

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-000432

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 08-Sep-2009

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

NCR #: ZPMC-0406

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Deck Panel Diaphragm at PP74
Procedural	Procedural	Description:	Fabrication is not following the approved drawing

Reference Description: Fabrication not according to the approved shop drawings

Description of Non-Conformance:

The Quality Assurance Inspector (QA) observed that the contractor deviated from approved drawing sheet no. SEGSD16A by cutting a beam cope/weld access hole. This non-approved beam cope/weld access was cut into the Deck Panel Diaphragm at the vertical splice connecting plates DP501A to DP339A to the Floor Beam on segment 9BE at PP74. The splice is located approximately 1730mm measured from the end of Deck Panel.



Applicable reference:

1. Approved Drawing Sheet No. SD6: Section – 6C and Section - 6F
2. Approved Drawing Sheet No. X1: Floor Beam Diaphragm ~ Mark X1B and : Floor Beam Diaphragm ~ Mark X1H
3. Approved Drawing Sheet No. SEGSD16A

Who discovered the problem: Tim McClendon

Name of individual from Contractor notified: Li Man Kit

Time and method of notification: 1300 hours, verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1400 hours, verbal

QC Inspector's Name: Lay Tao

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
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: 05.03.06-000395

Subject: NCR No. ZPMC-0406

Reference Description: Fabrication not according to the approved shop drawings

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:** 09

Remarks:

The Quality Assurance Inspector (QA) observed that the contractor deviated from approved drawing sheet no. SEGSD16A by cutting a beam cope/weld access hole. This non-approved beam cope/weld access was cut into the Deck Panel Diaphragm at the vertical splice connecting plates DP501A to DP339A to the Floor Beam on segment 9BE at PP74. The splice is located approximately 1730mm measured from the end of Deck Panel.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences.

Transmitted by: Ching Chao

Attachments: ZPMC-0406

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: 05.03.06-000395

Subject: NCR No. ZPMC-0406

Dated: 11-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000469 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC generated a CWR, has performed all required repair and inspections. See attached. ZPMC requests closure of this NCR.

ZPMC cut a weld access hole to accommodate welding a vertical splice weld that should have been welded in position on the shop floor before assembling to the other deck panels and floor beam. ZPMC generated a CWR, has performed all required repair and inspections. See attached. ZPMC requests closure of this NCR.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000469R00;

Caltrans' comments:

Status: CLO

Date: 13-Jan-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Date: 13-Jan-2010

Attachment(s):



No. B-573

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-1-11

REGARDING: NCR-00432 (ZPMC-0406)

With this letter of response, ZPMC requests closure of CT NCR-000432(ZPMC-0406), what mentioned that CT Inspector observed one cope hole was cut deviated from approved drawing.

- ZPMC acknowledged this problem and has issued internal NCR. See attached NCR-B-266.
- CWR was issued to fix the cope hole. See attached B-CWR731.
- NDT was performed to warrant the weld's quality.

Based on the taken actions and attached documentations, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-B-266(ZPMC-0406)

NCR-000432(ZPMC-0406)

B-CWR731

VT AFTER REPAIR

B787-UT-10706

A handwritten signature in black ink, appearing to be 'J. M.', is located below the attachment list.

1/11/10



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-266 (ZPMC-0406)	
Item: Fabrication not according to drawing 名称描述: 未按图纸施工		Item Number: 件号:	Drawing: Deck Panel Diaphragm at PP74 图号: PP74 处顶板连接板
Location: bay 14 位置: 14 车间		Date: 日期: 2009-9-30	
Description of Nonconformance: 不符合项状态描述: CT Inspector observed that the contractor deviated from approved drawing sheet no. SEGSD16A by cutting a beam cope/weld access hole. This non-approved beam cope/weld access was cut into the deck panel diaphragm at the vertical splice connecting plates DP501A to DP339A to the floor beam on segment 9BE at PP74. The splice is located approximately 1730mm measured from the end of Deck Panel. 加州检验员发现车间制作中违反了施工图纸 SEGSD16A 要求, 多切割了一处过焊孔。此处过焊孔位于 DP501A 和 DP339A 的垂直对接缝, 位于 PP74 箱体 9BE。此处焊缝经测量位于距顶板边缘大约 1730mm 处。 参考标准: 车间图纸 SD6, X1, SEGSD16A.			
Work By: 施工方: <u>魏建刚</u>		Prepared by: 准备: <u>9/10/09</u>	Reviewed by QCE: 质量工程师批准: <u>Wu Shuang</u> 9.30
<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: 处理措施:		<input type="checkbox"/> Use as is 回用	<input type="checkbox"/> Repair 返修
<input type="checkbox"/> Reject 拒收			
Recommendation: 建议:			
Prepared by: 准备		Approved by QCA: 质量经理批准	
Reason for Nonconformance: 不符合原因: <u>没有按照图纸施工. Didn't perform according to drawing requirement.</u>			
Prevention of Re-occurrence: 预防措施: <u>加强现场技术指导, 派技术好的工人施工.</u> <u>Enhance technique guiding to improve worker skill.</u>			
Approved by/批准: <u>[Signature]</u>			
Technical Justification for Use-As-Is/Repair: 回用或返修的技术依据:		<input type="checkbox"/> Attachment 附件.	<input type="checkbox"/> Non-attachment 无附件
<u>根据焊缝返修报告 CWR 731. Deal with it per CWR 731.</u>			
Reviewed/批准: <u>Mom/1/1/1 2009/10/13</u>			
Verification: 确认:		<input checked="" type="checkbox"/> Acceptable 可接受	<input type="checkbox"/> Unacceptable 不可接受
Verified by QCI/质检确认: <u>zhu zhonghai</u>		Reviewed by QCA/质检主任审核: <u>[Signature]</u>	

#R787-QCP-1300

07072101

20/10. of. 11

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changyang Island
Shanghai 201813 PR China
Tel: 021-56656666 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 0120P4
04-ST-80-13.2 / 13.9

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

Job Name: SAS Superstructure
Document No: 05.03.06-000395

Subject: NCR No. ZPMC-0406

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Lift: 09

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Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences.

Transmitted by: Ching Chao

Attachments: ZPMC-0406

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

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

Bay Area Branch
650 Walnut Ave. Ste. 150
Valejo, CA 94592-1133
(707) 649-6453
(707) 649-5492

Contract #: 04-012014

City: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Report No: NCR-000432

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

Date: 08-Sep-2009

NCR #: ZPMC-0406

Type of problem:

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

Bridge No: 34-0006

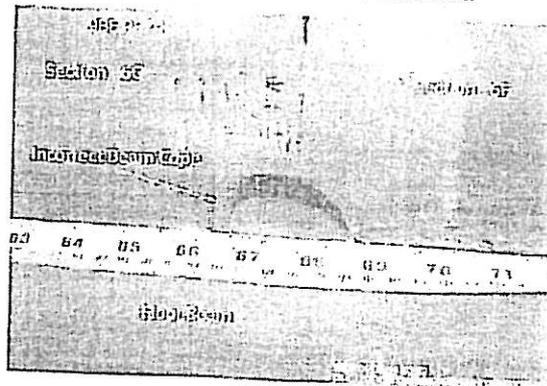
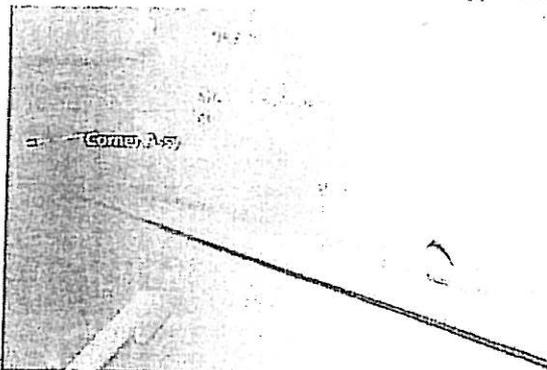
Component: Deck Panel Diaphragm at PP74

Description: Fabrication is not following the approved drawing

Reference Description: Fabrication not according to the approved shop drawings

Description of Non-Conformance:

The Quality Assurance Inspector (QA) observed that the contractor deviated from approved drawing sheet no SEGSD16A by cutting a beam cope/weld access hole. This non-approved beam cope/weld access was cut into the Deck Panel Diaphragm at the vertical splice connecting plates DP501A to DP339A to the Floor Beam on segment 9BE at PP74. The splice is located approximately 1730mm measured from the end of Deck Panel.



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2. Approved Drawing Sheet No. X1: Floor Beam Diaphragm - Mark X1B and : Floor Beam Diaphragm - Mark X1H

3. Approved Drawing Sheet No. SEGSD16A

Who discovered the problem: Tim McClendon

Name of individual from Contractor notified: Li Man Kit

Time and method of notification: 1300 hours, verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1400 hours, verbal

QC Inspector's Name: Lay Tao

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

DEPARTMENT OF TRANSPORTATION
 CHINA FABRICATION TEAM
 506 Shangcheng Rd., Pudong New District
 Shanghai 200120, PRC



REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Thomas Nilsson, American Bridge - Fluor, a Joint Venture
Gary Pursell, Resident Engineer

Review Date: 09/17/2009

From: Jim Simonis

Contract No.: 04-0120F4

Date/Time Submittal Received: 09/16/2009

China Standard Time
 (GMT+08:00)

Contractor's Transmittal #: ABF-CAL-TRN-003872

Rev. # 0

<input type="checkbox"/>	substantially complies with contract requirements and is approved	
<input checked="" type="checkbox"/>	substantially complies with contract requirements and is approved as noted.	
<input type="checkbox"/>	Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmittal	
Verbal Notification	<input checked="" type="checkbox"/> No <input type="checkbox"/> Yes Date: _____ Time: _____	
Name of individual from Contractor Notified: <u>Lu, ZPMC QA</u>		
This submittal is a:	<input type="checkbox"/> Welding Report <input checked="" type="checkbox"/> Critical Weld Repair <input type="checkbox"/> Request for Information <input type="checkbox"/> Heat Straightening Request <input type="checkbox"/> Fabrication Procedures <input type="checkbox"/> Other: _____	
Submitting Contractor: <u>ZPMC</u>		
ITEMS REVIEWED	COMPLIES	COMMENTS
1. B-CWR 731 Rev. 1	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	See remarks.
2.	<input type="checkbox"/> Yes <input type="checkbox"/> No	
3.	<input type="checkbox"/> Yes <input type="checkbox"/> No	

Remarks:

Disposition:

8. Perform MT after backgouging to ensure backgouged material is free of defect.

Reviewer: Serge Sinevod SS

Date: 09/17/2009

Construction Concurrence: Initials SJE Date 9/17/09

Received by (ABFJV): Rosmary Date 9/17/09 Time 4:50



关键焊缝返修报告
Critical Welding Repair Report (CWR)

版本
Rev. No.:

1

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SEG052A	报告编号 Report No.	B-CWR731
合同号 Contract No.:	04-012DF4	部件名称 Item Name:	顶板连接板 Deck plate connect plate	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:

检查发现9BE的顶板DP501A的连接板X1H与顶板DP339A的连接板X1B对接缝下端多开R=25的过焊孔, 具体如下图所示:

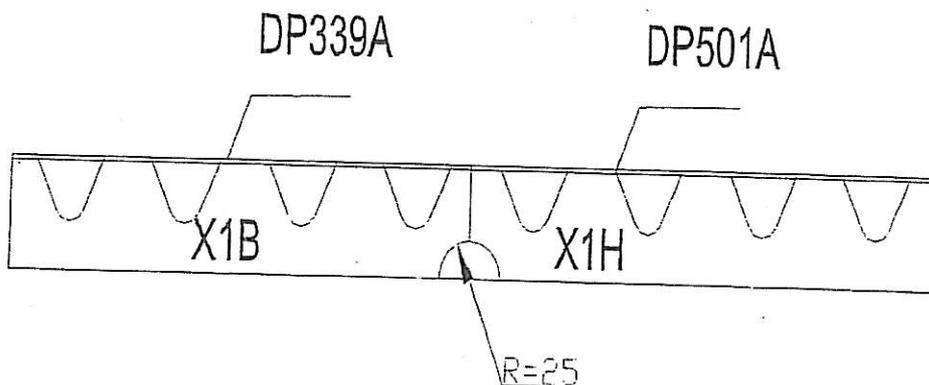
After inspection: the r-hole was fabricated error at 9BE deck plate DP501A X1H and DP339A X1B, 25mm in radius, the detail see the following draft.

检验员 (Inspector): zhaoxianji

日期 (Date): 2009-9-10

焊缝返修位置示意图:

Draft of Welding Discontinuity:



<input type="checkbox"/>	APPROVED
<input checked="" type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION Division of Engineering Services Office of Structure Construction	
<u>SOE for RM</u>	<u>9/17/09</u>
Structure Representative	Date

产生原因:

Cause:

工人在制作前没有看清楚图纸要求, 导致过焊孔制作错误。

Worker didn't review drawing carefully caused weld through hole fabricated error.

车间负责人 (Foreman): Li Zhigang

日期 (Date): 09.09.15

处理意见

Disposition :

- 1, QC和CWI在整个修补过程中都应在场;
- 2, 按照提交工艺200#进行修补, 信件号为05.03.01-003474;
- 3, 将孔采用碳刨的方法拓宽, 并打磨平滑, 拓宽的孔应符合修补WPS中的接头细节。碳刨前应根据相应的WPS进行预热;
- 4, 焊接前采用VT、MT检测确保无缺陷存在;
- 5, 贴加钢衬垫, 根据返修WPS进行预热及打底焊接, 焊接时采用线状纵向进行补焊, 焊后打磨焊缝使其与周围母材光滑过渡;
- 6, 在下一步焊接前对打底焊缝进行MT检测确认无缺陷存在;
- 7, 按照返修的WPS进行预热和焊接;
- 8, 去除衬垫, 根部焊道反面碳刨清根焊接;
- 9, 焊后将焊缝打磨与周围母材齐平;
- 10, 采用进行VT、UT、MT对返修区域进行检测。

注: QC和Leader CWI检测所有的碳刨, 打磨和焊接;

<input type="checkbox"/>	APPROVED
<input checked="" type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02	
of the Standard Specifications	
State of California	
DEPARTMENT OF TRANSPORTATION	
Division of Engineering Services	
Office of Structure Construction	
<u>STE Ser RM</u>	<u>9/17/09</u>
Structure Representative	Date

1. QC and CWI should be present to witness the repair.
2. Repair to be perform in according with submittal 200 and letter No.:05.03.01-003474.
3. Elongate the hole by arc gouging, and grind smooth the surface. The elongated hole should conform to the joint detail in Repair WPS. Preheat before gouging according to relevant WPS.
4. Perform VT and MT to ensure no defects exist.
5. Add steel backing. Preheat and perform root welding according to the repair WPS, weld stringers longitudinally along the elongated direction of the hole. Grind the weld to make it have a smooth transition with adjacent base metal.
6. Perform MT before following operations to ensure no defects exist.
7. Preheat and weld according to repair WPS.
8. Remove steel backing and back gouge the root pass, and complete the welding.
9. Grind the repair area flush with adjacent base metal.
10. Check with VT, UT, MT after welding to the repair area.

Note: ALL gouging, grinding and welding should be inspected by QC and Leader CWI.

MT AFTER BACK GOUGING TO ENSURE BACK GOUGING IS FREE OF DEFECT
 9-17-09

工艺:

Technical Engineer: Mu Tingfang 审核: Ray Yankina Approved By:

日期: 09.09.16
Date:



关键焊缝返修报告

Critical Welding Repair Report (CWR)

版本
Rev. No.:

1

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SEG052A	报告编号 Report No.	B-CWR731
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	顶板连接板 Deck plate conn ect plate	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

培训和教育操作工, 提高制作水平。

Train and educate operator to improve fabrication skill.

车间负责人 (Foreman):

Li Zhigang

日期 (Date):

07.09.15

参照的 WPS 编号 Repair WPS No.:	WPS-345-SMAW-2 G(2F)-Repair WPS-345-FCAW-2G (2F)-Repair WPS-345-SMAW-3 G(3F)-Repair-Misdr illed Hole	工艺员 Technologist:	Niu Tiefang 07.09.16
返修 (碳刨) 前预热温度 Preheat Temperature Before Gouging:	NA	返修的缺陷 Description of Discontinuity:	wrong hole
焊前处理检查 Inspection Before Welding:	Acc	焊前预热温度 Preheat Temperature Before Welding:	170°C
最大碳刨深度 Max. Depth of Gouge:	NA	碳刨总长 Total Length of Gouge:	NA
焊工 Welder:	069339	焊接类型 Welding Type:	SMAW
焊接电流 Current:	151	焊接电压 Voltage:	21.7
		焊接位置 Position:	2G
		焊接速度 Speed:	1/0

返修后检查

Inspection After Repair:

外观检查 VT Result:	Acc	检验员 Inspector:	Litahua 07/20/09	日期 Date:	07.12.29
NDT 复检 NDT Result:	Acc	探伤员 NDT Person:	Junh	日期	1/0
见证: Witness/Review:	<input type="checkbox"/> APPROVED <input checked="" type="checkbox"/> APPROVED AS NOTED <input type="checkbox"/> RETURNED FOR CORRECTION Pursuant to Section 5-1.02 of the Standard Specifications State of California DEPARTMENT OF TRANSPORTATION Division of Engineering Services Office of Structure Construction				
备注: Remark:	508 31 207 7/13/09 State Representative Date				

#R787-QCP-900



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-10706 DATE 2010.01.10 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: OBG DECK PLATE DRAWING NO.: SEG052A CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 NA SMAW Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2-X 12/14mm

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		
DP339A		70				32									100%
		0				22									100%
DP501A		70				32									100%
		0				22									100%

AFTER B-CWR731

BLANK

EXAMINED BY 主探
 Sun yin Sun Yin 2010.01.10
 LEVEL - II SIGN / DATE

REVIEWED BY 审核
WJ Chao 2010.01.10
 LEVEL - II SIGN / DATE

质量经理 / QCM

 签字 SIGN / 日期 DATE

用户 CUSTOMER

 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-000449**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0406**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: 08-Sep-2009**Description of Non-Conformance:**

The Quality Assurance Inspector (QA) observed that the contractor deviated from approved drawing sheet no. SEGSD16A by cutting a beam cope/weld access hole. This non-approved beam cope/weld access was cut into the Deck Panel Diaphragm at the vertical splice connecting plates DP501A to DP339A to the Floor Beam on segment 9BE at PP74. The splice is located approximately 1730mm measured from the end of Deck Panel.

Contractor's proposal to correct the problem:

Repair damage and perform the required NDT.

Corrective action taken:

Contractor submitted CWR documenting the repair was made along with NDT documentation 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**