

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 **Report No:** NCR-000348
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 08-Jul-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0322

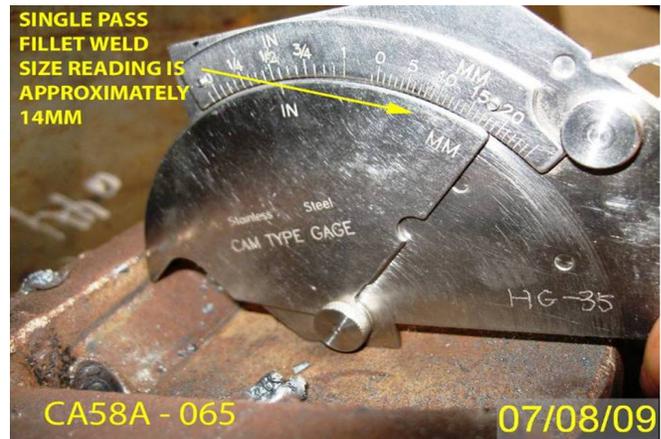
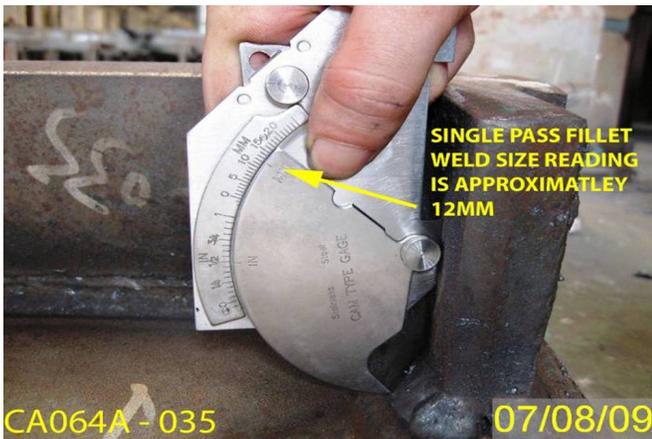
Type of problem:

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

Reference Description: Oversized Fillet Welds

Description of Non-Conformance:

During random in-process visual inspection on various X37A stiffeners, Caltrans Quality Assurance (QA) Inspector observed single pass fillet welds that exceeded the maximum allowable single pass weld size qualified and noted on WPS # WPS-B-T-2133. The following weld numbers are affected of CA58A – 065. The number of welds affected is approximately eighty welds on forty-four members. The weld sizes have been measured and range between 11mm and 14mm, the maximum qualified single pass weld is 9mm (WPS-B-T-2133). Examples of welds with this condition are as follows: Approximately 14mm single pass weld size at weld number CA58A-065 and weld number CA64A –35 has a single pass fillet weld size measuring approximately 12mm. This does not comply with applicable approved WPS # WPS – B – T – 2133, where the maximum fillet weld size for single pass should be 9mm. All members were located in Bay 3 at the time of this review.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Approved WPS # WPS – B – T – 2133.

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Shen Rushan

Time and method of notification: 1030 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 800 hours, Verbal

QC Inspector's Name: Yin Dong Hai

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: Simonis,Jim

QA Inspector

Reviewed By: Wahbeh,Mazen

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: 05-Aug-2009

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Document No: 05.03.06-000333

Subject: NCR No. ZPMC-0322

Reference Description: Oversized Fillet Welds

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: Xbeam **Lift:** 10

Remarks:

During random in-process visual inspection on various X37A stiffeners, Caltrans Quality Assurance (QA) Inspector observed single pass fillet welds that exceeded the maximum allowable single pass weld size qualified and noted on WPS # WPS-B-T-2133. The following weld numbers are affected of CA58A – 065. The number of welds affected is approximately eighty welds on forty-four members. The weld sizes have been measured and range between 11mm and 14mm, the maximum qualified single pass weld is 9mm (WPS-B-T-2133). Examples of welds with this condition are as follows: Approximately 14mm single pass weld size at weld number CA58A-065 and weld number CA64A –35 has a single pass fillet weld size measuring approximately 12mm. This does not comply with applicable approved WPS # WPS – B – T – 2133, where the maximum fillet weld size for single pass should be 9mm. All members were located in Bay 3 at the time of this review. This is a recurring QC issue that constitutes a systematic problem in quality control.

Action Required and/or Action Taken:

Submit repair procedure for approval. This is a recurring QC issue that constitutes a systematic problem in quality control.

Transmitted by: Bill Howe

Attachments: ZPMC-0322

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, 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: 05.03.06-000333

Subject: NCR No. ZPMC-0322

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000322 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will remove the excessive weld. ZPMC will submit inspection reports at a later date to close this NCR.
ZPMC will remove the excessive weld. ZPMC will submit inspection reports at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000322R00

Caltrans' comments:

Status: AAP

Date: 28-Aug-2009

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

Please provide documentation of the weld removal mentioned above, and provide documentation of acceptable inspection after re-welding. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0322 at that time.

Submitted by: Wright, Doug

Date: 28-Aug-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000333

Subject: NCR No. ZPMC-0322

Dated: 14-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000322 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has attached NDT documentation of the welds after they were ground to show they are acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC acknowledges in this case the oversized fillets welds were missed during the QC's visual inspection. ZPMC QA Department issued a internal NCR to the QC Department, which identified lack of supervision of the work leader and inadequate inspection by the QC as the reason for the oversized fillets. ZPMC QA will continue to improve their inspection technique and ensure their production monitors the fabrication more closely. The welds were ground to remove the excessive weld. ZPMC has attached NDT documentation of the welds after they were ground to show they are acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000322R01;

Caltrans' comments:

Status: CLO

Date: 22-Dec-2009

Documentation received is acceptable for closure of this NCR.

Submitted by: Howe, Bill

Date: 22-Dec-2009

Attachment(s):



No. B-529

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-12-12

REGARDING: NCR-000348 (ZPMC-0322)

With this letter of response, ZPMC requests closure for CALTRANS NCR-000348 (ZPMC-0322) what mentioned that QA observed oversize fillet welds.

ZPMC acknowledged this problem and has issued internal NCR. ZPMC will enhance our visual inspection at such issue and check drawing more carefully. ZPMC has arranged grinding to remove the excessive weld. After that NDT was performed to warrant welds' quality.

According to CT's comments in NPR, ZPMC providing internal NCR and NDT documentations, hoping CALTRANS could take a review and consider close the NCR.

ATTACHMENT:

NCR-B-219

NCR-000348 (ZPMC-0322)

B-VT-34384

B-VT-34379

B787-MT-12526

B787-MT-12523

A handwritten signature in black ink, appearing to be "Jing" followed by a stylized flourish.

12/12/09



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B 项目名称: 美国加州海湾大桥		NCR Number: NCR 编号: NCR-B-219 (ZPMC-0322)
Item: Oversized Fillet welds 名称描述: 焊脚过大	Item Number: 件号: OBG X37A	Drawing: 图号: OBG X37A
Location: BAY3 OBG corner assembly 位置: 第三车间, OBG 角单元装配件		Date: 日期: 2009-8-12

Description of Nonconformance:

不符合项状态描述:

During random in-process visual inspection on various X37A stiffeners, Caltrans Quality Quality Assurance (QA) Inspector observed single pass fillet welds that exceeded the maximum allowable single pass weld size qualified and noted on WPS# WPS-B-T-2133. The following weld numbers are affected of CA58A-065. The number of welds affected is approximately eight welds on forty-four members. The weld sizes have been measured and range between 11mm and 14mm, the maximum follows: Approximately 14mm single pass weld size at weld number CA58A-065 and weld number CA64A-35 has a single pass fillet weld size measuring approximately 12mm. This does not comply with applicable approved WPS# WPS-B-T-2133, where the maximum fillet weld size for single pass should be 9mm.

All members were located in Bay 3 at the time of this review. This is a recurring QC issue that constitutes a systematic problem in quality control.

加洲检验员在 BAY3 车间对 OBG 角单元构件 X37A 做目检时发现, 此构件上的单道焊角焊缝焊角尺寸过大。此处使用的 WPS 是: WPS-B-T-2133, 允许单道角焊缝最大尺寸是 9 毫米, 而实际焊缝是 11 到 14 毫米。大概有 44 个构件上的 80 条焊缝有此问题。

Work By: Liu jin Fei 施工方: Liu jin Fei	Prepared by: Shenhsun 准备: Shenhsun 2009.8.11	Reviewed by QCE: [Signature] 质量工程师批准: [Signature] 8/15/09
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input checked="" type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: 处理措施:	<input type="checkbox"/> Use as is 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
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Recommendation:
建议:

Prepared by: _____ 准备	Approved by QCA: _____ 质量经理批准
--------------------------	----------------------------------

Reason for Nonconformance: 不符合原因:	
① 带班未对图纸仔细, 焊缝焊角过大未看清楚 ② 带班给工人未交待清楚 ③ 检验人员现场监督不利	
Prevention of Re-occurrence: 预防措施:	
① 严格要求带班认真看清楚图纸后施工 ② 检验员现场监督控制过程 ③ 对过大焊角采取打磨处理	
Approved by/批准: <u>Hu Yuchang 09.08.13</u>	
Technical Justification for Use-As-Is/Repair: <input type="checkbox"/> Attachment <input type="checkbox"/> Non-attachment 回用或返修的技术依据:	
根据 AWS D1.5 3.6.2, 在对接和角接接头-表面余高 ^{附件} 后不得 ^{无附件} 超过 3mm, 若大于 3mm, 请打磨到要求尺寸。 According to AWS D1.5 Section 3.6.2, for welds in butt joint and fillet joint, the height of reinforcement shall not more than 3mm, otherwise, grind the reinforcement to the required size.	
Reviewed/批准: <u>Manli 8.17/09</u>	
Verification: 确认:	<input checked="" type="checkbox"/> Acceptable 可接受 <input type="checkbox"/> Unacceptable 不可接受
Verified by QCI/质检确认: <u>Zhu Tian shu 09.8.26</u> Reviewed by QCA/质检主任审核: _____	

#R787-QCP-1300

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

Caltrans

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 05-Aug-2009

Contract No: 04-0120F4

04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Document No: 05.03.06-000333

Subject: NCR No. ZPMC-0322

Reference Description: Oversized Fillet Welds

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- Non-Conformance Resolved.

Material Location: Xbeam

Lift: 10

Remarks:

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Transmitted by: Bill Howe

Attachments: ZPMC-0322

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao
File: 05.03.06

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

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

Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island

Report No: NCR-000348

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 08-Jul-2009

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

NCR #: ZPMC-0322

Type of problem:

Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:

Bridge No: 34-0006

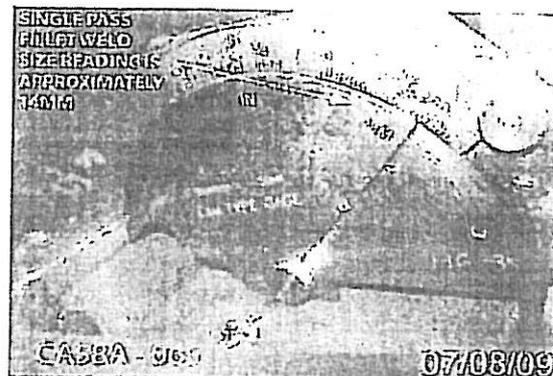
Component: Miscellaneous OBG Component

Reference Description: Oversized Fillet Welds

Description of Non-Conformance:

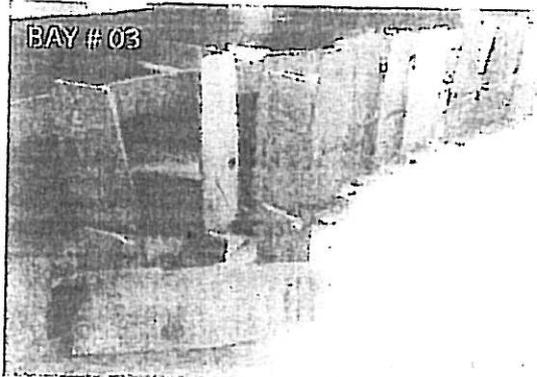
During random in-process visual inspection on various X37A stiffeners, Caltrans Quality Assurance (QA) Inspector observed single pass fillet welds that exceeded the maximum allowable single pass weld size qualified and noted on WPS # WPS-B-T-2133. The following weld numbers are affected of CA58A - 065. The number of welds affected is approximately eighty welds on forty-four members. The weld sizes have been measured and range between 11mm and 14mm, the maximum qualified single pass weld is 9mm (WPS-B-T-2133). Examples of welds with this condition are as follows: Approximately 14mm single pass weld size at weld number CA58A-065 and weld number CA64A -35 has a single pass fillet weld size measuring approximately 12mm. This does not comply with applicable approved WPS # WPS - B - T - 2133, where the maximum fillet weld size for single pass should be 9mm.

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Approved WPS # WPS - B - T - 2133.

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Shen Rushan

Time and method of notification: 1030 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 800 hours, Verbal

QC Inspector's Name: Yin Dong Hai

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: Simonis, Jim

QA Inspector

Reviewed By: Wahbeh, Mazen

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12526 DATE日期 2009.07.28 PAGE OF页码 1/4 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: CA064 9th lifting corner assembly		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 , 2009
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 16/25mm
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			
CA064-031				ACC.		100%MT
CA064-032				ACC.		100%MT
CA064-036				ACC.		100%MT
CA064-104				ACC.		100%MT
CA064-035				ACC.		100%MT
CA064-103				ACC.		100%MT
CA064-033				ACC.		100%MT
CA064-034				ACC.		100%MT
CA064-079				ACC.		100%MT
CA064-080				ACC.		100%MT
CA064-084				ACC.		100%MT
CA064-112				ACC.		100%MT
CA064-083				ACC.		100%MT
CA064-111				ACC.		100%MT

EXAMINED BY主探 Xu Huaxiang <i>Xu Huaxiang</i>	REVIEWED BY 审核 <i>Sun Gong cheng</i>
LEVEL - II SIGN 签名 / DATE日期 <i>09.07.28</i>	LEVEL-II SIGN / DATE日期 <i>09.07.28</i>
质量经理 / QCM <i>[Signature]</i>	用户CUSTOMER
签字 SIGN / 日期 DATE <i>[Signature]</i>	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12526		DATE日期 2009.07.28	PAGE OF页码 2/4	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: CA064 9th lifting corner assembly		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 , 2009	
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 16/25mm	
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			
CA064-081				ACC.		100%MT
CA064-082				ACC.		100%MT
CA064-055				ACC.		100%MT
CA064-056				ACC.		100%MT
CA064-060				ACC.		100%MT
CA064-108				ACC.		100%MT
CA064-059				ACC.		100%MT
CA064-107				ACC.		100%MT
CA064-057				ACC.		100%MT
CA064-058				ACC.		100%MT
CA064-019				ACC.		100%MT
CA064-020				ACC.		100%MT
CA064-023				ACC.		100%MT
CA064-101				ACC.		100%MT

EXAMINED BY主探 Xu Huaxiang Xu Huaxiang	REVIEWED BY 审核 Sun Guang cheng
LEVEL - II SIGN 签名 / DATE日期 09.07.28	LEVEL-II SIGN / DATE日期 09.07.28
质量经理 / QCM W. J. J.	用户CUSTOMER
签字 SIGN / 日期 DATE 09.08.03	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12526		DATE日期 2009.07.28	PAGE OF页码 3/4	Revision No: 0
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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 16/25mm	
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			
CA064-024				ACC.		100%MT
CA064-102				ACC.		100%MT
CA064-021				ACC.		100%MT
CA064-022				ACC.		100%MT
CA064-067				ACC.		100%MT
CA064-068				ACC.		100%MT
CA064-072				ACC.		100%MT
CA064-110				ACC.		100%MT
CA064-071				ACC.		100%MT
CA064-109				ACC.		100%MT
CA064-069				ACC.		100%MT
CA064-070				ACC.		100%MT
CA064-043				ACC.		100%MT
CA064-044				ACC.		100%MT

EXAMINED BY主探 Xu Huaxiang <u>Xu Huaxiang</u>	REVIEWED BY 审核 <u>Sun Gong Chang</u>
LEVEL - II SIGN 签名 / DATE日期 09.07.28	LEVEL-II SIGN / DATE日期 09.07.28
质量经理 / QCM <u>[Signature]</u>	用户CUSTOMER
签字 SIGN / 日期 DATE <u>[Signature]</u>	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12523 DATE日期 2009.07.28 PAGE OF页码 1/3 Revision No: 0

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

DRAWING NO. 图号: CA058 CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4
 9th lifting corner assembly

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, 2009

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

MAGNETIZING METHOD 磁化方法: Continuous magnetic yoke 磁轭式连续法 CURRENT 电流: AC

PARTICLE TYPE 磁粉类型: Dry magnet powder 干磁粉 YOKE SPACING 磁轭间距: 70~150mm

MATERIAL TO BE EXAMINED 检测材料: WELDING 焊接件 Material & thickness 母材,厚度: A709M-345T2-X
 CASTING 铸件 16/25mm
 FORGING 锻造

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			
CA058-051				ACC.		100%MT
CA058-052				ACC.		100%MT
CA058-056				ACC.		100%MT
CA058-071				ACC.		100%MT
CA058-055				ACC.		100%MT
CA058-072				ACC.		100%MT
CA058-053				ACC.		100%MT
CA058-054				ACC.		100%MT
CA058-039				ACC.		100%MT
CA058-040				ACC.		100%MT
CA058-044				ACC.		100%MT
CA058-069				ACC.		100%MT
CA058-043				ACC.		100%MT
CA058-070				ACC.		100%MT

EXAMINED BY主操: Xu Huaxiang REVIEWED BY 审核: Xu Gong cheng

LEVEL - II SIGN 签名 / DATE日期: Xu Huaxiang 07.28 LEVEL-II SIGN / DATE日期: Xu Gong cheng 07.28

质量经理 / QCM: [Signature] 用户CUSTOMER: [Signature]

签字 SIGN / 日期 DATE: [Signature] 08.03 签字 SIGN / 日期 DATE: [Signature]

(FORM# ZPQC-MT01)



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12523		DATE日期 2009.07.28	PAGE OF页码 2/3	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: CA058 9th lifting corner assembly		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 , 2009	
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 16/25mm	
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			
CA058-041				ACC.		100%MT
CA058-042				ACC.		100%MT
CA058-015				ACC.		100%MT
CA058-016				ACC.		100%MT
CA058-019				ACC.		100%MT
CA058-065				ACC.		100%MT
CA058-020				ACC.		100%MT
CA058-066				ACC.		100%MT
CA058-017				ACC.		100%MT
CA058-018				ACC.		100%MT
CA058-027				ACC.		100%MT
CA058-028				ACC.		100%MT
CA058-032				ACC.		100%MT
CA058-067				ACC.		100%MT

EXAMINED BY主探 Xu Huaxiang Xu Huaxiang	REVIEWED BY 审核 Sun Gong cheng
LEVEL - II SIGN 签名 / DATE日期 09.07.28	LEVEL-II SIGN / DATE日期 09.07.28
质量经理 / QCM [Signature]	用户CUSTOMER
签字 SIGN / 日期 DATE J.P. 08.03	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12523		DATE日期 2009.07.28	PAGE OF页码 3/3	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: CA058 9th lifting corner assembly		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 , 2009	
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 16/25mm	
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			
CA058-031				ACC.		100%MT
CA058-068				ACC.		100%MT
CA058-029				ACC.		100%MT
CA058-030				ACC.		100%MT
BLANK						

EXAMINED BY主探 Xu Huaxiang Xu Huaxiang	REVIEWED BY 审核 Sun Gongchang
LEVEL - II SIGN 签名 / DATE日期 10.07.28	LEVEL-II SIGN / DATE日期 10.07.28
质量经理 / QCM [Signature]	用户CUSTOMER
签字 SIGN / 日期 DATE 10.07.28	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**Report No:** NCS-000386**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0322**Type of problem:**

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

Date the Non-Conformance Report was written: 08-Jul-2009**Description of Non-Conformance:**

During random in-process visual inspection on various X37A stiffeners, Caltrans Quality Assurance (QA) Inspector observed single pass fillet welds that exceeded the maximum allowable single pass weld size qualified and noted on WPS # WPS-B-T-2133. The following weld numbers are affected of CA58A – 065. The number of welds affected is approximately eighty welds on forty-four members. The weld sizes have been measured and range between 11mm and 14mm, the maximum qualified single pass weld is 9mm (WPS-B-T-2133). Examples of welds with this condition are as follows: Approximately 14mm single pass weld size at weld number CA58A-065 and weld number CA64A –35 has a single pass fillet weld size measuring approximately 12mm. This does not comply with applicable approved WPS # WPS – B – T – 2133, where the maximum fillet weld size for single pass should be 9mm.

All members were located in Bay 3 at the time of this review.

Contractor's proposal to correct the problem:

Perform NDT to verify that the welds are acceptable per the contract requirement.

Corrective action taken:

The contractor ground the welds in removing the excessive welds. The welds of concerns were verified by ZPMC NDT with acceptable test result. The contractor acknowledged that there was no existing qualified procedure to perform single pass fillet weld as large as 14mm; therefore, shall not be used as an approved procedure for future welding.

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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer