

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-000388**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0362**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Crossbeam 7 and 10
Procedural	Procedural	Description:	

Reference Description: Fabrication not according to the Joint detail**Description of Non-Conformance:**

Caltrans Quality Assurance Inspector observed ZPMC welded the joints for intermediate diaphragm to rib stiffeners in Crossbeam 7 and 10 with a deviated joint design detail. According to the approved drawing, the welds are detailed as 8mm fillet welds. Currently the weld joints listed below have been turned into CJP welds and thus not conforming to the approved shop drawings. The detail change was performed without prior Engineer's approval. These were new welds and were deposited after the fit-up of them member, with root gap exceeding 5mm.

CB202G-025-043~062, 001~004, 111~114, 039, 040, 087, 088.

CB202G-026-047~054, 001, 004, 031, 032, 039, 040, 026, 025, 061, 062, 043, 044.

CB202G-027-039~044, 051~062, 001~004.

CB202G-028-021~024, 017, 018, 051, 052, 043, 044, 007, 008, 053, 054, 057, 058, 059, 060, 001~004

CB201G-013-049,

CB201G-014-043, 061, 067, 089, 099, 119, 167, 131

CB201G-015-043, 063, 065, 067, 097, 101, 131

CB201G-016-043, 017, 067, 069, 101, 103, 097

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

AWS D1.5 -3.7.4 Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies

Approved Drawing:-CB201G, CB202G

Who discovered the problem: Hiranch Patel

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Name of individual from Contractor notified: Wang Wen Bin, Guo Yuan Ting

Time and method of notification: 100 hours, verbal

Name of Caltrans Engineer notified: Ching Chao, Ching Chao

Time and method of notification: 1800 hours, Email

QC Inspector's Name: Li Xiu Hua, Zhang Yaxu

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: 31-Aug-2009

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0362

Job Name: SAS Superstructure
Document No: 05.03.06-000351

Reference Description: Fabrication not according to the Joint detail

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:** 07

Remarks:

Caltrans Quality Assurance Inspector observed ZPMC welded the joints for intermediate diaphragm to rib stiffeners in Crossbeam 7 and 10 with a deviated joint design detail. According to the approved drawing, the welds are detailed as 8mm fillet welds. Currently the weld joints listed below have been turned into CJP welds and thus not conforming to the approved shop drawings. The detail change was performed without prior Engineer's approval. These were new welds and were deposited after the fit-up of them member, with root gap exceeding 5mm.

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- CB202G-028-021~024, 017, 018, 051, 052, 043, 044, 007, 008, 053, 054, 057, 058, 059, 060, 001~004
- CB201G-013-049,
- CB201G-014-043, 061, 067, 089, 099, 119, 167, 131
- CB201G-015-043, 063, 065, 067, 097, 101, 131
- CB201G-016-043, 017, 067, 069, 101, 103, 097

Action Required and/or Action Taken:

Submit the CJP detail for approval of the engineer.

Transmitted by: Bill Howe

Attachments: ZPMC-0362

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: 05.03.06-000351

Subject: NCR No. ZPMC-0362

Dated: 21-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000358 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has again notified the ZPMC QA supervision that these types of repairs require engineer notification prior to performing such repairs.

ZPMC did not notify the engineer prior to performing these repairs. ABF has again notified the ZPMC QA supervision that these types of repairs require engineer notification prior to performing such repairs. ZPMC documented these repairs on a Welding Repair Report and inspection reports and will submit this documentation at a later date for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000358R00

Caltrans' comments:

Status: AAP

Date: 22-Sep-2009

Will review and confirm the acceptance when the repair documentation is submitted.

Submitted by: Chao, Ching

Date: 22-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000351

Subject: NCR No. ZPMC-0362

Dated: 29-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000358 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has now included the necessary documentation to provide objective evidence repair work has been completed. ZPMC requests closure of this NCR.

ZPMC has now included the necessary documentation to provide objective evidence repair work has been completed. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000358R01;

Caltrans' comments:

Status: CLO

Date: 08-Oct-2009

Per METS review comments, the contractor has submitted necessary documentation as required to indicate that the weld repair has been completed and the necessary NDT have been performed.

Submitted by: Chao, Ching

Date: 08-Oct-2009

Attachment(s):



No. B-477

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-9-29

REGARDING: NCR-000388 (ZPMC-0362)

With this letter of response, ZPMC requests closure for Caltrans NCR-000388 (ZPMC-0362). We have received the formal letter from ABF and we will notify the engineer for each case that change the fillet weld to the CJP which the gap is more than the tolerance, and this time we will wait for the approval comments from the caltrans' engineer prior the repair performance. But the case which describe in the non-conformance report have been done as the require of the before RFI, we have done the MT inspection to confirm there is no any defect after the back gouging, right now we providing the MT report to support the good quality and prove all of the weld have been changed to CJP weld.

Please reference attached documentation for acceptance and closure the NCR-000388 (ZPMC-0362) .

ATTACHMENT:

ZPMC internal NCR

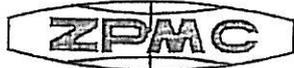
NCR-000388 (ZPMC-0362)

The RFI with the response

The MT reports after the back gouging

Zhao Shuangbo

2009.9.29



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-254 (ZPMC-0362)

Item: Fabrication not according to the Joint detail
 名称描述: 未经工程师批准, 将角焊缝改成 CJP 焊缝

Item Number:
 件号: OBG CB7, CB10

Drawing:
 图号: CB7, CB10

Location: CB7, CB10
 位置:

Date:
 日期: 2009-9-10

Description of Nonconformance:

不符合项状态描述:

Caltrans Quality Assurance Inspector observed ZPMC welded the joints for intermediate diaphragm to rib stiffeners in Crossbeam 7 and 10 with a deviated joint design detail. According to the approved drawing, the welds are detailed as 8mm fillet welds. Currently the weld joints listed below have been turned into CJP welds and thus not conforming to the approved shop drawings. The detail change was performed without prior Engineer's approval. These were new welds and were deposited after the fit-up of them member, with root gap exceeding 5mm.

加州检验员在 CB7 和 CB10 上的中间隔板与 I 肋的焊缝位置, 发现 ZPMC 没有按照批准的图纸进行操作。这些焊缝按照图纸应该是 8 毫米焊角, 但是由于现场装配时, 装配间隙超过 5 毫米, 所以 ZPMC 将此烧成 CJP, 但是改烧 CJP 前, 此更改后的坡口形式没有经过工程师批准。

牵涉到的角焊缝改成 CJP 焊缝的焊缝编号如下:

- CB202G-025-043-062,001-004,111-114,039,040,087,088
- CB202G-026-047-054,001,004,031,032,039,040,026,025,061,062,043,044
- CB202G-027-039-044,051-062,001-004
- CB202G-028-021-024,017,018,051,052,043,044,007,008,053,054,057,058,059,060,001-004
- CB201G-013-049
- CB201G-014-043,061,067,089,099,119,167,131
- CB201G-015-043,063,065,067,097,101,131
- CB201G-016-043,017,067,069,101,103,097

Work By: *Livingston Jimuel* Prepared by: *Shentun* Reviewed by QCE: *Zhu Shuangbao*
 施工方: *Livingston Jimuel* 准备: *2009.9.10* 质量工程师批准: *2009.9.10*

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

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

一面加钢衬垫焊后做 MT, 完工后两面 MT
② perform MT after weld with steel backing at both side.

Recommendation:

建议:

反面石炭刨清根后MT.
Perform MT after back-gauging.

Prepared by: Hu Yuzhang
准备

Approved by QCA: _____
质量经理批准

Reason for Nonconformance:

不符合原因:

① 由于壳体焊接后收缩引起, 导致焊缝过大, ①. Weld contraction caused gap exceeded requirement.
② 根据检查报告要求, 贴钢衬板进行焊接, ②. Weld with steel backing according to inspection report requirement.
③ 焊接前已开焊缝关键返修报告, 加刺已批准

Prevention of Re-occurrence:

预防措施:

一再加钢衬板焊后刨根并MT, 完工后再面MT.

3) Issue CUR report and approved by engineer

Perform MT after weld with steel backing at both side, before weld.

Approved by/批准: Hu Yuzhang

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

按照附件RFI进行处理,
Deal with the problem per attached RFI.

Reviewed /批准: Momli 2/29/07

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: _____

Bill Howe

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: 31-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: 05.03.06-000351

Subject: NCR No. ZPMC-0362

Reference Description: Fabrication not according to the Joint detail

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: 07

Remarks:

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- CB201G-016-043, 017, 067, 069, 101, 103, 097

Action Required and/or Action Taken:

Submit the CJP detail for approval of the engineer.

Transmitted by: Bill Howe

Attachments: ZPMC-0362

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

File: 05.03.06

05.03.06

05.03.06-000351.NCT

Received
05.03.09

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

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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000388

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 21-Aug-2009

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

NCR #: ZPMC-0362

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: Crossbeam 7 and 10

Procedural Procedural Description:

Reference Description: Fabrication not according to the Joint detail

Description of Non-Conformance:

Caltrans Quality Assurance Inspector observed ZPMC welded the joints for intermediate diaphragm to rib stiffeners in Crossbeam 7 and 10 with a deviated joint design detail. According to the approved drawing, the welds are detailed as 8mm fillet welds. Currently the weld joints listed below have been turned into CJP welds and thus not conforming to the approved shop drawings. The detail change was performed without prior Engineer's approval. These were new welds and were deposited after the fit-up of them member, with root gap exceeding 5mm.

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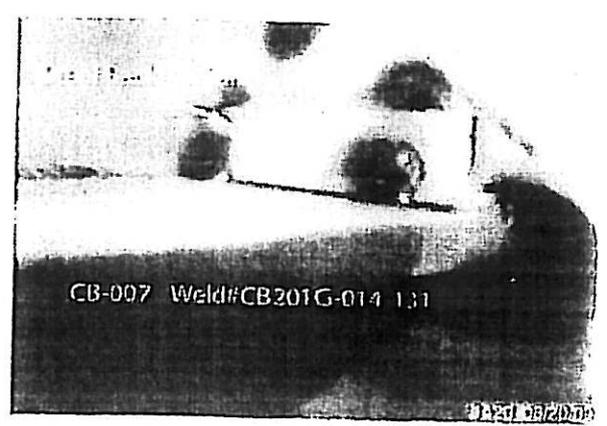
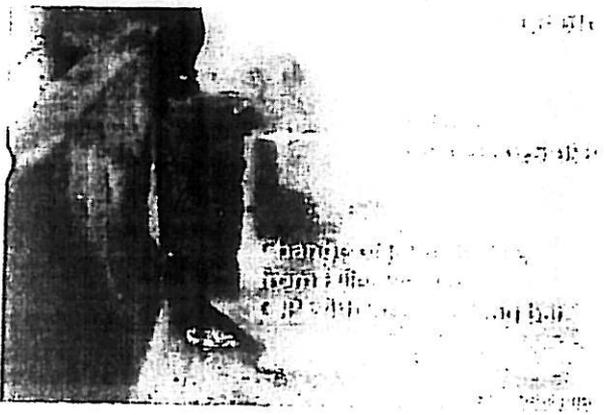
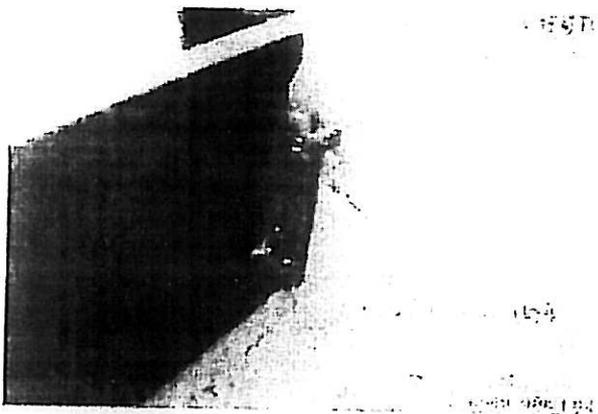
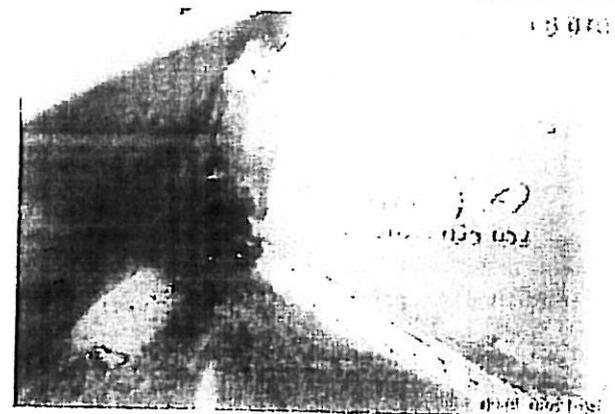
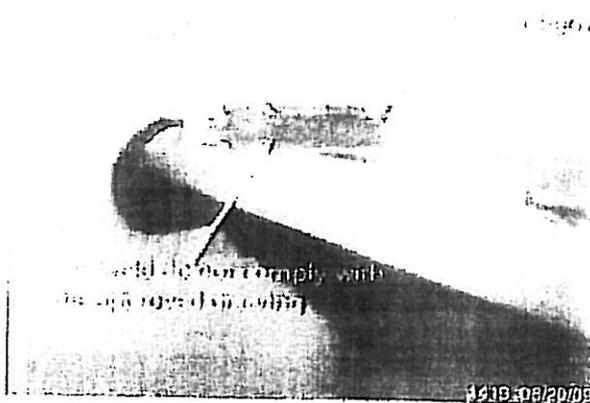
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT
 (Continued Page 2 of 3)



Applicable reference:

AWS D1.5 -3.7.4 Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies

Approved Drawing:-CB201G, CB202G

Who discovered the problem: Hiranch Patel

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Name of individual from Contractor notified: Wang Wen Bin, Guo Yuan Ting

Time and method of notification: 100 hours, verbal

Name of Caltrans Engineer notified: Ching Chao, Ching Chao

Time and method of notification: 1800 hours, Email

QC Inspector's Name: Li Xiu Hua, Zhang Yaxu

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

Reviewed By: Wahbeh, Mazen

SMR

REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001709R00 Submitted By: Raynor, Dan Pages: 2
 RFI Date: 01-April-2009 Contact Name: Weidong, Sun Pages Attached: 1
 Phone No. 86-21-51907428

Subject: Propose to Use MT to Inspect the CJP instead of Fillet Weld due to Over-tolerance Gap	
References:	
Sub/Sup: ZPM	Sub RFI #: RFI-ZPM-000635R00
Response Required by: 08-April-2009	Response affects critical path activity? Yes

Description:

Reference attached RFI-ZPM-000635R00:

When the gap between fillet weld seams exceeds 5mm, CJP is adopted instead of fillet weld and UT is performed per CJP weld requirement/rate.

For each weld that exceeds a 5mm root gap, ZPMC proposes to use MT lieu of UT to inspect this CJP weld. MT will be performed after backgouging has been completed and ground to bright metal. MT will be also performed on the final weld for each weld that was in excess of 5mm gap.

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:

The proposed use of a CJP weld with MT inspection, instead of a fillet weld, where weld seams exceed 5mm, is an acceptable repair procedure for Non-SPCM material. The groove preparation for the CJP weld must conform to an approved WPS.

For welds to SPCM material, the proposed CJP weld is only acceptable provided that it is tested per the requirements for inspection of CJP welds in that component type, as given in Section 10-1.59 "Steel Structures," Subsection "Inspection and Testing" of the Special Provisions.

Administrative Action:

This response resolves the RFI.

Date: 08-April-2009	Respondent: Brignano, Bob	Phone No.:
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REQUEST FOR INFORMATION (RFI)

RFI No.: ABF-RFI-001709R00 Submitted By: Raynor, Dan Pages: 2
 RFI Date: 01-April-2009 Contact Name: Weidong, Sun Pages Attached: 1
 Phone No. 86-21-51907428

Subject: Propose to Use MT to Inspect the CJP instead of Fillet Weld due to Over-tolerance Gap	
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Sub/Sup: ZPM	Sub RFI #: RFI-ZPM-000635R00
Response Required by: 08-April-2009	Response affects critical path activity? Yes

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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:

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Administrative Action:

This response resolves the RFI.

Date: 08-April-2009	Respondent: Brignano, Bob	Phone No.:
----------------------------	----------------------------------	-------------------





REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-13535		DATE 日期 2009.09.05		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: CB10 OBG CROSS BEAM			CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4						
REFERENCING CODE 参考规范编码 AWS D1.5-2002		ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002		PROCEDURE NO. 程序编号 ZPQC-MT-01		CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 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-345T2-X 14/20/22 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						
CB202G-026-054				ACC		after gouging			
CB202G-025-044				ACC		after gouging			
CB202G-025-046				ACC		after gouging			
CB202G-025-048				ACC		after gouging			
CB202G-025-050				ACC		after gouging			
CB202G-025-052				ACC		after gouging			
CB202G-025-054				ACC		after gouging			
CB202G-025-056				ACC		after gouging			
CB202G-025-058				ACC		after gouging			
CB202G-025-062				ACC		after gouging			
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EXAMINED BY 主探 Jin Jianting <i>jianting</i>				REVIEWED BY 审核 <i>axlx</i>					
LEVEL - II SIGN 签名 / DATE 日期 <i>09.29.05</i>				LEVEL-II SIGN / DATE 日期 <i>09.29.05</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-12519 DATE日期 2009.07.24 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: CB201G OBG CROSS BEAM		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4	
REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 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-345T2-X 14/12 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			
CB201G-013-049				ACC.		AFTER GOUGING
CB201G-014-043				ACC.		AFTER GOUGING
CB201G-014-061				ACC.		AFTER GOUGING
CB201G-015-043				ACC.		AFTER GOUGING
CB201G-016-043				ACC.		AFTER GOUGING

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EXAMINED BY主探 Tan chao wei <i>Tan chao wei</i>	REVIEWED BY 审核 <i>Sunfang Chang</i>
LEVEL - II SIGN 签名 / DATE日期 <i>09-27-09</i>	LEVEL-II SIGN / DATE日期 <i>09-27-09</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-13279 DATE日期 2009.08.25 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. CB201G CALTRANS CONTRACT NO.:
 图号: OBG CROSS BEAM 加州工程编号 04-0120F4

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

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

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

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

MATERIAL TO BE EXAMINED √ WELDING 焊接件 Material & thickness A709M-345F2-X
 检测材料 CASTING 铸件 母材, 厚度 12/14/22mm
 FORGING 锻造

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

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			
CB201G-014-067				ACC.		After Gouging
CB201G-015-063				ACC.		After Gouging
CB201G-015-065				ACC.		After Gouging
CB201G-015-067				ACC.		After Gouging
CB201G-016-067				ACC.		After Gouging
CB201G-016-069				ACC.		After Gouging
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EXAMINED BY 主探 REVIEWED BY 审核
 Jin Jianting Sun Jangchang
 LEVEL - II SIGN 签名 / DATE日期 8.25 LEVEL-II SIGN / DATE日期 8.25
 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-13993 DATE日期 2009.09.05 PAGE OF页码 1/1 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: CB202G OBG 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-345T2-X 12/14/22/15 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			
CB202G-028-004				ACC.		back gouging
CB202G-026-048				ACC.		back gouging
CB202G-026-050				ACC.		back gouging
CB202G-026-002				ACC.		back gouging
CB202G-026-004				ACC.		back gouging
CB202G-026-032				ACC.		back gouging
CB202G-026-040				ACC.		back gouging
CB202G-026-026				ACC.		back gouging
CB202G-028-044				ACC.		back gouging

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EXAMINED BY 主探 <u>Jin Jianting</u> <i>Jin Jianting</i> LEVEL - II SIGN 签名 / DATE日期 09.09.05	REVIEWED BY 审核 <u>Sun Guanghang</u> <i>Sun Guanghang</i> LEVEL-II SIGN / DATE日期 09.09.05
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-13993		DATE日期 2009.09.05	PAGE OF页码 1/1	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: CB202G OBG 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-345T2-X 12/14/22/15 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			
CB202G-025-046				ACC.		back gouging
CB202G-025-060				ACC.		back gouging
CB202G-025-088				ACC.		back gouging
CB202G-025-112				ACC.		back gouging
CB202G-025-114				ACC.		back gouging
CB202G-025-002				ACC.		back gouging
CB202G-025-004				ACC.		back gouging
CB202G-025-040				ACC.		back gouging
CB202G-028-022				ACC.		back gouging
CB202G-028-024				ACC.		back gouging
CB202G-028-018				ACC.		back gouging
CB202G-028-008				ACC.		back gouging
CB202G-028-002				ACC.		back gouging

EXAMINED BY 主探 Jin Jianting <i>Jin Jianting</i>	REVIEWED BY 审核 <i>Sun Jang Chaw</i>
LEVEL - II SIGN 签名 / DATE日期 <i>09.09.05</i>	LEVEL-II SIGN / DATE日期 <i>09.09.05</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-13994 DATE日期 2009.09.05 PAGE OF页码 1/1 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: CB202G OBG 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-345T2 12/14/15/22mm
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			
CB202G-027-040				ACC.		back gouging
CB202G-027-042				ACC.		back gouging
CB202G-027-062				ACC.		back gouging
CB202G-027-002				ACC.		back gouging
CB202G-027-004				ACC.		back gouging
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EXAMINED BY 主探 Jin Jianting <i>Jin Jianting</i> LEVEL - II SIGN 签名 / DATE日期 09.09.05	REVIEWED BY 审核 <i>Sunfang Chang</i> LEVEL-II SIGN / DATE日期 09.09.05
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000372**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0362**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: 21-Aug-2009**Description of Non-Conformance:**

Caltrans Quality Assurance Inspector observed ZPMC welded the joints for intermediate diaphragm to rib stiffeners in Crossbeam 7 and 10 with a deviated joint design detail. According to the approved drawing, the welds are detailed as 8mm fillet welds. Currently the weld joints listed below have been turned into CJP welds and thus not conforming to the approved shop drawings. The detail change was performed without prior Engineer's approval. These were new welds and were deposited after the fit-up of them member, with root gap exceeding 5mm.

CB202G-025-043~062, 001~004, 111~114, 039, 040, 087, 088.

CB202G-026-047~054, 001, 004, 031, 032, 039, 040, 026, 025, 061, 062, 043, 044.

CB202G-027-039~044, 051~062, 001~004.

CB202G-028-021~024, 017, 018, 051, 052, 043, 044, 007, 008, 053, 054, 057, 058, 059, 060, 001~004

CB201G-013-049,

CB201G-014-043, 061, 067, 089, 099, 119, 167, 131

CB201G-015-043, 063, 065, 067, 097, 101, 131

CB201G-016-043, 017, 067, 069, 101, 103, 097

Contractor's proposal to correct the problem:

Submit notification to the Engineer prior to performing weld detail changes in the future and perform MT in accordance with RFI 1709.

Corrective action taken:

Contractor submitted MT report confirming that welds were in conformance with Contract requirements.

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

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: 1347 246 3441, who represents the Office of Structural Materials for your project.

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