 / DATE日期 07.08.26	REVIEWED BY 审核 <u>Wang Wei</u> LEVEL-II SIGN / DATE日期 07.08.26
质量经理 / QCM <u>Hu...</u> 2008.08.07	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-523		DATE日期 2008.08.23	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: SA318(E) TOWER(E) 33M DIAPHRAGM		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 ST , 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	<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-HPS-485WT2-Z 40/60/75mm	
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT	

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
ESD1-SA318B/B-1				ACC.		
ESD1-SA318B/B-2				ACC.		
ESD1-SA318B/B-7				ACC.		
ESD1-SA318B/B-8				ACC.		
ESD1-SA318B/B-9				ACC.		
ESD1-SA318B/B-11				ACC.		
ESD1-SA318B/B-13				ACC.		
ESD1-SA318B/B-16				ACC.		
BLANK						

EXAMINED BY 主探 <u>Zhou Dong</u>	REVIEWED BY 审核 <u>Cai Xinxin</u>
LEVEL-II SIGN 签名 / DATE日期 <u>08-8-23</u>	LEVEL-II SIGN / DATE日期 <u>08-08-23</u>
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-294

DATE 2008.08.07

PAGE 1 OF 2

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 33M UPPER DIAPHRAGM

DRAWING NO.: ESD1-SA320

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 EDGE PLATE

图号

加州工程编号

REFERENCING CODE 参考规范

ACCEPTANCE STANDARD 接受标准

PROCEDURE NO. 程序编号

AWS D1.5-2002

AWS D1.5-2002(Table 6.3)

ZPQC-UT-01

WELDING PROCESS 焊接方法

JOINT TYPE 焊缝类型

CALIBRATION DUE DATE 仪器校正有效期

FCAW

BUTT

DEC. 28th, 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

071565311, 061488510,

CALIBRATION BLOCK 试块

COUPLANT 耦合剂

MATERIAL/THICKNESS 材料厚度

061495811, 070152011,

AWS IIW BLOCK TYPE II

C.M.C

A709M-345T2

60mm

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	18*18 mm	Changchao	60°	2.5 MHz	18*18 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								
ESD1-SA318A/B-5A5B		68.9				33									ACC.	
		59.3				33									ACC.	
ESD1-SA318A/B-6A6B																*
ESD1-SA318A/B-7A7B		68.9				33									ACC.	
		59.3				33									ACC.	
ESD1-SA318A/B-8A8B																*

EXAMINED BY 主探

REVIEWED BY 审核:

Xu Donggang 2008.08.07
LEVEL-II SIGN / DATE

Ma Jelong 2008.08.07
LEVEL-II SIGN / DATE

质量经理 / QCM

用户 CUSTOMER

Huobang 2008.08.13

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-217

DATE 2008.07.12

PAGE 1 OF 2

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 33M LOWER DIAPHRAGM

DRAWING NO.: SA338

CALTRANS CONTRACT NO.: 04-0120F4

EDGE PLATE

图号

加州工程编号

部件名称 (S)

REFERENCING CODE 参考规范

ACCEPTANCE STANDARD 接受标准

PROCEDURE NO. 程序编号

AWS D1.5-2002

AWS D1.5-2002 (Table 6.3)

ZPQC-UT-01

WELDING PROCESS 焊接方法

JOINT TYPE 焊缝类型

CALIBRATION DUE DATE 仪器校正有效期

FCAW

BUTT

DEC. 28th, 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

071565311, 061488510,

061495811, 070152011,

CALIBRATION BLOCK 试块

COUPLANT 耦合剂

MATERIAL/THICKNESS 材料厚度

AWS IIV BLOCK TYPE II

C.M.C

A709M-345T2 60mm

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	18*18 mm	Changchao	60 °	2.5 MHz	18*18 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 缺陷等级	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							
ESD1-SA317-5A5B														*	
ESD1-SA317-6A6B														*	
ESD1-SA317-7A7B		69.2					33							ACC.	
		58.2					33							ACC.	
ESD1-SA317-8A8B		69.2					33							ACC.	
		58.2					33							ACC.	

EXAMINED BY 主探

Ma Jibong 2008.07.12

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Zhuoqin

LEVEL - II SIGN / DATE 2008.07.12

质量经理 / QCM

Huobing 2008.07.15

用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-041

DATE 2008.04.25

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: SOUTHERN TOWER 38M UPPER
部件名称 DIAPHRAGMDRAWING NO.: SA277(S)+P560(S)
图号CALTRANS CONTRACT NO.: 04-0120F4
加州工程编号REFERENCING CODE 参考规范
AWS D1.5-2002ACCEPTANCE STANDARD 接受标准
AWS D1.5-2002(Table 6.3)PROCEDURE NO. 程序编号
ZPQC-UT-01WELDING PROCESS 焊接方法
SAWJOINT TYPE 焊缝类型
BUTTCALIBRATION DUE DATE 仪器校正有效期
DEC. 28th, 2008EQUIPMENT 设备
UT SCOPEMANUFACTURER 制造商
PANAMETRICSMODEL NO. 样式编号
EPOCH-4BSERIAL NO. 序列编号
071565311, 061488510,
061495811, 070152011,CALIBRATION BLOCK 试块
AWS IIV BLOCK TYPE IICOUPLANT 耦合剂
C.M.CMATERIAL/THICKNESS 材料厚度
A709M-HPS-485WT2-Z / 75mm

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	45 °	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 探头角度	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
SSD1-SA277A/B-1A/1B		68.5				36									ACC.	
		44.5				34									ACC.	

BLANK

EXAMINED BY 主探

Xue Haining 2008.04.25

LEVEL-II SIGN / DATE

REVIEWED BY 审核:

Mao Jisheng 2008.04.25

LEVEL-II SIGN / DATE

质量经理 / QCM

Hu Jiang 2008.5.1

签字 SIGN / 日期 DATE

用户 CUSTOMER

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-013 DATE 2008.04.07 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 38M Tower upper DRAWING NO.: SA293(S)+P559(S) CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 Diaphragm(S) 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 SAW BUTT 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-HPS-485WT2-Z / 75 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	45 °	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 焊缝标识	INDICATION NO. 指示号	PROBE ANGLE 探头角度	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								
SSD1-SA293-1A(1B)		68.7				34									ACC.	
		44.7	A	1	40	30	6	-4	10	96	68	-10	4230		REJ	

BLANK

EXAMINED BY 主操 REVIEWED BY 审核:
 _____ _____
 LEVEL-II SIGN / DATE LEVEL-II SIGN / DATE
 (Signature) (Signature) 2008.04.07

质量经理 / QCM 用户 CUSTOMER
 _____ _____
 签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-013R1

DATE 2008.04.23

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 38M Tower upper
部件名称 Diaphragm(S)

DRAWING NO.: SA293(S)+P559(S)
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
SMAW

JOINT TYPE 焊缝类型
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
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-HPS-485WT2-Z/ 75 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	45 °	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								
SSD1-SA293-1A(1B)		68.5				34									ACC.	
	1R1	44.6	A	1	43	33	6	+4	10	96	68	-10	4310		REJ.	

BLANK

EXAMINED BY 主控

Li L... 2008.04.23

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xue... 2008.04.23

LEVEL - II SIGN / DATE

质量经理 / QCM

Hu... 2008.5.1

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 T787-MT-532		DATE 日期 2008.08.25	PAGE OF 页码 1/2	Revision No: 0		
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS				
DRAWING NO. 图号: SA277+SA293 TOWER(S) 38M DIAPHRAGM		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4				
REFERENCING CODE 参考规范编号 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. 25 th , 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	<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-HPS-485WT2 75/60/40mm			
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT			
WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA277B/B-1				ACC.		
SSD1-SA277B/B-2				ACC.		
SSD1-SA277B/B-13				ACC.		
SSD1-SA277B/B-14				ACC.		
SSD1-SA277B/B-9				ACC.		
SSD1-SA277B/B-10				ACC.		
SSD1-SA277B/B-5				ACC.		
SSD1-SA277B/B-6				ACC.		
SSD1-SA277B/B-3				ACC.		
SSD1-SA277B/B-4				ACC.		
SSD1-SA277B/B-7				ACC.		
SSD1-SA277B/B-8				ACC.		
SSD1-SA277B/B-11				ACC.		
SSD1-SA277B/B-12				ACC.		
EXAMINED BY 主检 <u>Cai Xinyin</u>		REVIEWED BY 审核 <u>Wang Wei</u>				
LEVEL - II SIGN 签名 / DATE 日期 <u>2008.08.25</u>		LEVEL II SIGN / DATE 日期 <u>08.08.25</u>				
质量经理 / QCM <u>Wang Wei</u> <u>2008.09.03</u>		用户 CUSTOMER				
主手 SIGN / 日期 DATE		主手 SIGN / 日期 DATE				



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-532

DATE 日期 2008.08.25

PAGE OF 页码 2/2

Revision No: 0

PROJECT NO.

工程编号: ZP06-787

CONTRACTOR:

用户: CALTRANS

DRAWING NO.

SA277+SA293

CALTRANS CONTRACT NO.:

加州工程编号: 04-0120F4

型号:

TOWER(S) 38M DIAPHRAGM

REFERENCING CODE

参考规范编号

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. 28th, 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 锻件

Material & thickness

母材, 厚度

A709M-HPS-485WT2

75/50/40mm

WELDING PROCESS

焊接方法

SMAW

TYPE OF JOINT

焊缝类型

T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA277B/B-15				ACC.		
SSD1-SA277B/B-16				ACC.		
SSD1-SA293-11				ACC.		
SSD1-SA293-12				ACC.		
SSD1-SA293-13				ACC.		
SSD1-SA293-14				ACC.		
SSD1-SA293-15				ACC.		
SSD1-SA293-16				ACC.		
BLANK						

EXAMINED BY 主操

Cai Xinxin

LEVEL-II SIGN 签名 / DATE 日期

质量监督 / QCM

Wangwei

主手 SIGN / 日期 DATE

REVIEWED BY 审核

Wangwei

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

主手 SIGN / 日期 DATE

Attachment-1. CONTINUED



REPORT OF ULTRASONIC EXAMINATION

REPORT NO. 报告编号 T787-UT-274 DATE 2008.07.30 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				DISCONTINUITY 不连续处					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						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Face 'A' 距表面深度	From 'X' 距X	From 'Y' 距Y		
SSD1-SA293-9A(9B)														*	
SSD1-SA293-10A(10B)		69.2				33							ACC.		
		58.9				33							ACC.		
SSD1-SA293-17A(17B)														*	

*SSD1-SA293-2A(2B), SSD1-SA293-10A(10B) were 100% UT inspection and ACC, which is the result of required 25% UT.
 *SSD1-SA293-2A(2B), SSD1-SA293-10A(10B)焊缝经100%UT检测合格, 累积检测长度已经达到了这批要求的25%检测长度。

BLANK

EXAMINED BY 主操 <i>Xuehan Yang</i> 2008.07.30 LEVEL-II SIGN / DATE	REVIEWED BY 审核: <i>Zhang Lin</i> LEVEL-II SIGN / DATE 2008.7.30
质量经理 / QCM <i>Xuehan Yang</i> 2008.07.30	用户 CUSTOMER _____
主手 SIGN / DATE _____	主手 SIGN / DATE _____



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-151

DATE 2008.06.06

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 47.6M UPPER DIAPHRAGM
部件名称DRAWING NO.: SA169(S)+P659(S)
图号CALTRANS CONTRACT NO.: 04-0120F4
加州工程编号REFERENCING CODE 参考规范
AWS D1.5-2002ACCEPTANCE STANDARD 接受标准
AWS D1.5-2002(Table 6.3)PROCEDURE NO. 程序编号
ZPQC-UT-01WELDING PROCESS 焊接方法
SAWJOINT TYPE 焊缝类型
BUTTCALIBRATION DUE DATE 仪器校正有效期
DEC. 28ST, 2008EQUIPMENT 设备
UT SCOPEMANUFACTURER 制造商
PANAMETRICSMODEL NO. 样式编号
EPOCH-4BSERIAL NO. 序列编号
071565311, 061488510,
061495811, 070152011,CALIBRATION BLOCK 试块
AWS IIV BLOCK TYPE IICOUPLANT 耦合剂
C.M.CMATERIAL/THICKNESS 材料厚度
A709M-HPS-485WT2-Z / 75mm

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	18*18 mm	Changchao	45 °	2.5 MHz	18*18 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
SSD1-SA189A/B-1A/1B		68.3				32									ACC.	
		44.8				33									ACC.	

BLANK

EXAMINED BY 主探

Xuehairong 2008.06.06

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Ma Jitong 2008.06.06

LEVEL - II SIGN / DATE

质量经理 / QCM

HUGONG

签字 SIGN / 日期 DATE 07.06.08

用户 CUSTOMER

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-008

DATE 2008.04.06

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 47.6M LOWER
部件名称 DIAPHRAGM

DRAWING NO.: SA326 (S) +P632 (S)
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
SAW

JOINT TYPE 焊缝类型
BUTT

CALIBRATION DUE DATE 仪器校正有效期
Jan. 1ST, 2009

EQUIPMENT 设备
UT SCOPE

MANUFACTURER 制造商
PANAMETRICS

MODEL NO. 样式编号
EPOCH-4B

SERIAL NO. 序列编号
061488510, 061495811,

CALIBRATION BLOCK 试块
AWS IIV BLOCK TYPE II

COUPLANT 耦合剂
C.M.C

MATERIAL/THICKNESS 材料厚度
A709M-HPS-485WT2-Z/ 75 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	45 °	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 缺陷评价	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
SSD1-SA326-1A (1B)		44.6				33									ACC.	
		68.2				32									ACC.	
BLANK																

EXAMINED BY 主操

Wenhairong 2008.04.06

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Ma Jizhong 2008.04.06

LEVEL - II SIGN / DATE

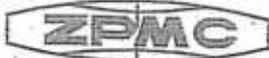
质量监督 / QCM

Huifang 2008.04.06

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 T787-MT-527

DATE日期 2008.08.25

PAGE OF页码 1/2

Revision No: 0

PROJECT NO.

工程编号: ZP06-787

CONTRACTOR:

用户: CALTRANS

DRAWING NO.

图号: SSD1-SA326, SSD1-SA169B/B
TOWER(S) 47.6M DIAPHRAGM

CALTRANS CONTRACT NO.:

加州工程编号 04-0120F4

REFERENCING CODE

参考规范编号

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. 28th, 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

磁架间距

70~150mm

MATERIAL TO BE

EXAMINED

检测材料

WELDING 焊接件

CASTING 铸件

FORGING 锻件

Material & thickness

母材, 厚度

A709M-HPS-485WT2-Z

75/60/40mm

WELDING PROCESS

焊接方法

SMAW

TYPE OF JOINT

焊缝类型

T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA326-11				ACC.		
SSD1-SA326-12				ACC.		
SSD1-SA326-13				ACC.		
SSD1-SA326-14				ACC.		
SSD1-SA326-15				ACC.		
SSD1-SA326-16				ACC.		
SSD1-SA169B/B-3				ACC.		
SSD1-SA169B/B-4				ACC.		
SSD1-SA169B/B-7				ACC.		
SSD1-SA169B/B-8				ACC.		
SSD1-SA169B/B-11				ACC.		
SSD1-SA169B/B-12				ACC.		
SSD1-SA169B/B-15				ACC.		
SSD1-SA169B/B-16				ACC.		

EXAMINED BY 主操

Wang Xueji

LEVEL-II SIGN 签名 / DATE日期 08.08.25

质量经理 / QCM

Huifang 2008.08.25

签字 SIGN / 日期 DATE

REVIEWED BY 审核

Cai Xinxin

LEVEL-II SIGN / DATE日期 08.08.25

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 T787-MT-527		DATE 日期 2008.08.25	PAGE OF 页码 2/2	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SSD1-SA325, SSD1-SA169B/B TOWER(S) 47.6M DIAPHRAGM		CALTRANS CONTRACT NO.: 加州工程编号 04-D120F4		
REFERENCING CODE 参考规范代码 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 ST , 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	<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-HPS-485WT2-Z 75/60/40mm	
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT	

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA169B/B-1				ACC.		
SSD1-SA169B/B-2				ACC.		
SSD1-SA169B/B-5				ACC.		
SSD1-SA169B/B-6				ACC.		
SSD1-SA169B/B-9				ACC.		
SSD1-SA169B/B-10				ACC.		
SSD1-SA169B/B-13				ACC.		
SSD1-SA169B/B-14				ACC.		
BLANK						

EXAMINED BY 主检 <u>Wang Uqi</u>	REVIEWED BY 审核 <u>Cai Xinmin</u>
LEVEL-II SIGN 签名 / DATE 日期 08.08.25	LEVEL-II SIGN / DATE 日期 08.08.25
质量经理 / QCM <u>Hickard</u> 2008.09.03	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-525 DATE日期 2008.08.25 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: SSD1-SA169 TOWER(S) 47.6M UPPER DIAPHRAGM CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4

REFERENCING CODE 参考规范编号: 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. 28th, 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 锻件 Material & thickness 母材, 厚度: A709M-345T2 / A709M-HPS-485WT2-Z 75/60mm

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA169A/B-8				ACC.		
SSD1-SA169A/B-9				ACC.		
BLANK						

EXAMINED BY 主检: Wang Wei REVIEWED BY 审核: Cai Xinxin

LEVEL-II SIGN 签名 / DATE日期: 08.08.25 LEVEL-II SIGN 签名 / DATE日期: 08.08.25

质量经理 / QCM: Huo Peng 用户 CUSTOMER: 2008.08.25

签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE

Attachment-1. CONTINUED



REPORT OF ULTRASONIC EXAMINATION

REPORT NO. 报告编号 T787-UT-295

DATE 2008.08.07

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				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						
									a	b	c	d	Length 长度		
SSD1-SA169A/B-7A(7B)		68.9				33								ACC.	
		59.3				33								ACC.	
SSD1-SA169A/B-10A(10B)															*
SSD1-SA169A/B-11A(11B)															*

*SSD1-SA169A/B-4A(4B), SSD1-SA169A/B-7A(7B) were 100% UT inspection and ACC, which is the result of required 25% UT.
 *SSD1-SA169A/B-4A(4B), SSD1-SA169A/B-7A(7B) 焊缝经100% UT 检测合格，累积检测长度已达到了总批要求的25%检测长度。

BLANK

EXAMINED BY 主探

Xu Ronggang 2008.08.07
LEVEL-II SIGN / DATE

REVIEWED BY 审核:

Ma Jizhong 2008.08.07
LEVEL-II SIGN / DATE

质量经理 / QCM

Hu... 2008.08.13

用户CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-193		DATE 2008.06.26	PAGE 1 OF 2	Revision No: 0
PROJECT NO.: 工程编号 ZP06-787		CONTRACTOR: CALTRANS		
ITEMS NAME: 47.6M LOWER DIAPHRAGM 部件名称 (S)		DRAWING NO.: SSD1-SA219 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 BUTT	CALIBRATION DUE DATE 仪器校正有效期 DEC. 28 th , 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 IIV BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2 / 60mm		

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	18*18 mm	Changchao	60 °	2.5 MHz	18*18 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							
SSD1-SA326-4A/B															*
SSD1-SA326-5A/B															*
SSD1-SA326-6A/B		69.4												ACC.	
		59.4												ACC.	
SSD1-SA326-7A/B		69.4												ACC.	
		59.4												ACC.	

EXAMINED BY 主探 <u>Xue Haiyang</u> 2008.06.26 LEVEL-II SIGN / DATE	REVIEWED BY 审核: <u>Zhou Jinhua</u> LEVEL-II SIGN / DATE 2008.06.26
---	--

质量经理 / QCM <u>Hu...</u> 2008.07.02 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE
--	---



REPORT OF ULTRASONIC EXAMINATION

REPORT NO. 报告编号 T787-UT-193 DATE 2008.06.26 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				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						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Face 'A' 距表面深度	From 'X' 距X	From 'Y' 距Y		
SSD1-SA326-8A/B															*
SSD1-SA326-9A/B															*
SSD1-SA326-10A/B															*
SSD1-SA326-18A/B															*

*SSD1-SA326-6A/B、SSD1-SA326-7A/B were 100% UT inspection and ACC, which is the result of required 25% UT.
 *SSD1-SA326-6A/B、SSD1-SA326-7A/B 焊缝经 100% UT 检测合格，累积检测长度已经达到了此批要求的 25% 检测长度。

BLANK

EXAMINED BY 主探 <i>Xue Hong</i> 2008.06.26 LEVEL-II SIGN / DATE	REVIEWED BY 审核: <i>Zhuo</i> LEVEL-II SIGN / DATE 2008.06.26
质量经理 / QCM <i>Hu Gang</i> 2008.07.02 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-178		DATE 2008.06.17	PAGE 1 OF 1	Revision No: 0
PROJECT NO.: 工程编号 ZP06-787			CONTRACTOR: CALTRANS	
ITEMS NAME: 23M UPPER DIAPHRAGM 部件名称		DRAWING NO.: SA333(S), P9(S) 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 SAW		JOINT TYPE 焊缝类型 BUTT		CALIBRATION DUE DATE 仪器校正有效期 DEC. 28 th , 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 IIV BLOCK TYPE II		COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-HPS-485WT2-Z / 75mm	

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	18*18 mm	Changchao	45 °	2.5 MHz	18*18 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							
SSD1-SA333A/B-1A/1B		69.1				32								ACC.	
		44.7				33								ACC.	
SSD1-SA333A/B-2A/2B		69.1				32								ACC.	
		44.7				33								ACC.	
BLANK															

EXAMINED BY 主探 <u>Xu Ronggang</u> 2008.06.17 LEVEL-II SIGN / DATE	REVIEWED BY 审核: <u>Ma Jiebang</u> 2008.06.17 LEVEL-II SIGN / DATE
质量经理 / QCM <u>Hu Kang</u> 2008.6.25 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-173

DATE 2008.06.13

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 23M LOWER DIAPHRAGM
部件名称

DRAWING NO.: SA261(S), P277(S)
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
SAW

JOINT TYPE 焊缝类型
BUTT

CALIBRATION DUE DATE 仪器校正有效期
DEC. 28th, 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 IIV BLOCK TYPE II

COUPLANT 耦合剂
C.M.C

MATERIAL/THICKNESS 材料厚度
A709M-HPS-485WT2-Z/ 75mm

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	18*18 mm	Changchao	45 °	2.5 MHz	18*18 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
SSD1-SA261-1A/1B		68.4				35										ACC.	
		44.7				32										ACC.	
SSD1-SA261-2A/2B		68.4				35										ACC.	
		44.7				32										ACC.	

BLANK

EXAMINED BY 主探

Mai Jibong 2008.06.13

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xiu Donggang 2008.06.13

LEVEL - II SIGN DATE

质量经理 / QCM

Hukeyang 2008.6.17

用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-539 DATE 日期 2008.08.26 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: SA261(S) TOWER(S) 23M DIAPHRAGM CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4

REFERENCING CODE 参考规范编号 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. 28th, 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 5517

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-HPS-485WT2-Z 75/60/40mm

WELDING PROCESS 焊接方法 SMAW TYPE OF JOINT 焊缝类型 T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA333B/B-7				ACC.		
SSD1-SA333B/B-8				ACC.		
SSD1-SA333B/B-11				ACC.		
SSD1-SA333B/B-12				ACC.		
SSD1-SA333B/B-3				ACC.		
SSD1-SA333B/B-4				ACC.		
SSD1-SA333B/B-15				ACC.		
SSD1-SA333B/B-16				ACC.		
BLANK						

EXAMINED BY 主检 Cai Xinlin

REVIEWED BY 审核 Wang Xij

LEVEL - II SIGN 签名 / DATE 日期 08.08.26

LEVEL II SIGN / DATE 日期 08.08.26

质量经理 / QCM Huibang 2008.09.01

用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-540		DATE 日期 2008.08.26	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: TOWER(S) 23M DIAPHRAGM		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 th , 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	<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-HPS-485WT2-Z 75/60/40mm	
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT	

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA333B/B-5				ACC.		
SSD1-SA333B/B-6				ACC.		
SSD1-SA333B/B-9				ACC.		
SSD1-SA333B/B-10				ACC.		
SSD1-SA333B/B-1				ACC.		
SSD1-SA333B/B-2				ACC.		
SSD1-SA333B/B-13				ACC.		
SSD1-SA333B/B-14				ACC.		
BLANK						

EXAMINED BY 主操 <u>Cai Xinlin</u>	REVIEWED BY 审核 <u>Wang Mei</u>
LEVEL - II SIGN 签名 / DATE 日期 <u>08.08.26</u>	LEVEL II SIGN / DATE 日期 <u>08.08.26</u>
质量经理 / QCM <u>Huobert</u> <u>2008.08.23</u>	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-286

DATE 2008.08.03

PAGE 1 OF 2

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: 23M UPPER DIAPHRAGM

DRAWING NO.: SSD1-SA331

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 EDGE PLATE

型号

加州工程编号

REFERENCING CODE 参考规范

ACCEPTANCE STANDARD 接受标准

PROCEDURE NO. 程序编号

AWS D1.5-2002

AWS D1.5:2002(Table 6.3)

ZPQC-UT-01

WELDING PROCESS 焊接方法

JOINT TYPE 焊缝类型

CALIBRATION DUE DATE 仪器校正有效期

FCAW

BUTT

DEC. 28th, 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

071565311,061488510,

061495811, 070152011,

CALIBRATION BLOCK 试块

COUPLANT 耦合剂

MATERIAL/THICKNESS 材料厚度

AWS IIW BLOCK TYPE II

C.M.C

A709M-345T2

60mm

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	18*18 mm	Changchao	60°	2.5 MHz	18*18 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 Reading	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									a	b	c	d	Length 长度			Sound Path 声程
SSD1-SA333A/B-3A3B		69.5					33								ACC.	
		59.6					33								ACC.	
SSD1-SA333A/B-4A4B																*
SSD1-SA333A/B-5A5B		69.5					33								ACC.	
		59.6					33								ACC.	
SSD1-SA333A/B-6A6B																*

EXAMINED BY 主操

REVIEWED BY 审核:

Xu Donggang 2008.08.03
LEVEL-II SIGN / DATE

Xuellaizong 2008.08.03
LEVEL-II SIGN / DATE

质量经理/QCM

用户CUSTOMER

主操 SIGN / 日期 DATE

主操 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000182**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Feb-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0164**Type of problem:**

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

Date the Non-Conformance Report was written: 02-Sep-2008**Description of Non-Conformance:**

ZPMC shipped five (5) Tower Double Diaphragms identified as ESD1-38m, ESD1-33m, SSD1-38m, SSD1-47.6m and SSD1-23m for machining with fabrication and testing not completed. The aforementioned double diaphragms were not accepted by ABF Quality Control (QC) at time of shipping to Nantong due to weld discontinuities in need of repair, required nondestructive testing not completed and weld terminations not acceptable to project specifications.

Contractor's proposal to correct the problem:

ZPMC understands that they violated the sequence of the fabrication procedure at their own risk. ABF has instructed ZPMC to follow the fabrication procedure. If the fabrication cannot be completed as written, ZPMC shall submit a revised fabrication procedure for approval.

Corrective action taken:

ZPMC understands that the fabrication procedures must be followed. NDT records verifying sound welds for the affected diaphragms have been submitted. All diaphragms have since been jointly green tagged by ZPMC, ABF, and the Department.

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 Serge Sinevod, +86 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer