

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

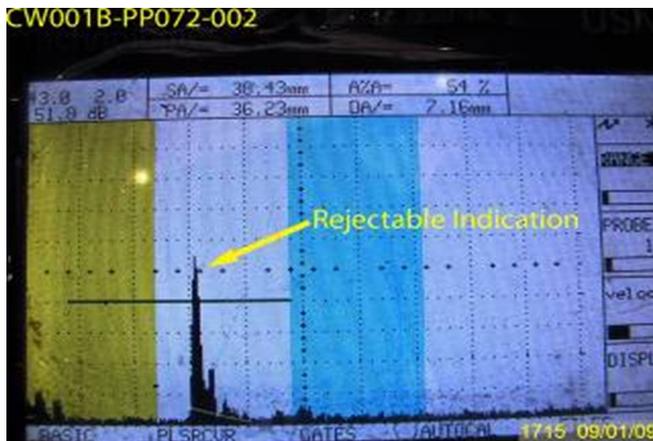
Quality Assurance and Source Inspection



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

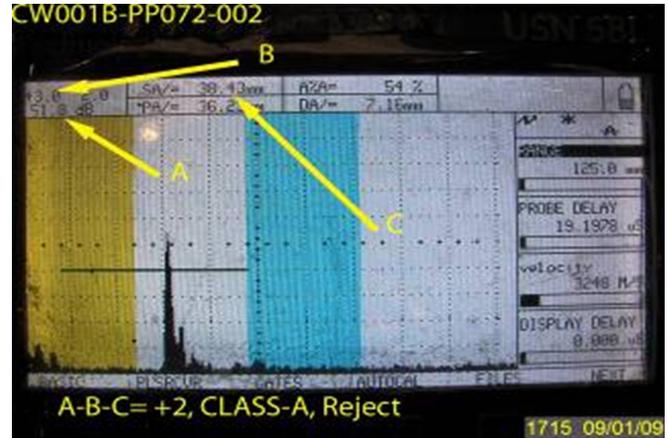
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000423**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Sep-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0397**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** CW001B-PP072**Procedural****Procedural****Description:** Missed UT Indication on Counterweight at PP72**Reference Description:** Missed UT indications by QC on CW001B**Description of Non-Conformance:**

During a random verification of Ultrasonic Testing (UT) on weld joint identified as CW001B-PP072-002, the Caltrans Quality Assurance inspector discovered two (2) class A non-conforming indication measuring approximately 20 mm in length. This weld was previously tested and accepted by ZPMC QC UT technicians.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )



## Applicable reference:

AWS D1.5-2002; Section 6, Table 6.3

**Who discovered the problem:** Hiranch Patel

**Name of individual from Contractor notified:** Zang Jian Ping

**Time and method of notification:** 1700 hours, Verbal

**Name of Caltrans Engineer notified:** Bill Howe

**Time and method of notification:** 1730 hours, Verbal

**QC Inspector's Name:** Tian 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.

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**Inspected By:** Tsang, Eric SMR

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**Reviewed By:** Wahbeh, Mazen SMR



**DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge**  
666 Feng Bin Road Room 708, Changxing Island  
Shanghai 201913 PR China  
Tel: 021-56856666 ext 207061 Fax:

## NON-CONFORMANCE REPORT TRANSMITTAL

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

**Date:** 28-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:** 05.03.06-000388

**Subject:** NCR No. ZPMC-0397

**Reference Description:** Missed UT indications by QC on CW001B

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:** N/A

### Remarks:

During a random verification of Ultrasonic Testing (UT) on weld joint identified as CW001B-PP072-002, the Caltrans Quality Assurance inspector discovered two (2) class A non-conforming indication measuring approximately 20 mm in length. This weld was previously tested and accepted by ZPMC QC UT technicians.

Please see the attached NCR No. ZPMC-397 for details.

### Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0397

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

**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000388

**Subject:** NCR No. ZPMC-0397

**Dated:** 16-Oct-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000389 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ABFJV QCM has implemented training with ZPMC to improve the quality of inspections. ABFJV will provide documentation showing attendance by ZPMC QC inspectors and the subject of training.

ABFJV QCM has implemented training with ZPMC to improve the quality of inspections. ABFJV will provide documentation showing attendance by ZPMC QC inspectors and the subject of training. Topics to be covered during the instruction are: inspection of equipment prior to use, proper conditions for inspection, proper technique for MT, and UT. In addition, ABFJV has committed to perform overchecks in both the Tower and OBG. This will serve two purposes, first to monitor if the training is effective at reducing the number of missed indications and second to ensure missed indications are prevented.

Documentation of repairs and subsequent NDT specific to this report will be transmitted through Daily Welding Reports and will be available in the documentation data base. Based on this course of action, ZPMC is requesting that this proposed resolution be approved with action pending. Once training records are available to be transmitted, ZPMC will request closure of this NCR.

### Submitted by:

**Attachment(s):** ABF-NPR-000389R00

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### Caltrans' comments:

**Status:** REJ

**Date:** 19-Oct-2009

The proposed resolution for training the QC inspectors is acceptable. However, documentation of repairs and subsequent NDT specific to this NCR should be submitted, along with the training records, for the Department's review prior to closure of the NCR.

**Submitted by:** Chao, Ching

**Date:** 19-Oct-2009

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000388

**Subject:** NCR No. ZPMC-0397

**Dated:** 08-Dec-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000389 Rev: 01

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### Contractor's Proposed Resolution:

**Reference Resolution:** Attached is documentation of the repair of the missed indications and subsequent NDT. The NDT documentation shows that the weld is acceptable.

Attached is documentation of the repair of the missed indications and subsequent NDT. The NDT documentation shows that the weld is acceptable. ABFJV's QCM has conducted training with ZPMC's MT inspectors and has previously submitted the training agenda and sign in sheet to the Department for verification to show the steps ABFJV is taking to address the missed indications. In addition, ABFJV has implemented NDT QA verification of welds to ensure that welds are acceptable prior to being inspected by the Engineer. Based on these actions and the attached documentation, ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000389R01;

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### Caltrans' comments:

**Status:** CLO

**Date:** 13-Dec-2009

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

**Submitted by:** Chao, Ching

**Attachment(s):**

**Date:** 13-Dec-2009



No. B-520

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2009-12-07**

**REGARDING: NCR-000423(ZPMC-0397)**

With this letter of response, ZPMC requests closure for CALTRANS NCR-000423(ZPMC-0397), what mentioned that QA rejected weld ID: CW001B-PP072-002, which has been tested and accepted by ZPMC.

After confirmation with UT, ZPMC acknowledged this issue and has written WWR to fix this rejection. After repair this weld was tested sound.

So ZPMC provided the internal NCR, WWR and NDT documentations, hoping CALTRANS could take a review and consider close this NCR.

**ATTACHMENT:**

NCR-B-268

NCR-000423(ZPMC-0397)

B-WR8541

B787-UT-9558

B787-UT-9558R1

  
12/07/09



# Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B 项目名称: 美国加州海湾大桥		NCR Number: NCR 编号: NCR-B-268 (ZPMC-0397)
Item: Missed UT Indication 名称描述: UT 漏检	Item Number: 件号:	Drawing: COUNTERWEIGHT 图号:
Location: BAY 1 位置: 1 车间	Date: 日期: 2009-10-1	

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

During a random verification of Ultrasonic Testing (UT) on weld joint identified as CW001B-PP072-002, the Caltrans Quality Assurance inspector discovered two (2) class A non-conforming indication measuring approximately 20mm in length. This weld was previously tested and accepted by ZPMC QC UT technicians.

在随机检验 CW001B-PP072-002 焊缝 UT 时, 加州检验发现两条 A 类缺陷将近有 20MM 长。这条焊缝之前已经被 ZPMC UT 检测人员检验并接受。

Work By: Liliang Prepared by: Zhangwei Reviewed by QCE: Chaochuangbao  
 施工方: 准备: 质量工程师批准:

Drawing Error  Material Defect  Fabrication Error  Other WJ  
 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

**Recommendation:**  
建议: 确认缺陷数值, 返修. Confirm defect dB and repair.

Prepared by: Liliang Approved by QCA: \_\_\_\_\_  
 准备 质量经理批准

**Reason for Nonconformance:**  
不符合原因: 缺陷不在检测比例 25% 范围内。  
 The defect without in 25% inspection area.

**Prevention of Re-occurrence:**  
预防措施: 注意检测比例, 加强控制。  
 Pay more attention and enhance controlling

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

Reviewed /批准: \_\_\_\_\_  
 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: \_\_\_\_\_

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge  
666 Feng Bin Road Room 708, Changxing Island  
Shanghai 201913 PR China  
Tel: 021-56856666 ext 207061 Fax:

*In Reply*

## NON-CONFORMANCE REPORT TRANSMITTAL

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

**Date:** 28-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:** 05.03.06-000388

**Subject:** NCR No. ZPMC-0397

**Reference Description:** Missed UT indications by QC on CW001B

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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**Material Location:** OBG

**Lift:** N/A

**Remarks:**

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**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0397

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

*05.03.06*

*05.03.06-000388.NCT*

Received  
NCT-000388 28 Sep 09

**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-000423

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 03-Sep-2009

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

**NCR #:** ZPMC-0397

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural  Bridge No: 34-0006

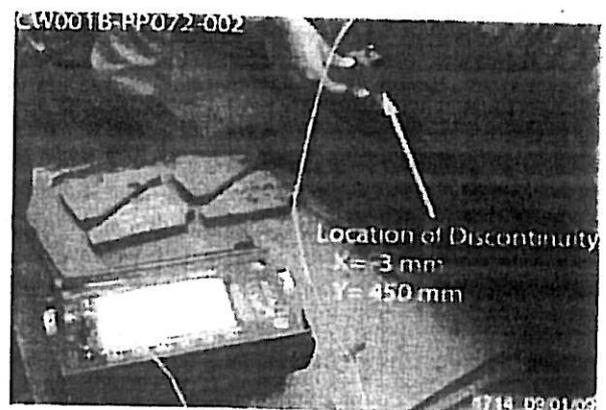
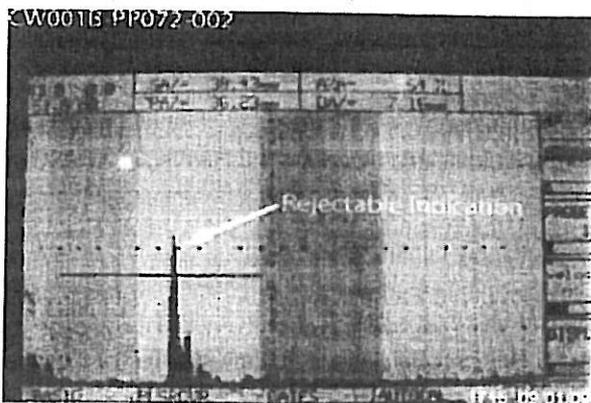
Joint fit-up  Coating  Other  Component: CW001B-PP072

Procedural  Procedural  Description: Missed UT Indication on Counterweight at PP72

**Reference Description:** Missed UT indications by QC on CW001B

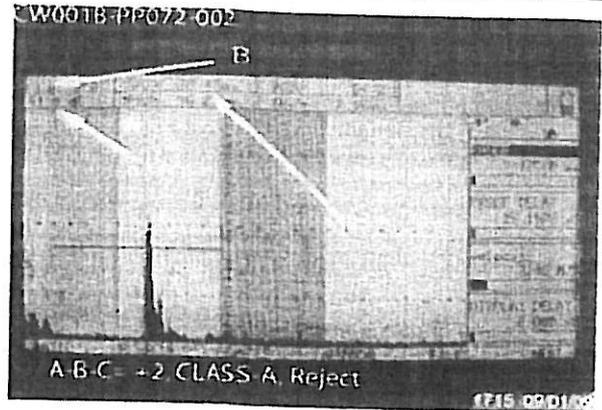
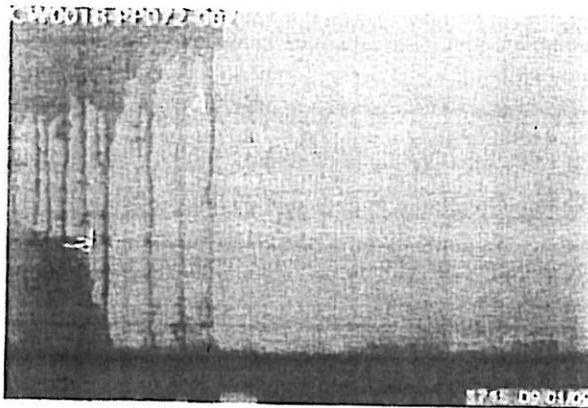
### Description of Non-Conformance:

During a random verification of Ultrasonic Testing (UT) on weld joint identified as CW001B-PP072-002, the Caltrans Quality Assurance inspector discovered two (2) class A non-conforming indication measuring approximately 20 mm in length. This weld was previously tested and accepted by ZPMC QC UT technicians.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



**Applicable reference:**

AWS D1.5-2002; Section 6, Table 6.3

**Who discovered the problem:** Hiranch Patel

**Name of individual from Contractor notified:** Zang Jian Ping

**Time and method of notification:** 1700 hours, Verbal

**Name of Caltrans Engineer notified:** Bill Howe

**Time and method of notification:** 1730 hours, Verbal

**QC Inspector's Name:** Tian 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.

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**Inspected By:** Tsang, Eric

SMR

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**Reviewed By:** Wahbeh, Mazen

SMR



# 焊缝返修报告

版本 Rev. No

. 0

## Welding Repair Report

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	CW001B	报告编号 Report No.	B-WR8541
合同号 Contract No.	04-0120F4	部件名称 Items Name	COUNTER WEIGHT ER BOXES	NDT报告编号 Report No. of NDT	
项目编号 Project No.:	ZP06-787				B787-UT-9558

焊缝缺陷描述:

Description of welding discontinuity:

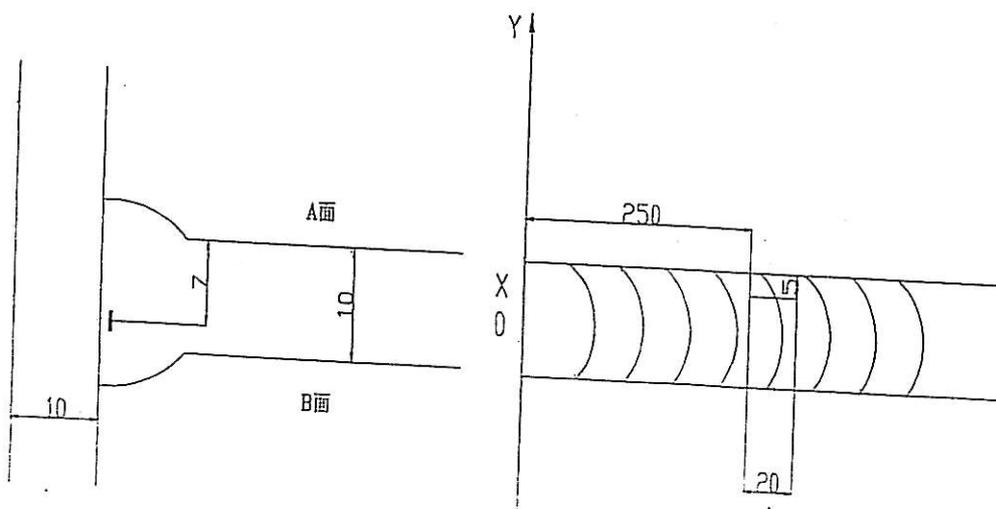
Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

(UT探伤发现的缺陷总长度小于最大允许长度。) CW001B-PP072-002

检验员 (Inspector): Han Feng 日期 (Date): 09.11.09

焊缝返修位置示意图:

Draft of welding discontinuity:



WELD NUMBER: CW001B-PP072-002

产生原因:

Caused:

1. 焊道未及时处理干净。
1. Did not clear the weld pass completely in time.

车间负责人(Foreman): Geo Lin 日期(Date): 09.11.11

处理意见

Disposition :

1. 从缺陷距离端面较近一侧 ( $D \leq 0.65T$ , D为缺陷深度, T为板厚) 采用碳刨或打磨的方法去除焊缝缺陷;
  2. 参照返修焊接工艺规程 (WPS) 准备正确的接头型式, 预热和焊接;
  3. 焊前对修补区域进行VT检测保证缺陷完全被清除;
  4. 将修补区域打磨到与母材或邻近焊缝平齐;
  5. 对焊缝进行UT检测, 检测范围为返修区域以及其两端各延长50mm.
- 
1. Gouge or grind from nearer side from metal edge ( $D \leq 0.65T$ , "D" is depth of defects, "T" is thickness of metal) to remove all defects;
  2. Follow repair WPS for joint preparation, preheat, and weld deposit;
  3. Verify with VT no defects remain in the weld joint prior to welding;
  4. Grind the repaired area flush with base metal or the adjacent weld;
  5. Perform UT inspection to the weld along with 50mm on each end of the repair area.

工艺: Hexiao Lin  
Technical engineer

审核:  
Approved by

日期  
Date

09.11.11



# 焊缝返修报告

## Welding Repair Report

版本 Rev. No.

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	CW001B	报告编号 Report No.	B-WR8541
合同号 Contract No.:	04-0120F4	部件名称 Items Name	COUNTER WEIGHT ER BOXES	NDT报告编号 Report No. of NDT	B787-UT-9558
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

1. 加强焊接监控和道间清理。

1. Improve monitoring of welding and interpass cleaning.

车间负责人(Foreman): Gao Jun 日期(Date): 09.11.11

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-2 G(2F)-Repair WPS-345-FCAW-2 G(2F)-Repair-1	工艺员 technologist	Hexiaolin 09.11.11
返修(碳刨)前预热温度 Preheat temperature before gouging	60°C	返修的缺陷 Description of discontinuity	slag
焊前处理检查 Inspection before welding	AW	焊前预热温度 Preheat temperature before welding	72°C
最大碳刨深度 Max. depth of gouging	5	碳刨总长 Total length of gouging	30
焊工 welder Limeng Qian 054460	焊接类型 welding type EPAW	焊接位置 position	26
焊接电流 Current 285	焊接电压 Voltage 28.6	焊接速度 Speed	5/0

返修后检查  
Inspection After repairing:

外观检查 VT result Acc	检验员 Inspector chen xi	日期 Date 2009.12.07.
NDT复检 NDT result AW	探伤员 NDT person Liang	日期 Date 12.9.11.
见证: Witness/Review:		
备注: Remark:		



# REPORT OF ULTRASONIC EXAMINATION

## UT探伤报告

REPORT NO. 报告编号 B787-UT-9558      DATE 2009.11.09      PAGE 1 OF 1      Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

ITEMS NAME: 部件名称 COUNTER WEIGHTER BOXES	DRAWING NO.: 图号 CW001B	CONTRACTOR: CALTRANS 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 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 <sup>ST</sup> , 2009

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 IIW BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X      10mm	

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		
CW001B-PP072-002	1	70	A	1	40	33	0	+7	20	30	7	-5	250	REJ.	100%
BLANK															

EXAMINED BY 主探 <i>Han Feng</i>	REVIEWED BY 审核 <i>Jin Fan</i>
LEVEL - II SIGN / DATE <i>11.09</i>	LEVEL - II SIGN / DATE <i>11.09</i>
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE





# REPORT OF ULTRASONIC EXAMINATION

## UT探伤报告

REPORT NO. 报告编号 B787-UT-9558R1      DATE 2009.12.07      PAGE 1 OF 1      Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

ITEMS NAME: 部件名称 COUNTER WEIGHTER BOXES	DRAWING NO.: 图号 CW001B	CONTRACTOR: CALTRANS 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 T-JOINT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 <sup>ST</sup> , 2009
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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 IIW BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X      10mm	

### 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				
Base metal inspected per AWS D1.5-2002 Section 6.19.5      0° UT OK.						Reference Level 参考灵敏度	20dB

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
CW001B-PP072-002	1R1	70						32								ACC.	100%

AFTER B-WR8541

BLANK

EXAMINED BY 主探 <i>Han Peng</i> 09.12.07 LEVEL - II SIGN / DATE 质量经理 / QCM	REVIEWED BY 审核 <i>Xue Ma Peng</i> 09.12.07 LEVEL - II SIGN / DATE 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-000435**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0397**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 03-Sep-2009**Description of Non-Conformance:**

During a random verification of Ultrasonic Testing (UT) on weld joint identified as CW001B-PP072-002, the Caltrans Quality Assurance inspector discovered two (2) class A non-conforming indication measuring approximately 20 mm in length. This weld was previously tested and accepted by ZPMC QC UT technicians.

**Contractor's proposal to correct the problem:**

Repair indications and perform required NDT.

**Corrective action taken:**

Contractor submitted WRR along with NDT reports verifying the repair is in conformance with 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

**Reviewed By:** Wahbeh, Mazen

QA Reviewer