

**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-000357

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 13-Jul-2009

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

**NCR #:** ZPMC-0331

### Type of problem:

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Side Plate
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Improper Welding Practices on SP207

### Description of Non-Conformance:

During random in-process visual inspection on Side Plate (SP207), Caltrans Quality Assurance (QA) Inspector observed the following:

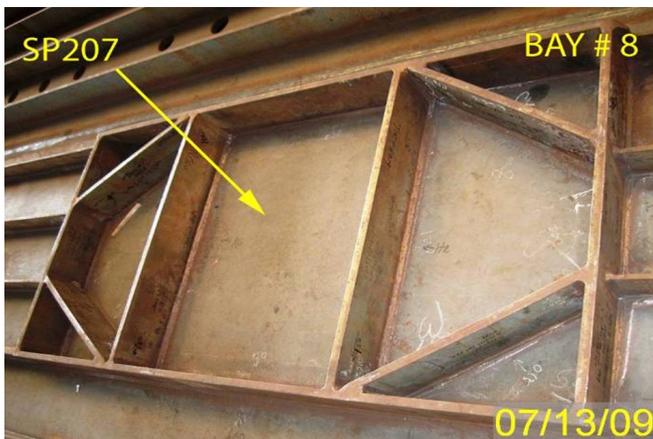
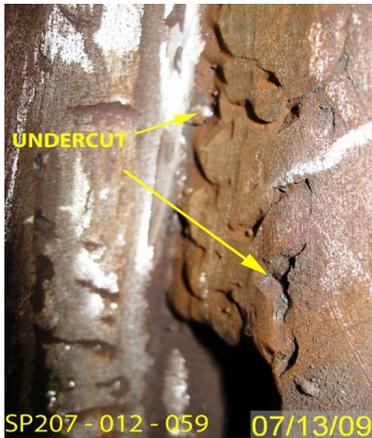
1. Plates X209F do not have 10mm snipe at interface areas with plates X209E as per detail Sheet No. SP207.
2. 8mm fillet weld was not completed full length of plate X209E as detailed.
3. Arc strikes are located on plate X209E.
4. Undercut on weld SP207-012-059 measured 3mm in depth.

For further details see attached photos and applicable reference below.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )



## Applicable reference:

1) Detail Sheet #SP207

**Who discovered the problem:** Naddi Sandeep Kumar.

**Name of individual from Contractor notified:** Hui Gui Hua

**Time and method of notification:** 15:00 / Verbal

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 08:00 / Verbal

**QC Inspector's Name:** Chen Chih Chien

**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.

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**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:** 05.03.06-000326

**Subject:** NCR No. ZPMC-0331

**Reference Description:** Improper Welding Practices on SP207

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:** 12

**Remarks:**

During random in-process visual inspection on Side Plate (SP207), Caltrans Quality Assurance (QA) Inspector observed the following:

1. Plates X209F do not have 10mm snipe at interface areas with plates X209E as per detail Sheet No. SP207.
2. 8mm fillet weld was not completed full length of plate X209E as detailed.
3. Arc strikes are located on plate X209E.
4. Undercut on weld SP207-012-059 measured 3mm in depth.

**Action Required and/or Action Taken:**

Submit repair procedure for approval.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0331

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

**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000326

**Subject:** NCR No. ZPMC-0331

**Dated:** 24-Aug-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000329 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC will perform repairs of these areas and submit documentation to verify acceptance at a later date and to close this NCR.

ZPMC will perform repairs of these areas and submit documentation to verify acceptance at a later date and to close this NCR.

**Submitted by:**

**Attachment(s):** ABF-NPR-000329R00

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**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 repairs that were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0331 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:** 05.03.06-000326

**Subject:** NCR No. ZPMC-0331

**Dated:** 14-Dec-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000329 **Rev:** 01

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**Contractor's Proposed Resolution:**

**Reference Resolution:** Per Caltrans comments to ABFJV's NPR, ZPMC is providing documentation to show the affected areas have been repaired, tested and found acceptable. Based on this ZPMC requests closure of this NCR.

Per Caltrans comments to ABFJV's NPR, ZPMC is providing documentation to show the affected areas have been repaired, tested and found acceptable. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000329R01;

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**Caltrans' comments:**

**Status:** REJ

**Date:** 21-Dec-2009

Remarks one through three of this NCR have not been addressed. Resubmit detailing the actions on these three remarks.

**Submitted by:** Howe, Bill

**Date:** 21-Dec-2009

**Attachment(s):**



No. B-530

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2009-12-12**

**REGARDING: NCR-000357 (ZPMC-0331) , NCR-000377(ZPMC-0351)**

With this letter of response, ZPMC requests closure for CALTRANS NCR-000357 (ZPMC-0331) & NCR-000377(ZPMC-0351) 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 & welding work to fix these problems. After that NDT was performed to warrant welds' quality. Due to the meeting memo (Memo-12), it's not necessary to issue any WWR/CWR to repair visual defects. So, ZPMC provides internal NCR and NDT documentations, hoping CALTRANS could take a review and consider close the NCR.

**ATTACHMENT:**

NCR-B-227

NCR-000357 (ZPMC-0331)

B-VT-31053

B787-MT-11743

NCR-B-240

NCR-000377 (ZPMC-0351)

B-VT-34630

B-VT-35172

B-VT-35838

B787-MT-12826

B787-MT-12679

B787-MT-12680

A handwritten signature in black ink, appearing to be "Jing" followed by a 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-227 (ZPMC-0331)

Item: Improper Welding Practices on SP207  
 Item Number: OBG CB12  
 Drawing: OBG SP207  
 名称描述: 板单元 SP207 未完成烧焊

Location: OBG CB12 SP207  
 位置:  
 Date: 2009-8-12  
 日期:

### Description of Nonconformance:

不符合项状态描述:

During random in-process visual inspection on side plate (SP207), Caltrans Quality Assurance (QA) Inspector observed the following:

- Plates X209F do not have 10mm snipe at interface areas with plates X209E as per detail Sheet No.SP207.
- 8mm fillet weld was not completed full length of plate X209E as detail.
- Arc strikes are located on plate X209E.
- Undercut on weld SP207-012-059 measured 3mm in depth.

加州检验员在对 CB12 中的板单元 SP207 做目检时发现以下问题:  
 1、SP207 板上的筋板 X209F, 与 X209E 的装配位置, 没有开 10 毫米的过焊孔 (倒角)。  
 2、X209E 上 8 毫米焊角的角焊缝没有烧完。  
 3、X209E 上有电弧擦伤。  
 4、焊缝 SP207-012-059 上有 3 毫米深的咬边。

Work By: 施工方: L J T Q  
 Prepared by: 准备: 2009.8.13  
 Reviewed by QCE: 质量工程师批准: 2009.8.13  
 Drawing Error 图纸错误  
 Material Defect 材料缺陷  
 Fabrication Error 制作错误  
 Other 其他原因

Disposition: 处理措施:  
 Use as is 回用  
 Repair 返修  
 Reject 拒收

Recommendation: 建议:  
 Educate welder and Balance inspection on-site.  
 对焊工进行教育, 并对 Q.C 的抽查力度进行加强

Prepared by: 准备: Xu Xianping 07/20/09  
 Approved by QCA: 质量经理批准

Reason for Nonconformance: 不符合原因:  
 1) copy hole size was short and weld after welding weld.  
 1) 因过焊孔太小, 10 毫米的过焊孔烧住。  
 2) Restrictate in this portion and oxide work can't access  
 2) 二氧化碳进不去无法烧焊, 焊角未烧完, 倒角漏焊咬边。  
 caused undercut after weld.

Prevention of Re-occurrence:

预防措施:

现场QC和自检员加强质量监督检查, 加强教育。

Enhance supervise and inspection by QC and owner inspector and enhance educate welder

Approved by/批准: Zhang Guizhuang

Technical Justification for Use-As-Is/Repair:

Attachment

Non-attachment

回用或返修的技术依据:

附件

无附件

责令施工队立即进行整改, 并出具相应的返修报告, 请QC加强质量监督。

Reviewed/批准:

Nimble

Verification:

Acceptable

Unacceptable

确认:

可接受

不可接受

- 1. 过焊孔已经切割打磨出来
- 2. 电弧焊已经补上
- 3. 电焊飞溅已全部去除

- 1. Weld through hole flats fabricated by gouging and grinding.
- 2. Fix weld size.
- 3. Remove arc strike.

Verified by QCU/质检确认:

Xu Xianping 07/20/11

Reviewed by QCA/质检主任审核:

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

05/03/09

### 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  
Job Name: SAS Superstructure  
Document No: 05.03.06-000326  
Dear: Mr. Charles Kanapicki  
Attention: Mr. Thomas Nilsson Project/Fabrication Manager  
Subject: NCR No. ZPMC-0331  
Reference Description: Improper Welding Practices on SP207

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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- Recurring QC issue that constitutes a systematic problem in quality control
- Non-Conformance Resolved.

Material Location: Xbeam Lift: 12

**Remarks:**

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Transmitted by: Bill Howe

Attachments: ZPMC-0331

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

DEPARTMENT OF TRANSPORTATION  
DIVISION OF ENGINEERING 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-000357

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 13-Jul-2009

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

NCR #: ZPMC-0331

### Type of problem:

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

Reference Description: Improper Welding Practices on SP207

### Description of Non-Conformance:

During random in-process visual inspection on Side Plate (SP207), Caltrans Quality Assurance (QA) Inspector observed the following:

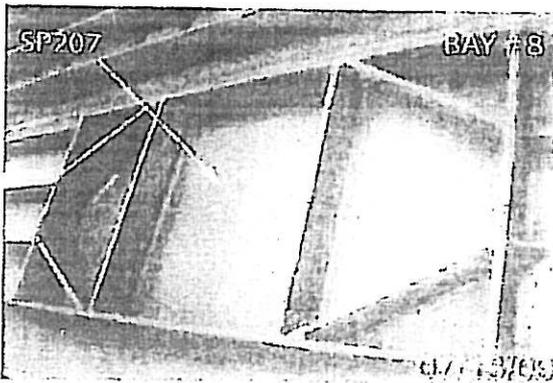
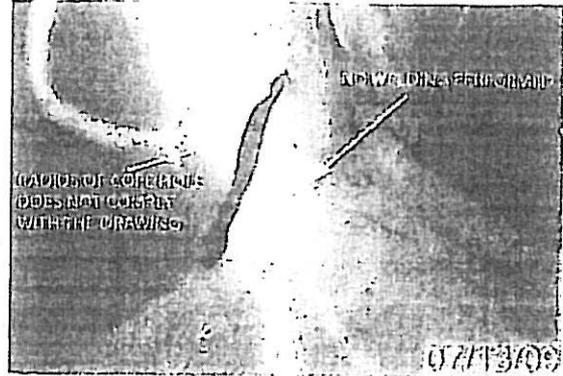
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For further details see attached photos and applicable reference below.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



**Applicable reference:**

1) Detail Sheet #SP207

Who discovered the problem: Naddi Sandeep Kumar.

Name of individual from Contractor notified: Hui Gui Hua

Time and method of notification: 15:00 / Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 08:00 / Verbal

QC Inspector's Name: Chen Chih Chien

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

2009.06.18



周数  
日期

85#  
2009.06.18

Visual Weld Inspection Report  
焊缝目视检查报告

Girder/梁: Crossbeam Web plate

Tower/塔: NA

Caltrans Contract No.  
加州合同编号

04-0120F4

Project No.:  
项目名称

San Francisco Oakland Bay Bridge  
海湾大桥

美国

Project No.:  
项目编号:

ZP06-787

Quality Assurance Manager  
~Approval  
质量控制经理:

*[Signature]*

Representative:  
质检代表:

*[Signature]*

CWI:  
检验员:

Chen Chih Chien  
03/10701

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 返修后接受 或拒收
SP207-012-032	205774	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-033	205774	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-040	054459	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-041	054459	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-043	054459	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-044	054459	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-054	205774	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-055	205774	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-058	054459	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
SP207-012-059	054459	2F	Supercored 71H(Φ1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA

After root weld

After CWR or WRR No.:

After cover pass

After HSR No.: HSR1(B) - ~~6496~~ 6746

✓ " " is no defects. "X" is defects. "NA" is not applicable.



# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-11743      DATE日期 2009.06.17      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: SP207A OBG WEB PLATE CB12		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 <sup>ST</sup> , 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 14/25 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			
SP207-012-020						*
SP207-012-019						*
SP207-012-018						*
SP207-012-017						*
SP207-012-016						*
SP207-012-015						*
SP207-012-014						*
SP207-012-013						*
SP207-012-023				ACC.		100%MT
SP207-012-024						*
SP207-012-028						*
SP207-012-029						*
SP207-012-035						*
SP207-012-036						*
SP207-012-038				ACC.		100%MT

EXAMINED BY 主操 Ta@ Chaowei <i>Tan Chaowei</i>	REVIEWED BY 审核 <i>Sun Guang chang</i>
LEVEL - II SIGN 签名 / DATE 日期 <i>9, 26, 11</i>	LEVEL-II SIGN <i>9, 26, 11</i> / DATE 日期
质量经理 / QCM <i>Lu</i>	用户 CUSTOMER
签字 SIGN / 日期 DATE <i>9, 26, 11</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-11743      DATE日期 2009.06.17      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: SP207A OBG WEB PLATE.CB12		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 <sup>ST</sup> , 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 14/25 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			
SP207-012-039						*
SP207-012-048						*
SP207-012-049						*
SP207-012-032						*
SP207-012-033						*
SP207-012-040				ACC.		100%MT
SP207-012-041						*
SP207-012-043						*
SP207-012-044						*
SP207-012-054						*
SP207-012-055						*
SP207-012-058						*
SP207-012-059				ACC.		100%MT
SP207-012-012						*
SP207-012-011						*

EXAMINED BY主探 Tzq Chaowei <i>Tan Chaowei</i>	REVIEWED BY 审核 <i>Sun Gony Chang</i>
LEVEL - II SIGN 签名 / DATE日期 <i>09.06.17</i>	LEVEL-II SIGN <i>P</i> DATE日期 <i>09.06.17</i>
质量经理 / QCM <i>Lu Tian</i>	用户CUSTOMER
签字 SIGN / 日期 DATE <i>J. P. 06.17</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-11743      DATE日期 2009.06.17      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: SP207A OBG WEB PLATE CB12		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 <sup>ST</sup> , 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 14/25 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			
SP207-012-010						*
SP207-012-009						*
SP207-012-008						*
SP207-012-007						*
SP207-012-006						*
SP207-012-005						*
SP207-012-004						*
SP207-012-003						*
SP207-012-002						*
SP207-012-001						*

### AFTER HSR1 (B) - 6746

\* SP207-012-023、SP207-012-038、SP207-012-040、SP207-012-059 were MT inspection and ACC, which is the result of required 10% MT.  
 \* SP207-012-023、SP207-012-038、SP207-012-040、SP207-012-059 焊缝经MT抽检合格, 且累积检测长度已经达到了此批要求的10%检测长度。

EXAMINED BY 主探 Tan Chaowei LEVEL - II SIGN 签名 / DATE 日期 09.06.17	REVIEWED BY 审核 Sun Hongdong LEVEL-II SIGN / DATE 日期 09.06.17
质量经理 / QCM [Signature]	用户 CUSTOMER
签字 SIGN / 日期 DATE [Signature]	签字 SIGN / 日期 DATE



Approved by/批准: Zhang Guiming

Technical Justification for Use-As-Is/Repair:  Attachment  Non-attachment

回用或返修的技术依据:

将焊脚打磨至要求范围之内; <sup>附件</sup>做NDT检测。 <sup>无附件</sup>

Grind the weld leg size to meet the requirement. Perform NDT inspection to it.

Reviewed /批准: Manliyi 8.28/09

Verification:  Acceptable  Unacceptable

确认: 可接受 不可接受

Verified by QCI/质检确认: Zhu Jian shu 09.9.2 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:

## NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 16-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: 05.03.06-000340

Subject: NCR No. ZPMC-0351

Reference Description: Excessive weld size on single pass welds on OBG Floorbeams

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG

Lift:

### Remarks:

During random in-process visual inspection of Floor Beams FB011-030-020,041, FB011-033-034, FB011-028-034, Caltrans Quality Assurance (QA) Inspector observed single pass fillet welds that exceeded the maximum allowable single pass weld size of 9mm. The weld sizes measured approximately 12mm and 14mm.

### Action Required and/or Action Taken:

Submit weld repair to engineer for review.

Transmitted by: Bill Howe

Attachments: ZPMC-0351

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coc, 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  
City: SF/ALA Rte: 80 PM: 13.2/13.9  
File #: 69.25B

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000377

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 03-Aug-2009

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

NCR #: ZPMC-0351

### Type of problem:

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

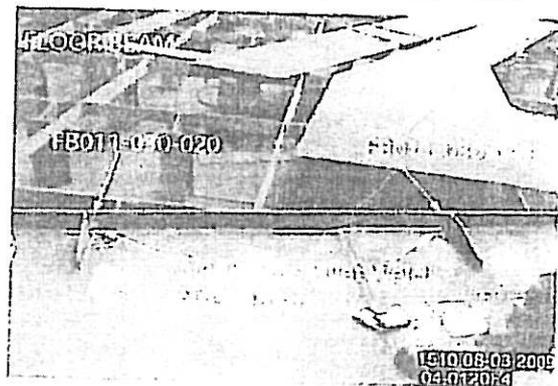
Bridge No: 34-0006

Component: OBG Floor Beam Sub-assembly

Reference Description: Excessive weld size on single pass welds on OBG Floorbeams

### Description of Non-Conformance:

During random in-process visual inspection of Floor Beams FB011-030-020,041, FB011-033-034, FB011-028-034, Caltrans Quality Assurance (QA) Inspector observed single pass fillet welds that exceeded the maximum allowable single pass weld size of 9mm. The weld sizes measured approximately 12mm and 14mm.



### Applicable reference:

Approved WPS # WPS - B - T - 2133

Who discovered the problem: Dhanasingh Sukanthan

Name of individual from Contractor notified: Wang Wen Bin

Time and method of notification: 1500 hours, verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 0800 hours, verbal

QC Inspector's Name: Zhan Hai Feng

Was QC Inspector aware of the problem:

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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Yes  No

Contractor's proposal to correct the problem:

N/A

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.

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Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR

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# REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12826      DATE日期 2009.08.08      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: FB11      CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4  
 OBG 10TH LIFTING FLOOR BEAM

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<sup>ST</sup>, 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      14/20 mm  
 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			
FB011-028-034				ACC.		100%MT
FB011-030-033				ACC.		100%MT
FB011-030-042				ACC.		100%MT
FB011-033-033				ACC.		100%MT
FB011-033-034				ACC.		100%MT

AFTER B-WR 6867

BLANK

EXAMINED BY 主探: Zhao Chenggong *Zhao Chenggong*      REVIEWED BY 审核: *Sun Gohy cheng*  
 LEVEL-II SIGN 签名 / DATE 日期: 09.08.08      LEVEL-II SIGN 签名 / DATE 日期: 09.08.08  
 质量经理 / QCM: *[Signature]*      用户 CUSTOMER: \_\_\_\_\_  
 签字 SIGN / 日期 DATE: *[Signature]*      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-12679		DATE日期 2009.08.01	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: FB11 OBG 10TH LIFTING FLOOR BEAM		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 <sup>ST</sup> , 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/A709M-345F2-X 12/14/18/20/30 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			
FB011-028-001				ACC.		100%MT
FB011-028-002				ACC.		100%MT
FB011-028-003				ACC.		25%MT
FB011-028-005				ACC.		25%MT
FB011-028-006				ACC.		25%MT
FB011-028-007				ACC.		25%MT
FB011-028-008				ACC.		25%MT
FB011-028-009				ACC.		25%MT
FB011-028-011				ACC.		25%MT
FB011-028-012				ACC.		25%MT
FB011-028-015				ACC.		25%MT
FB011-028-016				ACC.		25%MT
FB011-028-017				ACC.		25%MT
FB011-028-018				ACC.		25%MT
FB011-028-019				ACC.		25%MT

EXAMINED BY主探 Zhao Chenggong Zhao Chenggong LEVEL - II SIGN 签名 / DATE日期 09.08.01	REVIEWED BY审核 Sun Gongchang Sun Gongchang LEVEL-II SIGN / DATE日期 09.08.01
质量经理 / QCM 	用户CUSTOMER
签字 SIGN / 日期 DATE 	签字 SIGN / 日期 DATE



# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-12679      DATE日期 2009.08.01      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: FB11 OBG 10TH LIFTING FLOOR BEAM		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 <sup>ST</sup> , 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/A709M-345F2-X 12/14/18/20/30 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			
FB011-028-020				ACC.		25%MT
FB011-028-024				ACC.		100%MT
FB011-028-025				ACC.		100%MT
FB011-028-033				ACC.		25%MT
FB011-028-034				ACC.		25%MT
FB011-028-041				ACC.		25%MT
FB011-028-042				ACC.		25%MT
FB011-028-046				ACC.		100%MT
FB011-028-045				ACC.		100%MT
BLANK						

EXAMINED BY 主探 <u>Zhao Chengqiang</u> Zhao Chengqiang 2009.08.01	REVIEWED BY 审核 <u>Sun Gongchang</u> Sun Gongchang 2009.08.01
LEVEL - II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
质量经理 / QCM <u>[Signature]</u>	用户 CUSTOMER
签字 SIGN / 日期 DATE <u>[Signature]</u> 2009.08.01	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-12680      DATE日期 2009.08.01      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: OBG 10TH LIFTING FLOOR BEAM		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 <sup>ST</sup> , 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/A709M-345F2-X 12/14/18/20/30 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			
FB011-030-001				ACC.		100%MT
FB011-030-002				ACC.		100%MT
FB011-030-003				ACC.		25%MT
FB011-030-005				ACC.		100%MT
FB011-030-006				ACC.		100%MT
FB011-030-007				ACC.		25%MT
FB011-030-008				ACC.		25%MT
FB011-030-009				ACC.		25%MT
FB011-030-011				ACC.		25%MT
FB011-030-012				ACC.		25%MT
FB011-030-015				ACC.		25%MT
FB011-030-016				ACC.		25%MT
FB011-030-017				ACC.		25%MT
FB011-030-018				ACC.		25%MT
FB011-030-019				ACC.		25%MT

EXAMINED BY主探 Zhao Chenggong <i>Zhao Chenggong</i> 09.08.01	REVIEWED BY审核 Sun Gongchang <i>Sun Gongchang</i> 09.08.01
LEVEL - II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
质量经理 / QCM <i>[Signature]</i>	用户CUSTOMER
签字 SIGN / 日期 DATE <i>[Signature]</i> 09.08.01	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-12680      DATE日期 2009.08.01      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: FB11 OBG 10TH LIFTING FLOOR BEAM		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 <sup>ST</sup> , 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/A709M-345F2-X 12/14/18/20/30 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			
FB011-030-020				ACC.		25%MT
FB011-030-024				ACC.		100%MT
FB011-030-025				ACC.		100%MT
FB011-030-033				ACC.		100%MT
FB011-030-034				ACC.		25%MT
FB011-030-041				ACC.		25%MT
FB011-030-042				ACC.		25%MT
FB011-030-046				ACC.		100%MT
FB011-030-045				ACC.		100%MT

BLANK

EXAMINED BY 主探 Zhao Chengqong <i>Zhao Chengqong</i> 2009.08.01	REVIEWED BY 审核 Sun Gongchang <i>Sun Gongchang</i> 2009.08.01
LEVEL - II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
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

**NCR PROPOSED RESOLUTION**

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000326

**Subject:** NCR No. ZPMC-0331

**Dated:** 27-Jan-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000329 Rev: 02

---

**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC is providing visual inspection records to show that the side plate is visually acceptable after repairs were complete. ZPMC requests closure of this NCR.

ZPMC is providing visual inspection records to show that the side plate is visually acceptable after repairs were complete. ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000329R02;

---

**Caltrans' comments:**

**Status:** CLO  
**Date:** 02-Feb-2010

The documentation received is sufficient to close this NCR.

**Submitted by:** Howe, Bill

**Attachment(s):**

**Date:** 02-Feb-2010



No. B-591

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-1-26**

**REGARDING: NCR-00357 (ZPMC-0331)**

With this letter of response, ZPMC requests closure of CT NCR-00357 (ZPMC-0331), what mentioned that CT Inspector observed several Visual Rejection during random inspection.

- This CT inspection performed Visual Inspection prior to ZPMC's.
- These VT rejections have been removed, repaired, inspected and accepted.
- ZPMC provides the NDT reports & Green Tag for CT to review.

Based on the response above, ZPMC requests closure of this NCR.

**ATTACHMENT:**

NCR-00000357 (ZPMC-0331)

VT AFTER GRINDING (COPE HOLE)

VT AFTER REPAIR

APPLICATION FORM FOR NDT

B787-MT-18478

QA APPROVAL REQUEST FORM FOR SP207A

*Handwritten signature*

*1/26/10*



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  
Job Name: SAS Superstructure  
Document No: 05.03.06-000326  
Dear: Mr. Charles Kanapicki  
Attention: Mr. Thomas Nilsson Project/Fabrication Manager  
Subject: NCR No. ZPMC-0331  
Reference Description: Improper Welding Practices on SP207

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: 12

### Remarks:

During random in-process visual inspection on Side Plate (SP207), Caltrans Quality Assurance (QA) Inspector observed the following:

1. Plates X209F do not have 10mm snipe at interface areas with plates X209E as per detail Sheet No. SP207.
2. 8mm fillet weld was not completed full length of plate X209E as detailed.
3. Arc strikes are located on plate X209E.
4. Undercut on weld SP207-012-059 measured 3mm in depth.

### Action Required and/or Action Taken:

Submit repair procedure for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0331

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

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



Contract #: 04-0120F4

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

File #: 69.25B

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

### QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000357

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 13-Jul-2009

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

NCR #: ZPMC-0331

Type of problem:

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

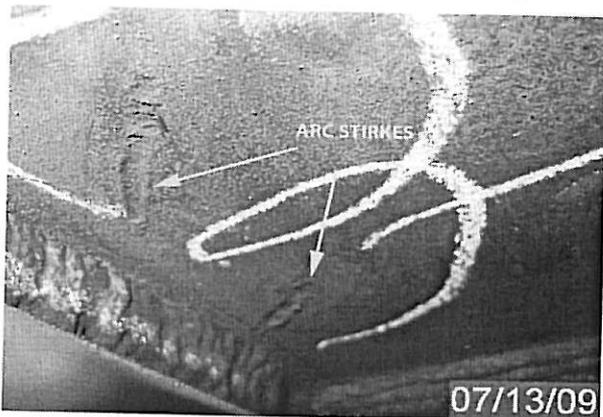
Reference Description: Improper Welding Practices on SP207

Description of Non-Conformance:

During random in-process visual inspection on Side Plate (SP207), Caltrans Quality Assurance (QA) Inspector observed the following:

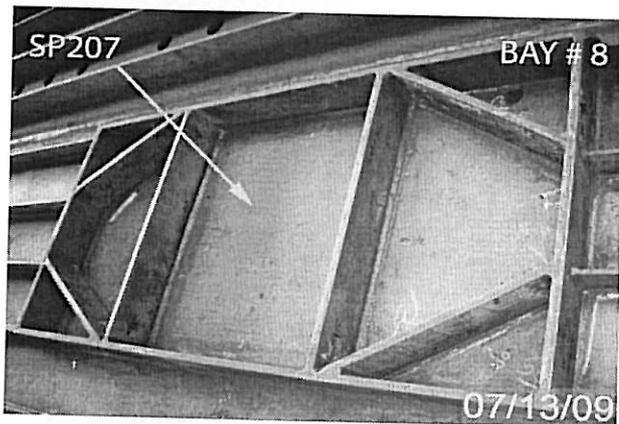
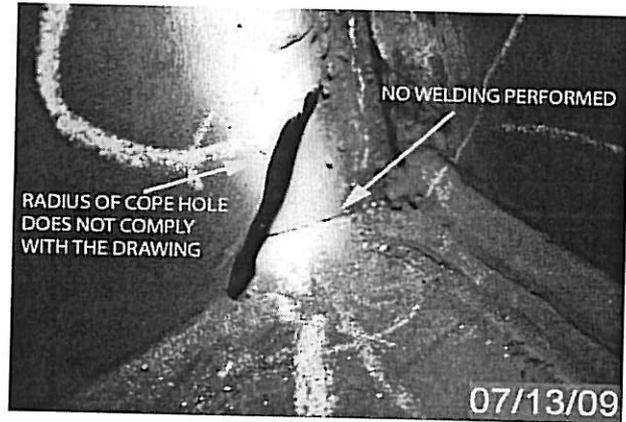
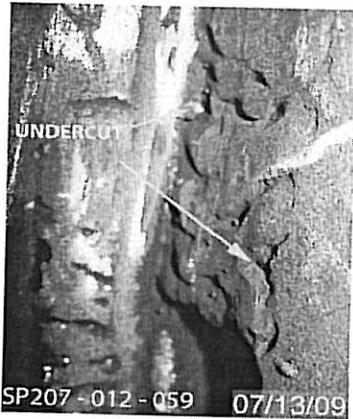
1. Plates X209F do not have 10mm snipe at interface areas with plates X209E as per detail Sheet No. SP207.
2. 8mm fillet weld was not completed full length of plate X209E as detailed.
3. Arc strikes are located on plate X209E.
4. Undercut on weld SP207-012-059 measured 3mm in depth.

For further details see attached photos and applicable reference below.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )



## Applicable reference:

1) Detail Sheet #SP207

**Who discovered the problem:** Naddi Sandeep Kumar.

**Name of individual from Contractor notified:** Hui Gui Hua

**Time and method of notification:** 15:00 / Verbal

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 08:00 / Verbal

**QC Inspector's Name:** Chen Chih Chien

**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





探伤报告编号: 18478



# 探伤申请表

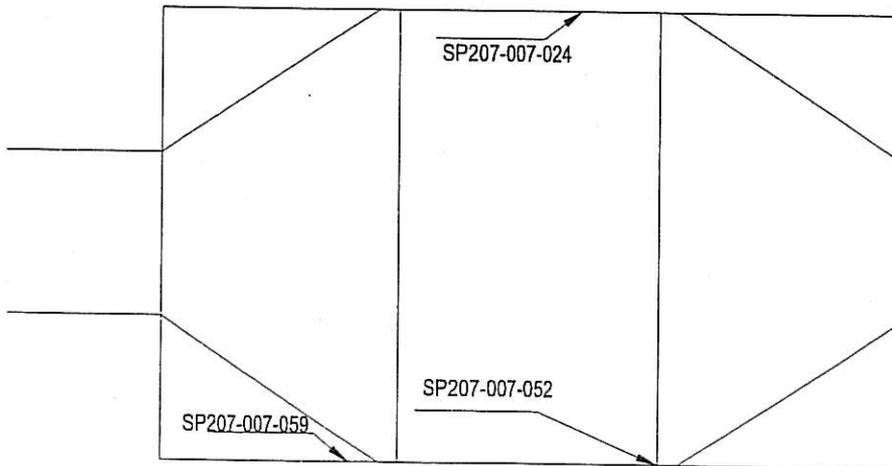
产品名称  
NAME OF PRODUCT

APPLICATION FORM FOR NDT

美国海湾大桥

零部件图号 Drawing No	SP207A	探伤类别 Test type	MT100%	编号 No	ZP06-787		
零部件名称 Items	腹板	材料 Material	A709M-345T2-X	数量 Quantit			
序号 No.	探伤编号 NDT No.	焊缝类型 Weld type	板厚/直径 thickness/diameter	焊工姓名 Welder name	焊工编号 Welder No.	结论 Result	备注 remark
1	SP207-012-024	T接	14×25×200	NA	054459	✓	
2	SP207-012-052	T接	25×25×200	NA	058174	✓	
3	SP207-012-059	T接	25×25×200	NA	048625	✓	

探伤位置图  
Scheme showing the test part



- 备注:
- 焊后
  - 校火后
  - WR/CWR 碳刨后  
WR/CWR NO: \_\_\_\_\_
  - WR/CWR 返修后  
WR/CWR NO: \_\_\_\_\_
  - SPCM
  - 其它 after repair
- 焊接方法: FAW
- 车间位置: w8

申请人 Applicant	郑喜芝 王亮	日期 Date	2009.07.20	主探者 Inspected by		日期 Date	2009.07.20
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QA APPROVAL REQUEST FORM

Component SP207A Date 07/28-09

In-Process tag No. 008448  
\*Attach In-Process tag

Green tag No. 008462 Location 9D/CB12

Weld numbers SP207-012-001~020

SP207-012-021~064

Xu Xian ping 07/28-09  
 ZPMC Team Representative Date

Hu Gui ma 07/28-09  
 ABF Team Representative Date

Subhan Bin (15205) 28-07-09  
 CT Team Representative Date

DOCUMENTATION REVIEW

	Yes	No
NDE complete	<input type="checkbox"/>	<input type="checkbox"/>
Repairs complete	<input type="checkbox"/>	<input type="checkbox"/>
NCR's closed	<input type="checkbox"/>	<input type="checkbox"/>

ABF QA Manager \_\_\_\_\_ 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-000499**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0331**Type of problem:**

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

**Date the Non-Conformance Report was written:** 13-Jul-2009**Description of Non-Conformance:**

During random in-process visual inspection on Side Plate (SP207), Caltrans Quality Assurance (QA) Inspector observed the following:

1. Plates X209F do not have 10mm snipe at interface areas with plates X209E as per detail Sheet No. SP207.
2. 8mm fillet weld was not completed full length of plate X209E as detailed.
3. Arc strikes are located on plate X209E.
4. Undercut on weld SP207-012-059 measured 3mm in depth.

For further details see attached photos and applicable reference below.

**Contractor's proposal to correct the problem:**

Address the items listed in the NCR such that SP207 conforms to the approved Shop Drawings and all welds listed conform to Contract specifications.

**Corrective action taken:**

Snipes were added to X209F Plates in accordance with approved Shop Drawings, the fillet weld on Plate X209E was completed, the noted arc strikes were repaired, and the undercut issue on weld SP207-012-059 was corrected. The Contractor submitted VT reports for the members/welds listed along with the signed Green Tag verifying SP207 is in conformance with Contract requirements.

**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 Jim Simonis 152. 1675.3703, who represents the Office of Structural Materials for your project.

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# QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**Inspected By:** Simonis,Jim

Quality Assurance Inspector

**Reviewed By:** Wahbeh,Mazen

QA Reviewer