

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**Report No:** NCR-000370**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0344**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG 1AAE & 1AAW**Procedural****Procedural****Description:****Reference Description:** End Plates**Description of Non-Conformance:**

During random visual observations of Heat Straightening of OBG Segment 1AAW end plates as directed by HSR(B)-298. The Quality Assurance (QA) Inspector observed ZPMC personnel using two (2) hydraulic jacks with a high amount of pressure (excessive hydraulic force) to correct deformation in end plate 1472A. The HSR(B)-298 states "Jacking shall not be used to plastically deform the plates. The jack shall only be used as a fixture."

It is also noted that ZPMC personnel have mechanically ground a 2mm deep by 150 mm diameter circle in the base material of 1AAE End Plate 1472C. It appears ZPMC was attempting to straighten the deformed end plate.

**Applicable reference:**

ZPMC Approved Heat Straightening Report; HSR(B)-298

Who discovered the problem: Larry Viars**Name of individual from Contractor notified:** Raymond Mah

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 0530 hours, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 0800 hours, Verbal

QC Inspector's Name: Chen Xi

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
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 04-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: 05.03.06-000323

Subject: NCR No. ZPMC-0344

Reference Description: End Plates

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:** 01

Remarks:

During random visual observations of Heat Straightening of OBG Segment 1AAW end plates as directed by HSR(B)-298. The Quality Assurance (QA) Inspector observed ZPMC personnel using two (2) hydraulic jacks with a high amount of pressure (excessive hydraulic force) to correct deformation in end plate 1472A. The HSR(B)-298 states "Jacking shall not be used to plastically deform the plates. The jack shall only be used as a fixture."

It is also noted that ZPMC personnel have mechanically ground a 2mm deep by 150 mm diameter circle in the base material of 1AAE End Plate 1472C. It appears ZPMC was attempting to straighten the deformed end plate.

See attached NCR No. ZPMC-0344 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.,A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0344

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000323

Subject: NCR No. ZPMC-0344

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000301 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has corrected the deficiency provided the required documents. ZPMC requests closure of this NCR.
ZPMC has corrected the deficiency provided the required documents. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000301R00;

Caltrans' comments:

Status: CLO

Date: 01-Sep-2009

The proposed resolution is acceptable. The heat straightening report is included, and all of the affected welds have been accepted by VT, MT, and UT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0344 is closed.

Submitted by: Wright, Doug

Date: 01-Sep-2009

Attachment(s):



No. B-455

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-19

REGARDING: NCR-000370 (ZPMC-344)

With this letter of response, ZPMC requests closure for Caltrans **NCR-000370 (ZPMC-344)**.

According to the HSR(B)-298, ZPMC used the jack as a fixture. After the heat straightening completed, the welds at the heat area and the surrounding affected welds were verified NDT by ZPMC and CT, the result was accepted.

So base on the above explanation and attached documentations, ZPMC applies to close the Caltrans's report **NCR-000370 (ZPMC-344)**.

Please reference attached document for acceptance and closure the **NCR-000370 (ZPMC-344)**.

ATTACHMENT:

NCR-000370 (ZPMC-344)

The heat straightening report

The final VT/MT/UT inspection reports

A handwritten signature in blue ink, which appears to read "Shen Xuejun". The signature is written in a cursive, flowing style.

2009. 8. 19



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 04-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: 05.03.06-000323

Subject: NCR No. ZPMC-0344

Reference Description: End Plates

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- 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: 01

Remarks:

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Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0344

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

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
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Bay Area Branch
 690 Walnut Ave. St. 150
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 (707) 649-5453
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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-000370

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-Jun-2009

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

NCR #: ZPMC-0344

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

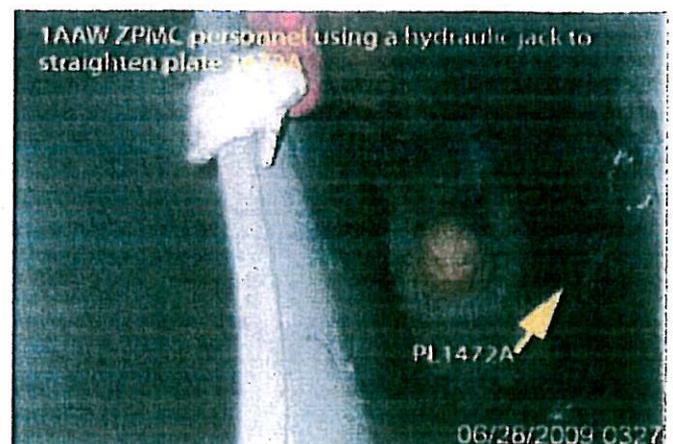
Procedural Procedural Description:

Reference Description: End Plates

Description of Non-Conformance:

During random visual observations of Heat Straightening of OBG Segment 1AAW end plates as directed by HSR(B)-298. The Quality Assurance (QA) Inspector observed ZPMC personnel using two (2) hydraulic jacks with a high amount of pressure (excessive hydraulic force) to correct deformation in end plate 1472A. The HSR(B)-298 states "Jacking shall not be used to plastically deform the plates. The jack shall only be used as a fixture."

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Applicable reference:

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Who discovered the problem: Larry Viars

Name of individual from Contractor notified: Raymond Mah

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 0530 hours, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 0800 hours, Verbal

QC Inspector's Name: Chen Xi

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



火工校正报告

Heat Straightening Report (HSR)

报告号/Report No.: HSR(B)-298

版本号/Revision No.: 0

日期/Date: 2009.06.26

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:	质检代表/Quality Control Representative
部装 Sub-Assembly:	<i>Xunjin 2009.06.26</i>
梁段 Gird: 1AAE/1AAW	质检经理/Quality Assurance Manager-Approval
塔段 Tower: N/A	<i>Lufanhua</i>
焊缝号 Weld No: N/A	
焊缝地图号 Weld Map No: N/A	

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(Defect Removal Method): Using hand torch and additional force as well 使用火焰枪以及外力

后续NDE(Post-Removal NDE):

Jacking shall not be used to plastically deform the flange. The Jack shall only be used as a fixture.

After finishing heat straightening, the weld of the treat area shall perform NDT according to the approved shop drawing. 不能使用千斤顶进行塑性变形。千斤顶只能用作固定装置，校火后需按照图纸上的要求对热影响区域进行 NDT 检测。

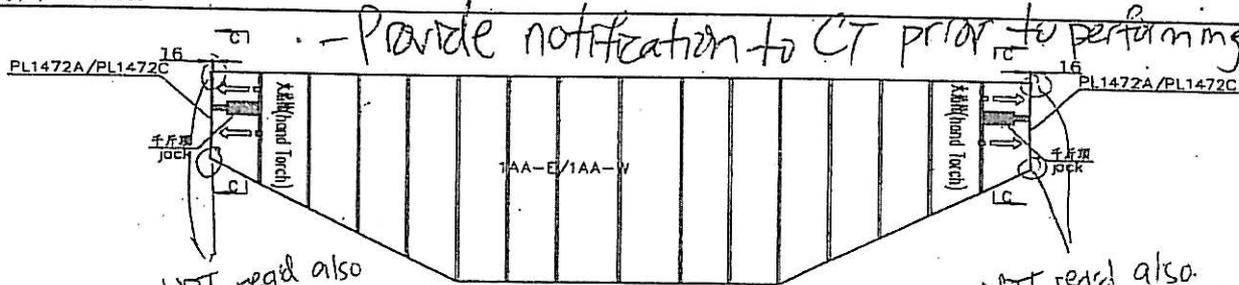
纠正措施(Corrective Action(s)):

Increase the flange anti-deformation allowance during the course of fit-up, and Control the welding parameters according to associated WPS. 在装配的过程中增加反变形量。根据相关WPS控制焊接参数。

实施次数(Number of application): 1~3

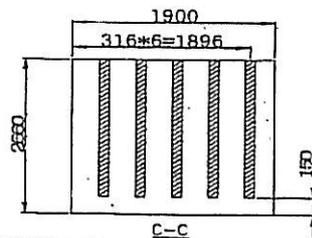
最高温度(Maximum temperature): <650°C

简图 Sketch



NOT reqd also after heating

NOT reqd also after heat straightening

注: 最大变形量约16mm, 校火厚度20~100mm.
NOTE: the max deformation is about 16mm, heat straightening the width is 20~100mm.-E.T.
2009.6.26

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

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

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

#R787-QCP-1100

This document is APPROVED as noted
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial *mi* Date: 6/26/09



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12094 DATE日期 2009.07.05 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: SEG2 OBG FLOOR BEAM CALTRANS CONTRACT NO.: 04-0120F4
加州工程编号

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 CASTING 铸件 FORGING 锻造 Material & thickness 母材,厚度: A709M-345F2-X 22/28 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			
SEG2F-022				ACC.		100%MT
SEG2F-023				ACC.		100%MT
SEG2F-027				ACC.		100%MT

AFTER HSR(B)-298

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EXAMINED BY主探: SunGongchang Sun Gongchang 2009.7.5
LEVEL - II SIGN 签名 / DATE日期

REVIEWED BY审核: Li Zhenhua 2009.7.5
LEVEL-II SIGN / DATE日期

质量经理 / QCM: [Signature]
签字 SIGN / 日期 DATE: 2009.7.5

用户CUSTOMER: _____
签字 SIGN / 日期 DATE: _____



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-7340 DATE 2009.07.01 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 1AA PLATE PANEL DRAWING NO.: SEG2/C
 部件名称 SPLICE 图号
 CALTRANS CONTRACT NO.: 04-0120F4
 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 FCAW T JOINT Dec. 28ST, 2009

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 IIV BLOCK TYPE II C.M.C A709M-345F2-X 22/38/20mm

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°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	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
SEG2-035		70				33									ACC.	100%
SEG2C-001	1	70	A	1	43	33	3	+2	180	60	19	-2	0		REJ.	100%
	2	70	A	2	39	33	3	+1	10	66	2	-13	1920		REJ.	100%
SEG2C-106	1	70	A	1	45	33	3	-1	110	68	21	-10	0		REJ.	100%
	2	70	A	1	39	33	2	+8	10	54	17	-28	610		REJ.	100%

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EXAMINED BY 主探 Xue hai rong <i>Xuehai rong</i> 09.07.07 LEVEL - II SIGN / DATE 质量经理 / QCM 签字 SIGN / 日期 DATE	REVIEWED BY 审核 <i>Luany...</i> 09.07.07 LEVEL - II SIGN / 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 B787-UT-7361R1 DATE 2009.07.20 PAGE 1 OF 2 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: OBG FLOOR BEAM
部件名称

DRAWING NO.: SEG1/C
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
SMAW

JOINT TYPE 焊缝类型
CORNER-JOINT

CALIBRATION DUE DATE 仪器校正有效期
Dec. 28ST, 2009

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
AWS IIV BLOCK TYPE II

COUPLANT 耦合剂
C.M.C

MATERIAL/THICKNESS 材料厚度
A709M-345F2-X 22/38/20mm

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°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	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
SEG1C-002	1R1	70														
	2R1	70														ACC. 100%
	3R1	70														ACC. 100%
SEG1C-094	1R1	70														ACC. 100%
	2R1	70														ACC. 100%
	3R1	70														ACC. 100%
	4R1	70														ACC. 100%
	5R1	70														ACC. 100%

EXAMINED BY 主探

Sun yin Sun Yin

REVIEWED BY 审核

Han Feng

LEVEL - II SIGN / DATE

07.20

LEVEL - II SIGN / DATE

07.20

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-13028 DATE日期 2009.07.20 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: SEG1 SEG1C SEG1D 1AAW		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-345 28/38 mm
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	BUTT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SEG1-035				ACC.		100%MT
SEG1-036				ACC.		100%MT
SEG1C-002				ACC.		100%MT
SEG1C-094				ACC.		100%MT
SEG1D-001				ACC.		100%MT
SEG1D-092				ACC.		100%MT

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EXAMINED BY主探 <i>Sun Jiong Chang</i>	REVIEWED BY 审核 <i>wangner</i>
LEVEL - II SIGN 签名 / DATE日期 <i>09.07.20</i>	LEVEL-II SIGN / DATE日期 <i>09.07.20</i>
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-13029 DATE日期 2009.07.20 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: SEG2\SEG2C\SEG2D 1AAE CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4

REFERENCING CODE 参考规范编码 AWS D1.5-2002 ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002 PROCEDURE NO. 程序编号 ZPQC-MT-01 CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST, 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 CASTING 铸件 FORGING 锻造 Material & thickness 母材, 厚度 A709M-345 28/38 mm

WELDING PROCESS 焊接方法 FCAW TYPE OF JOINT 焊缝类型 BUTT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SEG2-035				ACC.		100%MT
SEG2-036				ACC.		100%MT
SEG2C-003				ACC.		100%MT
SEG2C-106				ACC.		100%MT
SEG2D-001				ACC.		100%MT
SEG2D-091				ACC.		100%MT

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EXAMINED BY主探 Sun Gongchang REVIEWED BY 审核 Nanqun
 LEVEL - II SIGN 签名 / DATE日期 09.27.20 LEVEL-II SIGN / DATE日期 09.27.20
 质量经理 / QCM 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**Report No:** NCS-000270**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0344**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: 28-Jun-2009**Description of Non-Conformance:**

During random visual observations of Heat Straightening of OBG Segment 1AAW end plates as directed by HSR(B)-298. The Quality Assurance (QA) Inspector observed ZPMC personnel using two (2) hydraulic jacks with a high amount of pressure (excessive hydraulic force) to correct deformation in end plate 1472A. The HSR(B)-298 states "Jacking shall not be used to plastically deform the plates. The jack shall only be used as a fixture."

It is also noted that ZPMC personnel have mechanically ground a 2mm deep by 150 mm diameter circle in the base material of 1AAE End Plate 1472C. It appears ZPMC was attempting to straighten the deformed end plate.

Contractor's proposal to correct the problem:

Contractor has acknowledged that this item must be addressed, and the item was added to the Master Punchlist.

Corrective action taken:

Work was completed and item was cleared on Master Punchlist by Caltrans on 6-10-2009. Submittal of documentation by Contractor being tracked on Documentation Punchlist.

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

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer