

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-000462**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Oct-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0435**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Crossbeam CB16 Floorbeam
Procedural	Procedural	Description:	

Reference Description: The contractor did not follow the approved WPS and omit MT.**Description of Non-Conformance:**

This Quality Assurance Inspector (QA) observed the contractor's welding personnel performing Complete Joint Penetration (CJP) weld repairs on welds that have been rejected by the contractor's Quality Control (QC) Ultrasonic Testing (UT) technicians. The contractor's QC inspector Mr. Zheng Zhi Wei informed the QA inspector that the repairs were being performed in conformance with WPS-345-SMAW-2G (2F)-repair and WPS-345-FCAW-2G (2F)-repair. The QA inspector noted that the contractor had not performed Magnetic Particle Testing (MT) of the excavated areas prior to welding as specified in the repair WPSs on the following repaired weld joints: FB205-051-043, FB205-049-006, FB205-050-046, FB205-052-005 and 006 in CB16.

Applicable reference:

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

Approved Repair WPS numbers; WPS-345-SMAW-2G (2F)-repair and WPS-345-FCAW-2G (2F)-repair
“Grind all repair areas to bright metal and perform Magnetic Particle Testing prior to the start of welding”.

Who discovered the problem: Steve Hall**Name of individual from Contractor notified:** Yu Kum Ming**Time and method of notification:** 1000 hours, Verbal**Name of Caltrans Engineer notified:** Ching Chao**Time and method of notification:** 0800 hours, Email**QC Inspector's Name:** Zheng Zhi Wei**Was QC Inspector aware of the problem:**

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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:	Carreon,Albert	Lead Reviewer/Task Leader
Reviewed By:	Wahbeh,Mazen	SMR



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: 05-Nov-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: 05.03.06-000430

Subject: NCR No. ZPMC-0435

Reference Description: The contractor did not follow the approved WPS and omit MT.

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:** 11

Remarks:

This Quality Assurance Inspector (QA) observed the contractor's welding personnel performing Complete Joint Penetration (CJP) weld repairs on welds that have been rejected by the contractor's Quality Control (QC) Ultrasonic Testing (UT) technicians. The contractor's QC inspector Mr. Zheng Zhi Wei informed the QA inspector that the repairs were being performed in conformance with WPS-345-SMAW-2G (2F)-repair and WPS-345-FCAW-2G (2F)-repair. The QA inspector noted that the contractor had not performed Magnetic Particle Testing (MT) of the excavated areas prior to welding as specified in the repair WPSs on the following repaired weld joints: FB205-051-043, FB205-049-006, FB205-050-046, FB205-052-005 and 006 in CB16.

Action Required and/or Action Taken:

Submit a repair procedure for the approval of the engineer.

Transmitted by: Bill Howe

Attachments: ZPMC-0435

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

Dated: 01-Dec-2009

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000437 Rev: 00

Ref: 05.03.06-000430

Subject: NCR No. ZPMC-0435

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT documentation of the welds to show that they are acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC rejected the welds referenced in the NCR and wrote an internal NCR to address this issue. ZPMC is providing NDT documentation of the welds to show that they are acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000437R00;

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

Date: 13-Dec-2009

Attachment(s):



No. B-508

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-11-30

REGARDING: NCR-000462(ZPMC-0435)

With this letter of response, ZPMC requests closure for Caltrans NCR-000462 (ZPMC-0435). In NCR-000462 (ZPMC-0435) it mentioned that QA observed no MT was performed after excavation what was required in related WPS.

ZPMC acknowledged this problem. Actually, two of the mentioned weld IDs: FB205-051-043, FB205-050-046 were wrong. The correct weld IDs should be: FB204-051-043, FB204-050-046.

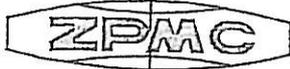
To avoid same problem in future, ZPMC will enhance supervision work team's control and review WPS requirement carefully. Please note that all these five welds had been rejected by ZPMC and repairing work has been done. After all UT tests were arranged to warrant welds quality.

So ZPMC hope Caltrans could take a review and consider close this NCR.

ATTACHMENT:

NCR-000462(ZPMC-0435)

Jay
12/01/09



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-293 (ZPMC NCR-19-073)	
Item: not follow the WPS 名称描述: 未按照 WPS		Item Number: 件号: N/A	Drawing: CB16 图号:
Location: BAY 5 位置: 5 车间		Date: 日期: 2009-11-14	

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

This Quality Assurance Inspector (QA) observed the contractor's welding personnel performing Complete Joint Penetration (CJP) weld repairs on welds that have been rejected by the contractor's Quality Control (QC) Ultrasonic Testing (UT) technicians. The contractor's QC inspector Mr. Zheng Zhi Wei informed the QA inspector that the repairs were being performed in conformance with WPS-345-SMAW-2G (2F)-repair and WPS-345-FCAW-2G (2F)-repair. The QA inspector noted that the contractor had not performed Magnetic Particle Testing (MT) of the excavated areas prior to welding as specified in the repair WPSs on the following repaired weld joints: FB205-051-043, FB205-049-006, FB205-050-046, FB205-052-005 and 006 in CB16.

加州检验员发现施工队烧焊人员所烧焊的 CJP 返修焊缝已经被 ZPMC UT 检验人员所拒收。QC 检验员告知 QA 检验员这些返修是按照 WPS-345-SMAW-2G (2F) 和 WPS-345-FCAW-2G (2F) 进行的。QA 检验员发现施工队没有在烧焊前凿开区域按照指定的返修 WPS 文件做 MT 探伤。这些返修焊缝是在 CB16, 焊缝编号为: FB205-051-043, FB205-049-006, FB205-050-046, FB205-052-005 和 006

Work By: 施工方: *Yonghui Yuan*
Prepared by: *Zhiwei* 4
Reviewed by QCE: *Zhao Shuang* 4
准备: 2009.11.14
质量工程师批准: 2009.11.14

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

Recommendation:
建议:

1. 加强对检验员的培训 1. Enhance QC training
2. 加强现场的检查力度 2. Enhance supervision on-site.

Prepared by: *Xu Xianping* 07/07/2011
准备: 2009.11.22
Approved by QCA: _____
质量经理批准

Reason for Nonconformance:
不符合原因:

1. 承包商在破包后清理干净, 打磨光滑, 由QC目视, 烧焊, 这是施工中的一贯做法, 没有看WPS及相关要求, 盲目施工。
1. clean the excavation and grind smoothly and view test by qc. didn't review WPS requirement carefully before fabrication

Prevention of Re-occurrence:

预防措施:

- 1. 认真阅读WPS相关要求; 1. Review WPS requirement carefully
- 2. QC监督施工队. 2. Enhance supervision work team.

Approved by/批准: Hu Jiazhai

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment

回用或返修的技术依据:

对焊缝做VT检测, 若合格, 附件, 否则返修。
Perform VT inspection to the weld. If the indication is acceptable, Use-as-is can be done, or repair it.

Reviewed/批准: Mami Li 1/20/09

Verification:

确认:

- 1. Acceptable 可接受
- Unacceptable 不可接受

Verified by QCI/质检确认:

Xu Xianping 07/20/11
2009.11.22

Reviewed by QCA/质检主任审核:

#R787-QCP-1300

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

tel/fax

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 05-Nov-2009

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

Job Name: SAS Superstructure

Document No: 05.03.06-000430

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0435

Reference Description: The contractor did not follow the approved WPS and omit MT

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Transmitted by: Bill Howe

Attachments: ZPMC-0435

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coc, 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-000462

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 06-Oct-2009

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

NCR #: ZPMC-0435

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Crossbeam CB16 Floorbeam
 Procedural Procedural Description:

Reference Description: The contractor did not follow the approved WPS and omit MT.

Description of Non-Conformance:

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Approved Repair WPS numbers; WPS-345-SMAW-2G (2F)-repair and WPS-345-FCAW-2G (2F)-repair
 "Grind all repair areas to bright metal and perform Magnetic Particle Testing prior to the start of welding".

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Yu Kum Ming

Time and method of notification: 1000 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 0800 hours, Email

QC Inspector's Name: Zheng Zhi Wei

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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Inspected By: Carreon, Albert

Lead Reviewer/Task Leader

Reviewed By: Wahbeh, Mazen

SMR



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-8940

DATE 2009.09.29

PAGE 2 OF 2

Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									a	b	c	d	Length 长度			Sound Path 声程
FB205-050-012		70				32									ACC.	100%
FB205-051-005	1	70	A	1	41	32	2	+7	20	55	20	-10	45		REJ.	100%
FB205-051-006	1	70	A	1	39	32	0	+7	20	30	8	-10	55		REJ.	100%
FB205-051-009		70				32									ACC.	100%
FB205-051-012		70				32									ACC.	100%
FB205-052-005	1	70	A	1	40	32	1	+7	40	38	12	-11	65		REJ.	100%
	2	70	A	1	39	32	1	+6	20	37	11	-12	35		REJ.	100%
	3	70	A	1	40	32	2	+6	20	45	14	-7	25		REJ.	100%
FB205-052-006	1	70	A	1	39	32	1	+6	20	40	14	-7	45		REJ.	100%
FB205-052-009		70				32									ACC.	100%
FB205-052-012		70				32									ACC.	100%

BLANK

EXAMINED BY主探

Han Ben
LEVEL - II SIGN / DATE 09.29.09

REVIEWED BY审核

Huang Ty
LEVEL - II SIGN / DATE 09.29.09

质量经理 / QCM

[Signature]
SIGN / 日期 DATE 09.30.09

用户CUSTOMER

签字 SIGN / 日期 DATE



周数 99 #
日期 2009.09.25

Visual Weld Inspection Report
焊缝目视检查报告

Girder/梁: OBG Corner Assembly
Tower/塔: NA

Caltrans Contract No. 04-0120F4
加州合同编号

Project No.: San Francisco Oakland Bay Bridge 美
项目名称 国海湾大桥

Representative: *Li Yang*
质检代表: 2009.9.27

Project No.: ZP06-787
项目编号: *shujian*

Quality Assurance Manager
~Approval
质量控制经理:

Weld No. 缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Overlap 焊瘤	Crater 弧坑	Arc strike 弧擦伤	Spatter 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 返修后接受
FB205-049-005	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-049-006	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-049-009	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-049-012	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-050-005	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-050-006	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-050-009	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-050-012	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-051-005	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-051-006	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-051-009	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-051-012	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-052-005	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-052-006	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-052-009	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA
FB205-052-012	204342	2G	Supercored71H(1.4)	√	√	√	√	√	√	√	Acc	NA	NA

After root weld
 After CWR or WRR No.:

After cover pass
 After HSR No.:

Others

"√" is no defects. "X" is defects. "NA" is not applicable.



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-8939 DATE 2009.09.29 PAGE 1 OF 2 Revision No: 0

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

ITEMS NAME: X205D FLOOR BEAM DRAWING NO.: FB204 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 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 CORNER-JOINT CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST, 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 18/25mm

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
FB204-049-037		70				32									ACC.	100%
FB204-049-040		70				32									ACC.	100%
FB204-049-043	1	70	A	1	39	32	0	+7	20	30	8	-10	50	REJ.	100%	
FB204-049-046	1	70	A	1	41	32	3	+6	20	60	19	-10	45	REJ.	100%	
FB204-050-037		70				32									ACC.	100%
FB204-050-040		70				32									ACC.	100%
FB204-050-043		70				32									ACC.	100%

EXAMINED BY 主探 *Han Ben* REVIEWED BY 审核 *Huang Jy*
 LEVEL - II SIGN / DATE *09.09.29* LEVEL - II SIGN / DATE *09.09.29*

质量经理 / QCM *[Signature]* 用户 CUSTOMER
 签字 SIGN / 日期 DATE *[Signature]* 签字 SIGN / 日期 DATE



周数 99 #
日期 2009.09.25

Visual Weld Inspection Report
焊缝目视检查报告

Girder/梁: OBG Corner Assembly
Tower/塔: NA
Representative: [Signature]
质检代表: Li Yang 07/20/11
CWI: [Signature]
检验员: [Signature]
Quality Assurance Manager: [Signature]
~Approval 质量控制经理:

Weld No. 缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Overlap 焊瘤	Crater 弧坑	Arc strike 弧擦伤	Spatter 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 返修后接受
FB204-029-037	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-029-040	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-029-043	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-029-046	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-030-037	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-030-040	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-030-043	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-030-046	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-031-037	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-031-040	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-031-043	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-031-046	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-032-037	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-032-040	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-032-043	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
FB204-032-046	215185	2G	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA

After root weld
 After CWR or WRR No. :
 After cover pass
 After HSR No. :
 Others

" / " is no defects. " X " is defects. " NA " is not applicable.

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-000441**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0435**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: 06-Oct-2009**Description of Non-Conformance:**

This Quality Assurance Inspector (QA) observed the contractor's welding personnel performing Complete Joint Penetration (CJP) weld repairs on welds that have been rejected by the contractor's Quality Control (QC) Ultrasonic Testing (UT) technicians. The contractor's QC inspector Mr. Zheng Zhi Wei informed the QA inspector that the repairs were being performed in conformance with WPS-345-SMAW-2G (2F)-repair and WPS-345-FCAW-2G (2F)-repair. The QA inspector noted that the contractor had not performed Magnetic Particle Testing (MT) of the excavated areas prior to welding as specified in the repair WPSs on the following repaired weld joints: FB205-051-043, FB205-049-006, FB205-050-046, FB205-052-005 and 006 in CB16.

Contractor's proposal to correct the problem:

Perform required NDT and increase Quality Control supervision during welding.

Corrective action taken:

Contractor submitted NDT reports verifying that the repairs are 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