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-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

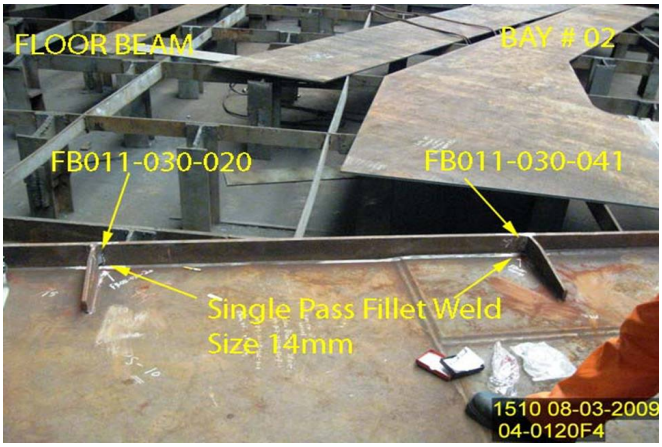
Type of problem:

Welding	☑	**Concrete**	☐	**Other**	☐	
Welding	☑	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:** OBG Floor Beam Sub-assembly
Procedural	☐	**Procedural**	☐	**Description:**		

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:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

☑ **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
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:**	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 Coe, Jason Tom, Contract Files, Ching Chao

File: 05.03.06

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV
P.O. BOX 23223 Oakland, CA 94623
Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000340

Subject: NCR No. ZPMC-0351

Dated: **24-Aug-2009**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000345 Rev: 00**

Contractor's Proposed Resolution:

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

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

Submitted by:

Attachment(s): ABF-NPR-000345R00

Caltrans' comments:

Status: AAP

Date: 28-Aug-2009

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

Please provide documentation of the weld removal mentioned above, and provide acceptable inspection documentation after re-welding. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0351 at that time.

Submitted by: Wright, Doug

Date: 28-Aug-2009

Attachment(s):

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV
P.O. BOX 23223 Oakland, CA 94623
Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000340

Subject: NCR No. ZPMC-0351

Dated: **14-Dec-2009**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000345 Rev: 01**

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-000345R01;

Caltrans' comments:

Status: CLO

Date: 27-Dec-2009

The documentation received closes this NCR.

Submitted by: Howe, Bill

Date: 27-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

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 名称描述: 板单元 SP207 未完成烧焊	Item Number: 件号: OBG CB12
Drawing: 图号: OBG SP207	
Location: OBG CB12 SP207 位置:	Date: 日期: 2009-8-12

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:

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 detail.
3. Arc strikes are located on plate X209E.
4. Undercut on weld SP207-012-059 measured 3mm in depth.

加洲检验员在对 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: Lj Zj Tao
Prepared by: Shen Xiejun 2009.8.13 准备:
Reviewed by QCE: Zhao Shuang bao 2009.8.13 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

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

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

Prepared by: Xu Xian Ping 07/07/2071 准备
Approved by QCA: 质量经理批准

Reason for Nonconformance: 1) copy hole size was short and weld after welding weld.
不符合原因: 1) 因过焊孔太小，10毫米的过焊孔堵住。
2) Restricate in this position and dioxide torch can't access
2) 二氧抢进不去 无法施焊 焊角未焊完 倒割 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，加强火焊工教育。
Enhance supervise and inspection by QC and owner inspector and enhance educate welder

Approved by/批准: Zhang Guiyuzhu

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:

责令施工队立即进行整改，并出具相应的返修报告，
请QC加强质量监控。

Reviewed /批准: Nimbu Jing

Verification: ☑ Acceptable 可接受 ☐ Unacceptable 不可接受
确认:

1. 过焊孔已经碳刨打磨出来 2. 少的角焊焊缝已经补上
3. 电弧擦伤已全部去除
1. Weld through hole has fabricated by gouging and grinding.
2. Fix weld size. 3. Remove arc strike.

Verified by QCI/质检确认: Xu Xiaoping 07/07/2071 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:	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

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY Arnold Schwarzenegger, Governor

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:		

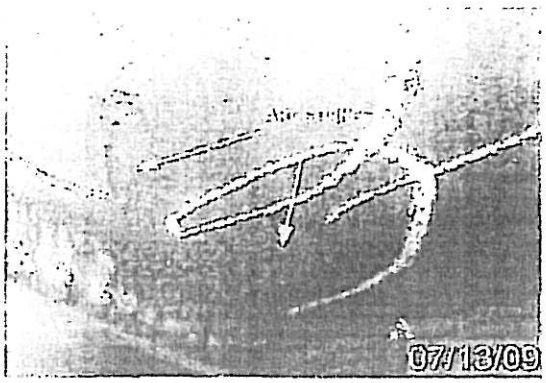
Reference Description: Improper Welding Practices on SP207

Description of Non-Conformance:

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

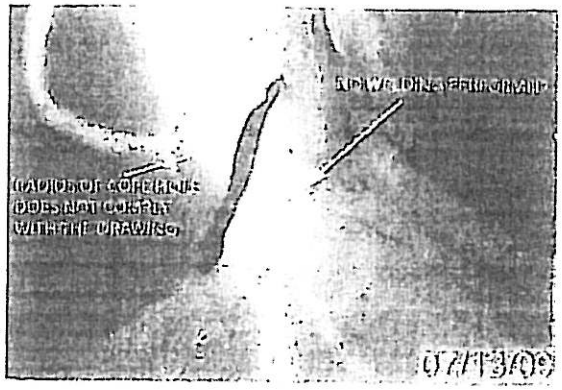
1. Plates X209F do not have 10mm snipe at interface areas with plates X209E as per detail Sheet No. SP207.
2. 8mm fillet weld was not completed full length of plate X209E as detailed.
3. Arc strikes are located on plate X209E.
4. Undercut on weld SP207-012-059 measured 3mm in depth.

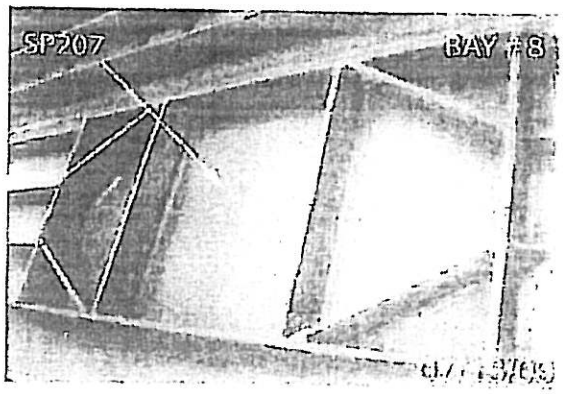
For further details see attached photos and applicable reference below.



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

ZPMC

周数	85#
日期	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	Representative: 质检代表:	
Project No.: 项目名称	San Francisco Oakland Bay Bridge 美国 海湾大桥	CWI: 检验员:	Chen Chih Chiem 03110701
Project No.: 项目编号:	ZP06-787	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
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 cover pass

☐ After CWR or WRR No.: ☑ After HSR No.: HSR1(B)-~~6446~~ 6746 ☐ Others

" √ " 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. 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-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主探 Tao Chaowei Tao Chaowei LEVEL - II SIGN 签名 / DATE日期 09.06.17	REVIEWED BY 审核 Sun Guang chang LEVEL-II SIGN / DATE日期 09.06.17
质量经理 / QCM Lo Tak 签字 SIGN / 日期 DATE 09.06.24	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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. 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-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 Tan Chaowei Tan Chaowei LEVEL - II SIGN 签名 / DATE日期 09.06.17	REVIEWED BY 审核 Sun Gang Chang LEVEL-II SIGN DATE日期 09.06.17
质量经理 / QCM Lu Tao 签字 SIGN / 日期 DATE 09.06.17	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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. 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-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 Tan Chaowei 09.06.17 LEVEL - II SIGN 签名 / DATE日期	REVIEWED BY 审核 Sun Gongchang 09.06.17 LEVEL-II SIGN / DATE日期
质量经理 / QCM 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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-240 (ZPMC-0351)
Item: Excessive weld size on single pass welds on OBG Floorbeams 名称描述: 单道焊焊角尺寸过大 Item Number: 件号: OBG FB011	Drawing: 图号: OBG FB011
Location: OBG FB 位置: BAY 3	Date: 日期: 2009-8-21

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

During random in-process visual inspection of floorbeam 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.

加洲检验员在对隔板焊缝 FB011-030-020，041，FB011-033-034，FB011-028-034 做目检时发现，角焊缝单道焊焊角尺寸大于允许的 9 毫米，实际大小为 12~14 毫米。

Work By: 施工方: jin jian
Prepared by: 准备: 2009.8.21
Reviewed by QCE: 质量工程师批准: 8/21/2009

☐ 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:

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

Reason for Nonconformance:
不符合原因:

由于探伤不合格，返修一次，导致焊角加大，焊后不易打磨。
Reject by NDT, enlarge weld size during repair ~~and~~ grind adequately

Prevention of Re-occurrence:
预防措施:

烧焊时，按图施工。 Weld and perform according to drawing requirement

Approved by/批准: Zhang Guiming

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:

将焊角打磨至要求范围之内，做NDT检测。

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

Reviewed /批准: Man Liyi 8.28/09

Verification: ☑ Acceptable ☐ Unacceptable

确认: 可接受 不可接受

Verified by QCI/质检确认: Zhu Tian shu 09.9.3 Reviewed by QCA/质检主任审核: _____

#R787-QCP-1300

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

Caltrans

NON-CONFORMANCE REPORT TRANSMITTAL

To:	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	Date:	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 Coe, Jason Tom, Contract Files, Ching Chao

File: 05.03.06

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY

Arnold Schwarzenegger, Governor

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
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

Report No: NCR-000377
Date: 03-Aug-2009
NCR #: ZPMC-0351

Type of problem:

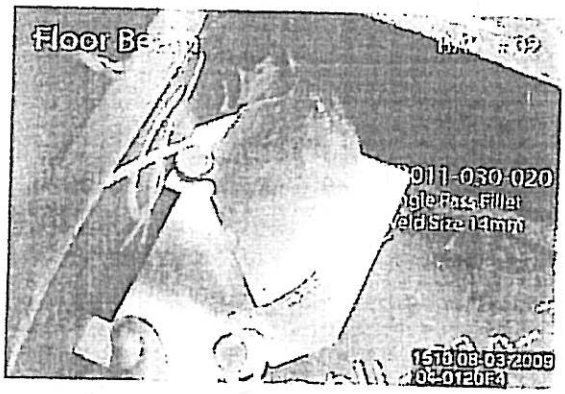
Welding	☑	Concrete	☐	Other	☐
Welding	☑	Curing	☐	Procedural	☐
Joint fit-up	☐	Coating	☐	Other	☐
Procedural	☐	Procedural	☐	Description:	

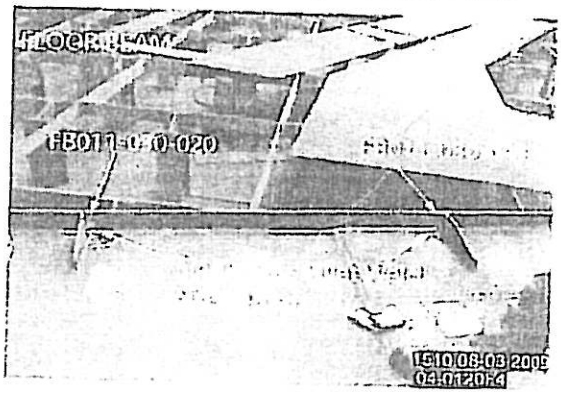
Bridge No: 34-0006
Component: OBG Floor Beam Sub-assembly

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:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

☑ 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
Reviewed By:	Wahbeh,Mazen	SMR

B-VT 34630

ZPMC

周数	90#
日期	2009-07-25

Visual Weld Inspection Report
焊缝目视检查报告

		Girder/梁:	OBG Floor Beam
		Tower/塔:	NA
Caltrans Contract No. 加州合同编号	04-0120F4	Quality Control Representative: 质检代表:	
Project No.: 项目名称	San Francisco Oakland Bay Bridge 美国海湾大桥	C W I : 检验员:	chen xi' 07/07/2021
Project No.: 项目编号:	ZP06-787	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
FB011-028-020	045209	2F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-024	045209	2F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-025	045209	2F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-033	045209	3F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-034	045209	3F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-041	045209	3F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-042	045209	3F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-046	045209	2F	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-028-045	045209	2G	supercored71H φ1.4	√	√	√	√	√	√	√	ACC	NA	NA

☐ After root weld

☑ After cover pass

☐ After CWR or WRR No. :

☐ After HSR No. :

☐ Others

#R787-QCP-603

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

B-VT 35172

ZPMC

周数	91 #
日期	2009-230

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 Floor Beam
		Tower/ 塔:	NA
Project No.: 项目名称	San Francisco Oakland Bay Bridge 美国海湾大桥	Quality Control Representative: 质检代表:	[signature]
		C W I : 检验员:	Chen XT 07072021
Project No.: 项目编号:	ZP06-787	Quality Assurance Manager ~Approval 质量控制经理:	[signature]

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
FB011-030-020	045209	2F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-024	045209	2F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-025	045209	2F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-033	045209	3F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-034	045209	3F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-041	045209	3F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-042	045209	3F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-046	045209	2F	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-045	045209	2G	supercored71Hφ1.4	√	√	√	√	√	√	√	ACC	NA	NA

☐ After root weld
☐ After CWR or WRR No. :
☑ After cover pass
☐ After HSR No. :
☐ Others

#R787-QCP-603

", √ " is no defects. " X " is defects. "NA" is not applicable.

BVT25838

ZPMC

周数	92#
日期	2009.08.08

Visual Weld Inspection Report
焊缝目视检查报告

Girder/梁:	OBG Floor Beam		
Tower/塔:	NA		
Caltrans Contract No. 加州合同编号	04-0120F4	Quality Control Representative: 质检代表:	[signature]
Project No.: 项目名称	San Francisco Oakland Bay Bridge 美国海湾大桥	CWI: 检验员:	[signature] 02051311
Project No.: 项目编号:	ZP06-787	Quality Assurance Manager ~Approval 质量控制经理:	[signature]

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
FB011-028-034	062708	3F	Supercored71H	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-033	062708	3F	Supercored71H	√	√	√	√	√	√	√	ACC	NA	NA
FB011-030-042	062708	3F	Supercored71H	√	√	√	√	√	√	√	ACC	NA	NA
FB011-033-033	062708	3F	Supercored71H	√	√	√	√	√	√	√	ACC	NA	NA
FB011-033-034	062708	3F	Supercored71H	√	√	√	√	√	√	√	ACC	NA	NA

☐ After root weld
☑ After CWR or WRR No.:B-WR6867
☐ After cover pass
☐ After HSR No.:
☐ Others

#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-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 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. 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-345T2-X 14/20 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 INDICATION 指示	TYPE 类型	LENGTH IN mm 长度	ACCEPT 接受	REJECT 拒收	REMARKS 备注
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 LEVEL - II SIGN 签名 / DATE日期 09.08.08	REVIEWED BY 审核 Sun Gong chang LEVEL-II SIGN / DATE日期 09.08.08
质量经理 / QCM 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

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. 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-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 LEVEL-II SIGN / DATE日期 09.08.01
质量经理 / QCM 签字 SIGN / 日期 DATE 09.08.01	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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. 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-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 INDICATION 指示	TYPE 类型	LENGTH IN mm 长度	ACCEPT 接受	REJECT 拒收	REMARKS 备注
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 Zhao Chenggong LEVEL - II SIGN 签名 Zhao Chenggong / DATE日期 09.08.01	REVIEWED BY 审核 Sun Gongchang LEVEL-II SIGN / DATE日期 09.08.01
质量经理 / QCM 签字 SIGN / 日期 DATE 09.08.01	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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

(FORM# ZPQC-MT01)

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. 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-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 INDICATION 指示	TYPE 类型	LENGTH IN mm 长度	ACCEPT 接受	REJECT 拒收	REMARKS 备注
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FB011-030-024				ACC.		100%MT
FB011-030-025				ACC.		100%MT
FB011-030-033				ACC.		25%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 Chenggong Zhaochenggong LEVEL - II SIGN 签名 / DATE日期 09.08.01	REVIEWED BY 审核 Sun Gongchang LEVEL-II SIGN / DATE日期 09.08.01
质量经理 / QCM 签字 SIGN / 日期 DATE 09.08.01	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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 #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCS-000390
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 25-Dec-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0351

Type of problem:

Welding	☑	**Concrete**	☐	**Other**	☐	
Welding	☑	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:**
Procedural	☐	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 03-Aug-2009

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.

Contractor's proposal to correct the problem:
ZPMC is providing documentation to show the affected areas have been repaired, tested and found acceptable.

Corrective action taken:
The weld in question has been repaired with acceptable NDT result and documentation.

Did corrective action require Engineer's approval? ☐ **Yes** ☑ **No**
If so, name of Engineer providing approval: **Date:**
Is Engineer's approval attached? ☐ **Yes** ☑ **No**

Comments:
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By:	Simonis,Jim	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer