

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-000383

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 14-Aug-2009

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

NCR #: ZPMC-0357

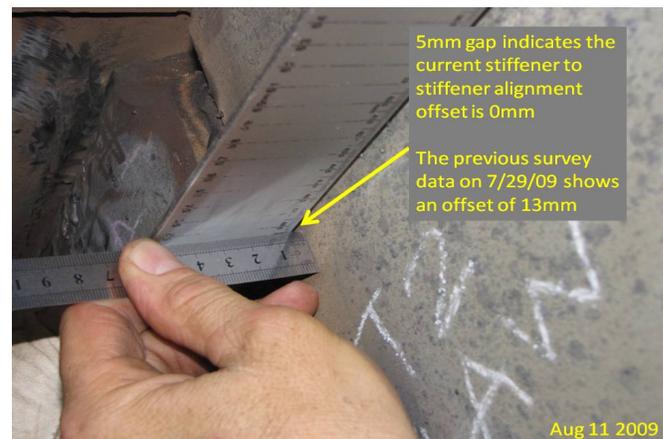
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 1AAW End Stiffeners to 1AW Open Rib Stiffeners
Procedural	Procedural	Description:	

Reference Description: Adjustment to Segment 1AAW/1AW stiffeners offset exceeding the allowable DCP tolerances

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed the joint survey on stiffeners offset measurement at OBG Segment 1AAW to 1AW. In comparing the offset survey data on July 29, 2009 provided by ABF to the joint survey data on August 11, 2009, it was found that the stiffeners with offset exceeding 3mm tolerance previously have now been corrected. Per the "approved as noted" Dimensional Control Plan (DCP) revision 8, it was found that a correction of each millimeter offset should require a stiffener unzip length of 150mm. According to the QA measurement of the total unzip length at 18 locations on the Segment 1AAW end stiffener and 1AW open rib stiffener, the adjustment made to these stiffeners have exceeded this DCP requirement of L/150. Following the notation used on the previous survey data, these 18 locations are labeled as T2, T3, T4, T5, T6, T15, T16, T17, T20, T28, T29, T30, T31, T32, T33, B5, B7, and B13.



Applicable reference:

-Dimensional Control Plan (Submittal 234 Rev.8) Section 3.5.2: Allowable local "bend" at splice shall be less than or equal to L/150.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

-Special Provisions Section 10-1.59/Shop Welding/Design Details (p.322): "Where a discontinuous member provides a continuous load path on either side of a through member, the method of marking and ensuring alignment shall be described in the dimensional control procedure. Misalignment between discontinuous members shall not exceed 10% of the thickness of the thinner member or 3mm, whichever is less.

Who discovered the problem: Bert Madison, Eric Tsang

Name of individual from Contractor notified: Gang Jiao

Time and method of notification: 1415 hours, verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1420 hours, verbal

QC Inspector's Name: Zhao Shuang Bao

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: 19-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: 05.03.06-000345

Subject: NCR No. ZPMC-0357

Reference Description: Adjustment to Segment IAAW/1AW stiffeners offset exceeding the allowable DCP tolerances

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:

Caltrans Quality Assurance (QA) Inspector observed the joint survey on stiffeners offset measurement at OBG Segment IAAW to 1AW. In comparing the offset survey data on July 29, 2009 provided by ABF to the joint survey data on August 11, 2009, it was found that the stiffeners with offset exceeding 3mm tolerance previously have now been corrected. Per the "approved as noted" Dimensional Control Plan (DCP) revision 8, it was found that a correction of each millimeter offset should require a stiffener unzip length of 150mm. According to the QA measurement of the total unzip length at 18 locations on the Segment IAAW end stiffener and 1AW open rib stiffener, the adjustment made to these stiffeners have exceeded this DCP requirement of L/150. Following the notation used on the previous survey data, these 18 locations are labeled as T2, T3, T4, T5, T6, T15, T16, T17, T20, T28, T29, T30, T31, T32, T33, B5, B7, and B13.

Action Required and/or Action Taken:

Submit repair plan to the engineer indicating methods used to comply with the approved DCP.

Transmitted by: Bill Howe

Attachments: ZPMC-0357

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: 05.03.06-000345

Subject: NCR No. ZPMC-0357

Dated: 27-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000351 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The tolerance of 1 in 150 that is not achievable is not a contract requirement. ZPMC has met the contract required 12 in 300 tolerance. ABF has submitted a letter addressing these facts to CT.

The tolerance of 1 in 150 that is not achievable is not a contract requirement. ZPMC has met the contract required 12 in 300 tolerance. ABF has submitted a letter addressing these facts to CT. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000351R00

Caltrans' comments:

Status: REJ

Date: 20-Sep-2009

The requirement is achievable as ZPMC is currently fixing the stiffeners per details provided by the response to RFI 1870R2 and the approved DCP tolerance. The contractor is requested to submit after-repair survey on the stiffeners in question for the Department's review and acceptance. Please refer to State letters no. 05.03.01-005228.

Submitted by: Chao, Ching

Date: 20-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000345

Subject: NCR No. ZPMC-0357

Dated: 30-Nov-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000351 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT documentation for the lateral brace welds which shows they are acceptable. ZPMC requests closure of this NCR.

ZPMC has completed the work related to ABF-RFI-001870R00, ABF-RFI-001870R01, ABF-RFI-001870R02. The work has been accepted by ABFJV, ZPMC and Caltrans and closed on the punchlist to document the acceptance. ZPMC is providing NDT documentation for the lateral brace welds which shows they are acceptable. Based on the acceptance of this item on the punchlist and the acceptable NDT results of the lateral brace welds, ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000351R01;

Caltrans' comments:

Status: CLO

Date: 03-Dec-2009

The documentation submitted has been reviewed by the Engineer and is found to be acceptable.

Submitted by: Chao, Ching

Date: 03-Dec-2009

Attachment(s):



No. B-501

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-11-25

REGARDING: NCR-000383 (ZPMC-0357)

With this letter of response, ZPMC requests closure for Caltrans NCR-000383 (ZPMC-0357). We agree what describe in the non-conformance report, and have submitted one RFI for the proper resolution, with the comments of RFI and survey record on site, we add up the lateral brace between the stiffeners which the straight joint are over the tolerance. And some areas are CJP weld for the influence with the 1AA longitudinal stiffener. Please review all of the attached documents to support the drawing change and the new repair.

By the way we have completed the weld of the lateral brace, and perform the UT inspection for the CJP weld with the steel back plate, the others all just perform the visual and MT inspection to confirm the surface without any defects.

We have to remind that the related items in the punchlist already be closed out and verified the final condition by the CT's inspector on site. We are providing all of the design change and final accepted NDT report to apply the closure.

so base on the above explanation, ZPMC applies to close the caltrans's report NCR-000383 (ZPMC-0357).

Please reference attached document for acceptance and closure the NCR-000383 (ZPMC-0357).

ATTACHMENT:

NCR-000383 (ZPMC-0357)

The RFI with the response

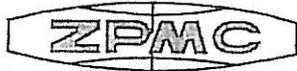
The UT and MT report

The survey record for the offset

ZPMC internal NCR

A handwritten signature in black ink, appearing to read "Chao Shuangbao", is written in a cursive style.

2009. 11. 25



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-243 (ZPMC-0357)
 NCR 编号: NCR-B-243 (ZPMC-0357)

Item: Adjustment to Segment
 1AAW/1AW stiffeners
 offset exceeding the
 allowable DCP
 tolerances
 名称描述:
 Item Number: 件号:
 OBG
 1AAW+1AW
 Drawing: 图号:
 OBG 1AAW+1AW

Location: OBG 1AAW+1AW
 位置:
 Date: 日期:
 2009-8-21

Description of Nonconformance:
 不符合项状态描述:
 Caltrans Quality Assurance (QA) Inspector observed the joint survey on stiffeners offset measurement at OBG Segment 1AAW to 1AW. In comparing the offset survey data on July 29, 2009 provided by ABF to the joint survey data on August 11, 2009, it was found that the stiffeners with offset exceeding 3mm tolerance previously have now been corrected. Per the "approved as noted" Dimensional Control Plan (DCP) revision 8, it was found that a correction of each millimeter offset should require a stiffener unzip length of 150mm. According to the QA measurement of the total unzip length at 18 locations on the Segment 1AAW end stiffener and 1AW open rib stiffener, the adjustment made to these stiffeners have exceeded this DCP requirement of L/150. Following the notation used on the previous survey data, these 18 locations are labeled as T2, T3, T4, T5, T6, T15, T16, T17, T20, T28, T29, T30, T31, T32, T33, B5, B7, and B13.

加洲检验员在测量 1AAW 和 1AW 的对筋后,比较 ABF 在 2009 年 7 月 29 日和 8 月 11 日的测量数据,发现有部分对筋错边超过 3 毫米的已经修正.但是根据已批准的尺寸控制计划第 8 版的要求,筋板直线度要满足 1:150 的要求.实际现场对筋后的测量数据中,有 18 个位置,直线度超过 L/150 的标准.这些位置标记为:T2, T3, T4, T5, T6, T15, T16, T17, T20, T28, T29, T30, T31, T32, T33, B5, B7, B13.

Work By: 施工方: Xiq Fa Ling
 Prepared by: Shen Ruijun 准备: 2009.8.21
 Reviewed by QCE: Lu Jianhua 质量工程师批准: 8/21/09
 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
 处理措施:

对该处加加强筋,减少变形及加强.该处加强的材料
 经做如下: 修改表格内容.

Recommendation: 建议:
 Jiu Yong Jian 9/20/09
 9.11.10

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

Reason for Nonconformance:

不符合原因:

由于IAAW与IAW的对筋位置, 有少部分钢筋错位已修正, 有部分钢筋
长度超标. After assembly IAAW and IAW, I rib misalignment
and part of linear ~~was~~ exceeded requirement.

Prevention of Re-occurrence:

预防措施:

加强监督和检查. Enhance supervision and inspection.

Approved by/批准: Gao Jun 09.8.22

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

见附件 RFI 1870R00~R02

Reviewed /批准:

Mom/2019.25/29

Verification:

Acceptable

Unacceptable

确认:

可接受

不可接受

Verified by QCI/质检确认: _____

Reviewed by QCA/质检主任审核: _____

REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001870R00 Submitted By: Jiao, Gang Pages: 5
 RFI Date: 25-August-2009 Contact Name: Jiao, Gang Pages Attached: 4
 Phone No. 86-136-4181-1974

Subject: <u>Segment 1AA to 1A Stiffener Plate Connection</u>	
References:	
Sub/Sup: <u>ABF</u>	Sub RFI #:
Response Required by: <u>01-September-2009</u>	Response affects critical path activity? <u>Yes</u>

Description:

Per discussion with Caltrans/TY Lin at Shanghai, ABF proposes to use the lateral bracing details shown below at Segment 1AA to Segment 1A stiffener connections to address any concerns about eccentric loading due to relatively large slope. The locations of the stiffeners requiring this lateral bracing are highlighted in the attached spreadsheet. Also attached are stiffeners offset surveys performed by ABF prior to any adjustment made. Please note the proposed lateral bracing will only be used for deck plate stiffeners. The offset of bottom or side plate stiffeners have been corrected by adjusting stiffeners at both Segment 1AA and 1A ends.

Please review and respond.

Contractor Disposition:

This RFI is being submitted for:
 The Cost and Time Impact from this RFI is: Not selected

Response: _____ Agreed Ext. Due Date: _____
 Pages: _____
 Pages Attached: _____

Administrative Action:

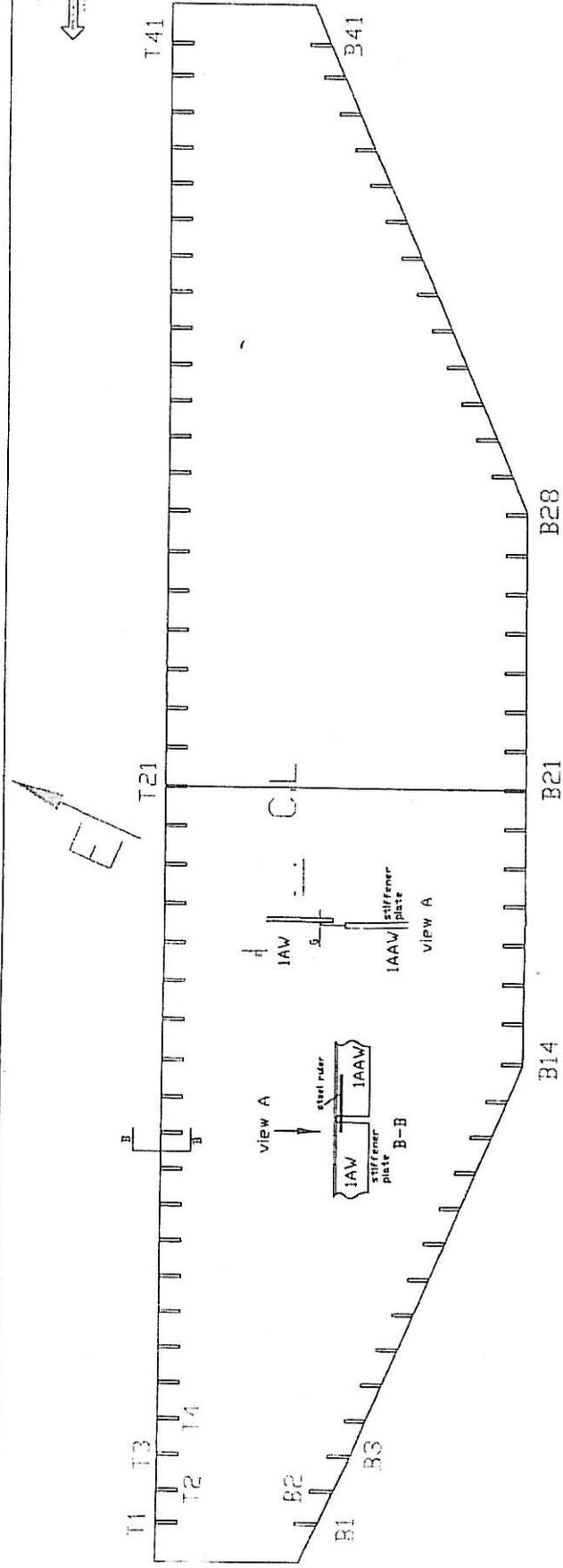
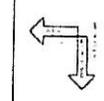
Date:	Respondent:	Phone No.:
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1AAW/1AW Plate Stiffener Alignment and Required Adjustment Length																					
Survey Point	T1	T2	T3	T4	T5	T6	T7	T8	T9	T10	T11	T12	T13	T14	T15	T16	T17	T18	T19	T20	T21
Offset	4	13	8	5	7	4	4	2	2	5	0	3	3	3	13	12	9	5	6	7	0
Adjust Length on 1AAW	150	600	600	300	600	150	150	0	0	300	0	0	0	600	600	600	600	300	450	600	0
Lateral Brace Required	N	Y	Y	N	N	N	N	N	N	N	N	N	N	N	Y	Y	Y	N	N	N	N
Survey Point	T22	T23	T24	T25	T26	T27	T28	T29	T30	T31	T32	T33	T34	T35	T36	T37	T38	T39	T40	T41	
Offset	5	5	6	4	-1	-4	4	8	8	7	8	7	3	-1	5	3	4	2	5	4	
Adjust Length on 1AAW	300	300	450	150	0	150	0	600	600	600	600	600	0	0	300	0	150	0	300	150	
Lateral Brace Required	N	N	N	N	N	N	Y	Y	Y	N	Y	N	N	N	N	N	N	N	N	N	N
1AAE/1AE Plate Stiffener Alignment and Required Adjustment Length																					
Survey Point	T1	T2	T3	T4	T5	T6	T7	T8	T9	T10	T11	T12	T13	T14	T15	T16	T17	T18	T19	T20	T21
Offset	-1	9	5	6	0	1	4	2	3	1	1	4	1	3	4	6	4	-1	6	4	3
Adjust Length on 1AAW	0	600	300	450	0	0	150	0	0	0	0	150	0	600	150	450	150	0	450	150	0
Lateral Brace Required	N	Y	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N	N
Survey Point	T22	T23	T24	T25	T26	T27	T28	T29	T30	T31	T32	T33	T34	T35	T36	T37	T38	T39	T40	T41	
Offset	1	-1	-1	0	1	-3	7	8	4	4	6	3	4	1	5	-3	-2	0	2	6	
Adjust Length on 1AAW	0	0	0	0	0	0	0	600	150	150	450	0	150	0	300	0	0	0	0	450	
Lateral Brace Required	N	N	N	N	N	N	N	Y	N	N	N	N	N	N	N	N	N	N	N	N	N

Note:

1. All measurements are between CL of 1AAW stiffener and 1AW stiffener.
2. Max cutback length of 1AA stiffener to skin plate weld is approximately 600mm, which can have 4mm adjustment per 1:150 slope.
3. T14 is designed as flush at the Counterweight side, thus the theoretical CL offset should be -5mm.
4. T28 is designed as flush at the Bikepath side, thus the theoretical CL offset should be 5mm.



survey point	T1	T2	T3	T4	T5	T6	T7	T8	T9	T10	T11	T12	T13	T14	T15	T16	T17	T18	T19	T20	T21
offset	-1	9	5	6	0	1	4	2	3	1	1	4	1	3	4	6	4	-1	6	4	3
survey point	T22	T23	T24	T25	T26	T27	T28	T29	T30	T31	T32	T33	T34	T35	T36	T37	T38	T39	T40	T41	N/A
offset	1	-1	-1	0	1	3	7	8	4	4	6	3	4	1	5	-3	-2	0	2	6	N/A
survey point	B1	B2	B3	B4	B5	B6	B7	B8	B9	B10	B11	B12	B13	B14	B15	B16	B17	B18	B19	B20	B21
offset	-5	1	3	2	4	5	4	-1	2	3	1	0	1	8	-5	-4	-5	-6	-3	-4	-6
survey point	B22	B23	B24	B25	B26	B27	B28	B29	B30	B31	B32	B33	B34	B35	B36	B37	B38	B39	B40	B41	N/A
offset	-8	-8	-7	-10	-12	-8	-12	-6	-3	-4	-4	-7	-6	-5	-5	0	0	-2	-1	1	N/A

TEMPERATURE DATA		DATE & TIME of SURVEY	
IDP = 25	14:00	Date:	2-Aug-2009
IAIR = 24	14:00	Start:	14:00
IBP = 25	14:00	End:	16:00
SHEET #: 1 OF 1			

NOTES:
1. Dimensional Tolerance: ± 4 mm

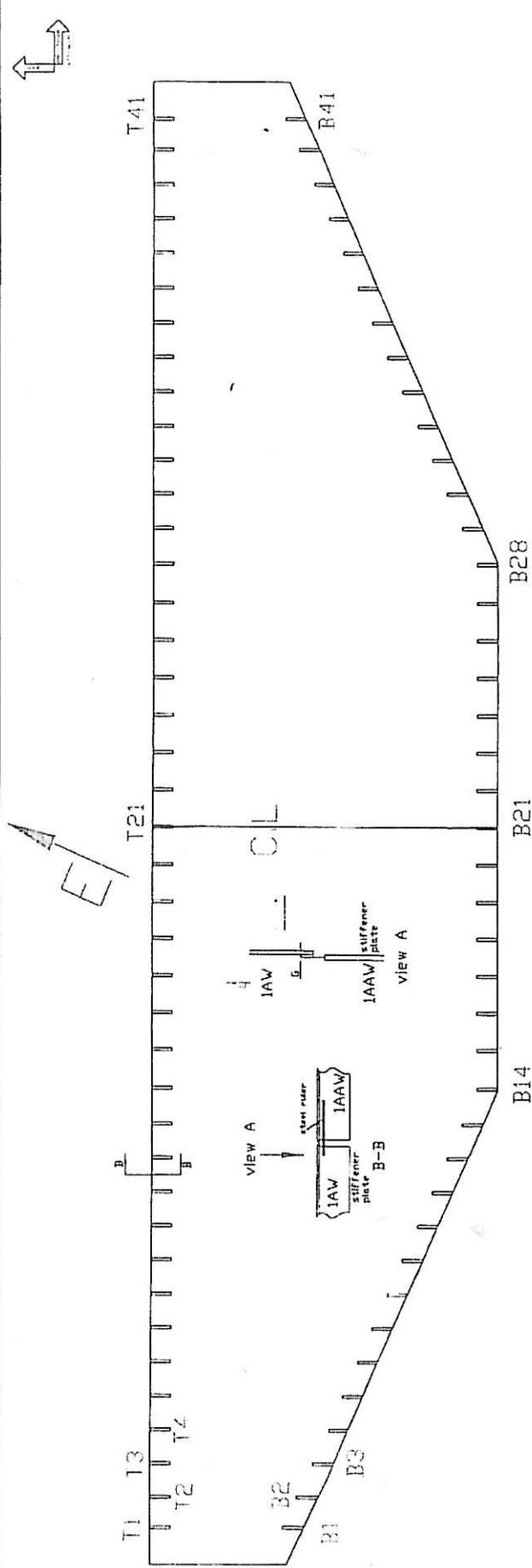
FLUOR

1AAE+1AE

Stiffener plate alignment
before lack welding survey

Drawn by:	Tom Lee	Date:	2-Aug-2009
Checked by:	Levi Lee	Date:	2-Aug-2009
Approved by:	Roger Northern	Date:	2-Aug-2009

DCP REFERENCE:
DC 108
REV. 0.7



survey point	T1	T2	T3	T4	T5	T6	T7	T8	T9	T10	T11	T12	T13	T14	T15	T16	T17	T18	T19	T20	T21
offset	4	13	8	5	7	4	4	2	2	5	0	3	3	3	13	12	9	5	6	7	0
survey point	T22	T23	T24	T25	T26	T27	T28	T29	T30	T31	T32	T33	T34	T35	T36	T37	T38	T39	T40	T41	N/A
offset	5	5	6	4	-1	-4	4	8	8	7	8	7	3	-1	5	3	4	2	5	4	N/A
survey point	B1	B2	B3	B4	B5	B6	B7	B8	B9	B10	B11	B12	B13	B14	B15	B16	B17	B18	B19	B20	B21
offset	3	1	-2	0	6	5	6	5	5	1	4	5	9	-4	0	3	4	5	4	0	0
survey point	B22	B23	B24	B25	B26	B27	B28	B29	B30	B31	B32	B33	B34	B35	B36	B37	B38	B39	B40	B41	N/A
offset	2	-1	3	1	-1	-2	0	3	4	3	2	4	7	4	2	3	6	3	8	6	N/A

TEMPERATURE DATA

IDP = 28, 7:00

LAIR = 26, 7:00

IBP = 25, 7:00

SHEET #: 1 OF 1

DATE & TIME OF SURVEY

Date: 29-July-2009

Start: 13:00

End: 15:20

NOTES:

1. Dimensional Tolerance: 5.4mm

1AAW+1AW

Stiffener plate alignment survey

Drawn by: Tom Lee

Checked by: Levi Lee

Approved by: Roger Northern

Date: 29-July-2009

Date: 29-July-2009

Date: 29-July-2009

DCP REFERENCE: DC 108

REV. 0.7

REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001870R00 Submitted By: Jiao, Gang Pages: 5
 RFI Date: 25-August-2009 Contact Name: Jiao, Gang Pages Attached: 4
 Phone No. 86-136-4181-1974

Subject: Segment 1AA to 1A Stiffener Plate Connection	
References:	
Sub/Sup: ABF	Sub RFI #:
Response Required by: 01-September-2009	Response affects critical path activity? Yes

Description:

Per discussion with Caltrans/TY Lin at Shanghai, ABF proposes to use the lateral bracing details shown below at Segment 1AA to Segment 1A stiffener connections to address any concerns about eccentric loading due to relatively large slope. The locations of the stiffeners requiring this lateral bracing are highlighted in the attached spreadsheet. Also attached are stiffeners offset surveys performed by ABF prior to any adjustment made. Please note the proposed lateral bracing will only be used for deck plate stiffeners. The offset of bottom or side plate stiffeners have been corrected by adjusting stiffeners at both Segment 1AA and 1A ends.

Please review and respond.

Contractor Disposition:

This RFI is being submitted for:

The Cost and Time Impact from this RFI is: Not selected

Response:

Agreed Ext. Due Date:

Pages: 1

Pages Attached: 0

The proposed lateral bracing details to address concerns about eccentric loading is acceptable. The details can only be used at deck plate stiffeners (end stiffeners) at the following locations (survey points):
 Stiffener connections at segments 1AAW and 1AW: T2, T3, T15, T16, T17, T29, T30, and T32
 Stiffener connections at segments 1AAE and 1AE: T2, T29

The material for brace plates shall meet the requirement for end stiffener plates.

Administrative Action:

This response resolves the RFI.

Date: <u>28-August-2009</u>	Respondent: <u>Ku, Stanley</u>	Phone No.:
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REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001870R01 Submitted By: Jiao, Gang Pages: 1
 RFI Date: 11-September-2009 Contact Name: Jiao, Gang Pages Attached: 0
 Phone No. 86-136-4181-1974

Subject: Segment 1AA to 1A Stiffener Plate Connection	
References:	
Sub/Sup: ABF	Sub RFI #:
Response Required by: 14-September-2009	Response affects critical path activity? Yes

Description:

EXPEDITED RESPONSE REQUESTED.

Based on a joint QA survey by CT and ABFJV, there are stiffeners not listed in ABF-RFI-001870R00 being found exceeding the 1:150 slope at 1AAW to 1AW splice. They are: T4, T5, T6, T20, T28, T31, T33, B5, B7, and B13, see NCR ZPMC-0357. ABFJV proposes to use the approved lateral bracing details to correct those stiffeners, as well as any additional stiffeners exceeding the 1:150 slope at 1AAE to 1AE splice identified by future QA survey.

Please review and respond.

Contractor Disposition:

This RFI is being submitted for:

The Cost and Time Impact from this RFI is: Not selected

Response: _____ Agreed Ext. Due Date: _____
 Pages: _____
 Pages Attached: _____

Administrative Action:

Date:	Respondent:	Phone No.:
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REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001870R01 Submitted By: Jiao, Gang Pages: 1
 RFI Date: 11-September-2009 Contact Name: Jiao, Gang Pages Attached: 0
 Phone No. 86-136-4181-1974

Subject: <u>Segment 1AA to 1A Stiffener Plate Connection</u>	
References:	
Sub/Sup: <u>ABF</u>	Sub RFI #:
Response Required by: <u>14-September-2009</u>	Response affects critical path activity? <u>Yes</u>

Description:

EXPEDITED RESPONSE REQUESTED.

Based on a joint QA survey by CT and ABFJV, there are stiffeners not listed in ABF-RFI-001870R00 being found exceeding the 1:150 slope at 1AAW to 1AW splice. They are: T4, T5, T6, T20, T28, T31, T33, B5, B7, and B13, see NCR ZPMC-0357. ABFJV proposes to use the approved lateral bracing details to correct those stiffeners, as well as any additional stiffeners exceeding the 1:150 slope at 1AAE to 1AE splice identified by future QA survey.

Please review and respond.

Contractor Disposition:

This RFI is being submitted for:

The Cost and Time Impact from this RFI is: Not selected

Response:

Agreed Ext. Due Date:

Pages: 1
Pages Attached: 0

The Contractor's proposal to correct the above referenced stiffeners using the previously approved (RFI 1870R0) lateral bracing details, is acceptable with the following additional requirements:

In the RFI-1870R0 bracing detail, the second PL 24x230 brace is illustrated to be 600mm away from the centerline of the segment. However, if the bend line is located at another distance away from the splice, the second PL24x230 shall be located at no more than 50mm from the bend lines on either side.

Before proceeding with this work, notify the Department.

Administrative Action:

Date: <u>11-September-200</u>	Respondent: <u>Granados, Roman</u>	Phone No.:
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REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001870R02 Submitted By: Jlao, Gang Pages: 1
 RFI Date: 14-September-2009 Contact Name: Jlao, Gang Pages Attached: 0
 Phone No. 86-136-4181-1974

Subject: Segment 1AA to 1A Stiffener Plate Connection	
References:	
Sub/Sup: ABF	Sub RFI #:
Response Required by: 15-September-2009	Response affects critical path activity? Yes

Description:

EXPEDITED RESPONSE REQUESTED.

Per the additional requirement in the response to ABF-RFI-001870R01, all bracing stiffeners will be located within 50mm of the kink point. Kink points are interpreted as the end of each "unzip length". Following this requirement, some bracing stiffeners will be put very close to the bearing plates in 1AAW. In that case, double sided fillet welds can not be performed. ABFJV proposes to use PJP with an effective weld size (E) of 18mm plus a 6mm reinforcement in lieu of two 14mm fillet welds per original design. Please confirm if this substitution is acceptable.

Based on a joint QA survey by CT and ABFJV on 09/12, 14 stiffeners on 1AAE/1AE were identified as requiring retrofit per details provided in ABF-RFI-001870R00, including stiffeners T2 and T29. When the survey results became available, ZPMC had fully welded bracing stiffener "A" for both T2 and T29 based on the original RFI layout (600mm from CL of splice). However, the joint survey shows the "unzip length" of T2 and T29 at 1AAE side is 450mm and 400mm, respectively. To avoid causing unnecessary damage to the base metal during weld removal, ABFJV proposes to leave those two stiffeners as they are. Please confirm if this is acceptable.

Please review and respond.

Contractor Disposition:

This RFI is being submitted for:
 The Cost and Time Impact from this RFI is: Not selected

Response: _____ Agreed Ext. Due Date: _____
 Pages: _____
 Pages Attached: _____

Administrative Action:

Date:	Respondent:	Phone No.:
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REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001870R02 Submitted By: Jiao, Gang Pages: 1
 RFI Date: 14-September-2009 Contact Name: Jiao, Gang Pages Attached: 0
 Phone No. 86-136-4181-1974

Subject: Segment 1AA to 1A Stiffener Plate Connection	
References:	
Sub/Sup: ABF	Sub RFI #:
Response Required by: 15-September-2009	Response affects critical path activity? Yes

Description:

EXPEDITED RESPONSE REQUESTED.

Per the additional requirement in the response to ABF-RFI-001870R01, all bracing stiffeners will be located within 50mm of the kink point. Kink points are interpreted as the end of each "unzip length". Following this requirement, some bracing stiffeners will be put very close to the bearing plates in 1AAW. In that case, double sided fillet welds can not be performed. ABFJV proposes to use PJP with an effective weld size (E) of 18mm plus a 6mm reinforcement in lieu of two 14mm fillet welds per original design. Please confirm if this substitution is acceptable.

Based on a joint QA survey by CT and ABFJV on 09/12, 14 stiffeners on 1AAE/1AE were identified as requiring retrofit per details provided in ABF-RFI-001870R00, including stiffeners T2 and T29. When the survey results became available, ZPMC had fully welded bracing stiffener "A" for both T2 and T29 based on the original RFI layout (600mm from CL of splice). However, the joint survey shows the "unzip length" of T2 and T29 at 1AAE side is 450mm and 400mm, respectively. To avoid causing unnecessary damage to the base metal during weld removal, ABFJV proposes to leave those two stiffeners as they are. Please confirm if this is acceptable.

Please review and respond.

Contractor Disposition:

This RFI is being submitted for:

The Cost and Time Impact from this RFI is: Not selected

Response:

Agreed Ext. Due Date:

Pages: **2**

Pages Attached: **0**

The proposal of a PJP with reinforcing fillet is not acceptable. In the cases where there is no access to perform the 14mm fillet welds, the Contractor can perform a CJP with backing to remain.

Kink points or bend lines do not necessarily occur at the end of the unzipped length in all cases. The kink points/bend lines in the stiffener need to be identified prior to locating the second brace. Identifying the bend location can be done with a straight edge or similar method.

Should the bend line not be vertical across the stiffener, place the brace vertically at the center of the bend line, and trim to fit to the bent stiffener for the full depth of the brace plate and weld.

For T2 and T29, determine the location of the actual bend line for the braces placed 600mm away. If that brace is more than 50mm from the bend line, remove and reweld the brace at the correct location.

✓

REQUEST FOR INFORMATION (RFI)

Notify the Department prior to performing any of this work.

Administrative Action:

This response resolves this RFI.

Date: 15-September-200	Respondent: Granados, Roman	Phone No.:
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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-9759 DATE 2009.11.19 PAGE 2 OF 3 Revision No: 0

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		
OBW1-097		70				33								ACC.	100%
OBW1-049		70				33								ACC.	100%
OBW1-051		70				33								ACC.	100%
OBW1-053		70				33								ACC.	100%
OBW1-159		70				33								ACC.	100%
OBW1-171		70				33								ACC.	100%
OBW1-173		70				33								ACC.	100%
OBW1-063		70				33								ACC.	100%
OBW1-061		70				33								ACC.	100%
OBW1-059		70				33								ACC.	100%
OBW1-057		70				33								ACC.	100%
OBW1-055		70				33								ACC.	100%
OBW1-243		70				33								ACC.	100%
OBW1-115		70				33								ACC.	100%
OBW1-111		70				33								ACC.	100%
OBW1-107		70				33								ACC.	100%
OBW1-103		70				33								ACC.	100%
OBW1-099		70				33								ACC.	100%
OBW1-257		70				33								ACC.	100%
OBW1-117		70				33								ACC.	100%
OBW1-113		70				33								ACC.	100%
OBW1-109		70				33								ACC.	100%

EXAMINED BY主探
Wang Tim 09.11.19
 LEVEL - II SIGN / DATE

REVIEWED BY审核
Xue Hanyang 09.11.19
 LEVEL - II SIGN / DATE

质量经理 / QCM

 签字 SIGN / 日期 DATE

用户CUSTOMER

 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-15931 DATE日期 2009.11.20 PAGE OF页码 1/7 Revision No: 0

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

DRAWING NO. 图号: OBW1 CALTRANS CONTRACT NO.: 04-0120F4
 OBG 1AW I-RIB EDGE PLATE 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 Material & thickness 母材,厚度: A709M-345
 CASTING 铸件 22/35/20/28/24mm
 FORGING 锻造

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: CORNER-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			
OBW1-267				ACC.		100%MT
OBW1-268				ACC.		100%MT
OBW1-263				ACC.		100%MT
OBW1-264				ACC.		100%MT
OBW1-037				ACC.		100%MT
OBW1-038				ACC.		100%MT
OBW1-041				ACC.		100%MT
OBW1-042				ACC.		100%MT
OBW1-045				ACC.		100%MT
OBW1-046				ACC.		100%MT
OBW1-181				ACC.		100%MT
OBW1-182				ACC.		100%MT
OBW1-185				ACC.		100%MT
OBW1-186				ACC.		100%MT
OBW1-189				ACC.		100%MT
OBW1-190				ACC.		100%MT

EXAMINED BY主探: Zhao Chenggong
 LEVEL - II SIGN 签名 / DATE日期: Zhao Chenggong 09.11.20
 质量经理 / QCM

REVIEWED BY 审核: Su Wei
 LEVEL-II SIGN / DATE日期: Su Wei 09.11.20
 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-15931 DATE日期 2009.11.20 PAGE OF 页码 3/7 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: OBW1 OBG 1AW I-RIB EDGE PLATE		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 22/35/20/28/24mm
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	CORNER-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			
OBW1-019				ACC.		100%MT
OBW1-020				ACC.		100%MT
OBW1-021				ACC.		100%MT
OBW1-022				ACC.		100%MT
OBW1-157				ACC.		100%MT
OBW1-158				ACC.		100%MT
OBW1-161				ACC.		100%MT
OBW1-162				ACC.		100%MT
OBW1-165				ACC.		100%MT
OBW1-166				ACC.		100%MT
OBW1-219				ACC.		100%MT
OBW1-220				ACC.		100%MT
OBW1-207				ACC.		100%MT
OBW1-208				ACC.		100%MT
OBW1-221				ACC.		100%MT
OBW1-222				ACC.		100%MT

EXAMINED BY 主探 Zhao Chenggong LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM 09.11.20	REVIEWED BY 审核 Su Wei LEVEL-II SIGN / DATE 日期 用户 CUSTOMER 09.11.20
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-15931 DATE日期 2009.11.20 PAGE OF页码 4/7 Revision No: 0

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

DRAWING NO. 图号: OBW1 CALTRANS CONTRACT NO.: 04-0120F4
 OBG 1AW I-RIB EDGE PLATE 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 Material & thickness 母材, 厚度: A709M-345
 CASTING 铸件 22/35/20/28/24mm
 FORGING 锻造

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: CORNER-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			
OBW1-209				ACC.		100%MT
OBW1-210				ACC.		100%MT
OBW1-215				ACC.		100%MT
OBW1-216				ACC.		100%MT
OBW1-217				ACC.		100%MT
OBW1-218				ACC.		100%MT
OBW1-235				ACC.		100%MT
OBW1-236				ACC.		100%MT
OBW1-241				ACC.		100%MT
OBW1-242				ACC.		100%MT
OBW1-251				ACC.		100%MT
OBW1-252				ACC.		100%MT
OBW1-081				ACC.		100%MT
OBW1-082				ACC.		100%MT
OBW1-153				ACC.		100%MT
OBW1-154				ACC.		100%MT

EXAMINED BY 主探: Zhao Chenggong
 LEVEL - II SIGN 签名 / DATE日期: 09.11.20
 质量经理 / QCM

REVIEWED BY 审核: Su Wei
 LEVEL-II SIGN / DATE日期: 09.11.20
 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-15931 DATE日期 2009.11.20 PAGE OF 页码 5/7 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: OBW1 OBG 1AW I-RIB EDGE PLATE		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 22/35/20/28/24mm
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	CORNER-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			
OBW1-079				ACC.		100%MT
OBW1-080				ACC.		100%MT
OBW1-149				ACC.		100%MT
OBW1-150				ACC.		100%MT
OBW1-077				ACC.		100%MT
OBW1-078				ACC.		100%MT
OBW1-145				ACC.		100%MT
OBW1-146				ACC.		100%MT
OBW1-075				ACC.		100%MT
OBW1-076				ACC.		100%MT
OBW1-141				ACC.		100%MT
OBW1-142				ACC.		100%MT
OBW1-073				ACC.		100%MT
OBW1-074				ACC.		100%MT
OBW1-137				ACC.		100%MT
OBW1-138				ACC.		100%MT

EXAMINED BY 主操 Zhao Chenggong LEVEL-II SIGN 签名 / DATE日期 09.11.20 质量经理 / QCM	REVIEWED BY 审核 Su Wei LEVEL-II SIGN / DATE日期 09.11.20 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-15931 DATE日期 2009.11.20 PAGE OF页码 6/7 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: OBW1 OBG 1AW I-RIB EDGE PLATE		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 22/35/20/28/24mm
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	CORNER-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			
OBW1-245				ACC.		100%MT
OBW1-246				ACC.		100%MT
OBW1-259				ACC.		100%MT
OBW1-260				ACC.		100%MT
OBW1-253				ACC.		100%MT
OBW1-254				ACC.		100%MT
OBW1-151				ACC.		100%MT
OBW1-152				ACC.		100%MT
OBW1-147				ACC.		100%MT
OBW1-148				ACC.		100%MT
OBW1-143				ACC.		100%MT
OBW1-144				ACC.		100%MT
OBW1-139				ACC.		100%MT
OBW1-140				ACC.		100%MT
OBW1-135				ACC.		100%MT
OBW1-136				ACC.		100%MT

EXAMINED BY主探 Zhao Chenggong <i>Zhao Chenggong</i>	REVIEWED BY 审核 <i>Su Wei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>09.11.20</i>	LEVEL-II SIGN / DATE日期 <i>09.11.20</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-15942 DATE日期 2009.11.20 PAGE OF页码 1/5 Revision No: 0

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

DRAWING NO. 图号: OBW1 CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4
 OBG 1AAW I-RIB EDGE PLATE

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. 28th, 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-345
 CASTING 铸件 28/24/45mm
 FORGING 锻造

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: CORNER-JOINT

DISCONTINUITY 不连续性

WELD I.D. 焊缝编号	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度	ACCEPT 接受	REJECT 拒收	REMARKS 备注
OBW1-025				ACC.		100%MT
OBW1-087				ACC.		100%MT
OBW1-029				ACC.		100%MT
OBW1-030				ACC.		100%MT
OBW1-033				ACC.		100%MT
OBW1-034				ACC.		100%MT
OBW1-169				ACC.		100%MT
OBW1-170				ACC.		100%MT
OBW1-173				ACC.		100%MT
OBW1-177				ACC.		100%MT
OBW1-178				ACC.		100%MT
OBW1-023				ACC.		100%MT
OBW1-091				ACC.		100%MT
OBW1-027				ACC.		100%MT
OBW1-028				ACC.		100%MT
OBW1-031				ACC.		100%MT

EXAMINED BY 主探: Zhao Chenggong LEVEL - II SIGN 签名 / DATE 日期: 09.11.20
 质量经理 / QCM

REVIEWED BY 审核: Su Wei LEVEL-II SIGN / DATE 日期: 09.11.20
 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-15942 DATE日期 2009.11.20 PAGE OF页码 3/5 Revision No: 0

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

DRAWING NO. 图号: OBW1 CALTRANS CONTRACT NO.: 04-0120F4
 OBG 1AAW I-RIB EDGE PLATE 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 Material & thickness 母材, 厚度: A709M-345
 CASTING 铸件 28/24/45mm
 FORGING 锻造

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: CORNER-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			
OBW1-164				ACC.		100%MT
OBW1-211				ACC.		100%MT
OBW1-212				ACC.		100%MT
OBW1-203				ACC.		100%MT
OBW1-204				ACC.		100%MT
OBW1-213				ACC.		100%MT
OBW1-214				ACC.		100%MT
OBW1-205				ACC.		100%MT
OBW1-206				ACC.		100%MT
OBW1-215				ACC.		100%MT
OBW1-216				ACC.		100%MT
OBW1-217				ACC.		100%MT
OBW1-218				ACC.		100%MT
OBW1-089				ACC.		100%MT
OBW1-093				ACC.		100%MT
OBW1-097				ACC.		100%MT

EXAMINED BY 主探: Zhao Chenggong
 LEVEL - II SIGN 签名 / DATE 日期: 09.11.20
 质量经理 / QCM

REVIEWED BY 审核: Su Wei
 LEVEL-II SIGN / DATE 日期: 09.11.20
 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-15942 DATE日期 2009.11.20 PAGE OF 页码 4/5 Revision No: 0

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

DRAWING NO. 图号: OBW1 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
 OBG 1AAW I-RIB EDGE PLATE

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 28/24/45mm

WELDING PROCESS 焊接方法 FCAW TYPE OF JOINT 焊缝类型 CORNER-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			
OBW1-197				ACC.		100%MT
OBW1-198				ACC.		100%MT
OBW1-195				ACC.		100%MT
OBW1-196				ACC.		100%MT
OBW1-049				ACC.		100%MT
OBW1-051				ACC.		100%MT
OBW1-053				ACC.		100%MT
OBW1-191				ACC.		100%MT
OBW1-192				ACC.		100%MT
OBW1-063				ACC.		100%MT
OBW1-061				ACC.		100%MT
OBW1-059				ACC.		100%MT
OBW1-057				ACC.		100%MT
OBW1-055				ACC.		100%MT
OBW1-243				ACC.		100%MT
OBW1-115				ACC.		100%MT

EXAMINED BY 主探 Zhao Chenggong
 LEVEL - II SIGN 签名 / DATE 日期 09.11.20
 质量经理 / QCM

REVIEWED BY 审核 Su Wei
 LEVEL-II SIGN / DATE 日期 09.11.20
 用户 CUSTOMER

签字 SIGN / 日期 DATE
 (FORM# ZPQC-MT01)

签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B767-MT-15942 DATE日期 2009.11.20 PAGE OF页码 5/5 Revision No: 0

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

DRAWING NO. 图号: OBW1 CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4
 OBG 1AAW I-RIB EDGE PLATE

REFERENCING CODE 参考规范编码: AWS D1.5-2002 ACCEPTANCE STANDARD 接受标准: AWS D1.5-2002 PROCEDURE NO. 程序编号: ZPQC-MT-01 CALIBRATION DUE DATE 仪器校正有效期: Dec. 28ST, 2009

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

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

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

MATERIAL TO BE EXAMINED 检测材料: WELDING 焊接件 Material & thickness 母材,厚度: A709M-345
 CASTING 铸件 28/24/45mm
 FORGING 锻造

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: CORNER-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			
OBW1-111				ACC.		100%MT
OBW1-107				ACC.		100%MT
OBW1-103				ACC.		100%MT
OBW1-099				ACC.		100%MT
OBW1-257				ACC.		100%MT
OBW1-117				ACC.		100%MT
OBW1-113				ACC.		100%MT
OBW1-109				ACC.		100%MT
OBW1-105				ACC.		100%MT
OBW1-101				ACC.		100%MT
OBW1-255				ACC.		100%MT
BLANK						

EXAMINED BY主探: Zhao Chenggong
 LEVEL - II SIGN 签名 / DATE日期: 09/11/20
 质量经理 / QCM

REVIEWED BY审核: Su Wei
 LEVEL-II SIGN / DATE日期: 09/11/20
 用户CUSTOMER

签字 SIGN / 日期 DATE
 (FORM# ZPQC-MT01)

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-000430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0357**Type of problem:**

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

Date the Non-Conformance Report was written: 14-Aug-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed the joint survey on stiffeners offset measurement at OBG Segment 1AAW to 1AW. In comparing the offset survey data on July 29, 2009 provided by ABF to the joint survey data on August 11, 2009, it was found that the stiffeners with offset exceeding 3mm tolerance previously have now been corrected. Per the "approved as noted" Dimensional Control Plan (DCP) revision 8, it was found that a correction of each millimeter offset should require a stiffener unzip length of 150mm. According to the QA measurement of the total unzip length at 18 locations on the Segment 1AAW end stiffener and 1AW open rib stiffener, the adjustment made to these stiffeners have exceeded this DCP requirement of L/150. Following the notation used on the previous survey data, these 18 locations are labeled as T2, T3, T4, T5, T6, T15, T16, T17, T20, T28, T29, T30, T31, T32, T33, B5, B7, and B13.

Contractor's proposal to correct the problem:

Add additional bracing to stiffeners.

Corrective action taken:

Additional stiffeners were added in conformance with RFI 1870. Contractor performed the required NDT and submitted documentation verifying the welds made are in conformance with the Contract specifications.

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Reviewed By: Wahbeh,Mazen

QA Reviewer