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-000200
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 16-Sep-2008
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0178

Type of problem:

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

Reference Description: 04-0120F4 Special Provisions

Description of Non-Conformance:

ABF representative inform Caltrans Quality Assurance that ZPMC was shipping two Tower Double Diaphragms identified as SSD1-28m and SSD1-33m 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.

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: N/A; Contractor was aware of the issue
Name of Caltrans Engineer notified: Jim Reid
Time and method of notification: 9/16/08;Verbal; 0800
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 Mazen Wahbeh, (818) 292-0659, 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:**	25-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:**	05.03.06-000171
Subject:	NCR No. ZPMC-0178		

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

ABF representative inform Caltrans Quality Assurance that ZPMC was shipping two Tower Double Diaphragms identified as SSD1-28m and SSD1-33m 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. The failure to follow the approved procedure, specifically the failure to complete “Step 5 Inspection and correction” prior to progressing to Step 6 has resulted in the issuance of this NCR and NCR ZPMC-0159 and ZPMC-0164.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0178

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

File: 05.03.06

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 23223 Oakland, CA 94623

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000171

Subject: NCR No. ZPMC-0178

Dated: **07-Nov-2008**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000179 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution:

The fabrication procedure sequence documents that the ispection of welding will be completed prior to the machining process. Initial inpection of the Double Diaphragms was completed but reqairs relative to Visual inspection had not been completed. ZPMC then shipped the Double Diaphragms to Nantong for machining at their own risk noting that the repairs remaining would not adversly affect the final machined demensions. ZPMC and ABF has since completed the weld repairs and will forward the inspection documents to CT for NCR closure.

Submitted by:

Attachment(s): ABF-NPR-000179R00

Caltrans' comments:

Status: AAP

Date: 10-Nov-2008

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

The proposed resolution mentions that the repairs have been completed, and the inspection documents will be forwarded to Caltrans for NCR closure. Please provide this documentation. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0178 at that time.

Submitted by: Wright, Doug

Date: 10-Nov-2008

Attachment(s):

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: 05.03.06-000171

Subject: NCR No. ZPMC-0178

Dated: **15-Dec-2008**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000179 Rev: 01**

Contractor's Proposed Resolution:

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

Please see attached.

Submitted by:

Attachment(s): ABF-NPR-000179R01; docs to close this NCR

Caltrans' comments:

Status: CLO

Date: 21-Dec-2008

The proposed resolution is acceptable. The documents requested in Rev 0 of NPR-0179 have been provided. The Department concurs that Non-Conformance ZPMC-0178 is closed.

Submitted by: Wright, Doug

Date: 22-Dec-2008

Attachment(s):

TL-001973

TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 12/12/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: CALTRANS NCR FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

(1) COPY OF LETTER OF RESPONSE WITH NO.T-021 FOR CLOSURE.
(2) COPY OF NCR WITH NUMBER NCR-000200(ZPMC-0178).
(3) COPY OF ABF-NPR-000179
(4) COPY OF NDT REPORTS.

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEGEMENT:

RECEIVED 12 DEC 2008

PLAN HOLDER

DATE

American Bridge / FLUOR

COMPANY

PHONE NO.

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

ZPMC

No. T-021

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-12-11
REGARDING: NCR-200 ZPMC-178

ZPMC received NCR-200(ZPMC-178), it mentioned that ZPMC was shipping two tower double diaphragms identified as SSD1-28m and SSD1-33m 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 two 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 both diaphragms getting back, the technician finished all the required NDT and these two diaphragms had gotten Caltrans' green tag.

So here ZPMC attached AB/F NCR proposed solution ABF-NPR-000179 and all the NDT reports, hoped Caltrans can take a review and close this NCR.

ATTACHMENT:

NCR-000200 (ZPMC-0178)
ABF-NPR-000179
28M NDT reports:
Upper diaphragm plate butt welding: T787-UT-035 & T787-MT-031
Lower diaphragm plate butt welding: T787-UT-235 & T787-MT-342
Welds between upper and lower diaphragm plates with web plates: T787-MT-994
Welds between upper diaphragm plate with flange ring: T787-MT-993
Welds between lower diaphragm plate with flange ring: T787-MT-992
Upper diaphragm flange ring butt welding: T787-UT-317
Lower diaphragm flange ring butt welding: T787-UT-250
33M NDT reports:
Upper diaphragm plate butt welding: T787-UT-039 & T787-MT-035
Lower diaphragm plate butt welding: T787-UT-051 & T787-MT-062
Welds between upper and lower diaphragm plates with web plates:
T787-MT-592 & T787-MT-597
Welds between upper diaphragm plate with flange ring: T787-MT-598
Welds between lower diaphragm plate with flange ring: T787-MT-596
Upper diaphragm flange ring butt welding: T787-UT-273
Lower diaphragm flange ring butt welding: T787-UT-312

ABF QCM
15 DEC. 08

2008-12-12

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	Date:	25-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 Consultant	Document No:	05.03.06-000171
Subject:	NCR No. ZPMC-0178		

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

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- ☑ Quality Control (QC) not performed in conformance with contract documents.
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- ☐ Non-Conformance Resolved.

Material Location: Tower **Lift:** 01

Remarks:

ABF representative inform Caltrans Quality Assurance that ZPMC was shipping two Tower Double Diaphragms identified as SSD1-28m and SSD1-33m 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.

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Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0178

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

File: 05.03.06

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

Bay Area Branch
690 Walnut Ave.St. 15
Vallejo, CA 94592-113
(707) 649-545
(707) 649-549

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC **Report No:** NCR-000200
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 16-Sep-2008
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0178

Type of problem:

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

Reference Description: 04-0120F4 Special Provisions

Description of Non-Conformance:

ABF representative inform Caltrans Quality Assurance that ZPMC was shipping two Tower Double Diaphragms identified as SSD1-28m and SSD1-33m 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.

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Name of individual from Contractor notified: Don Walton
Time and method of notification: N/A; Contractor was aware of the issue
Name of Caltrans Engineer notified: Jim Reid
Time and method of notification: 9/16/08;Verbal; 0800
QC Inspector's Name: Fu Yuhong
Was QC Inspector aware of the problem: ☑ Yes ☐ No
Contractor's proposal to correct the problem:

Comments:

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Inspected By:	Ishibashi,Josh	SMR
Reviewed By:	Smith,Ryan	SMR

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: 05.03.06-000171

Subject: NCR No. ZPMC-0178

Dated: 07-Nov-2008
Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9
Job Name: SAS Superstructure
Document No.: ABF-NPR-000179 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

The fabrication procedure sequence documents that the ispection of welding will be completed prior to the machining process. Initial inpection of the Double Diaphragms was completed but reqairs relative to Visual inspection had not been completed. ZPMC then shipped the Double Diaphragms to Nantong for machining at their own risk noting that the repairs remaining would not adversly affect the final machined demensions. ZPMC and ABF has since completed the weld repairs and will forward the inspection documents to CT for NCR closure.

Submitted by:

Attachment(s): ABF-NPR-000179R00

Caltrans' comments:

Status: AAP

Date: 10-Nov-2008

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

The proposed resolution mentions that the repairs have been completed, and the inspection documents will be forwarded to Caltrans for NCR closure. Please provide this documentation. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0178 at that time.

Submitted by: Wright, Doug

Date: 10-Nov-2008

Attachment(s):

RECEIVED
NOV 14 2008
AMERICAN BRIDGE/FLUOR

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 T787-UT-039	DATE 2008.04.22	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 33M UPPER DIAPHRAGM 部件名称	DRAWING NO.:SA322(S), P283(S) 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS焊接方法	JOINT TYPE焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
SAW	BUTT	DEC. 28ST, 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-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)						
					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-SA322-A/B-1A/1B		68.4				34								ACC.	
		44.3				33								ACC.	
SSD1-SA322-A/B-2A/2B		68.4				34								ACC.	
		44.3				33								ACC.	
BLANK															

EXAMINED BY 主探	REVIEWED BY 审核:
Ma Zilong 2008.04.22.	XueHaiYong 2008.04.22
LEVEL - II SIGN / DATE	LEVEL- II SIGN / DATE
质量经理 / QCM	用户CUSTOMER
HuGang 2008.5.1	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-035	DATE日期 2008.04.23	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:	SA322(S), P283(S) SOUTHERN TOWER 33M UPPER 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 ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5360 5362 5395
MAGNETIZING METHOD磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
MATERIAL TO BE EXAMINED 检测材料	√ WELDING 焊接件 ☐ CASTING 铸件 ☐ FORGING 锻造	Material & thickness 母材,厚度	A709M-HPS-485WT2-Z 75mm
WELDING PROCESS 焊接方法	SAW	TYPE OF JOINT 焊缝类型	BUTT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA322A/B-1A/1B				ACC.		
SSD1-SA322A/B-2A/2B				ACC.		
BLANK						

EXAMINED BY主探

Zhou Dongyun

LEVEL - II SIGN 签名 / DATE日期 2008.04.23

REVIEWED BY 审核

Bo Tinrui

LEVEL-II SIGN / DATE日期 2008.4.23

质量经理 / QCM

Hu Fang 2008.5.1

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 T787-UT-051	DATE 2008.04.30	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 33M LOWER DIAPHRAGM 部件名称	DRAWING NO.:SA276(S), P284(S) 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS焊接方法	JOINT TYPE焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
SAW	BUTT	DEC. 28ST, 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
[illegible]S IIW BLOCK TYPE II	C.M.C	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)						
					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-SA276-1A/1B		68.7				32								ACC.	
		44.6				34								ACC.	
SSD1-SA276-2A/2B		68.7				32								ACC.	
		44.6				34								ACC.	
BLANK															

EXAMINED BY 主探	REVIEWED BY 审核:
Majilong 2008.04.30	XueMingrong 2008.04.30
LEVEL - II SIGN / DATE	LEVEL- II SIGN / DATE
质量经理 / QCM Hugang 2008.5.6	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-062	DATE日期 2008.05.01	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: -	SA276(S),P284(S) 33M LOWER 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 ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5617 5395 5360
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 75mm
WELDING PROCESS 焊接方法	SAW	TYPE OF JOINT 焊缝类型	BUTT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA276-1A/1B				ACC.		
SSD1-SA276-2A/2B				ACC.		
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Zhou Dongjun LEVEL - II SIGN 签名 / DATE日期 2008.5.01	Wang Wei LEVEL-II SIGN / DATE日期 2008.05.01
质量经理 / QCM HuGang 2008.5.6 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-592	DATE日期 2008.09.01	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:	SA322(S) TOWER(S) 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 仪器校三有效期 Dec. 28ST ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-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-SA322B/B-1				ACC.		
SSD1-SA322B/B-2				ACC.		
SSD1-SA322B/B-5				ACC.		
SSD1-SA322B/B-6				ACC.		
SSD1-SA322B/B-9				ACC.		
SSD1-SA322B/B-10				ACC.		
SSD1-SA322B/B-13				ACC.		
SSD1-SA322B/B-14				ACC.		
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Zhou Dayuan	XuHai
LEVEL - II SIGN 签名 / DATE日期 2008.9.01	LEVEL-II SIGN / DATE日期 08.9.1
质量经理 / QCM Huang 2008.09.10 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-597	DATE日期 2008.09.02	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:	SA276(S) TOWER(S) 33M DIAPHRAGM FIG PLATE	CALTRANS CONTRACT NO.: 加州工程编号	04-0120F4

REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校三有效期 Dec. 28ST ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√ WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-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-SA322B/B-11				ACC.		
SSD1-SA322B/B-12				ACC.		
SSD1-SA322B/B-7				ACC.		
SSD1-SA322B/B-8				ACC.		
SSD1-SA322B/B-15				ACC.		
SSD1-SA322B/B-16				ACC.		
SSD1-SA322B/B-3				ACC.		
SSD1-SA322B/B-4				ACC.		
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Zhou Dongjun LEVEL - II SIGN 签名 / DATE日期 2008.9.07	Xu Hui LEVEL-II SIGN / DATE日期 08.9.12
质量经理 / QCM Huang 2008.09.10 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-598	DATE日期 2008.09.02	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:	SA322(S)+SA272 TOWER(S) 33M UPPER DIAPHRAGM	CALTRANS CONTRACT NO.: 加州工程编号	04-0120F4

REFERENCING CODE 参考规范编码	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号	CALIBRATION DUE DATE 仪器校正有效期
AWS D1.5-2002	AWS D1.5-2002	ZPQC-MT-01	Dec. 28ST ,2008

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

MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√ WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2/ A709M-HPS-485WT2 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-SA322A/B-8				ACC.		
SSD1-SA322A/B-9				ACC.		
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Zhou Dongjun	Xu Hai
LEVEL - II SIGN 签名 / DATE日期 2008.9.02	LEVEL-II SIGN / DATE日期 08.9.2
质量经理 / QCM	用户CUSTOMER
Huang 2008.09.10	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-596	DATE日期 2008.09.02	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:	SA276(S)+SA275 TOWER(S) 33M LOWER 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. 28ST ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2/ A709M-HPS-485WT2 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-SA276-8				ACC.		
SSD1-SA276-9				ACC.		
BLANK						

EXAMINED BY主察

Zhou Dongjun

LEVEL - II SIGN 签名 / DATE日期 2008.9.02

REVIEWED BY 审核

Xu Hai

LEVEL-II SIGN / DATE日期 08.9.2

质量经理 / QCM

Huang 2008.09.10

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO.报告编号 T787-UT-273	DATE 2008.07.30	PAGE 1 OF 2	Revision No: 0

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

ITEMS NAME: 33M UPPER DIAPHRAGM 部件名称 EDGE PLATE	DRAWING NO.:SSD1-SA272 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS焊接方法	JOINT TYPE焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
FCAW	BUTT	DEC. 28ST, 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	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SSD1-SA322A/B-3A3B															*
SSD1-SA322A/B-4A4B															*
SSD1-SA322A/B-5A5B		68.5				32								ACC.	
		59.2				32								ACC.	
SSD1-SA322A/B-6A6B		68.5				32								ACC.	
		59.2				32								ACC.	

EXAMINED BY 主探	REVIEWED BY 审核:
Xie Haixiong 2008.7.30	Xu Rongqang 2008.07.30
LEVEL - II SIGN / DATE	LEVEL- II SIGN / DATE
质量经理 / QCM	用户CUSTOMER
Huhang 2008.08.05	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

Attachment-1. CONTINUED

ZPMC

REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 T787-UT-273 | 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-SA322A/B-7A7B															*
SSD1-SA322A/B-10A10B															*
SSD1-SA322A/B-11A11B															*
SSD1-SA322A/B-12A12B															*

*SSD1-SA322A/B-5A5B, SSD1-SA322A/B-6A6B were 100% UT inspection and ACC, which is the result of required 25% UT.

*SSD1-SA322A/B-5A5B, SSD1-SA322A/B-6A6B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。

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EXAMINED BY主探

Xie Haiyong 2008.07.30

LEVEL - II SIGN / DATE

REVIEWED BY 审核：

Xu Rongqang 2008.07.30

LEVEL- II SIGN / DATE

质量经理 / QCM

Hu Bing 2008.08.05

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO.报告编号 T787-UT-312	DATE 2008.08.11	PAGE 1 OF 2	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 33M LOWER DIAPHRAGM 部件名称 EDGE PLATE	DRAWING NO.:SSD1-SA275 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS焊接方法	JOINT TYPE焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
FCAW	BUTT	DEC. 28ST, 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	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SSD1-SA276-3A3B		68.7				34								ACC.	
		58.8				34								ACC.	
SSD1-SA276-4A4B															*
SSD1-SA276-5A5B															*
SSD1-SA276-6A6B		68.7				34								ACC.	
		58.8				34								ACC.	

EXAMINED BY 主探

Ma Jinlong 2008.08.11

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xu Rongqing 2008.08.11

LEVEL- II SIGN / DATE

质量经理 / QCM

Huang 2008.08.11

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

Attachment-1. CONTINUED

ZPMC

REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 T787-UT-312 DATE 2008.08.11 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					Discontinulty 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-SA276-7A7B															*
SSD1-SA276-10A10B															*
SSD1-SA276-11A11B															*
SSD1-SA276-12A12B															*

*SSD1-SA276-3A3B , SSD1-SA276-6A6B were 100% UT inspection and ACC, which is the result of required 25% UT.

*SSD1-SA276-3A3B , SSD1-SA276-6A6B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

Mo Jizhong 2008.08.11

LEVEL - II SIGN / DATE

REVIEWED BY 审核：

XU Rongqang 2008.08.11

LEVEL- II SIGN / DATE

质量经理 / QCM

Hubang 2008.08.11

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 T787-UT-035	DATE 2008.04.19	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: SOUTHERN TOWER 28M UPPER 部件名称 DIAPHRAGM	DRAWING NO.:SA334(S)+P248(S) 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS焊接方法	JOINT TYPE焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
SAW	BUTT	DEC. 28ST, 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-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)						
					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-SA334A/B-1A/1B		68.5				33								ACC.	
		44.5				34								ACC.	
SSD1-SA334A/B-2A/2B		68.5				33								ACC.	
		44.5				34								ACC.	
BLANK															

EXAMINED BY 主探	REVIEWED BY 审核:
2008.04.19	XueHaitong 2008.04.19
LEVEL - II SIGN / DATE	LEVEL- II SIGN / DATE
质量经理 / QCM	用户CUSTOMER
HuTang 2008.4.23	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-031	DATE日期 2008.04.22	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:	SA334(S)+P248(S) SOUTHERN TOWER 28M UPPER 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 ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5360 5362 5395
MAGNETIZING METHOD磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE, 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√ WELDING 焊接件 ☐ CASTING 铸件 ☐ FORGING 锻造	Material & thickness 母材,厚度	A709M-HPS-485WT2-Z 75mm
WELDING PROCESS 焊接方法	SAW	TYPE OF JOINT 焊缝类型	BUTT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA334A/B-1A/1B				ACC.		
SSD1-SA334A/B-2A/2B				ACC.		
BLANK						

EXAMINED BY主探

Zhou Dongyun

LEVEL - II SIGN 签名 / DATE日期 2008-04-22

REVIEWED BY 审核

Bo Jinrui

LEVEL-II SIGN / DATE日期 2008.04.22

质量经理 / QCM

HuGang 2008.5.1

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 T787-UT-235	DATE 2008.07.20	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 28M LOWER 部件名称 DIAPHRAGM SPLICE	DRAWING NO.:SA270(S)+P249(S) 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS焊接方法	JOINT TYPE焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
SAW	BUTT	DEC. 28ST, 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-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-SA270-1A(1B)		69.0				32								ACC.	
		44.7				32								ACC.	
SSD1-SA270-2A(2B)		69.0				32								ACC.	
		44.7				32								ACC.	
BLANK															

EXAMINED BY 主探

Maizhong 2008.07.20

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Li Chunlong 2008.07.20

LEVEL- II SIGN / DATE

质量经理 / QCM

Hubang 2008.07.21

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-342	DATE日期 2008.07.21	PAGE OF页码 1/1	Revision No: 0

PROJECT NO. 工程编号:	ZP06-787	CONTRACTOR: 用 户:	CALTRANS
DRAWING NO. 图号:	SA270(S)+P249(S) TOWER(S) 28M LOWER 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. 28ST ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√ WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-HPS-485WT2-Z 75mm
WELDING PROCESS 焊接方法	SAW	TYPE OF JOINT 焊缝类型	BUTT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA270-1A				ACC.		
SSD1-SA270-1B				ACC.		
SSD1-SA270-2A				ACC.		
SSD1-SA270-2B				ACC.		
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Bo Tianmi	Wang Wei
LEVEL - II SIGN 签名 / DATE日期 08.07.21	LEVEL-II SIGN / DATE日期 08.07.21
质量经理 / QCM	用户CUSTOMER
Hu Gang 2008.07.29	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-994	DATE日期 2008.10.10	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:	SA270+SA334 TOWER(S) 28M 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. 28ST ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-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-SA334B/B-1				ACC.		
SSD1-SA334B/B-2				ACC.		
SSD1-SA334B/B-13				ACC.		
SSD1-SA334B/B-14				ACC.		
SSD1-SA334B/B-7				ACC.		
SSD1-SA334B/B-8				ACC.		
SSD1-SA334B/B-9				ACC.		
SSD1-SA334B/B-10				ACC.		
SSD1-SA334B/B-3				ACC.		
SSD1-SA334B/B-4				ACC.		
SSD1-SA334B/B-15				ACC.		
SSD1-SA334B/B-16				ACC.		
SSD1-SA334B/B-5				ACC.		
SSD1-SA334B/B-6				ACC.		

EXAMINED BY主探 Cai Xinxin LEVEL - II SIGN 签名 / DATE日期 08.10.10	REVIEWED BY 审核 Wang Wei LEVEL-II SIGN / DATE日期 08.10.10
质量经理 / QCM Hugeng 2008.10.15 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-994	DATE日期 2008.10.10	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:	SA270+SA334 TOWER(S) 28M DIAPHRAGM	CALTRANS CONTRACT NO.: 加州工程编号	04-0120F4

REFERENCING CODE 参考规范编码	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号	CALIBRATION DUE DATE 仪器校正有效期
AWS D1.5-2002	AWS D1.5-2002	ZPQC-MT-01	Dec. 28ST ,2008
EQUIPMENT 设备	MANUFACTURER 制造商	MODEL NO. 样式编号	SERIAL NO. 连续编号
MT YOKE	PARKER	B310S	5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√ WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-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-SA334B/B-11				ACC.		
SSD1-SA334B/B-12				ACC.		
SSD1-SA270-13				ACC.		
SSD1-SA270-14				ACC.		
SSD1-SA270-15				ACC.		
SSD1-SA270-16				ACC.		
SSD1-SA270-17				ACC.		
SSD1-SA270-18				ACC.		
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Cai Xinxin	Wang Wei
LEVEL - II SIGN 签名 / DATE日期 08.10.10	LEVEL-II SIGN / DATE日期 08.10.10
质量经理 / QCM	用户CUSTOMER
Hu Qing 08.10.15	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-992	DATE日期 2008.10.10	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:	SSD1-SA270 TOWER(S) 28M LOWER 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. 28ST ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√WELDING 焊接件 ☐ CASTING 铸件 ☐ FORGING 锻造	Material & thickness 母材,厚度	A709M-HPS-485WT2-ZI A709M-345T2 60/75mm
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-SA270-8				ACC.		
SSD1-SA270-9				ACC.		
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Cai Xinxin LEVEL - II SIGN 签名 / DATE日期 08.10.10	Wang Wei LEVEL - II SIGN / DATE日期 08.10.10
质量经理 / QCM Hubaug 2008.10.15 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-993	DATE日期 2008.10.10	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:	SSD1-SA334A/B TOWER(S) 28M TOP 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. 28ST ,2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-HPS-485WT2-Z/ A709M-345T2 60/75mm
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-SA334A/B-8				ACC.		
SSD1-SA334A/B-9				ACC.		
BLANK						

EXAMINED BY主探

Cai Xinxin

LEVEL - II SIGN 签名 / DATE日期 08.10.10

REVIEWED BY 审核

Wang Wei

LEVEL-II SIGN / DATE日期 08.10.10

质量经理 / QCM

Hubert 2008.10.15

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 T787-UT-317	DATE 2008.08.13	PAGE 1 OF 2	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 28M LOWER DIAPHRAGM 部件名称 EDGE PLATE	DRAWING NO.:SSD1-SA328 图号	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS焊接方法	JOINT TYPE焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
FCAW	BUTT	DEC. 28ST, 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 探测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷评估	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(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-SA270-3A(3B)															*
SSD1-SA270-4A(4B)															*
SSD1-SA270-5A(5B)															*
SSD1-SA270-6A(6B)		69.3				33								ACC.	
		58.6				33								ACC.	
SSD1-SA270-7A(7B)															*

EXAMINED BY 主探

XuRongqiang 2008.08.13

LEVEL - II SIGN DATE

REVIEWED BY 审核:

2008.08.13

LEVEL- II SIGN / DATE

质量经理 / QCM

Huang 2008.08.13

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

Attachment-1. CONTINUED

ZPMC

REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 T787-UT-317 DATE 2008.08.13 PAGE 2 OF 2 Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷评定	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-SA270-10A(10B)		69.3				33								ACC.	
		58.6				33								ACC.	
SSD1-SA270-11A(11B)															*
SSD1-SA270-12A(12B)															*

*SSD1-SA270-6A(6B), SSD1-SA270-10A(10B)were 100% UT inspection and ACC, which is the result of required 25% UT.

*SSD1-SA270-6A(6B), SSD1-SA270-10A(10B)焊缝经100%UT检测合格，累积检测长度已经达到了先批要求的25%检测长度。

BLANK

EXAMINED BY主探

XuRongqang 2008.08.13

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

LiLiming 2008.8.13

LEVEL- II SIGN / DATE

质量经理 / QCM

Huxiang 2008.8.13

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

ZPMC

REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 T787-UT-250	DATE 2008.07.23	PAGE 1 OF 2	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 28M UPPER DIAPHRAGM 部件名称 EDGE PLATE	DRAWING NO.: SSD1-SA271 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. 28ST, 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	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SSD1-SA334A/B-3A(3B)															*
SSD1-SA334A/B-4A(4B)															*
SSD1-SA334A/B-5A(5B)		68.5				32								ACC.	
		58.6				32								ACC.	
SSD1-SA334A/B-6A(6B)															*
SSD1-SA334A/B-7A(7B)															*

EXAMINED BY 主探

MaJiCong 2008.07.23

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

XueHaitong 2008.07.23

LEVEL- II SIGN / DATE

质量经理 / QCM

HuGang 2008.07.24

签字 SIGN / 日期 DATE

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-1)

Attachment-1. CONTINUED

ZPMC

REPORT OF ULTRASONIC EXAMINATION

REPORT NO.报告编号 T787-UT-250	DATE 2008.07.23	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-SA334A/B-10A(10B)		68.5				32								ACC.	
		58.6				32								ACC.	
SSD1-SA334A/B-11A(11B)															*
SSD1-SA334A/B-12A(12B)															*

*SSD1-SA334A/B-5A(5B), SSD1-SA334A/B-10A(10B)were 100% UT inspection and ACC, which is the result of required 25% UT.

*SSD1-SA334A/B-5A(5B), SSD1-SA334A/B-10A(10B)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	REVIEWED BY 审核:
NaJiLong 2008.07.23	YueHaitong 2008.07.23
LEVEL - II SIGN / DATE	LEVEL- II SIGN / DATE
质量经理 / QCM	用户CUSTOMER
HuGang 2008.07.24	
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01-2)

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

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

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, PRC **Report No:** NCS-000130
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 25-Dec-2008
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0178

Type of problem:

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

Date the Non-Conformance Report was written: 16-Sep-2008

Description of Non-Conformance:

ABF representative inform Caltrans Quality Assurance that ZPMC was shipping two Tower Double Diaphragms identified as SSD1-28m and SSD1-33m 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:

The fabrication procedure sequence documents that the inspection of welding will be completed prior to the machining process. Initial inspection of the Double Diaphragms was completed but repairs relative to Visual Inspection had not been completed. ZPMC then shipped the Double Diaphragms to Nantong for machining at their own risk noting that the repairs remaining would not adversely affect the final machined dimensions. ZPMC and ABF have since completed the weld repairs and will forward the inspection documents to CT for NCR closure.

Corrective action taken:

ZPMC has acknowledged this problem. Due to the tight schedule, the two diaphragms were shipped prior to completion of all NDT and repairs. Since then, ZPMC has completed and submitted documentation of all NDT inspections and final repairs. The final dimensions are acceptable and the diaphragms have been green tagged.

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By:	Sinevod,Serge	Quality Assurance Inspector
Reviewed By:	Sinevod,Serge	QA Reviewer