

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

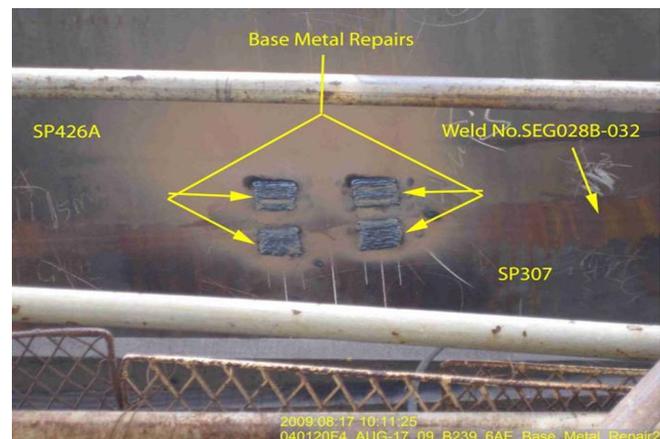
Quality Assurance and Source Inspection



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-000392**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0366**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG Segment 6AE Side Panel Repair**Procedural****Procedural****Description:****Reference Description:** Unacceptable Base metal repair on OBG side panel**Description of Non-Conformance:**

This Quality Assurance (QA) Inspector observed the in-process welding of a base metal repair being performed on side plate SP307 and SP426A adjacent to side plate splice weld No. SEG028B-032 on OBG Segment 6AE. Approximately four areas of 75mm x 75mm of filler material were deposited into four locations, in and around the splice weld to rectify the fit up of the traveler rail bolt attachments by building up the surface thickness to compensate the gap at the faying surface. These additional welds are not in the approved shop drawings or weld map. This is an unacceptable base metal repair and was performed without the approval of the Engineer.

**Applicable reference:**

AWS D1.5 2002-Section 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 defects."

Who discovered the problem: Rodney Patterson**Name of individual from Contractor notified:** Lee Man Kit

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 1030, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1100, Verbal

QC Inspector's Name: Tao Lei

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: 01-Sep-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: 05.03.06-000356

Subject: NCR No. ZPMC-0366

Reference Description: Unacceptable Base metal repair on OBG side panel

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:** 06

Remarks:

This Quality Assurance (QA) Inspector observed the in-process welding of a base metal repair being performed on side plate SP307 and SP426A adjacent to side plate splice weld No.SEG028B-032 on OBG Segment 6AE. Approximately four areas of 75mm x 75mm of filler material were deposited into four locations, in and around the splice weld to rectify the fit up of the traveler rail bolt attachments by building up the surface thickness to compensate the gap at the faying surface. These additional welds are not in the approved shop drawings or weld map. This is an unacceptable base metal repair and was performed without the approval of the Engineer.

Action Required and/or Action Taken:

Submit repair procedure to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0366

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: 05.03.06-000356

Subject: NCR No. ZPMC-0366

Dated: 21-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000362 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has informed ZPMC that base metal repairs not pre-approved per section 9 of the WQCP require a CWR. ABF has informed ZPMC that base metal repairs not pre-approved per section 9 of the WQCP require a CWR. For this application, ZPMC performed repairs without a CWR, but did have a WRR to document the welding and inspection procedures used. ZPMC will provide the necessary repair and inspection documentation at a later date for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000362R00

Caltrans' comments:

Status: AAP

Date: 22-Sep-2009

Will review and confirm the acceptance when the repair documentation including a CWR 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: 05.03.06-000356

Subject: NCR No. ZPMC-0366

Dated: 11-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000362 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC was in error providing a request for OBG within the request for Tower, therefore the work for this OBG part was still ongoing. This panel has subsequently been green tagged.

ZPMC was in error providing a request for OBG within the request for Tower, therefore the work for this OBG part was still ongoing. This panel has subsequently been green tagged. Also, for NCR's of this type, please note that the Notification for Inspection is a time documented when ZPMC will begin performing NDT, not necessarily that NDT is complete and accepted for the option of CT having a chance to observe the NDT in process. ZPMC requests closure of this NCR.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000362R01;

Caltrans' comments:

Status: REJ

Date: 11-Jan-2010

Unable to understand the description in the response letter. None of the information supplied is relevant to ZPMC NCR 366, therefore this NPR is rejected.

Submitted by: Howe, Bill

Date: 11-Jan-2010

Attachment(s):



No. B-560

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-1-7

REGARDING: NCR-000540(ZPMC-0513)

With this letter of response, ZPMC requests closure of CT NCR-000393(ZPMC-0366), after reviewing the description of the non-conformance report we found that the notification sheet(004853) was actually just for the tower but not any relation with the OBG panel inspection, so please re-check and assure the corrected information as the component of each NCR, thanks for you understand any good cooperation with us.

Remind that the panel have been got the green tag of 10595, please evaluated the real situation and then decide to turn the incident report to NCR.

So base on the above clarification we are applying to close this NCR.

ATTACHMENT:

NCR-000540(ZPMC-0513)

Wang Shuangbo

2010.1.7



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: 24-Dec-2009

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

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

Job Name: SAS Superstructure
 Document No: 05.03.06-000501

Subject: NCR No. ZPMC-0513

Reference Description: Fillet Weld Excavation with Final QC Acceptance, Crossbeam CB17

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: N/A

Remarks:

During a random in-process visual verification prior to performing Magnetic Particle Testing (MT) on a Floor Beam (FB) for Crossbeam CB17 located at Bay # 6, the Caltrans Quality Assurance (QA) Inspector observed a fillet weld that had been excavated approximately 50 mm in length and 6 mm in depth. The contractor (ZPMC) offered a formal NDT Inspection Notification Sheet, acknowledging the weld was complete and that ZPMC MT technicians had tested and accepted 100% MT on this FB. Additional information identifying the non-conformance is listed below.

- The Floor Beam is identified as FB3049-017-008.
- The fillet weld connects the FB Web Plate (PL3089A) to FB Girders (X3090R).
- The fillet weld size is 6 mm in size per the approved contract drawings.
- The NDT Inspection Notification Sheet request number was identified as: 004835

Action Required and/or Action Taken

Submit a repair procedure to the engineer for approval. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe
 Attachments: ZPMC-0513

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

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

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

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000540

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Dec-2009

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

NCR #: ZPMC-0513

Type of problem:

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

Bridge No: 34-0006

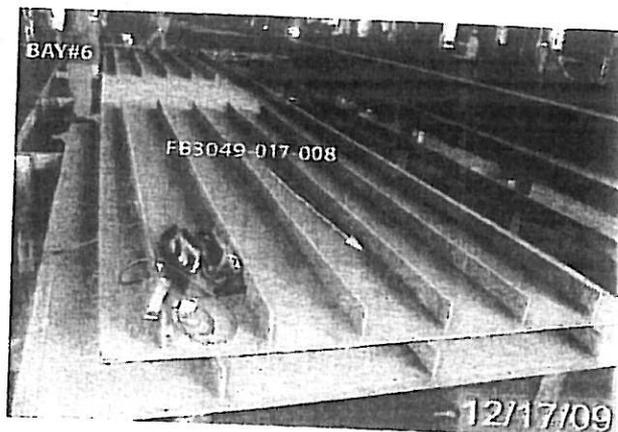
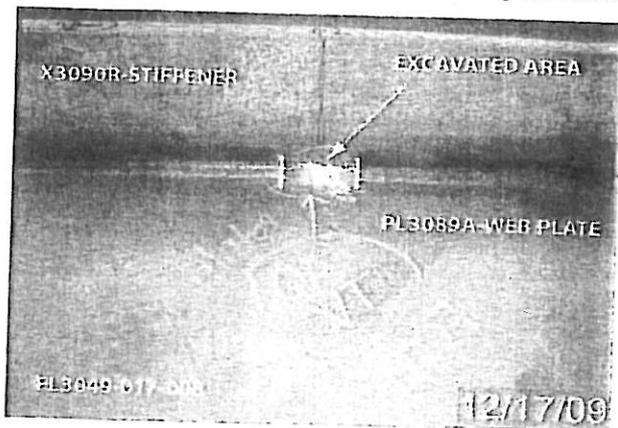
Component: Crossbeam CB17

Reference Description: Fillet Weld Excavation with Final QC Acceptance, Crossbeam CB17

Description of Non-Conformance:

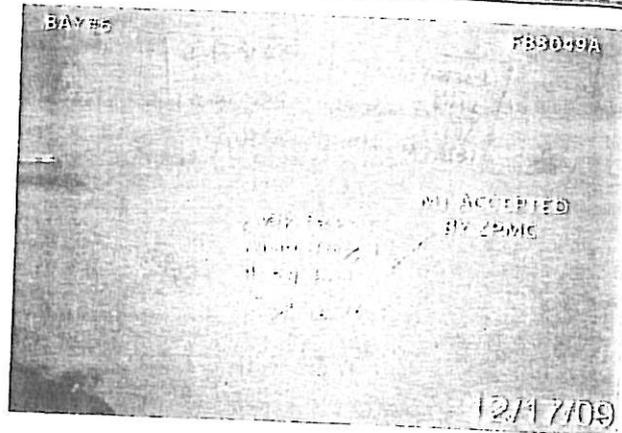
During a random in-process visual verification prior to performing Magnetic Particle Testing (MT) on a Floor Beam (FB) for Crossbeam CB17 located at Bay # 6, the Caltrans Quality Assurance (QA) Inspector observed a fillet weld that had been excavated approximately 50 mm in length and 6 mm in depth. The contractor (ZPMC) offered a formal NDT Inspection Notification Sheet, acknowledging the weld was complete and that ZPMC MT technicians had tested and accepted 100% MT on this FB. Additional information identifying the non-conformance is listed below.

- The Floor Beam is identified as FB3049-017-008.
- The fillet weld connects the FB Web Plate (PL3089A) to FB Stiffener (X3090R).
- The fillet weld size is 6 mm in size per the approved contract drawings.
- The NDT Inspection Notification Sheet request number was identified as: 004835



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 (02) Section 6.6.3; "The Contractor shall comply with all requests of the QA Inspector to correct deficiencies in materials and workmanship, as specified in the contract documents."

AWS D1.5 (02) Section 6.6.6; "The Contractor shall schedule NDT to facilitate attendance by the QA Inspector. The QA Inspector shall be advised by the Contractor of operational and NDT schedules and scheduled changes."

AWS D1.5 (02) Section 6.7.3; "After repairs of discontinuities have been made, additional NDT inspection shall be performed to ensure that the repairs are satisfactory. This testing shall include the repaired area plus at least 50 mm [2 in.] on each side of the repaired area."

Who discovered the problem: Naddi Sandeep Kumar
Name of individual from Contractor notified: Chang Bao Qian
Time and method of notification: 1000 hours, 12/17/09, Verbal
Name of Caltrans Engineer notified: Bill Howe
Time and method of notification: 1400 hours, 12/17/09, Verbal
QC Inspector's Name: Li Jian
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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler SMR
Reviewed By: Wahbeh, Mazen SMR

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000356

Subject: NCR No. ZPMC-0366

Dated: 22-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000362 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the weld repair report and NDT of the areas repaired to show that the base metal is acceptable. Based on this ZPMC requests this NCR be closed.

ZPMC is providing the weld repair report and NDT of the areas repaired to show that the base metal is acceptable. Based on this ZPMC requests this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000362R02;

Caltrans' comments:

Status: REJ

Date: 26-Jan-2010

The documentation submitted by the contractor has been reviewed by the Engineer. ZPMC only provided NDT documentation for one of the Side Panels listed in the NCR. NDT documentation was submitted for plates designated as PL1158 and PL 1160A, both of which are associated with SP426A. In order to close this NCR, the Engineer will need verification that the weld metal added to SP307 is also in conformance with Contract requirements.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010



No. B-559

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-1-7

REGARDING: NCR-000392(ZPMC-0366)

With this letter of response, ZPMC requests closure of CT NCR-000393(ZPMC-0366), what mentioned that QA observed improper buttering on base metal in 6AE.

ZPMC built up the surface thickness on several base metal areas around the Side Plates Splice weld in order to rectify the faying surface of the traveler rail bolt attachments. ZPMC acknowledged this was an unapproved procedure and has issued internal NCR. For warrant the buttering areas' quality, MT & UT were performed.

So ZPMC provides internal NCR, WWR & NDT documentations, hoping CT could take a review and consider close this NCR.

ATTACHMENT:

NCR-000392(ZPMC-0366)

NCR-B-251(ZPMC-0366)

B-WR6970

VT FOR B-WR6970

B787-UT-10608

B787-MT-17561

by [signature]
1/7/10



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

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A IV Date: 01-Sep-2009
 375 BURMA ROAD Contract No: 04-0120F4
 OAKLAND CA 95607 .. 04-SF-80-13.2 / 13.9
 Dear: Mr. Charles Kanapicki Job Name: SAS Superstructure
 Attention: Mr. Thomas Nilsson Project/Fabrication Manager Document No: 05.03.06-000356
 Subject: NCR No. ZPMC-0366

Reference Description: Unacceptal Base metal repair on OBG side pauci

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: 06

Remarks:

This Quality Assurance (QA) Inspector observed the in-process welding of a base metal repair being performed on side plate SP307 and SP426A adjacent to side plate splice weld No.SEG028B-032 on OBG Segment 6AE. Approximately four areas of 75mm x 75mm of filler material were deposited into four locations, in and around the splice weld to rectify the fit up of the traveler rail bolt attachments by building up the surface thickness to compensate the gap at the faying surface. These additional welds are not in the approved shop drawings or weld map. This is an unacceptable base metal repair and was performed without the approval of the Engineer.

Action Required and/or Action Taken:

Submit repair procedure to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0366

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

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

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

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000392

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Aug-2009

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

NCR #: ZPMC-0366

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

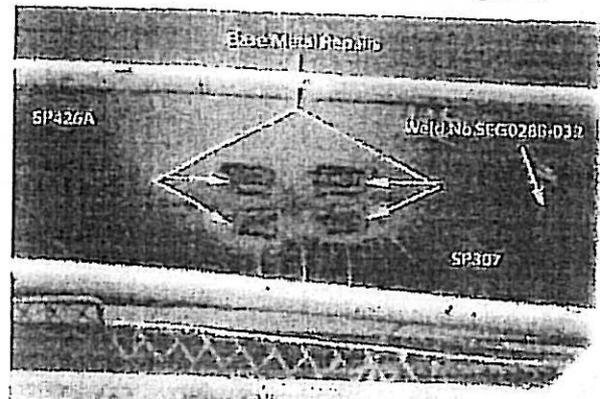
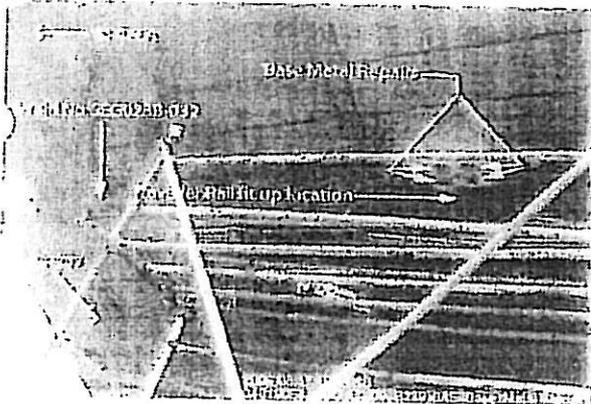
Bridge No: 34-0006

Component: OBG Segment 6AE Side Panel Repair

Reference Description: Unacceptable Base metal repair on OBG side panel

Description of Non-Conformance:

This Quality Assurance (QA) Inspector observed the in-process welding of a base metal repair being performed on side plate SP307 and SP426A adjacent to side plate splice weld No. SEG028B-032 on OBG Segment 6AE. Approximately four areas of 75mm x 75mm of filler material were deposited into four locations, in and around the splice weld to rectify the fit up of the traveler rail bolt attachments by building up the surface thickness to compensate the gap at the faying surface. These additional welds are not in the approved shop drawings or weld map. This is an unacceptable base metal repair and was performed without the approval of the Engineer.



Applicable reference:

AWS D1.5 2002-Section 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 defects."

Who discovered the problem: Rodney Patterson

Name of individual from Contractor notified: Lee Man Kit

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 1030, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1100, Verbal

QC Inspector's Name: Tao Lei

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 Wabbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wabbeh, Mazen

SMR



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-251 NCR 编号: (ZPMC-0366)	
Item: Unacceptable Base Metal Repair 名称描述: 未经批准的母材返修		Item Number: 件号: N/A	Drawing: 图号: SP307,SP426A
Location: Outside Yard 位置: OBG 外场		Date: 日期: 2009-09-10	
Description of Nonconformance: 不符合项状态描述: <p>CT Inspector observed the in-process welding of a base metal repair being performed on side plate SP307 and SP426A adjacent to side plate splice weld No. SEG028B-032 on OBG Segment 6AE. Approximately four areas of 75mm x 75mm of filler material were deposited into four locations, in and around the splice weld to rectify the fit up of the traveler rail bolt attachments by building up the surface thickness to compensate the gap at the faying surface. These additional welds are not in the approved shop drawing or weld map. This is an unacceptable base metal repair and was performed without the approval of Engineer.</p> <p>加州检验员发现在 6AE 斜底板 SP307 和 SP426A 靠近焊缝 SEG028B-032 位置在木材表面的堆焊。有 4 处大约 75mm x 75mm 大小的返修区域,其目的是增加行车轨道支架位置的母材厚度,已保证贴合位置的充分接触。这些附加焊缝并没有相关图纸或者焊缝编号。并且该工艺没有得到工程师的批准。</p> <p>(参考标准 AWD D1.5 章节 3.7.4)</p>			
Work By: <u>Zi Zhigang</u> 施工方: <u>Zi Zhigang</u>		Prepared by: <u>[Signature]</u> 准备: <u>9/10/09</u>	Reviewed by QCE: <u>[Signature]</u> 质量工程师批准: <u>[Signature]</u>
<input type="checkbox"/> Drawing Error 图纸错误		<input type="checkbox"/> Material Defect 材料缺陷	<input checked="" type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因			
Disposition: <input type="checkbox"/> Use as is <input type="checkbox"/> Repair <input type="checkbox"/> Reject 处理措施: 回用 返修 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: <u>工程师未批准进行母材表面堆焊。</u> <u>Build up surface of base metal before approved by engineer.</u>			
预防措施: <u>工程师未批准进行堆焊。</u> <u>Approved by engineer and then repair</u> Approved by/批准: <u>[Signature]</u>			
Technical Justification for Use-As-Is/Repair: <input type="checkbox"/> Attachment <input type="checkbox"/> Non-attachment 回用或返修的技术依据: <u>回用。根据缺陷报告进行处理。</u> <u>Perform use as is. Deal with the problem per Repair Report.</u> 附件 无附件			
Reviewed /批准: <u>[Signature]</u> 2009.9.15			
Verification: <input checked="" type="checkbox"/> Acceptable 确认: 可接受		<input type="checkbox"/> Unacceptable 不可接受 <u>对堆焊区域进行 MT/UT 检测。</u>	
Verified by QCI/质检确认: <u>Zhu zhonghai</u>		Reviewed by QCA/质检主任审核: _____	

#R787-QCP-1300

07072101

2009.11.05



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	SEG028/SEG036 SEG038	报告编号 Report No.	B-WR6970
合同号 Contract No.:	04-0120F4	部件名称 Items Name	6AE/7BE/7CE	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

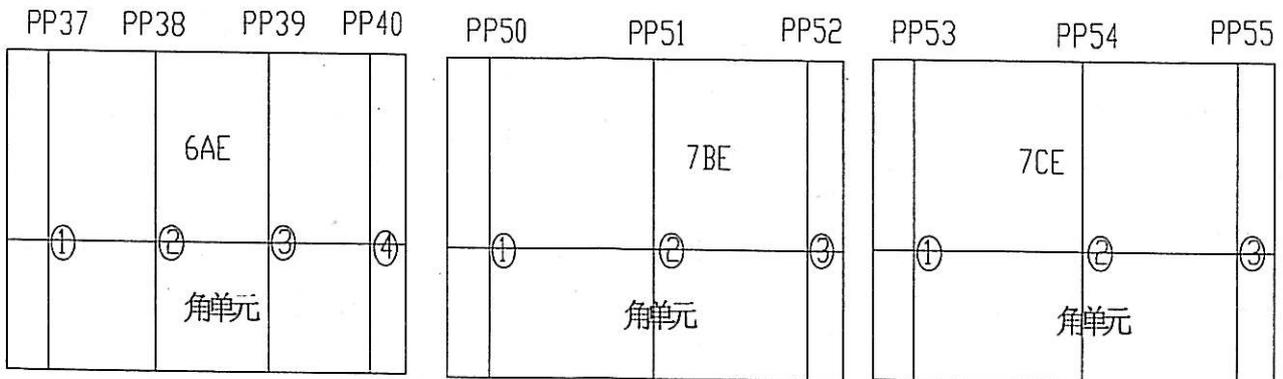
Description of welding discontinuity:

根据检查报告1075#的工艺处理结果,对梁段6AE/7BE/7CE的相关位置进行堆焊处理,并保证工艺要求的平整度。具体见下图!

According to inspection report 1075# disposition, it shall build up 6AE/7BE/7CE relevant position to ensure flatness, see the following draft.

检验员 (Inspector): Li Yanhua 日期(Date): 09.08.13

焊缝返修位置示意图:

Draft of welding discontinuity:

产生原因:

Caused:

焊接变形和制作误差。

Weld distortion and fabricate error.

车间负责人(Foreman): *Li Zhigang* 日期(Date): *09.08.13*

处理意见

Disposition :

1. 按照焊接返修工艺规程 (WPS) 打磨缺陷区域;
 2. 对该区域作100%MT检查, 确保缺陷全部去除;
 3. 根据批准的焊接返修工艺规程 (WPS) 进行预热及焊接;
 4. 将焊接区域打磨至与母材平齐;
 5. 对修补区域进行VT与MT检测;
-
1. Remove all the defects according to the approved repair WPS by means of grinding.
 2. Verify with MT and VT no defects remain in the repair area prior to weld;
 3. Preheat and weld according to the relevant WPS.
 4. Grind the weld flush with base metal after welding.
 5. Perform VT and MT inspection of the repaired area.

工艺: *Xu Deyuan*
Technical engineer

审核:
Approved by

日期
Date *09.08.13*



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-10608 DATE 2009.11.05 PAGE 1 OF 1 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787		CONTRACTOR: CALTRANS	
ITEMS NAME: 部件名称 OBG SIDE PLATE	DRAWING NO.: 图号 SP426	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号	
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01	
WELDING PROCESS 焊接方法 FCAW	JOINT TYPE 焊缝类型 NA	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2010	
EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311, 061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 AWS IIV BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X 18/75mm	

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	Reference Level 参考灵敏度		20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y			
PL1158A+PL1160A		70				32									ACC.	100%
BLANK																

EXAMINED BY 主探 <u>Li Liming</u> LEVEL - II SIGN / DATE 09.11.5	REVIEWED BY 审核 <u>Xue Hairong</u> LEVEL - II SIGN / DATE 09.11.5
质量经理 / QCM _____ 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000356

Subject: NCR No. ZPMC-0366

Dated: 02-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000362 Rev: 03

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is submitting the requested documentation to show the plates which make up the SP307 are acceptable after the weld built up. Based on this ZPMC requests closure of this NCR.

ZPMC is submitting the requested documentation to show the plates which make up the SP307 are acceptable after the weld built up. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000362R03;

Caltrans' comments:

Status: CLO
Date: 07-Mar-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Attachment(s):

Date: 07-Mar-2010



No. B-631

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-2-28

REGARDING: NCR-000392 (ZPMC-0366)

With this letter of response, ZPMC requests closure of CT NCR-000392 (ZPMC-0366) what mentioned about the issue of building up for SP.

Based on the requirement from NPR, ZPMC now providing the NDT documentations for the plates associated with SP307 and requesting closure of this NCR.

ATTACHMENT:

ABF-NPR-000362 R0

B787-MT-19767

B787-UT-11491

A handwritten signature in black ink, appearing to be "J. Wu" or similar, is written in a cursive style.

3/2/10



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

Dated: 22-Jan-2010

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000362 **Rev:** 02

Ref: 05.03.06-000356

Subject: NCR No. ZPMC-0366

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the weld repair report and NDT of the areas repaired to show that the base metal is acceptable. Based on this ZPMC requests this NCR be closed.

ZPMC is providing the weld repair report and NDT of the areas repaired to show that the base metal is acceptable. Based on this ZPMC requests this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000362R02;

Caltrans' comments:

Status: REJ

Date: 26-Jan-2010

The documentation submitted by the contractor has been reviewed by the Engineer. ZPMC only provided NDT documentation for one of the Side Panels listed in the NCR. NDT documentation was submitted for plates designated as PL1158 and PL 1160A, both of which are associated with SP426A. In order to close this NCR, the Engineer will need verification that the weld metal added to SP307 is also in conformance with Contract requirements.

Submitted by: Chao, Ching

Date: 26-Jan-2010

Attachment(s):

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-000539**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 10-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0366**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: 17-Aug-2009**Description of Non-Conformance:**

This Quality Assurance (QA) Inspector observed the in-process welding of a base metal repair being performed on side plate SP307 and SP426A adjacent to side plate splice weld No. SEG028B-032 on OBG Segment 6AE. Approximately four areas of 75mm x 75mm of filler material were deposited into four locations, in and around the splice weld to rectify the fit up of the traveler rail bolt attachments by building up the surface thickness to compensate the gap at the faying surface. These additional welds are not in the approved shop drawings or weld map. This is an unacceptable base metal repair and was performed without the approval of the Engineer.

Contractor's proposal to correct the problem:

Perform Magnetic Particle Testing (MT) to verify weld quality.

Corrective action taken:

Contractor submitted MT report verifying the quality of the welds.

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 152. 1675.3703, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer