

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000373**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0347**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Crossbeam 2
Procedural	Procedural	Description:	

Reference Description: Undercut welds were accepted by QC at Crossbeam 2**Description of Non-Conformance:**

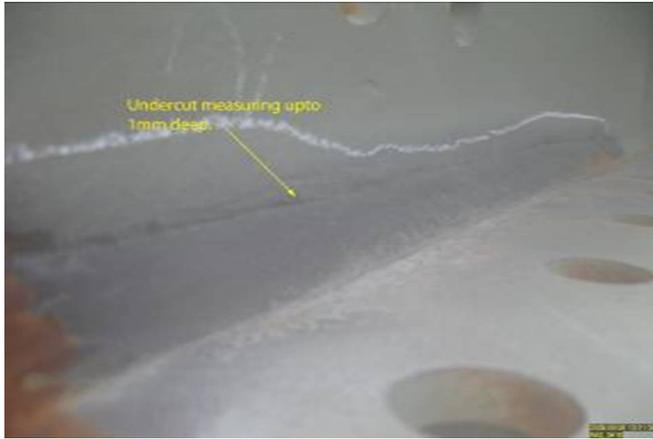
This Quality Assurance (QA) Inspector perform VT and MT inspection on holdback welds at the CB204A-004, 006, 010, 012, 016, 018, 023 and 024. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple (SPCM) Hold back areas. These welds are listed below. These welds were previously approved and accepted by ZPMC QC.

SP220A-1 To BP215A-1 (SP to BP Corner Joint With Fillet)
 SP220A-2 To BP215A-2 (SP to BP Corner Joint With Fillet)
 BP212A-1 To FB212A-1 (FB to BP Fillet weld)
 BP212A-2 To FB212A-2 (FB to BP Fillet weld)
 BP216A-1 To SP 217A-1 (SP to BP Corner Joint With Fillet)
 BP216A-2 To SP 218A-2 (SP to BP Corner Joint With Fillet)



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5-2002 section 6.26.1.5: In Primary members, undercut shall be no more than 0.25 mm (0.01 in.) deep when the weld is transverse to tensile stress under any design loading condition. Undercut shall be no more than 1 mm (1/32) deep for all other cases.

Who discovered the problem: Stefan Holmes

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 1300 hours, verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1720 hours, email

QC Inspector's Name: Wang Lu

Was QC Inspector aware of the problem: 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.

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	Wahbeh, Mazen	SMR
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DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 13-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: 05.03.06-000336

Subject: NCR No. ZPMC-0347

Reference Description: Undercut welds were accepted by QC at Crossbeam 2

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:** 02

Remarks:

This Quality Assurance (QA) Inspector perform VT and MT inspection on holdback welds at the CB204A-004, 006, 010, 012,016 018, 023 and 024. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple (SPCM) Hold back areas. These welds are listed below. These welds were previously approved and accepted by ZPMC QC.

SP220A-1 To BP215A-1 (SP to BP Corner Joint With Fillet)

Action Required and/or Action Taken:

Submit repair procedure to engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0347

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: 05.03.06-000336

Subject: NCR No. ZPMC-0347

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000341 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will perform the remedial actions necessary and submit supporting inspection reports verifying work is complete and acceptable.

ZPMC will perform the remedial actions necessary and submit supporting inspection reports verifying work is complete and acceptable. These documents will be submitted to close this NCR at a later date.

Submitted by:

Attachment(s): ABF-NPR-000341R00

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-0347 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: 05.03.06-000336

Subject: NCR No. ZPMC-0347

Dated: 16-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000341 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has performed the necessary remedial actions and has attached the supporting inspection documentation verifying work is complete. ZPMC requests closure of this NCR.

ZPMC has performed the necessary remedial actions and has attached the supporting inspection documentation verifying work is complete. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000341R01;

Caltrans' comments:

Status: REJ

Date: 24-Sep-2009

Contractor submitted VT and MT for all welds except CB204A-001-024, signed off Master Punchlist on 8-23-09. Please provide MT and VT reports for weld CB204A-001-024, and WRR for the entire repair.

Submitted by: Chao, Ching

Date: 24-Sep-2009

Attachment(s):



No. B-472

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-9-14

REGARDING: NCR-000373 (ZPMC-0347)

With this letter of response, ZPMC requests closure for Caltrans NCR-000373 (ZPMC-0347). We agree what describe in the non-conformance report, and have do the weld repair on the undercut areas, and then flush grinding on the fillet top to assure the profile reach the specification of 0.25mm undercut. By the way we have done the MT inspection on the related weld and providing the report as the attachment. Also we remind here that all of the repair process was witnessed by the CT inspector and accepted the final condition by each parties, the corresponding items in the punchlist have been closed out too.

so base on the above explanation, ZPMC applies to close the caltrans's report NCR-000373 (ZPMC-0347).

Please reference attached document for acceptance and closure the NCR-000373 (ZPMC-0347).

ATTACHMENT:

NCR-000373 (ZPMC-0347)

ZPMC internal NCR

The acceptable VT/MT reports

Shao Shuangbao

2009. 9. 14



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-B-247
 NCR 编号: (ZPMC-0347)

Item: Undercut welds were accepted by QC at Crossbeam 2
 Item Number: N/A
 Drawing: Crossbeam 2
 名称描述: 件号: 图号:

Location: 总拼后场
 位置: Date: 2009-08-26
 日期:

Description of Nonconformance:

不符合项状态描述:

This Quality Assurance inspector perform VT and MT inspection on holdback welds at the CB204A-004,006,010,012,016,018,023. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple Holdback back areas, These welds were previously approved and accepted by ZPMC QC.

加州检验员在对 CB2 上的预留焊缝做 VT 和 MT 时发现不同程度的咬边存在, 被拒收的咬边最大达到 1.75 mm 深。而此前这些焊缝已被 ZPMC QC 接受。

Work By: Xia Fu Ling Prepared by: Wang Reviewed by QCE: Huo Shuangbao
 施工方: 准备: 质量工程师批准:

Drawing Error 图纸错误 Material Defect 材料缺陷 Fabrication Error 制作错误 Other 其他原因 8.26

Disposition: Use as is 回用 Repair 返修 Reject 拒收

处理措施:

Recommendation:

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

Reason for Nonconformance:
 不符合原因: 对于联系梁 CB2 上的预留焊缝做 VT, MT 时发现不同程度的咬边存在。

预防措施: Perform VT, MT on CB2 struct plate prepare weld on holdback weld.
 增强现场检查 Enhance inspection on-site.

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
 回用或返修的技术依据: 无附件

对咬边区域进行堆焊返修 Perform repair to the undercut area.

Reviewed /批准: Daihui 08.21.09 Acceptable 可接受 Unacceptable 不可接受

Verification: 确认: Ju Yong Jian 37120671 09.9.13
 Verified by QCI/质检确认: Reviewed by QCA/质检主任审核:

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: 13-Aug-2009

Contract No: 04-0120F4
04-SF-80-13 2 / 13 9

Dear: Mr. Charles Kanapick
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0347

Job Name: SAS Superstructure
Document No: 05.03 06-000336

Reference Description: Undercut welds were accepted by QC at Crossbeam 2

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: 02

Remarks:

This Quality Assurance (QA) Inspector perform VT and MT inspection on holdback welds at the CB204A-004, 006, 010, 012, 016, 018, 023 and 024. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple (SPCM) Hold back areas. These welds are listed below. These welds were previously approved and accepted by ZPMC QC.

SP220A-1 to BP215A-1 (SP to BP Corner Joint With Fillet)

Action Required and/or Action Taken:

Submit repair procedure to engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0347

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

05.03.06

05.03.06-000336.NCT

Received
NCT-000336 18 Aug 09

DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICESOffice of Structural Materials
Quality Assurance and Source InspectionBay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493Contract #: 04-0120F4
Cty: 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-000373**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0347**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Crossbeam 2Procedural Procedural Description:**Reference Description:** Undercut welds were accepted by QC at Crossbeam 2**Description of Non-Conformance:**

This Quality Assurance (QA) Inspector perform VT and MT inspection on holdback welds at the CB204A-004, 006, 010, 012, 016 018, 023 and 024. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple (SPCM) Hold back areas. These welds are listed below. These welds were previously approved and accepted by ZPMC QC.

SP220A-1 To BP215A-1 (SP to BP Corner Joint With Fillet)

SP220A-2 To BP215A-2 (SP to BP Corner Joint With Fillet)

BP212A-1 To FB212A-1 (FB to BP Fillet weld)

BP212A-2 To FB212A-2 (FB to BP Fillet weld)

BP216A-1 To SP 217A-1 (SP to BP Corner Joint With Fillet)

BP216A-2 To SP 218A-2 (SP to BP Corner Joint With Fillet)





Visual Weld Inspection Report
焊缝目视检查报告

Caltrans Contract No. 加州合同编号		04-0120F4		Girder/ 梁:		OBG Plate Panel Splice		周数	96				
Project No.: 项目名称		San Francisco Oakland Bay Bridge 美国海湾大桥		Tower/ 塔:				日期	209.09.04				
Project No.: 项目编号:		ZP06-787		Quality Control Representative: 质检代表:									
		Quality Assurance Manager ~Approval 质量控制经理:		CWI: 检验员:		guroy izan							
								0720671					
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 修后接受或拒收
CB204A-001-004	051246	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-006	051246	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-016	058174	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-018	058174	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-010	218958	2F	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-023	218958	2F	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-012	218958	2F	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
				√	√	√	√	√	√	√	ACC	NA	NA
<input type="checkbox"/> After root weld <input type="checkbox"/> After CWR or WRR No.: <input type="checkbox"/> After cover pass <input type="checkbox"/> After HSR No.:													

#R787-QCP-603

Others: NCR-B-247

"√" 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-13688

DATE日期 2009.09.09

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:

CB2

CALTRANS CONTRACT NO.:

加州工程编号

04-0120F4

PLATE PANEL SPLICE

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

WELDING PROCESS

焊接方法

FCAW

TYPE OF JOINT

焊缝类型

12/14/16 mm

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			
CB204A-001-004				ACC.		100%MT
CB204A-001-006				ACC.		100%MT
CB204A-001-016				ACC.		100%MT
CB204A-001-018				ACC.		100%MT
CB204A-001-010				ACC.		100%MT
CB204A-001-023				ACC.		100%MT
CB204A-001-012				ACC.		100%MT

BLANK

EXAMINED BY主探

Xu Huaxiang

LEVEL - II SIGN 签名 / DATE日期

质量经理 / QCM

REVIEWED BY 审核

LEVEL-II SIGN

用户CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000336

Subject: NCR No. ZPMC-0347

Dated: 16-Oct-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000341 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: Per Caltrans' NCT 05.05.06-000336, VT and MT reports are attached. A WRR was not issued in this case because the undercut was removed by grinding. ZPMC requests closure of this NCR.

Per Caltrans' NCT 05.05.06-000336, VT and MT reports are attached. A WRR was not issued in this case because the undercut was removed by grinding. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000341R02;

Caltrans' comments:

Status: CLO

Date: 29-Oct-2009

The documentation submitted for successful weld repair was found acceptable. However, a CWR will be still required prior to weld repair in the future for similar situation.

Submitted by: Chao, Ching

Date: 29-Oct-2009

Attachment(s):



No. B-478

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-10-14

REGARDING: NCR-000373 (ZPMC-0347)

With this letter of response, ZPMC requests closure for Caltrans NCR-000373 (ZPMC-0347). Per the commence of the NPR, we are providing the final VT and MT report which include the weld of the CB204A-001-024, please review again and apply to close out the NCR.

so base on the above explanation, ZPMC applies to close the caltrans's report NCR-000373 (ZPMC-0347).

Please reference attached document for acceptance and closure the NCR-000373 (ZPMC-0347).

ATTACHMENT:

NCR-000373 (ZPMC-0347)

ZPMC internal NCR

The acceptable VT/MT reports

Chao Shuangbao

2009. 10. 14.



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-B-247
 NCR 编号: (ZPMC-0347)

Item: Undercut welds were accepted by QC at Crossbeam 2
 Item Number: N/A
 Drawing: Crossbeam 2
 图号: Crossbeam 2

Location: 总拼后场
 位置: _____

Date: 2009-08-26
 日期: 2009-08-26

Description of Nonconformance:
 不符合项状态描述:

This Quality Assurance inspector perform VT and MT inspection on holdback welds at the CB204A-004,006,010,012,016,018,023. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple Holdback back areas. These welds were previously approved and accepted by ZPMC QC.

加州检验员在对 CB2 上的预留焊缝做 VT 和 MT 时发现不同程度的咬边存在, 被拒收的咬边最大达到 1.75 mm 深。而此前这些焊缝已被 ZPMC QC 接受。

Work By: Xia Fu Ling
 施工方: Xia Fu Ling

Prepared by: [Signature]
 准备: [Signature]

Reviewed by QCE: [Signature]
 质量工程师批准: [Signature]

Drawing Error 图纸错误
 Material Defect 材料缺陷
 Fabrication Error 制作错误
 Other 其他原因

Disposition: Use as is 回用
 Repair 返修
 Reject 拒收

Recommendation:
 建议:

Prepared by: _____
 准备

Approved by QCA: _____
 质量经理批准

Reason for Nonconformance:
 不符合原因:

对于联系架 CB2 上的预留焊缝做 VT, MT 时发现不同程度的咬边存在。
 Perform VT, MT on CB2 struct plate prepare weld on holdback weld.

预防措施:
 加强了现场检查
 Enhance inspection on-site

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

回用或返修的技术依据:
 对咬边区域进行堆焊返修
 Perform repair to the undercut area.

Reviewed / 批准: [Signature]
 确认: Acceptable 可接受
 Unacceptable 不可接受

Verified by QCI/质检确认: [Signature]
 Reviewed by QCA/质检主任审核: [Signature]

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
575 BURMA ROAD
OAKLAND CA 95607

Date: 05-03-06

Contract No: 04 012074
04-SF-80-13 2/13/9

Dear: Mr. Charles Kanapick
Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure
Document No: 05.03.06-000336

Subject: NCR No. ZPMC-0347

Reference Description: Undercut welds were accepted by QC at Crossbeam 2

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: 02

Remarks:

This Quality Assurance (QA) Inspector perform VT and MT inspection on holdback welds at the CB204A-004, 006, 010, 012, 016, 018, 023 and 024. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple (SPCM) Hold back areas. These welds are listed below. These welds were previously approved and accepted by ZPMC QC.

SP220A-1 To BP215A-1 (SP to BP Corner Joint With Fillet)

Action Required and/or Action Taken:

Submit repair procedure to engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0347

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

05.03.06-000336-NCT

Received
05-03-06 18 AUG 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, P.R. China

Report No: NCR-000373

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 06-Aug-2009

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

NCR #: ZPMC-0347

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

Joint fit-up Coating Other Component: Crossbeam 2

Procedural Procedural Description:

Reference Description: Undercut welds were accepted by QC at Crossbeam 2

Description of Non-Conformance:

This Quality Assurance (QA) Inspector perform VT and MT inspection on holdback welds at the CB204A-004, 006, 010, 012, 016 018, 023 and 024. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple (SPCM) Hold back areas. These welds are listed below. These welds were previously approved and accepted by ZPMC QC.

SP220A-1 To BP215A-1 (SP to BP Corner Joint With Fillet)

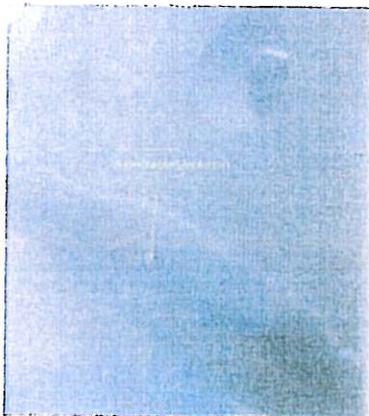
SP220A-2 To BP215A-2 (SP to BP Corner Joint With Fillet)

BP212A-1 To FB212A-1 (FB to BP Fillet weld)

BP212A-2 To FB212A-2 (FB to BP Fillet weld)

BP216A-1 To SP 217A-1 (SP to BP Corner Joint With Fillet)

BP216A-2 To SP 218A-2 (SP to BP Corner Joint With Fillet)





周数 96#

日期 2009.09.04

Visual Weld Inspection Report
焊缝目视检查报告

Girder/梁: **OBG Plate Panel Splice**

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**
美国海湾大桥

Project No.: 项目编号: **ZP06-787**

Quality Control Representative: 质检代表:

CWI: 检验员: **Gyu Kyujin 07120671**

Quality Assurance Manager ~Approval 质量控制经理:

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
CB204A-001-004	051246	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-006	051246	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-016	058174	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-018	058174	2G	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-010	218958	2F	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-023	218958	2F	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-012	218958	2F	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
CB204A-001-024	218958	2F	supercore71H(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
<input type="checkbox"/> After root weld <input type="checkbox"/> After CWR or WRR No.:												?	

After cover pass

After HSR No.:

Others **NA-B-247**

#R787-QCP-603

"√" 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-13688 DATE日期 2009.09.09 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: CB2 PLATE PANEL SPLICE		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 12/14/16 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			
CB204A-001-004				ACC.		100%MT
CB204A-001-006				ACC.		100%MT
CB204A-001-016				ACC.		100%MT
CB204A-001-018				ACC.		100%MT
CB204A-001-010				ACC.		100%MT
CB204A-001-023				ACC.		100%MT
CB204A-001-012				ACC.		100%MT
CB204A-001-024				ACC.		100%MT
BLANK						

EXAMINED BY主探 Xu Huaxiang <i>Xu Huaxiang</i> 09.09.09 LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM	REVIEWED BY 审核 Sun Gongchang <i>Sun Gongchang</i> 09.09.09 LEVEL-II SIGN / DATE日期 用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000252**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0347**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: 06-Aug-2009**Description of Non-Conformance:**

This Quality Assurance (QA) Inspector perform VT and MT inspection on holdback welds at the CB204A-004, 006, 010, 012, 016, 018, 023 and 024. Rejectable undercuts were found measuring up to a maximum of 1.75 mm deep in multiple (SPCM) Hold back areas. These welds are listed below. These welds were previously approved and accepted by ZPMC QC.

SP220A-1 To BP215A-1 (SP to BP Corner Joint With Fillet)
SP220A-2 To BP215A-2 (SP to BP Corner Joint With Fillet)
BP212A-1 To FB212A-1 (FB to BP Fillet weld)
BP212A-2 To FB212A-2 (FB to BP Fillet weld)
BP216A-1 To SP 217A-1 (SP to BP Corner Joint With Fillet)
BP216A-2 To SP 218A-2 (SP to BP Corner Joint With Fillet)

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:

Completion of work being tracked on Master Punchlist. 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.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer