

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-000192

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Sep-2008

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

NCR #: ZPMC-0173

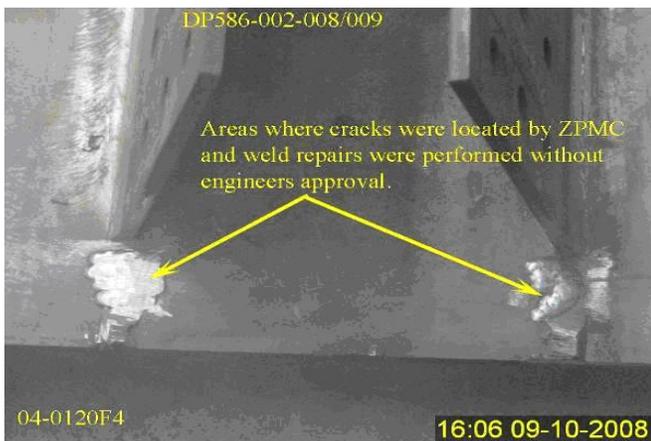
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP582-001
Procedural	Procedural	Descriptor: OBG Deck Panel	

Reference Description: Unapproved base metal repair DP582

Description of Non-Conformance:

The Contractor performed unapproved weld repairs. The Contractor performed repairs of cracks in base metal without prior Engineer approval. It was noted that the Contractor's QC inspector was not recording the welding parameters during the repair. This was observed in base metal repairs to deck panel DP582-001 on cracks found at the ends of weld joint #'s -008 and -009.



Applicable reference:

Special Provisions, Sec. 8-3.01 Welding Quality Control (p. 154): "In addition to the provisions in AWS D1.5, Section 3.7.4 and Section 12.17, third-time repairs of welds or base metal, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer."

ASTM A6, Sec 9.2.1: "The grinding of plates by the manufacturer or processor to remove imperfections on the top or bottom surface shall be subject to the limitations that the area ground is well faired without abrupt changes in contour and the grinding does not reduce the thickness of the plate by (1) more than 7 % under the nominal thickness for plates ordered to weight per square foot or mass per square metre, but in no case more than 1/8 in. [3 mm]; or (2) below the permissible minimum thickness for plates ordered to thickness in inches

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

or millimetres."

Welding Quality Control Plan (approved 26-Oct-2007), Sec 6.4: "Inspections shall be performed at suitable intervals during all phases of the work and the inspection shall include but not be limited to the following...

Verify that the requirements of the Welding Procedure Specification are being followed."

WQCP, Sec. 6.6: "Visual inspections shall be documented on the Continuous Visual Inspection Report."

WQCP, Sec. 7.4.6: "The repair documentation shall include the same information that was required when the original weld was made."

Special Provisions, Sec. 8-3.01 Welding (p. 150): "Inspection and approval of all joint preparations, assembly practices, joint fit-ups, welding techniques, and the performance of each welder, welding operator, and tack welder shall be documented by the QC Inspector on a daily basis for each day that welding is performed. For each inspection, the QC Inspector shall confirm and document compliance with the requirements of the AWS code criteria and the requirements of these special provisions on all weld joints before welding, during welding, and after the completion of each weld."

Who discovered the problem: Caltrans Quality Assurance(QA), Kenneth Riley

Name of individual from Contractor notified: ABF Quality Control Manager, Steve Lawton

Time and method of notification: In person @ 4:30pm

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: Verbal notification at 10:30 on 15-Sep-08

QC Inspector's Name: ZPMC Quality Control, Fu Yu Hong via phone @ 5:13 pm

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 Abifhram Velasco, who represents the Office of Structural Materials for your project.

Inspected By:	Velasco,Abifhram	SMR
Reviewed By:	Velasco,Abifhram	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: 17-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: 05.03.06-000163

Subject: NCR No. ZPMC-0173

Reference Description: Unapproved base metal repair DP582

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 performed unapproved weld repairs. The Contractor performed repairs of cracks in base metal without prior Engineer approval. It was noted that the Contractor's QC inspector was not recording the welding parameters during the repair. This was observed in base metal repairs to deck panel DP582-001 on cracks found at the ends of weld joint #'s -008 and -009.

Please refer to the attached NCR #ZPMC-0173 for details.

Action Required and/or Action Taken:

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

Transmitted by: Ching Chao

Attachments: ZPMC-0173

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, 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: 05.03.06-000163

Subject: NCR No. ZPMC-0173

Dated: 01-Oct-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000164 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC disagrees with the methods and definitions of the nonconformance and provides documentation to support their claim.

Please find attached.

Submitted by:

Attachment(s): ABF-NPR-000164R00;

Caltrans' comments:

Status: REJ

Date: 11-Nov-2008

The proposed resolution is not acceptable. Weld repairs to base metal require prior approval of the Engineer.

Please provide documentation of the weld repairs that were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0173 at that time.

Submitted by: Wright, Doug

Date: 12-Nov-2008

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 09/25/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000192(ZPMC-0173)FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-302.
- (2) COPY OF NCR WITH NUMBER NCR-000192(ZPMC-0173)
- (3) COPY OF AASHTO/AWS D1.5 PAGE 176.

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

RECEIVED 25 SEP 2008

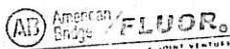
RECEIVED 25 SEP 2008

1540

Ruby C.

PLAN HOLDER

DATE



COMPANY

PHONE NO.

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



No. B-302

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-9-25

REGARDING: NCR-000192 (ZPMC-0173)

With this letter of response, ZPMC requests closure for Caltrans NCR-000192 (ZPMC-0173) .we agree what described in the non-conformance report, but that areas were where the extension bars and run off plates had been removed upon. Basic as the temporary plates we should remove the weld include all of the weld plus 3mm of the adjacent base metal to remove the HAZ. So we consider that the area less than 3mm in depth is weld HAZ but not base metal. And the method to remove the temporary parts should be same with tack weld , therefore it's obviously not need the approval from the engineer.

Besides that we will perform the MT to confirm that the cracks had been removed completely after repair. so there is not need for us to worry about the weld quality .

So ZPMC considers NCR-000192 can be closed and submits the application .

Please reference attached documentation for acceptance and closure the NCR-000192.

ATTACHMENT:

NCR-000192 (ZPMC-0173)

Zhaoshuangbao

2008.9.25.

ABF QCM
26 SEPT. 08



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. S. S.
375 BURMA ROAD
OAKLAND CA 95677

Date: 17-Sep-2005

Contract No: 04-01205-
04-SF-80-13.2 / 13.3

Dear: Mr. Charles Kanapick

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000163

Subject: NCR No. ZPMC-0173

Reference Description: Unapproved base metal repair DP582

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 performed unapproved weld repairs. The Contractor performed repairs of cracks in base metal without prior Engineer approval. It was noted that the Contractor's QC inspector was not recording the welding parameters during the repair. This was observed in base metal repairs to deck panel DP582-001 on cracks found at the ends of weld joint #'s -008 and -009.

Please refer to the attached NCR #ZPMC-0173 for details.

Action Required and/or Action Taken:

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

Transmitted by: Ching Chao

Attachments: ZPMC-0173

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao

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. St. 1E

Vallejo, CA 94592-1130

(707) 649-5453

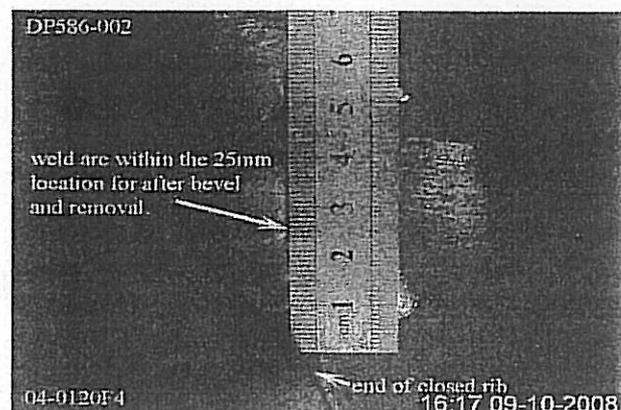
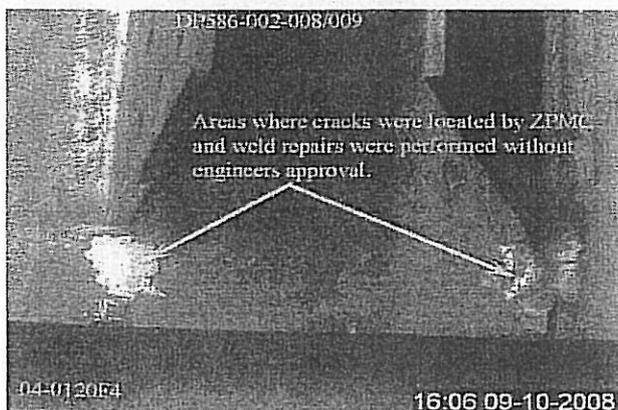
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25E**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, PRC**Report No:** NCR-000192**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 10-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0173**Type of problem:**

Welding **Concrete** **Other**
Welding **Curing** **Procedural** **Bridge No:** 34-0006
Joint fit-up **Coating** **Other** **Component:** DP582-001
Procedural **Procedural** **Descriptor:** OBG Deck Panel

Reference Description: Unapproved base metal repair DP582**Description of Non-Conformance:**

The Contractor performed unapproved weld repairs. The Contractor performed repairs of cracks in base metal without prior Engineer approval. It was noted that the Contractor's QC inspector was not recording the welding parameters during the repair. This was observed in base metal repairs to deck panel DP582-001 on cracks found at the ends of weld joint #'s -008 and -009.

**Applicable reference:**

Special Provisions, Sec. 8-3.01 Welding Quality Control (p. 154): "In addition to the provisions in AWS D1.5, Section 3.7.4 and Section 12.17, third-time repairs of welds or base metal, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer."

ASTM A6, Sec 9.2.1: "The grinding of plates by the manufacturer or processor to remove imperfections on the top or bottom surface shall be subject to the limitations that the area ground is well faired without abrupt changes in contour and the grinding does not reduce the thickness of the plate by (1) more than 7 % under the nominal thickness for plates ordered to weight per square foot or mass per square metre, but in no case more than 1/8 in. [3 mm]; or (2) below the permissible minimum thickness for plates ordered to thickness in inches

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

or millimetres."

Welding Quality Control Plan (approved 26-Oct-2007), Sec 6.4: "Inspections shall be performed at suitable intervals during all phases of the work and the inspection shall include but not be limited to the following...

Verify that the requirements of the Welding Procedure Specification are being followed."

WQCP, Sec. 6.6: "Visual inspections shall be documented on the Continuous Visual Inspection Report."

WQCP, Sec. 7.4.6: "The repair documentation shall include the same information that was required when the original weld was made."

Special Provisions, Sec. 8-3.01 Welding (p. 150): "Inspection and approval of all joint preparations, assembly practices, joint fit-ups, welding techniques, and the performance of each welder, welding operator, and tack welder shall be documented by the QC Inspector on a daily basis for each day that welding is performed. For each inspection, the QC Inspector shall confirm and document compliance with the requirements of the AWS code criteria and the requirements of these special provisions on all weld joints before welding, during welding, and after the completion of each weld."

Who discovered the problem: Caltrans Quality Assurance(QA), Kenneth Riley

Name of individual from Contractor notified: ABF Quality Control Manager, Steve Lawton

Time and method of notification: In person @ 4:30pm

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: Verbal notification at 10:30 on 15-Sep-08

QC Inspector's Name: ZPMC Quality Control, Fu Yu Hong via phone @ 5:13 pm

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 Abifhram Velasco, who represents the Office of Structural Materials for your project.

Inspected By:	Velasco, Abifhram	SMR
Reviewed By:	Velasco, Abifhram	SMR

Exceptions to the provisions of this subsection shall require the Engineer's approval.

No permanent welds or base metal shall be removed or cut to affect a dimensional change without prior approval of the Engineer. Base metal and weld metal that is sharply bent or kinked shall be rejected and replaced.

12.13 Tack Welds and Temporary Welds

12.13.1 Tack Welds

12.13.1.1 Location. All tack welds used in assembly shall be located within the joint unless otherwise approved by the Engineer.

12.13.1.2 Requirements. All tack welds shall meet the requirements of Table 12.2, or shall be removed as described in 12.13.3.

12.13.2 Temporary Welds. All welds not shown as permanent welds on the drawings or approved by the Engineer shall be removed as described in 12.13.3.

12.13.3 Weld Removal. When required, weld removal shall include all of the weld plus 3 mm [1/8 in.] of the adjacent base metal to remove the HAZ. Weld and base metal removal sites shall be faired to adjacent surfaces on a slope not steeper than 1 into the metal to 10 along the surface. The surface roughness shall not exceed 3 µm [125 µin.].

12.14 Preheat and Interpass Temperature Control

Preheat and interpass temperature control shall be as specified in 4.2. The minimum preheat and interpass temperature for AASHTO M270M (M270) Grade 250 (36), 345 (50), 345W (50W), and 485W (70W) (ASTM A 709M (A 709) Grade 250 [36], 345 [50], 345W [50W], and 485W [70W]) steels shall be as described in Tables 12.3 and 12.4. The minimum and maximum preheat temperatures for Grades 690/690W (100/100W) steels shall be as described in Table 12.5. The maximum preheat and maximum interpass temperature for Grade 485W (70W) steel shall not exceed 200°C [400°F] for thicknesses up to 40 mm [1-1/2 in.] inclusive and 260°C [500°F] for greater thicknesses.

[1-1/2 in.]

12.15 Postweld Thermal Treatments

12.15.1 Hydrogen Diffusion Postheat. Hydrogen diffusion postheat shall be required when specified in the contract documents, WPS, repair procedure, or when required by the Engineer to prevent cracking or minimize lamellar tearing.

12.15.1.1 Minimum Temperature Prior to Hydrogen Diffusion Postheat. When hydrogen diffusion postheat is required, the weld shall not be allowed to cool below the minimum preheat and interpass temperature before being raised to the hydrogen diffusion postweld heat treatment (PWHT) temperature.

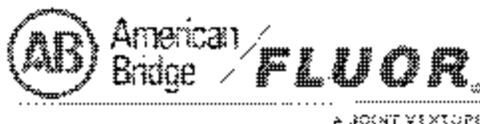
Table 12.2
Tack Weld Requirements (see 12.13.1.2)

Type	WPS Required?	Minimum Size	Minimum Length	Minimum Preheat	Notes
Remelted by SAW	No	None	None	None	1, 2
Covered by non-SAW	Yes	Table 2.1 or 2.2	75 mm [3 in.]	Table 12.3, 12.4, or 12.5	
Tack welds outside joint	Yes	Table 2.1 or 2.2	75 mm [3 in.]	Table 12.3, 12.4, or 12.5	3
Tack welds <75 mm [3 in.] long, or smaller than Table 2.1 or 2.2	Yes	None	None	200°C [400°F]	

General Note: Filler metals listed in Tables 4.1 or 4.2 shall be used.

Notes:

1. GMAW may be used for tack welding without the Engineer's approval.
2. SMAW electrodes shall meet the requirements of 12.6.2.
3. Tack welds outside the joint shall require the Engineer's approval (see 12.13.1.1).



AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 23223 Oakland, CA 94623

Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000163

Subject: NCR No. ZPMC-0173

Dated: 26-Nov-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000164 **Rev:** 01

Contractor's Proposed Resolution:

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

Please find attached.

Submitted by:

Attachment(s): ABF-NPR-000164R01; ZPMC-0173

Caltrans' comments:

Status: CLO

Date: 08-Dec-2008

The proposed resolution is acceptable. The documents requested in Rev 0 of NPR-0164 have been provided that show the welds in question have been accepted by VT and MT. The Department concurs that Non-Conformance ZPMC-0173 is closed.

Submitted by: Wright, Doug

Date: 08-Dec-2008

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 11/26/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000192(ZPMC-0173)FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-302R1.
- (2) COPY OF NCR WITH NUMBER NCR-000192(ZPMC-0173)
- (3) COPY OF THE CORRESPONDING VT AND MT REPORTS.

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

RECEIVED 26 NOV 2008

09/30

PLAN HOLDER

DATE



COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. B-302R1

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-11-25

REGARDING: NCR-000192(ZPMC-0173)

With this letter of response, ZPMC requests closure for Caltrans NCR-000192 (ZPMC-0173). 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.

Therefore ZPMC considers NCR-000192 (ZPMC-0173) can be closed.

Please check the attached documentation for acceptance and close the NCR-000192 (ZPMC-0173).

ATTACHMENT:

NCR-000192.(ZPMC-0173)

The corresponding VT and MT reports

Zhou Shuangbao

Nov 8. 2008

[Signature]
ABF QCM
26 Nov. 08

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



Bay Area Branch
690 Walnut Ave. St. 15
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000192

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Sep-2008

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

NCR #: ZPMC-0173

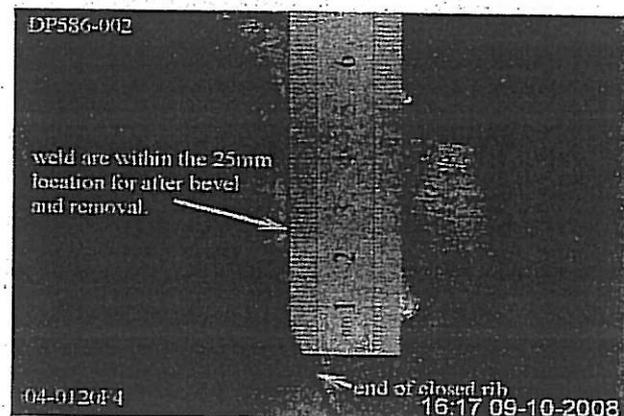
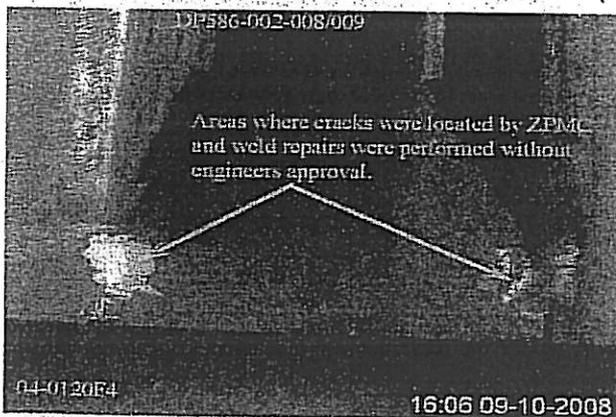
Type of problem:

Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: DP582-001
Procedural Procedural Descriptor: OBG Deck Panel

Reference Description: Unapproved base metal repair DP582.

Description of Non-Conformance:

The Contractor performed unapproved weld repairs. The Contractor performed repairs of cracks in base metal without prior Engineer approval. It was noted that the Contractor's QC inspector was not recording the welding parameters during the repair. This was observed in base metal repairs to deck panel DP582-001 on cracks found at the ends of weld joint #'s -008 and -009.



Applicable reference:

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探伤申请表

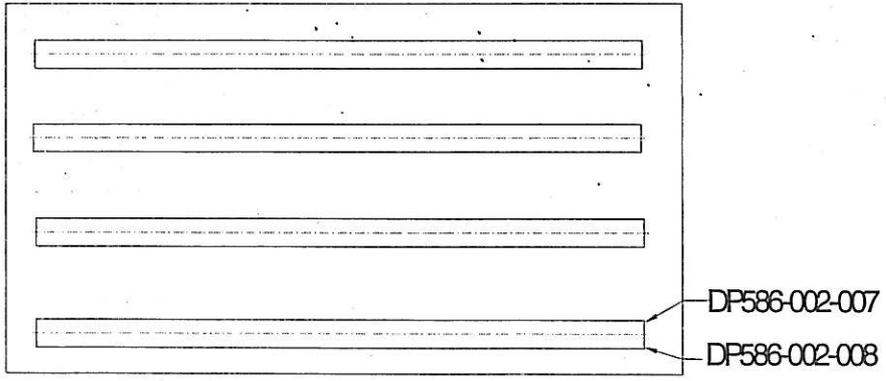
APPLICATION FORM FOR NDT

产品名称
NAME OF PRODUCT
美国海湾大桥

零部件图号 Drawing No	DP586	探伤类别 Test type	MT100%	编号 No	ZP06-787
零部件名称 Items	U肋板单元	材料 Material	A709M-345T2-X-S	数量 Quantit	

序号 No.	探伤编号 NDT No.	焊缝类型 Weld type	板厚/直径 thickness/diameter	焊工姓名 Welder name	焊工编号 Welder No.	结论 Result	备注 remark
1	DP586-002-007	T 接	12*20*50	Huyongchang	203805	✓	
2	DP586-002-008	T 接	12*20*50	Huyongchang	203805	✓	

探伤位置图
Scheme showing the test part



- 备注:
- 焊后
 - 校火后
 - WR/CWR 碳刨后
WR/CWR NO: _____
 - WR/CWR 返修后
WR/CWR NO: _____
 - SPCM
 - 其它 *After repair*
- 焊接方法: FCW
- 车间位置: _____

注: (于 _____ 月 _____ 日 _____ 时烧焊结束)

申请人 Applicant	陈石刚 张延军	日期 Date	2008.09.10	主探者 Inspected by	<i>[Signature]</i>	日期 Date	2008.09.10
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REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-5041		DATE日期 2008.09.10		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: DP586 OBG U-RIB			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 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	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造		Material & thickness 母材, 厚度		A709M-345T2-X-S 12/20mm	
WELDING PROCESS 焊接方法	FCAW		TYPE OF JOINT 焊缝类型 N/A			
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			
DP586-002-007				ACC.		web tab area
DP586-002-008				ACC.		web tab area
BLANK						
EXAMINED BY主探 <i>Wang Wei</i>			REVIEWED BY 审核 <i>B. J. ...</i>			
LEVEL - II SIGN 签名 / DATE日期 <i>08.09.10</i>			LEVEL-II SIGN / DATE日期 <i>2008.9.10</i>			
质量经理 QCM <i>H. G. ...</i>			用户 CUSTOMER			
签字 SIGN / 日期 DATE <i>10.10</i>			签字 SIGN / 日期 DATE			

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000128**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0173**Type of problem:**

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

Date the Non-Conformance Report was written: 10-Sep-2008**Description of Non-Conformance:**

The Contractor performed repairs of cracks in base metal without prior Engineer approval. Furthermore, it was noted that the Contractor's QC inspector was not recording the welding parameters during the repair. This was observed in base metal repairs to deck panel DP582-001 on cracks found at the ends of weld joint #'s -008 and -009.

Contractor's proposal to correct the problem:

Provided documents that include acceptable VT and MT reports ... no welding repair report.

Corrective action taken:

Closed by Caltrans Construction. METS closed the NCR based on Construction's direction.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Stanley Ku and Doug Wright**Date:** 09-Dec-2008**Is Engineer's approval attached?** Yes No Email on file showing concurrence to close NCR.**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 Sang Le, who represents the Office of Structural Materials for your project.

Inspected By: Dautermann, Peter

Quality Assurance Inspector

Reviewed By: Dautermann, Peter

QA Reviewer