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-000535
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 11-Dec-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0508

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:** Segment 5AW SP (SP469A) to SP (SP415A)
Procedural	☐	**Procedural**	☐	**Description:** Out of flatness		

Reference Description: Out of Panel Flatness found on the Side Panel of 5AW

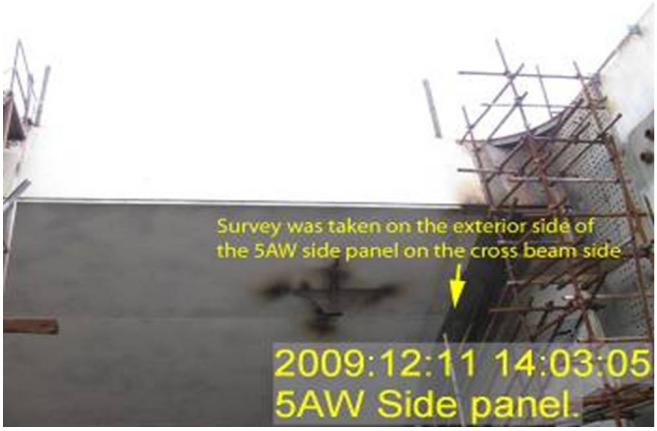
Description of Non-Conformance:

During a random visual skin flatness survey of exterior surfaces of segment 5AW located in the Trial Assembly area, the Caltrans Quality Assurance (QA) Inspector discovered the following issues:
Surface flatness surveys were taken on the exterior Side Panel (SP) surface of weld splice SEG021A-010, Cross Beam side of 5AW between PP31 to PP32. The out of flatness measurements were taken across the Side Panel in the transverse direction between the longitudinal weld splice. These measurements were out of flatness 9mm in 630mm, which exceeds the maximum 5mm out of flatness requirement per the approved State letter 05. 03.01.004667.

The weld is identified as: SEG021A-010.

The SP to SP plate numbers are: SP469A to SP415A.

The location was at the Cross Beam side of Segment 5AW.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Applicable reference:

CALTRANS Letter No. 05.03.01-004667 Subject: OBG Skin Plate Flatness

"The maximum deviation from detailed flatness for the stiffened plate would not exceed the greater of 5mm."

"The 630mm long template (straight edge) could be used to check both transversely between stiffeners, and along the length of the stiffeners to determine local deviations."

Who discovered the problem: M.Manikandan

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 1600 hour, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1700 hours, Verbal

QC Inspector's Name: Wang Lu

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:	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:**	24-Dec-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:**	05.03.06-000496
Subject:	NCR No. ZPMC-0508		

Reference Description: Out of Panel Flatness found on the Side Panel of 5AW

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:** 05

Remarks:

During a random visual skin flatness survey of exterior surfaces of segment 5AW located in the Trial Assembly area, the Caltrans Quality Assurance (QA) Inspector discovered the following issues:
Surface flatness surveys were taken on the exterior Side Panel (SP) surface of weld splice SEG021A-010, Cross Beam side of 5AW between PP31 to PP32. The out of flatness measurements were taken across the Side Panel in the transverse direction between the longitudinal weld splice. These measurements were out of flatness 9mm in 630mm, which exceeds the maximum 5mm out of flatness requirement per the approved State letter 05.03.01.004667.

The weld is identified as: SEG021A-010.

The SP to SP plate numbers are: SP469A to SP415A.

The location was at the Cross Beam side of Segment 5AW.

Action Required and/or Action Taken:

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

Transmitted by: Bill Howe
Attachments: ZPMC-0508

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

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000496

Subject: NCR No. ZPMC-0508

Dated: **08-Feb-2010**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000575 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution: Dimensional acceptance will be available at the time of shipment after all parties are in agreement. ZPMC requests that this NCR be approved with actions pending.

As these are related to the final dimensions of the sub assembly and there is potential for distortion with ongoing work in trial assembly, dimensional acceptance will be available at the time of shipment after all parties are in agreement. Until that those results are available, ZPMC requests that this NCR be approved with actions pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000575R00

Caltrans' comments:

Status: REJ

Date: 08-Feb-2010

Submit a repair procedure. This NPR is rejected.

Submitted by: Howe, Bill

Date: 08-Feb-2010

Attachment(s):

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000496

Subject: NCR No. ZPMC-0508

Dated: **10-Feb-2010**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000575 Rev: 01**

Contractor's Proposed Resolution:

Reference Resolution: To close this NCR, once the distortion documented in this non conformance is corrected and the applicable documents that verify this are submitted ZPMC will request closure.

To close this NCR, once the distortion documented in this non conformance is corrected and the applicable documents that verify this are submitted ZPMC will request closure. Until they become available ZPMC requests that this proposal be accepted with action pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000575R01

Caltrans' comments:

Status: AAP

Date: 11-Feb-2010

AAP approved.

Submitted by: Howe, Bill

Date: 12-Feb-2010

Attachment(s):

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000496

Subject: NCR No. ZPMC-0508

Dated: **01-Mar-2010**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000575 Rev: 02**

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has heat straightened the side panels noted in the NCR and has attached the heat straightening record and NDT which shows that welds were not affected by the heat straightening.

ZPMC has heat straightened the side panels noted in the NCR and has attached the heat straightening record and NDT which shows that welds were not affected by the heat straightening. The results of the heat straightening were acceptable as noted by the closing of the item on the work punchlist which is verified by Caltrans inspectors. Based on this ZPMC requests that this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000575R02;

Caltrans' comments:

Status: CLO

Date: 18-Mar-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Date: 18-Mar-2010

Attachment(s):

No. B-628

LETTER OF RESPONSE

TO: American Bridge/Flour
DATE: 2010-2-28
REGARDING: NCR-000535（ZPMC-0508）

With this letter of response, ZPMC requests closure of CT NCR-000535（ZPMC-0508）what mentioned about the flatness issue of SPs.

- ZPMC has rectified the flatness according to approved HSRs.
- After heat straightening the flatness for SPs were accepted by three parities.
- Punch List Item 342 what mentioned this issue has been confirmed and closed by CT inspector.
- The affected weld weas tested, repaired, retested and accepted after then.

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

ATTACHMENT:
NCR-000535（ZPMC-0508）
B-WR10699
B787-UT-11240 R1
B787-MT-19651

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
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Attention:	Mr. Thomas Nilsson Project/Fabrication Manager	**Document No:**	05.03.06-000496
Subject:	NCR No. ZPMC-0508		

Reference Description: Out of Panel Flatness found on the Side Panel of 5AW

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Transmitted by: Bill Howe

Attachments: ZPMC-0508

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

File: 05.03.06

Zeon PDF Driver Trial
www.zeon.com.tw

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY Arnold Schwarzenegger, Governor

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 11-Dec-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0508

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:** Segment 5AW SP (SP469A) to SP (SP415A)
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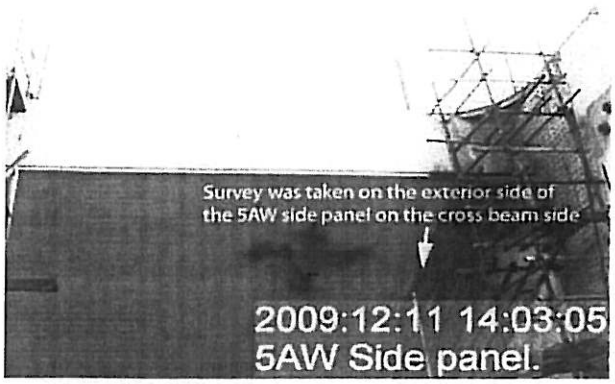

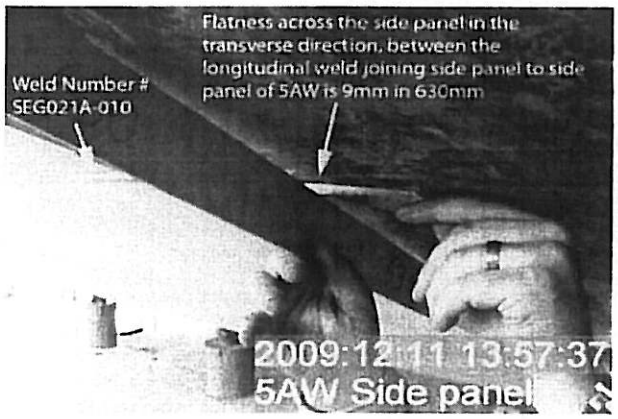

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Who discovered the problem: M.Manikandan

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 1600 hour, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1700 hours, Verbal

QC Inspector's Name: Wang Lu

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

2PMC-508 (3421)

	焊缝返修报告 Welding Repair Report				0
项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	5AW/5BW/5CW	报告编号 Report No.	B-WR10699
合同号 Contract No.	04-0120F4	部件名称 Items Name	CORNER ASSEMBLY BOTTOM PLATE AND BOX SIDE PLATE	NDT报告编号 Report No.of NDT	B787-UT-11240
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述：

Description of welding discontinuity:

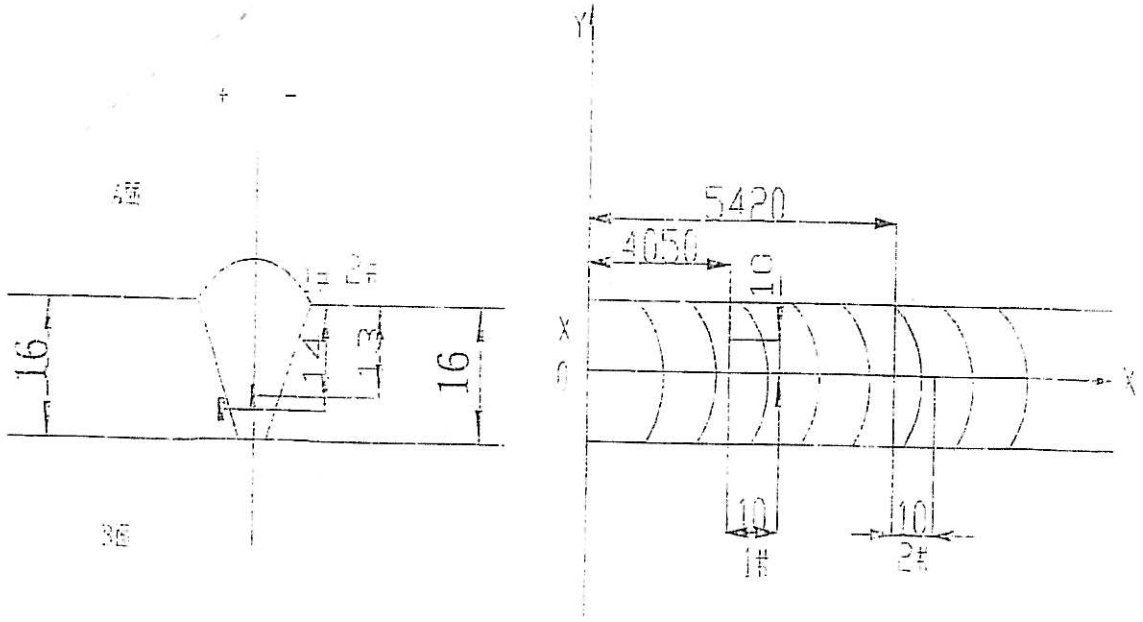
Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

(UT探伤发现的缺陷总长度小于最大允许长度。) SEG021A-010 (5AW SP(A))

检验员（Inspector）：Xue Hairong 日期(Date)：2010.02.20

焊缝返修位置示意图：

Draft of welding discontinuity:



WELD NUMBER: SEG021A-010

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): Mafuiquan 日期(Date): 10.02.20

处理意见

Disposition:

1. 从缺陷距离端面较近一侧（D≤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. 根据批准的车间图纸检查焊缝.

1. Gouge or grind from nearer side from metal edge （D≤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. Check the welds according to the working drawings.

工 艺: Technical engineer	审核: Approved by	日期 Date
Xu Donghai		10.02.20

ZPMC	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	5AW/5BW/5CW	报告编号 Report No.	B-WR10699
合同号 Contract No.:	04-0120F4	部件名称 Items Name	CORNER ASSEMBLY BOTTOM PLATE AND BOX SIDE PLATE	NDT报告编号 Report No.of NDT	B787-UT-11240
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): MaRuiquan 日期(Date): 10.02.20

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair WPS-345-FCAW-1 G(1F)-Repair-1 WPS-345-SMAW-4 G(4F)-Repair	工艺员 technologist	Xu Dongkai 10.02.20
返修（碳刨）前预热温度 Preheat temperature before gouging	N/A	返修的缺陷 Description of discontinuity	I.F
焊前处理检查 Inspection before welding	Acc	焊前预热温度 Preheat temperature before welding	85°c
最大碳刨深度 Max. depth of gouging	7mm	碳刨总长 Total length of gouging	230mm

焊工 welder 069683	焊接类型 welding type SMAW	焊接位置 position 4G
焊接电流 Current 157	焊接电压 Voltage 24	焊接速度 Speed 102

返修后检查
Inspection After repairing:

外观检查 VT result Acc	检验员 Inspector L. Kanhua 07120701	日期 Date 2010.2.21
NDT复检 NDT result Acc	探伤员 NDT person Tang Xing Shan	日期 Date 2010.02.25

见证：
Witness/Review:

备注：
Remark :

#R787-QCP-900

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号 B787-UT-11240	DATE 2010.02.20	PAGE 1 OF 1	Revision No: 0

PROJECT NO. : 工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 部件名称 CORNER BOTTOM PLATE AND BOX SIDE PLATE	DRAWING NO.: 图号 5AW/5BW/5CW	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 SAW	JOINT TYPE 焊缝类型 BUTT	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST ,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 IIW BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2/F2-X	18/16mm

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 探测面	LEG (次数)	DECIBELS分贝 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
SEG021A-001	1	70	A	1	41	32	2	+7	10	48	16	-10	1900	REJ.	100%
SEG021A-010	1	70	A	1	40	32	1	+7	10	42	14	+10	4050	REJ.	100%
	2	70	A	1	40	32	1	+7	10	39	13	0	5420	REJ.	100%
SEG023A-031	1	70	A	1	41	32	1	+8	10	38	10	0	3140	REJ.	100%
	2	70	A	1	41	32	2	+7	10	56	2	-10	9100	REJ.	100%
SEG025A-009		70				32								ACC.	100%
SEG025A-010	1	70	A	1	41	32	2	+7	10	55	4	-10	8500	REJ.	100%

AFTER HSR1(B)-348~350

EXAMINED BY主探 Tang Xingshan 20/02.20 LEVEL - II SIGN / DATE	REVIEWED BY 审核 XU Rong yang 20/02.20 LEVEL - II SIGN / DATE
质检经理 / QCM 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号	B787-UT-11240R1	DATE	2010.02.25	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS	
ITEMS NAME: 部件名称	CORNER BOTTOM PLATE AND BOX SIDE PLATE	DRAWING NO.: 图号	5AW/5BW/5CW
CALTRANS CONTRACT NO.: 04-0120F4 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	
SMAW	BUTT	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/F2-X	18/16mm

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 Indication Level a	Reference Level b	Attenuation Factor c	Indication Rating d	DISCONTINUITY 不连续性 LOCATION OF DISCONTINUITY 不连续位置(mm) Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y	Discontinuity Evaluation 缺陷估计	Remark 备注
SEG021A-001	1R1	70				32								ACC.	100%
SEG021A-010	1R1	70				32								ACC.	100%
	2R1	70				32								ACC.	100%
SEG023A-031	1R1	70				32								ACC.	100%
	2R1	70				32								ACC.	100%
SEG025A-010	1R1	70				32								ACC.	100%

AFTERB-WR10699.10700.10705.10706.

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EXAMINED BY 主探 Tang Yingshan 2010.02.25 LEVEL - II SIGN / DATE	REVIEWED BY 审核 Xu Baoyang 2010.02.25 LEVEL - II SIGN / DATE
质量经理 / QCM 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-19651	DATE日期 2010.02.25	PAGE OF页码 1/1	Revision No: 0

PROJECT NO. 工程编号:	ZP06-787	CONTRACTOR: 用 户:	CALTRANS
DRAWING NO. 图号:	5AE/5BE/5CE CORNER ASSEMBLY BOTTOM PLATE	CALTRANS CONTRACT NO.: 加州工程编号	04-0120F4
REFERENCING CODE 参考规范编码	AWS D1.5-2002	PROCEDURE NO. 程序编号	ZPQC-MT-01
ACCEPTANCE STANDARD 接受标准	AWS D1.5-2002	CALIBRATION DUE DATE 仪器校正有效期	Dec. 28ST ,2010
EQUIPMENT 设备	MT YOKE	MANUFACTURER 制造商	PARKER
MODEL NO. 样式编号	B310S	SERIAL NO. 连续编号	5395 5617 5620
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70～150mm
MATERIAL TO BE EXAMINED 检测材料	√ WELDING 焊接件 ☐ CASTING 铸件 ☐ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2/F2-X 16/18mm
WELDING PROCESS 焊接方法	SAW	TYPE OF JOINT 焊缝类型	BUTT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性 INDICATION 指示	TYPE 类型	LENGTH IN mm 长度	ACCEPT 接受	REJECT 拒收	REMARKS 备注
SEG021A-001				ACC.		100%MT
SEG021A-010				ACC.		100%MT
SEG023A-031				ACC.		100%MT
SEG025A-009				ACC.		100%MT
SEG025A-010				ACC.		100%MT
AFTER HSR(B)-349~354						
BLANK						

EXAMINED BY主探 Ding Zhong 10.02.25 LEVEL - II SIGN 签名 / DATE日期	REVIEWED BY 审核 10.02.25 LEVEL-II SIGN / DATE日期
质量经理 / QCM 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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 #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCS-000522
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 11-Mar-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0508

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:**
Procedural	☐	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 11-Dec-2009

Description of Non-Conformance:

During a random visual skin flatness survey of exterior surfaces of segment 5AW located in the Trial Assembly area, the Caltrans Quality Assurance (QA) Inspector discovered the following issues:
Surface flatness surveys were taken on the exterior Side Panel (SP) surface of weld splice SEG021A-010, Cross Beam side of 5AW between PP31 to PP32. The out of flatness measurements were taken across the Side Panel in the transverse direction between the longitudinal weld splice. These measurements were out of flatness 9mm in 630mm, which exceeds the maximum 5mm out of flatness requirement per the approved State letter 05. 03.01.004667.

The weld is identified as: SEG021A-010.

The SP to SP plate numbers are: SP469A to SP415A.

The location was at the Cross Beam side of Segment 5AW.

Contractor's proposal to correct the problem:

Perform Heat Straightening at said location along with required NDT to verify weld quality.

Corrective action taken:

Out of tolerance was corrected in accordance with approved HSR and repairs were performed on defective welds. Contractor has submitted NDT reports to verify welds 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 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