

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-000208**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Oct-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0185**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: ESD1-SA97
Procedural	Procedural	Description:	East Shaft Internal Splice Plate

Reference Description: 04-0120F4 Special Provisions**Description of Non-Conformance:**

ZPMC was performing heat straightening operations to Internal Splice Plate ESD1-SA97 according to an ZPMC internal heat straightening request HSR(T)-205 which stated the maximum deformation was 10 millimeters. QA measured the member to be out of flatness to be approximately 14 millimeters as shown in the digital photograph below.

**Applicable reference:**

ZPMC Welding Quality Control Plan Section 11.1.2. "For material greater than 16mm in thickness, heat straightening shall not be performed on members with out of flatness tolerances greater than 3/1000 without prior approval of the Engineer."

Who discovered the problem: Greg Bertlesman, Quality Assurance Inspector**Name of individual from Contractor notified:** Mike Williams**Time and method of notification:** 10/23/08; 1000; Verbal**Name of Caltrans Engineer notified:** Jun Xu

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 10/23/08; 1330; Verbal

QC Inspector's Name: Zhao Chen Sun

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

None at this time.

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

Inspected By:	Ishibashi,Josh	SMR
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Reviewed By:	Smith,Ryan	SMR
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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: 27-Oct-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: 05.03.06-000179

Subject: NCR No. ZPMC-0185

Reference Description: exceed flatness tolerances 3/1000 without prior approval of the Engineer

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 was performing heat straightening operations to Internal Splice Plate ESD1-SA97 according to an ZPMC internal heat straightening request HSR(T)-205 which stated the maximum deformation was 10 millimeters. QA measured the member, and the deformation was approximately 14 millimeters, which is out of flatness tolerances 3/1000.

See the attachment.

Action Required and/or Action Taken:

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

Transmitted by: Jun Xu

Attachments: ZPMC-0185

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000179

Subject: NCR No. ZPMC-0185

Dated: 21-Nov-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000184 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been notified that material thicknesses greater than 16mm has a tolerance of 3/1000, heat straightening beyond this tolerance requires Engineers approval.

ZPMC performed heat straightening without Engineers approval. The Heat Straightening was documented on a Heat Straightening report. ZPMC has been notified that material thicknesses greater than 16mm has a tolerance of 3/1000, heat straightening beyond this tolerance requires Engineers approval.

Submitted by:

Attachment(s): ABF-NPR-000184R00

Caltrans' comments:

Status: AAP

Date: 28-Dec-2008

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

Please provide documentation to identify the requirements for straightening, and confirm that the distortion has been corrected to within acceptable dimensional tolerances. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0185 at that time.

Submitted by: Wright, Doug

Date: 30-Dec-2008

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000179

Subject: NCR No. ZPMC-0185

Dated: 06-Apr-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000184 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: Per CT request ZPMC has attached all inspection documents relative to this NCR. ZPMC requests closure of this NCR.

Per CT request ZPMC has attached all inspection documents relative to this NCR. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000184R01;

Caltrans' comments:

Status: CLO

Date: 12-Apr-2009

The proposed resolution is acceptable. The inspection documents requested in Rev 0 of NPR-0184 have been provided. The Department concurs that Non-Conformance ZPMC-0185 is closed.

Submitted by: Wright, Doug

Date: 12-Apr-2009

Attachment(s):



火工校正报告

报告号 Record #

HSR(T)-205

版本号 Revision #

0

日期 Date

2008.10.14.

Heat Straightening Report(HSR)

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:	N/A	质检代表/Quality Control Representative
部装 Sub-Assembly:	N/A	Xu Jun
梁段 Girder:	The 1st lift	质检经理/Quality Assurance Manager-Approval
塔段 Tower:	东塔内部连接板组件 Interior splice Assembly	Huifang 10.14.
焊缝号 Weld No:	1A, 1B, 2A, 2B, 3A, 3B, 4A, 4B	
焊缝地图号 Weld Map No:	ESD1-SA97	

情况描述 Description of Condition

Cause原因 Welding distortion 焊接变形

Type of Defect缺陷类型 Welding distortion 焊接变形

Inspection Method检查方法 Visual 目检

处置方法 Disposition

缺陷去除方法(Defect Removal Method): Flame Straightening by natural gas

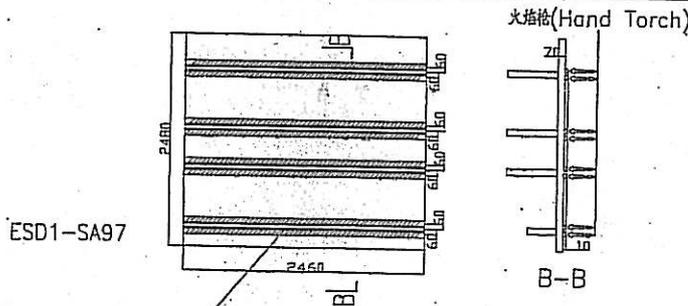
后续NDE(Post-Removal NDE): After finishing heat straightening, the weld of the heat area shall perform NDT according to the approved shop drawing

纠正措施(Corrective Action(s)): workers will perform weld sequence to evenly distribute welds in joint, closely monitor distortion during weld process to help prevent deformation.

实施次数(Number of application): 2~3

最高温度(Maximum temperature): <650°C

简图 Sketch



校火区域:此板最大变形量均10mm

Flame straightening area: the max deformation is about 10mm

纵向:最大校火长度均2460mm,宽度50~100mm

transverse: the max length is about 2460mm, the width is 50~100mm

注:根据实际需结合起重块进行校火

Conduct the heat straightening combining with the weight according to the actual deformed area, if necessary

REVIEWED
 Huifang
 ASB QCP
 14 OCT. 08

To be signed when Closing HSR~Verify compliance and all necessary reports are ready to attach

检验员 Inspector:	Xu Jun	签字 Signature:	[Signature]
CWI #	073141	Closing Date:	2008.10.05
II级探伤 NDE Certification:	Level II	审核日期 Review Date:	
质检经理 QC Manager			

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787--QCP-1100

APPROVED
 APPROVED AS NOTED
 RETURNED FOR CORRECTION
 Pursuant to Section 5-1.02
 of the Standard Specifications
 State of California
 DEPARTMENT OF TRANSPORTATION
 Division of Engineering Service
 Office of Structure Construction

Structure Representative: [Signature] Date: 10/25/08

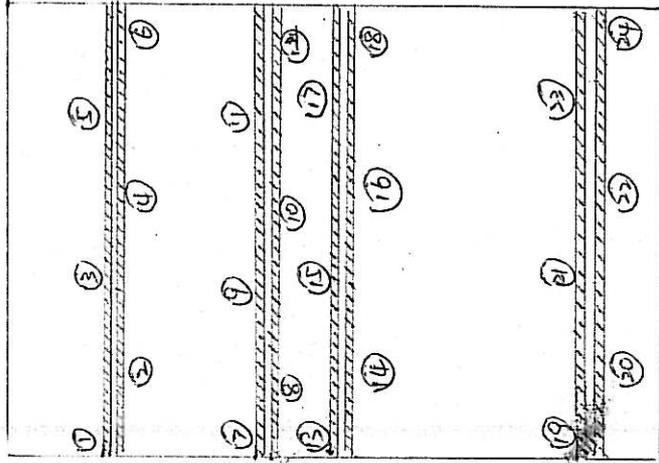


美国钢桥钢塔平整度火工校正检查记录卡

The report of steel plate heat straightening process checking

工程编号: The serial no. of project: ZP06-787	图号: The drawing no.: SA97	构件名称: Part name: A面板内部连接板
材质: A709M-34572-Z	炉批号: The heat no. of plate: 703190N	塔段名称: Section name: 第一吊装段
移植是否正确: Material mark checking: 正确	轧制方向标注是否正确: Rolling direction checking: 正确	WY070616Q143

ESD1-SA97



火工校正温度控制 The temperature record of heat straightening

检查时间 Checking time:	7:40	7:50	8:00	8:10	8:20	8:30	8:40	8:50	9:00	9:10	9:20	9:30	10:00	10:20	10:30
测量温度 Measure result	498	534	556	543	502	512	508	517	513	525	547	561			

校火前平整度测量 Flatness checking before heat straightening (mm)

测量点 Measure position	①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩	⑪	⑫
测量值 Measure result:	9.5	9.6	8.7	9.1	9.9	9.7	9.6	9.4	8.8	8.2	8.7	9.2

校火后平整度测量 Flatness checking after heat straightening (mm)

测量点 Measure position:	①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩	⑪	⑫
测量值 Measure result:	2.7	2.1	2.2	2.5	2.9	2.6	2.5	1.1	0.5	1.6	1.7	0.8

整体平整度/筋板垂直度是否合格
Heat straightening result

合格

检验员
QC inspector:

日期
Date:

若校正影响焊缝,请填写以下项目

Fill the following items if the straightening affects the weld

对应NDT报告编号 NDT report no.	UT	NDT检验员签字 NDT inspector	日期 Date:
	✓	Wang Xue	2008.12.03
		Wang Xue	2008.12.03



美国钢桥钢塔平整度火工校正检查记录卡

The report of steel plate heat straightening process checking

工程编号: The serial no. of project: ZP06-78.7	图号: The drawing no.: SA97	构件名称: Part name: A面板内部连接板
材质: Material: A709M-345T2-Z	炉批号: The heat no. of plate: 720319011	塔段名称: Section name: 第一吊装段
移植是否正确: Material mark checking: 正确	轧制方向标注是否正确: Rolling direction checking: 正确	WY0706.6Q143

火工校正温度控制 The temperature record of heat straightening

检查时间 Checking time:	13:00	13:10	13:20	13:30	13:40	15:00	15:10	15:20	15:30	15:40	15:50
测量温度 Measure result:	571	564	563	551	554	557	553	528	517	521	525

校火前平整度测量 Flatness checking before heat straightening (mm)

测量点 Measure position:	13	14	15	16	17	18	19	20	21	22	23	24
测量值: Measure result:	9.3	9.5	9.1	9.3	9.4	9.5	9.7	9.2	8.3	8.5	8.7	8.1

校火后平整度测量 Flatness checking after heat straightening (mm)

测量点 Measure position:	13	14	15	16	17	18	19	20	21	22	23	24
测量值: Measure result:	2.1	2	1.8	1.7	1.5	1.9	1.1	1.3	1.5	2.1	2.2	2.3

整体平整度/筋板垂直度是否合格
Heat straightening result

合格

检验员
QC inspector:

日期
Date:

若校正影响焊缝,请填写以下项目

Fill the following items if the straightening affects the weld

对应NDT报告编号 NDT report no.	UT	NDT检验员签字	日期
	MT	NDT inspector	Date:
	RT		



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-1617		DATE 日期 2008.11.29		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-SA97 THE 1ST LIFT TOWER(E) SKIN A INTERIOR SPLICE 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-345T2-Z25 75 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-SA97-1A(1B)				ACC.		25%MT
ESD1-SA97-2A(2B)				ACC.		25%MT
ESD1-SA97-3A(3B)				ACC.		25%MT
ESD1-SA97-4A(4B)				ACC.		25%MT
AFTER HSR1(T)-5428, HSR(T)-205						
AFTER B-WR323,324,325,333						
BLNAK						
EXAMINED BY 主操 <u>Bo Tinvui</u> LEVEL - II SIGN 签名 / DATE 日期 08.11.29				REVIEWED BY 审核 <u>Cai Xinxin</u> LEVEL-II SIGN / DATE 日期 08.11.29		
质量经理 / QCM <u>Huang</u> 2008.12.03				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-709

DATE 2008.11.19

PAGE 1 OF 2

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: THE FIRST LIFTING
部件名称 TOWER(E) SKIN A

DRAWING NO.: ESD1-SA97
图号

CALTRANS CONTRACT NO.: 04-0120F4
加州工程编号

REFERENCING CODE 参考规范
AWS D1.5-2002

ACCEPTANCE STANDARD 接受标准
AWS D1.5-2002(Table 6.3)

PROCEDURE NO. 程序编号
ZPQC-UT-01

WELDING PROCESS 焊接方法
FCAW

JOINT TYPE 焊缝类型
CORNER-JOINT

CALIBRATION DUE DATE 仪器校正有效期
DEC. 28ST, 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-Z25 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								
ESD1-SA97-1A(1B)		70				32									ACC.	100%
	1	45	C	1	43	32	6	+5	50	103	73	+2	710	REJ.	距B0	
ESD1-SA97-2A(2B)		70				32									ACC.	100%
	1	45	C	1	43	32	6	+5	10	103	73	+2	1770	REJ.	距B0	
ESD1-SA97-3A(3B)		70				32									ACC.	100%
		45				32									ACC.	100%

EXAMINED BY 主探

Mao Jitong 2008.11.19

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Zhang Lin

LEVEL - II SIGN / DATE 08.11.19

质量经理 / QCM

Huang 2008.11.19

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-709R1

DATE 2008.11.24

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: THE FIRST LIFTING

DRAWING NO.: ESD1-SA97

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 TOWER(E) SKIN A

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

SMAW

CORNER-JOINT

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-Z25

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							
ESD1-SA97-1A(1B)		70				32								ACC.	100%
	1R1	45				32								ACC.	100%
ESD1-SA97-2A(2B)		70				32								ACC.	100%
	1R1	45				32								ACC.	100%
ESD1-SA97-4A(4B)	1R1	70				32								ACC.	100%
	2R1	45	C	1	41	32	7	+2	10	117	82	-7	330	REJ.	距A5

ESD1-SA97-1A(1B) AFTER T-WR436, ESD1-SA97-2A(2B) AFTER T-WR437, ESD1-SA97-4A(4B) AFTER T-WR438

EXAMINED BY 主探 <i>Liangshengshun</i> 11/24/08 LEVEL - II SIGN / DATE	REVIEWED BY 审核: <i>Xu Ronggang</i> 08.11.24 LEVEL - II SIGN / DATE
--	--

质量经理 / QCM <i>Huang</i> 2008.11.28 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE
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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-709R2

DATE 2008.11.28

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: THE FIRST LIFTING

DRAWING NO.: ESD1-SA97

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 TOWER(E) SKIN A

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

SMAW

CORNER-JOINT

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-Z25 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
ESD1-SA97-4A(4B)	1R2	70				32									ACC.	100%
	2R2	45				33									ACC.	100%

ESD1-SA97-4A(4B) AFATER T-WR504

BLANK

EXAMINED BY 主操

Xu Donggang 08.11.28

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xu Donggang 08.11.28

LEVEL - II SIGN / DATE

质量经理 / QCM

Hubang 2008.12.02

用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 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-000198**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Mar-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0185**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: 23-Oct-2008**Description of Non-Conformance:**

ZPMC was performing heat straightening operations to Internal Splice Plate ESD1-SA97 according to an ZPMC internal heat straightening request HSR(T)-205 which stated the maximum deformation was 10 millimeters. QA measured the member to be out of flatness to be approximately 14 millimeters.

Contractor's proposal to correct the problem:

ZPMC has been notified that material thickness greater than 16mm has a tolerance of 3/1000 - heat straightening beyond this tolerance requires engineer approval.

Corrective action taken:

ZPMC understands that heat straightening beyond tolerance requires engineer approval. ESD1-SA97 has since been jointly green tagged by the Department, ABF, & ZPMC.

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

Inspected By: Sinevod, Serge

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer