

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-000594**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0567**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Crossbeam CB16 DP to SP
Procedural	Procedural	Description: Missed UT indication by QC	

Reference Description: Missed UT Indication by QC in Crossbeam 16 Deck Plate to Side Plate Joint**Description of Non-Conformance:**

During random 10% verification Ultrasonic Testing (UT) of OBG Crossbeam 16, this Quality Assurance Inspector (QA) discovered the following issue:

One (1) Class "A" non conforming longitudinal indication measuring approximately 30 mm in length.

-The weld is a complete joint penetration (CJP) corner joint, joining Side Plate SP203A to Deck Plate DP204A and is identified as CB202A-016-002.

-The discontinuity rating is +3, Class "A" reject

-Depth of the discontinuity from face A is approximately 13 mm, and Y location was 1920mm when measured from the north end of the crossbeam.

-The Material thickness is 18 mm.

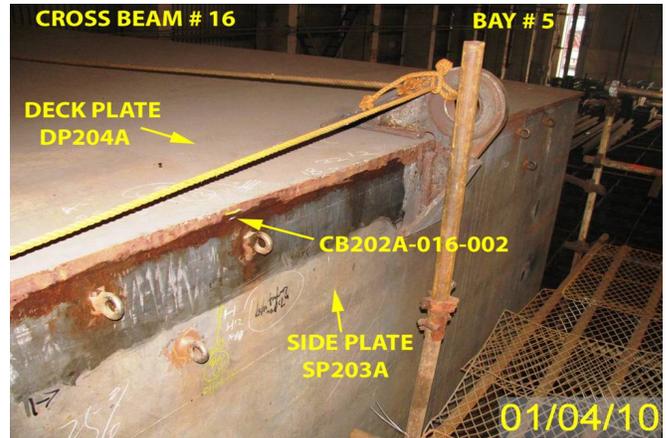
-The member is located in fabrication Bay 5.

-The indication is in an area previously tested and accepted by ZPMC QC UT technicians.

-The Notice of Witness Inspection Number (NWIT) is 004990.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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."

AWS D1.5 Section 6.26.3.1; "Welds that are subject to UT in addition to visual inspection shall be acceptable if they meet the following requirements:...(1) Welds subject to tensile stress under any condition of loading shall conform to the requirements of Table 6.3...(2) Welds subject to compressive stress shall conform to the requirements of Table 6.4."

AWS D1.5-02 Section 6; Table 6.3

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Wang Wen Bin

Time and method of notification: 1600 hours, 01/04/10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1830 hours, 01/04/10, E-mail

QC Inspector's Name: Zhong Chong Biao

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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

SMR

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-Jan-2010
Dear:	Mr. Charles Kanapicki	Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Attention:	Mr. Thomas Nilsson Project/Fabrication Manager	Job Name:	SAS Superstructure
Subject:	NCR No. ZPMC-0567	Document No:	05.03.06-000556

Reference Description: Missed UT Indication by QC in Crossbeam 16 Deck Plate to Side Plate Joint

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:

During random 10% verification Ultrasonic Testing (UT) of OBG Crossbeam 16, this Quality Assurance Inspector (QA) discovered the following issue:

One (1) Class "A" non conforming longitudinal indication measuring approximately 30 mm in length.

- The weld is a complete joint penetration (CJP) corner joint, joining Side Plate SP203A to Deck Plate DP204A and is identified as CB202A-016-002.
- The discontinuity rating is +3, Class "A" reject
- Depth of the discontinuity from face A is approximately 13 mm, and Y location was 1920mm when measured from the north end of the crossbeam.
- The Material thickness is 18 mm.
- The member is located in fabrication Bay 5.
- The indication is in an area previously tested and accepted by ZPMC QC UT technicians.
- The Notice of Witness Inspection Number (NWIT) is 004990.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide training required to enable the ZPMC UT technician to find these types of indications in the future. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer
Attachments: ZPMC-0567

NCT

(*Continued Page 2 of 2*)

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000556

Subject: NCR No. ZPMC-0567

Dated: 18-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000524 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: As a means of preventing future occurrences, the ABF QCM has performed refresher UT training. See attached UT training agenda and attendance roster.

As it is necessary to respond to the NCR with a proposed plan of action, ABF is doing so without all of the repair documentation at this time. As a means of preventing future occurrences, the ABF QCM has performed refresher UT training. See attached UT training agenda and attendance roster. The ABF QCM has been discussing missed UT indications with the ZPMC QCM and related NDT supervisory personnel. The ZPMC level III is in the process of assessing personnel, techniques and equipment. ABF has purchased GE Technology transducers to distribute to both ZPMC and ABF UT personnel in a cooperative effort to match the equipment of CT. These transducers will arrive to the job site approximately the end of January 10 at which time they will be put into immediate use. ZPMC requests this NCR be placed in the Approved Action Pending status category until such time that all the repair documents have been assembled and submitted.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000524R00;

Caltrans' comments:

Status: AAP

Date: 25-Jan-2010

The preventative measures taken by the QCM and the proposed resolution for closing NCR submitted by the contractor are acceptable. The NCR will be closed upon completion of the repair and review of the repair documents by the Engineer when submitted by the contractor.

Submitted by: Chao, Ching

Attachment(s):

Date: 25-Jan-2010

UT Refresher Training Agenda

Subject: UT Techniques

Reason for Training: Several CT NCR's for missed UT indications

1. Safety

- a. Safety Glasses
- b. Gloves (if required)
- c. Knee Pads
- d. Electrical Shock

2. Tools

- a. Calibrated UT Machine condition of machine
- b. Coaxial cable condition of cable
- c. Transducer condition of transducer
- d. IIW Block
- e. Scraper
- f. UT couplant

3. Inspection Techniques

- a. Surface preparation
- b. Location of weld UT from beveled plate
- c. Scanning patterns
- d. Correct choice of Angles
- e. Calibration per ZPMC procedure at regular intervals
- f. Scanning speed
- g. Know where your sound is at.... First leg, second leg etc...

4. Inspection Criteria

- a. Table 6.3 or Table 6.4
- b. Are surface inspections complete VT and or MT should always occur before UT
- c. Scanning Levels
- d. Criteria dictated by the thinner of the two members
- e. Planar flaws



教育培训纪录

培训编号:

培训内容:	UT复习培训教程 UT Techniques
培训对象:	ZPMC UT GUYS
授课人员:	STEVE LAWTON
培训类型:	UT Refresher Training Agenda
培训时间:	2009. 12. 24. 16:30
计划培训地点:	ZPMC NDT OFFICE

人员签到:

姓名	部门	姓名	部门
戴斌 Dai Goud Shen	江江 Jiang Jun		
薛宇 Xuellamang	黄廷 Huang Ting		
马志长 Majzhang	黄廷 Huang Ting		
谭善 Tanxingshan	李黎明 Li Liming		
马强 Ma Jiana	李黎明 Li Liming		
王福 Wangfu	徐军 Xu Jun		
沈健 Sheng Jian	李黎明 Li Liming		
黄宇 Huang Jiaoy			
金峰 Jin Feng			
吴文 Wu Chen			
解建 Xie Jian			
周海周 Zhou Haijun			
徐峰 Xu Feng			

NCR PROPOSED RESOLUTION

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

Dated: 12-Feb-2010

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Ref: 05.03.06-000556

Document No.: ABF-NPR-000524 **Rev:** 01

Subject: NCR No. ZPMC-0567

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has issued an internal NCR for this incident and where necessary issued a WRR or CWR and performed NDT to show the weld is acceptable. Enclosed are all documents.

ZPMC has issued an internal NCR for this incident and where necessary issued a WRR or CWR and performed NDT to show the weld is acceptable. Enclosed are all documents, based on this ZPMC request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000524R01;

Caltrans' comments:

Status: CLO

Date: 15-Feb-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Date: 15-Feb-2010

Attachment(s):



No. B-610

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-2-11

REGARDING:

NCR-000583,594,602,603,625,626,627,628,644,651(ZPMC-0556,567,575,576,598,599,600,601,615,622)

With this letter of response, ZPMC requests closure of CT NCR-000583, 594, 602, 603, 625, 626, 627, 628, 644, 651 (ZPMC - 0556, 567, 575, 576, 599, 601, 615, 622), what mentioned that CT Inspector observed missed MT/UT indications by ZPMC QC.

- ZPMC acknowledged these issues and has issued internal NCRs.
- The missed indications were confirmed by ZPMC and related WRRs/CWRs were issued reflecting these rejections.
- After repair, NDTs were performed to warrant the welds' quality.
- Refresh training has been performed by ABF QCM, to improve QC's technique.

Based on the taken action and attached documentations, ZPMC requests withdrawal of these NCRs.

ATTACHMENT:

NCR-000583, 594, 602, 603, 625, 626, 627, 628, 644, 651 (ZPMC - 0556, 567, 575, 576, 599, 615, 622)

NCR-B-396, 401, 394, 393, 408, 429, 426

B-CWR1029, 1043, 1044, 1106, 1167, 1151

B-WR10060,

B787-MT-17496R1, 17605R1, 17606R1, 17999R1, 17997R1, 17930R1

B787-UT-10854R1,

[Handwritten signature]
2/11/10

WR1029



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-396(ZPMC-0556)
Item: Missed MT indication 名称描述: MT 漏检	Item Number: 件号: Bike Path	Drawing: 图号:
Location: Bay 5 位置: 5 车间	Date: 日期: 2010-01-18	

Description of Nonconformance:

During Magnetic Particle Testing (MT) review of welds on Bike Path Cantilever Beams, this Quality Assurance Inspector (QA) discovered the following issues:

One (1) transverse linear indication measuring approximately 8mm in length.
The member is identified as Bike Path Cantilever Beam BK001-032.
The weld is identified as BK001-032-008.
The weld is a Partial Joint Penetration (PJP) T-joint joining the Web Plate (BKX4A) to the Diaphragm Flange Plate (BKX3C).
The member is non-Seismic Performance critical Member (SPCM).
The member is located in OBG Bay 5.
The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% MT inspection of this weld.

在随机对自行车悬臂梁进行 MT 检验时, 加州检验员发现以下问题:
一条横向线性缺陷长度将近 8Mm。
该构件号是: BK001-032. 焊缝是: BK001-032-008。
该焊缝是 PJP 焊缝与 BKX4A 和 BKX3C 连接。该构件不是 SPCM。
该缺陷之前已经被 ZPMC MT 人员所检验并接受。

Work By: <i>Li Hong</i> 施工方: 2010.02.02	Prepared by: <i>Zhang Wei</i> 准备: 2010.1.18	Reviewed by QCE: <i>Li Jiahua</i> 质量工程师批准: 11/19/10
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: Use as is Repair Reject
处理措施: 回用 返修 拒收

Recommendation:
建议: *现场确认出具报告送修*

Prepared by: *Li Hong* Approved by QCA: _____
准备: 2010.02.02 质量经理批准

Reason for Nonconformance:
不符合原因: *线性缺陷未超规格*

Prevention of Re-occurrence:

预防措施:

及时检测 报险 加修 复检

Approved by/批准:

2010.02.02
[Signature]

Technical Justification for Use-As-Is/Repair:

回用或返修的技术依据:

Attachment

附件

Non-attachment

无附件

Reviewed /批准:

Verification:

确认:

Acceptable

可接受

Unacceptable

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
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: 03-Jan-2010

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: 05.03.06-000546

Subject: NCR No. ZPMC-0556

Reference Description: Missed MT transverse indication by QC for Bike Path Cantilever Beam BK001-032

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: Bike Path

Lift: N/A

Remarks:

During Magnetic Particle Testing (MT) review of welds on Bike Path Cantilever Beams, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse linear indication measuring approximately 8mm in length.
 - The member is identified as Bike Path Cantilever Beam BK001-032.
 - The weld is identified as BK001-032-008.
 - The weld is a Partial Joint Penetration (PIP) T-joint joining the Web Plate (BKX4A) to the Diaphragm Flange Plate (BKX3C).
 - The member is Non-Seismic Performance critical Member (SPCM).
 - The member is located in OBG Bay 5.
- The Notice of Witness Inspection Number (NWIT) is 004981. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% MT inspection of this weld.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide training and equipment as required to the ZPMC MT technician to ensure these types of indications are identified in the future. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0556

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. 15D
 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-000583

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 02-Jan-2010

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

NCR #: ZPMC-0556

Type of problem:

Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: OBG Bike Path Cantilever Beam BK001-032Procedural Procedural Description: Missed MT transverse indication by QC

Reference Description: Missed MT transverse indication by QC for Bike Path Cantilever Beam BK001-032

Description of Non-Conformance:

During Magnetic Particle Testing (MT) review of welds on Bike Path Cantilever Beams, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse linear indication measuring approximately 8mm in length.
- The member is identified as Bike Path Cantilever Beam BK001-032.
- The weld is identified as BK001-032-008.
- The weld is a Partial Joint Penetration (PJP) T-joint joining the Web Plate (BKX4A) to the Diaphragm Flange Plate (BKX3C).
- The member is Non-Seismic Performance critical Member (SPCM).
- The member is located in OBG Bay 5.

The Notice of Witness Inspection Number (NWIT) is 004981. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% MT inspection of this weld.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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."

AWS D1.5 (02) Section 6.26.2 – "Welds that are subject to MT in addition to visual inspection shall have no cracks.

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Wang Wen Bin

Time and method of notification: 1500 hours, 01/02/10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1000 hours, 01/03/10, Email

QC Inspector's Name: Zhong Chong Biao

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, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



关键焊缝返修报告

Critical Welding Repair Report (CWR)

版本
Rev. No.

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	BK1	报告编号 Report No.:	B-CWR102
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	DBG CANTILEVER BOX BRACKET	NDT 报告编号 NDT Report No.:	B787-MT-174
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对BK001-032-008检测时, 发现1处横向裂纹, L1=5mm

Welder ID No. (焊工编号): 217805

Position: (位置): 3G

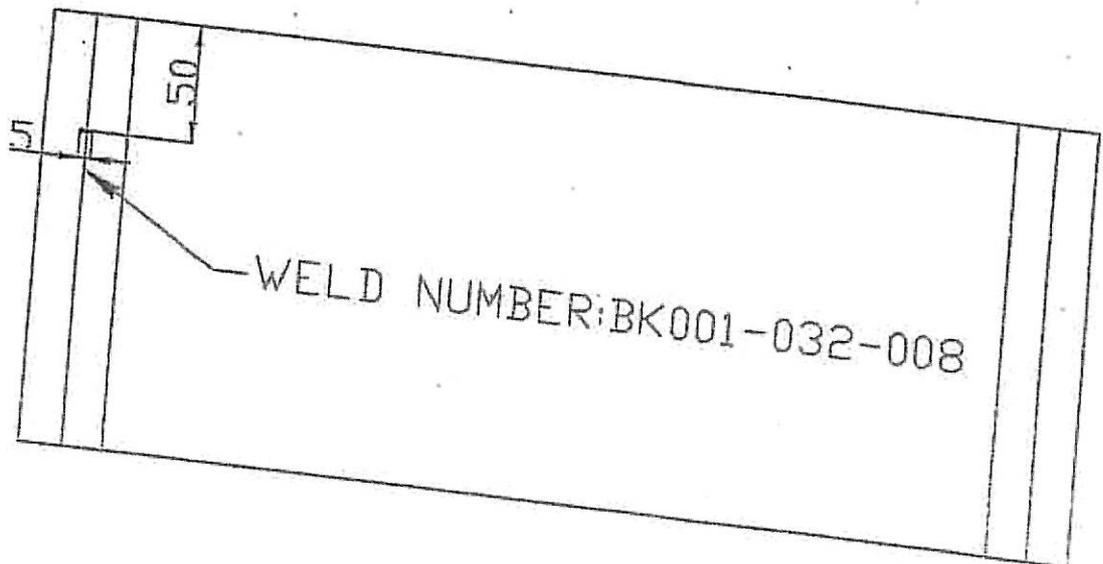
One transverse crack was found by use of MT on BK001-032-008.

检验员 (Inspector): Chang Fangle

日期 (Date): 2010-01-03

焊缝返修位置示意图:

Draft of Welding Discontinuity:



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REPRODUCTION IS STRICTLY PROHIBITED

产生原因:

Cause:

1. 火焰加热时, 水汽没有完全的去除或者这个区域预热不够;
1. Moisture wasn't completely removed during drying operation (preheating) or the area wasn't preheated sufficiently.

车间负责人 (Foreman): *Yu Zhay*

日期 (Date): *10.01.04*

处理意见

Disposition:

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
3. 去除热影响区域上在各个方向上不小于25mm范围内的油漆;
4. 将杂物以及MT检测遗留的残留物清理干净。然后采用打磨的方法去除裂纹, 打磨前预热至65° C。对于单个裂纹返修, 打磨返修范围为沿缺陷焊缝每一端加50mm;
5. 如果打磨时母材损伤, 则在返修前将损伤区域打磨干净; 如果打磨时或打磨后根部间隙大于5mm, 则在继续返修前另需递交文件给工程师予以审核批准, 并按照被批准的方法将角焊缝改成CJP焊缝;
6. 焊接前按照新的焊接返修工艺准备各焊缝接头形式;
7. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在, 同时靠近裂纹的母材也要做MT, 保证没有裂纹延伸到母材。如果在母材上发现裂纹, 则另外需CWR, 且只有当这份另出的CWR批准后才能继续返修;
8. 将杂物以及MT检测遗留的残留物清理干净。按照WPS进行预热和焊接, 预热温度为160° C-230° C;
9. 焊接后WPS要求进行后热, 后热温度为230° C-315° C, 后热时间至少1个小时;
10. 后热后将焊缝逐渐冷却到周围环境温度, 并控制冷却速率不超过50° C每小时;
11. 后热后将修补区域打磨与母材或相邻焊缝平齐;
12. 在焊缝冷却至环境温度至少经过48小时以后进行NDT检查;
13. 返修后根据图纸进行MT检测, 并按照合同10-1.59 "钢结构" 中的 "检测和试验" 要求进行附加MT检测。对于CJP焊缝, NDT为VT, MT和UT.

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial *CHW* Date: *1/5/2010*

1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements
2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
3. Remove paint ≥ 25 mm in all direction of HAZ prior to MT.
4. Clean the excavation area of all loose debris including MT powder. Preheat to 65° C before removing cracks by grinding, repair area shall extend a minimum of 50mm beyond each end of single crack repairs.
5. If base metal is damaged by grinding, the damaged area shall be ground clean prior to performing weld repair. If gap > 5 mm is found during or after grinding, comply with the notification on changing fillet weld to CJP which is submitted for Engineer's review and approval form.
6. Prepare excavation in accordance with the New Repair Procedure prior to welding.
7. Before this repair, Verify with VT and MT repair areas are defects free, and also MT shall be performed on the base metal laying abroad cracks to ensure that no cracks were propagated to the base metal. Separate CWR approval is needed if cracks are found in the base metal, and only after this new CWR's approval can continue the repair.
8. Clean excavation area of all loose debris including MT powder after excavation. Preheat and weld according to repair WPS, the preheat shall between 160° C-230° C.
9. Perform post weld heating according to repair WPS, the postheat shall between 230° C-315° C and for one hour minimum.
10. Allow the weld to cool to ambient temperature gradually. Control cooling rate after PWHT to no more than 50° C per hour.
11. Grind the repaired area flush with base metal or the adjacent weld after post weld heating.
12. Wait 48 hours at least after the repair area has cooled to ambient temperature before performing NDT.
13. Perform MT inspection to all repair area according to Contract Drawings along with all additional NDT required by the applicable noise Special Provision Section 10-1.59 "Steel Structure", subsection "Inspection testing". NDT include VT, MT and UT if it is a CJP weld.



关键焊缝返修报告

Critical Welding Repair Report (CWR)

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	BK1	报告编号 Report No.:	B-CWR1029
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG CANTILEVER BOX BRACKET	NDT 报告编号 NDT Report No.:	B787-MT-17496
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

1. 返修前, QC确认有效的预热, 以将水汽全部去除。

1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.

车间负责人 (Foreman):

Hu Yuzhang

日期 (Date):

10.01.04

参照的 WPS 编号 Repair WPS No.:	WPS-345-SMAW-3G(3F)-Repair	工艺员 Technologist:	Xu Donghai 10.01.04
返修 (碳刨) 前预热温度 Preheat Temperature Before Gouging:	NA	返修的缺陷 Description of Discontinuity:	crack
焊前处理检查 Inspection Before Welding:	Acc	焊前预热温度 Preheat Temperature Before Welding:	171
最大碳刨深度 Max. Depth of Gouge:	NA	碳刨总长 Total Length of Gouge:	NA
焊工 Welder:	215083	焊接类型 Welding Type:	SMAW
焊接电流 Current:	111	焊接电压 Voltage:	23
		焊接位置 Position:	3G
		焊接速度 Speed:	113

返修后检查
Inspection After Repair:

外观检查 VT Result:	Acc	检验员 Inspector:	F.W. Lin. 08126531	日期 Date:	10.01.08
NDT 复检 NDT Result:	Acc	探伤员 NDT Person:	Jim Jian tgy	日期 Date:	1/8

见证:
Witness/Review:备注:
Remark:The document is APPROVED
STATE DEPARTMENT OF TRANSPORTATION
OFFICE OF THE CHIEF ENGINEER
OFFICE OF THE CHIEF INSPECTOR
OFFICE OF THE CHIEF DESIGNER
OFFICE OF THE CHIEF ESTIMATOR
OFFICE OF THE CHIEF MATERIALS ENGINEER
OFFICE OF THE CHIEF SAFETY ENGINEER
OFFICE OF THE CHIEF TRAINING ENGINEER
OFFICE OF THE CHIEF WELDING ENGINEER
OFFICE OF THE CHIEF INSPECTION ENGINEER
OFFICE OF THE CHIEF QUALITY ENGINEER
OFFICE OF THE CHIEF RECORDS ENGINEER
OFFICE OF THE CHIEF SECURITY ENGINEER
OFFICE OF THE CHIEF SYSTEMS ENGINEER
OFFICE OF THE CHIEF TECHNOLOGY ENGINEER
OFFICE OF THE CHIEF TRAINING ENGINEER
OFFICE OF THE CHIEF WELDING ENGINEER
OFFICE OF THE CHIEF INSPECTION ENGINEER
OFFICE OF THE CHIEF QUALITY ENGINEER
OFFICE OF THE CHIEF RECORDS ENGINEER
OFFICE OF THE CHIEF SECURITY ENGINEER
OFFICE OF THE CHIEF SYSTEMS ENGINEER
OFFICE OF THE CHIEF TECHNOLOGY ENGINEER

#R787-30P-000



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-17496R1

DATE日期 2010.01.08

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: BK1
OBG CANTILEVER BOX BRACKET

CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4

REFERENCING CODE 参考规范编码
AWS D1.5-2002

ACCEPTANCE STANDARD 接受标准
AWS D1.5-2002

PROCEDURE NO. 程序编号
ZPQC-MT-01

CALIBRATION DUE DATE 仪器校正有效期
Dec. 28th, 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-X

WELDING PROCESS 焊接方法
SMAW

TYPE OF JOINT 焊缝类型
CORNER JOINT

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

BK001-032-008

1R1

ACC.

100%MT

AFTER B-CWR1029

BLANK

EXAMINED BY 主操

Jin Jianting Jin Jianting

LEVEL - II SIGN 签名 / DATE日期 2010.01.08

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核

Sun Gongchang

LEVEL-II SIGN 1 / DATE日期 2010.01.08

用户 CUSTOMER

签字 SIGN / 日期 DATE

WR10060



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-401(ZPMC-0567)
Item: Missed MT indication 名称描述: MT 漏检	Item Number: 件号:	Drawing: 图号:
Location: BAY 14 位置: 14 车间	Date: 日期: 2010-01-19	

Description of Nonconformance:

During random 10% verification Ultrasonic Testing (UT) of OBG Crossbeam 16, this Quality Assurance Inspector (QA) discovered the following issue:

One (1) Class "A" non conforming longitudinal indication measuring approximately 30mm in length.

The weld is a complete joint penetration (CJP) corner joint, joining Side Plate SP203A to Deck Plate DP204A and is identified as CB202A-016-002.

The discontinuity rating is +3, Class "A" reject

Depth of the discontinuity from face A is approximately 13mm, and Y location was 1920mm when measured from the north end of the crossbeam.

The Material thickness is 18mm.

The member is located in fabrication Bay 5.

The indication is an area previously tested and accepted by ZPMC QC UT technicians.

在对 OBG CB16 进行随机 UT 检验时, 加州检验员发现以下问题:

— "A" 级不符合的纵向缺陷长度将近 30mm。该焊缝是一完成的 PJP 焊缝, 连接 SP203A 至 DP204A, 编号是 CB202A-016-002。

DB 值是+3, "A" 级拒收。A 面部连续长度将近 13mm, 从联系梁北端头测量 Y 值是 1920mm。材质厚度是 18mm。该构件在 5 车间里, 该缺陷所处位置之前已经被 ZPMC QC UT 人员所检查并接受。

Work By: <u>Li Bin</u>	Prepared by: <u>Zhang Wei</u>	Reviewed by QCE: <u>Liu Jianshu</u>
施工方: <u>2010.01.19</u>	准备: <u>2010.1.19</u>	质量工程师批准: <u>11/19/10</u>
<input type="checkbox"/> Drawing Error	<input type="checkbox"/> Material Defect	<input type="checkbox"/> Fabrication Error
图纸错误	材料缺陷	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:

现场确认后出具具体报告通知

Prepared by: <u>Li Bin</u>	Approved by QCA: _____
准备: <u>2010.01.19</u>	质量经理批准

Reason for Nonconformance:

不符合原因:

该处缺陷未被检测到

Prevention of Re-occurrence:

预防措施:

加强复检并及时检验报验.

Approved by/批准:

Li Hui 20/01/20

Technical Justification for Use-As-Is/Repair:

回用或返修的技术依据:

Attachment

附件

Non-attachment

无附件

Reviewed /批准: _____

Verification:

确认:

Acceptable

可接受

Unacceptable

不可接受

Verified by QCI/质检确认: _____

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:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 05-Jan-2010

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

Dear: Mr. Charles Kannpicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0567

Job Name: SAS Superstructure
Document No: 05.03.06-000556

Reference Description: Missed UT Indication by QC in Crossbeam 16 Deck Plate to Side Plate Joint

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:

During random 10% verification Ultrasonic Testing (UT) of OBG Crossbeam 16, this Quality Assurance Inspector (QA) discovered the following issue:

One (1) Class "A" non conforming longitudinal indication measuring approximately 30 mm in length.

-The weld is a complete joint penetration (CJP) corner joint, joining Side Plate SP203A to Deck Plate DP204A and is identified as CB202A-016-002.

-The discontinuity rating is +3, Class "A" reject

-Depth of the discontinuity from face A is approximately 13 mm, and Y location was 1920mm when measured from the north end of the crossbeam.

-The Material thickness is 18 mm.

-The member is located in fabrication Bay 5.

-The indication is in an area previously tested and accepted by ZPMC QC UT technicians.

-The Notice of Witness Inspection Number (NWIT) is 004990.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide training required to enable the ZPMC UT technician to find these types of indications in the future. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer
Attachments: ZPMC-0567

NCT

(Continued Page 2 of 2)

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 #: 04-0120F4City: 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-000594

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Jan-2010

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

NCR #: ZPMC-0567

Type of problem:

Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Crossbeam CB16 DP to SPProcedural Procedural Description: Missed UT indication by QC

Reference Description: Missed UT Indication by QC in Crossbeam 16 Deck Plate to Side Plate Joint

Description of Non-Conformance:

During random 10% verification Ultrasonic Testing (UT) of OBG Crossbeam 16, this Quality Assurance Inspector (QA) discovered the following issue:

One (1) Class "A" non conforming longitudinal indication measuring approximately 30 mm in length.

-The weld is a complete joint penetration (CJP) corner joint, joining Side Plate SP203A to Deck Plate DP204A and is identified as CB202A-016-002.

-The discontinuity rating is +3, Class "A" reject

-Depth of the discontinuity from face A is approximately 13 mm, and Y location was 1920mm when measured from the north end of the crossbeam.

-The Material thickness is 18 mm.

-The member is located in fabrication Bay 5.

-The indication is in an area previously tested and accepted by ZPMC QC UT technicians.

-The Notice of Witness Inspection Number (NWIT) is 004990.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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."

AWS D1.5 Section 6.26.3.1; "Welds that are subject to UT in addition to visual inspection shall be acceptable if they meet the following requirements:...(1) Welds subject to tensile stress under any condition of loading shall conform to the requirements of Table 6.3...(2) Welds subject to compressive stress shall conform to the requirements of Table 6.4."

AWS D1.5-02 Section 6; Table 6.3

Who discovered the problem: Naddi Sandeep Kumar
Name of individual from Contractor notified: Wang Wen Bin
Time and method of notification: 1600 hours, 01/04/10, Verbal
Name of Caltrans Engineer notified: Bill Howe
Time and method of notification: 1830 hours, 01/04/10, E-mail
QC Inspector's Name: Zhong Chong Biao
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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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

SMR
SMR



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	CB202A	报告编号 Report No.	B-WR10060
合同号 Contract No.	04-0120F4	部件名称 Items Name	CB16 STRUT	NDT报告编号 Report No. of NDT	B787-UT-10854
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

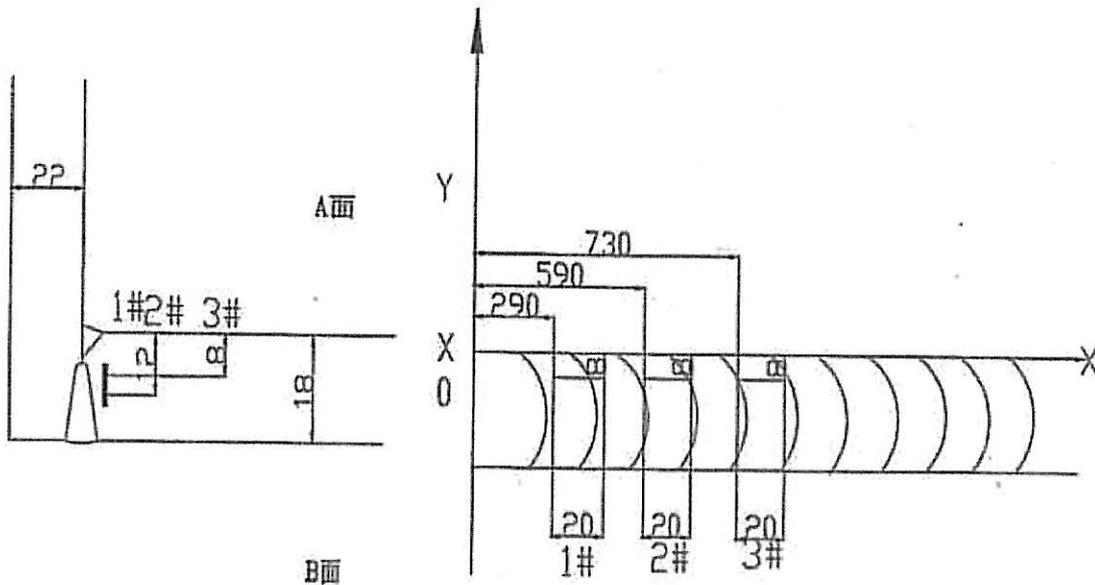
Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

(UT探伤发现的缺陷总长度小于最大允许长度。) CB202A-016-002

检验员 (Inspector): Han Feng 日期(Date): 2010.01.18

焊缝返修位置示意图:

Draft of welding discontinuity:



WELD NUMBER: CB202A-016-002

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): *Zhang Jiuming* 日期(Date): 1.19

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) 采用碳锉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 ($D \leq 0.65T$, "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. Check the welds according to the working drawings;

工艺: *Jin Dong Kari*
Technical engineer
1.19

审核: *[Signature]*
Approved by

日期: 1/21/16
Date



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	CB202A	报告编号 Report No.	B-WR10060
合同号 Contract No.:	04-0120F4	部件名称 Items Name	CB16 STRUT	NDT报告编号 Report No. of NDT	B787-UT-10854
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): *Zhang Guimin* 日期(Date): 1.19

参照的WPS编号 Repair WPS No.:	WPS-345-SMAW-2 G(2F)-Repair WPS-345-SMAW-4 G(4F)-Repair WPS-345-SMAW-2 G(2F)-FCM-Repair WPS-345-SMAW-4 G(4F)-FCM-Repair	工艺员 technologist	<i>Xu Peng kuan</i> 1.19
返修(碳刨)前预热温度 Preheat temperature before gouging	70°C	返修的缺陷 Description of discontinuity	NA
焊前处理检查 Inspection before welding	ACC	焊前预热温度 Preheat temperature before welding	172°C
最大碳刨深度 Max. depth of gouging	Ø mm	碳刨总长 Total length of gouging	60 mm
焊工 welder	215248	焊接类型 welding type	SMAW
焊接电流 Current	160	焊接电压 Voltage	23.5
		焊接位置 position	2G
		焊接速度 Speed	112
返修后检查 Inspection After repairing:			
外观检查 VT result	Acc	检验员 Inspector	F.W. Lin. 08176531
		日期 Date	2010.01.21
NDT复检 NDT result	Acc	探伤员 NDT person	<i>Wu</i>
		日期 Date	2010.1.21
见证: Witness/Review:			
备注: Remark:			



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-394(ZPMC-0575)
Item: Missed MT indication 名称描述: MT 漏检	Item Number: 件号: 7DW	Drawing: 图号:
Location: Outside yard 位置: 外场		Date: 日期: 2010-01-18

Description of Nonconformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector (QA) discovered the following issues:

One (1) Longitudinal linear indication measuring approximately 20mm in length.
The welds are identified as: SSD10-PP56-108,109.
These welds are a Fillet Weld type joining the Bottom Plate (BP92A) to Floor Beam (FB5B) web plate.

These welds are designated as Seismic Performance Critical Member (SPCM) on the approved drawing (SEGSD10)

The OBG segment 7DW is located outside in the Trial Assembly area.

The Notice of Witness Inspection Number (NWIT) is 004993. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.

在对 7DW 进行 MT 随机检验时, 加州检验员发现以下问题:
一条纵向线性缺陷长度将近 20mm。
该焊缝是: SSD10-PP56-108,109
这条焊缝是角焊缝连接底板 (BP92A) 至隔板 (FB5B) 腹板。
这些焊缝被认为是在 SPCM 板上。
预约单编号是 004993. 这些缺陷之前已经被 ZPMC MT 人员所检验并接收。

Work By: <u>Li Liang</u> 施工方: <u>2010.01.28</u>	Prepared by: <u>Zhang Wei</u> 准备: <u>2010.1.18</u>	Reviewed by QCE: <u>Lu Jia</u> 质量工程师批准: <u>1/19/10</u>
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: <input type="checkbox"/> Use as is 处理措施: 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
---	---------------------------------------	---------------------------------------

Recommendation:
建议: 现场确认该问题报告是否

Prepared by: <u>Li Liang</u> 准备: <u>2010.01.28</u>	Approved by QCA: _____ 质量经理批准
---	----------------------------------

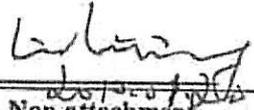
Reason for Nonconformance:
不符合原因: 该焊缝缺陷未被检测到

Prevention of Re-occurrence:

预防措施:

及时检测 报险加强复检.

Approved by/批准:



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: _____

#R787-QCP-1300



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: 06-Jan-2010
Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0575

Job Name: SAS Superstructure
Document No: 05.03.06-000565

Reference Description: Missed MT Indication by QC on 7DW on FB to BP joint

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: 07

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Longitudinal linear indication measuring approximately 20mm in length.
- The welds are identified as: SSD10-PP56-108, 109.
- These welds are a Fillet Weld type joining the Bottom Plate (BP92A) to Floor Beam (FB5B) web plate.
- These welds are designated as Seismic Performance Critical Member (SPCM) on the approved drawing (SEGSD10).
- The OBG segment 7DW is located outside in the Trial Assembly area.

The Notice of Witness Inspection Number (NWIT) is 004993. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide the training and equipment required for the ZPMC MT technician such that these indications are found. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0575

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) 649-5483

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-000602

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 05-Jan-2010

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

NCR #: ZPMC-0575

Type of problem:

Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: OBG Segment 7DW FB to BP
Procedural Procedural Description: Missed MT indication by QC

Reference Description: Missed MT Indication by QC on 7DW on FB to BP joint

Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector (QA) discovered the following issues:

-One (1) Longitudinal linear indication measuring approximately 20mm in length.

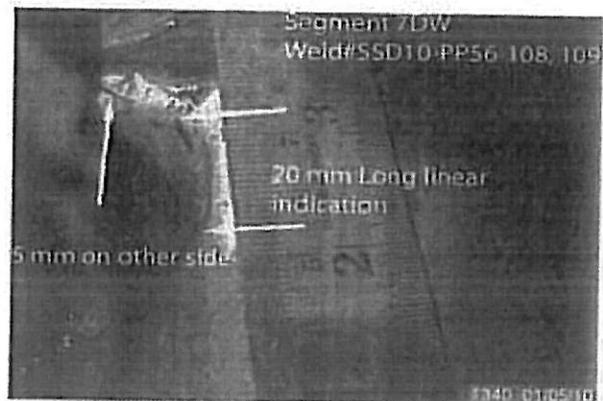
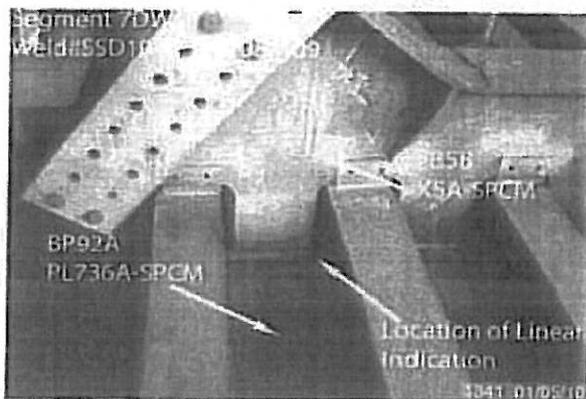
-The welds are identified as: SSD10-PP56-108, 109.

-These welds are a Fillet Weld type joining the Bottom Plate (BP92A) to Floor Beam (FB5B) web plate.

-These welds are designated as Seismic Performance Critical Member (SPCM) on the approved drawing (SEGSD10).

-The OBG segment 7DW is located outside in the Trial Assembly area.

The Notice of Witness Inspection Number (NWIT) is 004993. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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."

AWS D1.5 (02) Section 6.26.2 – "Welds that are subject to MT in addition to visual inspection shall have no cracks."

Approved Drawing: SEGSD10 (SPCM Welds)."

Who discovered the problem: Hiranch Patel

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1/5/2010, 17:00; Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1/6/2010, 07:00; Verbal

QC Inspector's Name: Wang Xian Pin

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: Sinevod,Serge

ASMR

Reviewed By: Wabbeh,Mazen

SMR



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

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SSD10	报告编号 Report No.:	B-CWR1043
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG FLOOR BEAM AND BOTTOM PLAT E	NDT 报告编号 NDT Report No.:	B787-MT-17605
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对SSD10-PP56-108检测时, 发现1处纵向裂纹, L1=18mm

Welder ID No. (焊工编号): 037705

Position:(位置): 2F

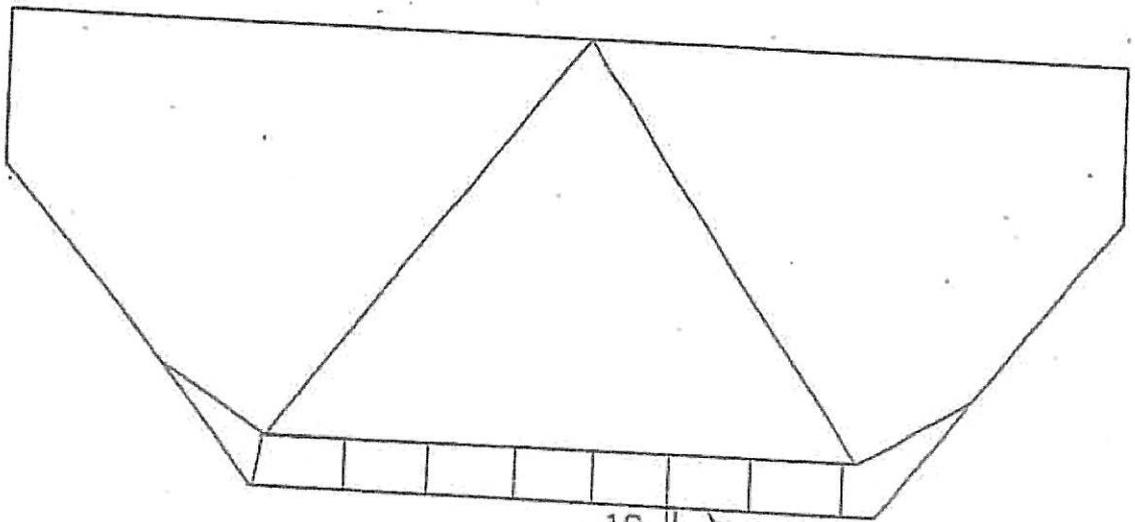
One longitudinal crack was found by use of MT on SSD10-PP56-108.

检验员 (Inspector): Sun Gonchana

日期 (Date): 2010-01-07

焊缝返修位置示意图:

Draft of Welding Discontinuity:



WELD NUMBER:SSD10-PP56-108

THE COMPANY IS APPROVED
FOR THE PERFORMANCE OF
INSPECTION AND TESTING
SERVICES IN ACCORDANCE
WITH THE REQUIREMENTS
OF THE STANDARD
AS PER THE SCOPE OF
THE CONTRACT.

产生原因:

Cause:

1. 火焰加热时, 水汽没有完全的去掉或者这个区域预热不够;
1. Moisture wasn't completely removed during drying operation (preheating) or the area wa sn't preheated sufficiently.

车间负责人 (Foreman):

Li Zhigang

日期 (Date):

10.1.7

处理意见

Disposition :

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
3. 去除热影响区域上在各个方向上不小于25mm范围内的油漆;
4. 将杂物以及MT检测遗留的残留物清理干净, 然后采用打磨的方法去除裂纹, 打磨前预热至65° C. 对于单个裂纹返修, 打磨返修范围清除长度为沿裂纹长度加上超出其每一端50mm;
5. 如果打磨时母材损伤, 则在返修前将损伤区域打磨干净; 如果打磨时或打磨后根部间隙大于5mm, 则在继续返修前另需递交文件给工程师予以审核批准, 并按照被批准的方法将角焊缝改成CJP焊缝;
6. 焊接前按照新的焊接返修工艺准备各焊接接头形式;
7. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在, 同时靠近裂纹的母材也要做MT, 保证没有裂纹延伸到母材. 如果在母材上发现裂纹, 则另外需CWR, 且只有当这份另出的CWR批准后才能继续返修;
8. 将杂物以及MT检测遗留的残留物清理干净. 按照WPS进行预热和焊接, 预热温度为160° C-230° C;
9. 焊接后WPS要求进行后热, 后热温度为230° C-315° C, 后热时间至少1个小时;
10. 后热后将焊缝逐渐冷却到周围环境温度, 并控制冷却速率不超过50° C每小时;
11. 后热后将修补区域打磨与母材或相邻焊缝平齐;
12. 在焊缝冷却至环境温度至少经过48小时以后进行NDT检查;
13. 返修后根据图纸进行MT检测, 并按照合同10-1.59 "钢结构" 中的 "检测和试验" 要求进行附加MT检测. 对于CJP焊缝, NDT为VT, MT和UT.

This document is APPROVED
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant to Section 5-1.02 of the
 Standard Specifications
 Initial: [Signature] Date: 1/1/10

1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements
2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
3. Remove paint $\geq 25\text{mm}$ in all direction of HAZ prior to MT.
4. Clean the excavation area of all loose debris including MT powder. Preheat to 65° C before removing cracks by grinding, repair area shall extend a minimum of 50mm beyond each end of single crack repairs.
5. If base metal is damaged by grinding, the damaged area shall be ground clean prior to performing weld repair. If gap $> 5\text{mm}$ is found during or after grinding, comply with the notification on changing fillet weld to CJP which is submitted for Engineer's review and approval form.
6. Prepare excavation in accordance with the New Repair Procedure prior to welding.
7. Before this repair, Verify with VT and MT repair areas are defects free, and also MT shall be performed on the base metal laying abroad cracks to ensure that no cracks were propagated to the base metal. Separate CWR approval is needed if cracks are found in the base metal, and only after this new CWR's approval can continue the repair.
8. Clean excavation area of all loose debris including MT powder after excavation. Preheat and weld according to repair WPS, the preheat shall between 160° C-230° C.
9. Perform post weld heating according to repair WPS, the postheat shall between 230° C-315° C and for on a hour minimum.
10. Allow the weld to cool to ambient temperature gradually. Control cooling rate after PWHT to no more than 50° C per hour.
11. Grind the repaired area flush with base metal or the adjacent weld after post weld heating.
12. Wait 48 hours at least after the repair area has cooled to ambient temperature before performing NDT.
13. Perform MT inspection to all repair area according to Contract Drawings along with all additional NDT required by the applicable notes Special Provision Section 10-1.59 'Steel Structure', subsection 'Inspection testing'. NDT include VT, MT and UT if it is a CJP weld.

工艺:

Technical Engineer: [Signature]

审核:

Approved By: [Signature]

日期:

Date: 10.1.7



关键焊缝返修报告

Critical Welding Repair Report (CWR)

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SSD10	报告编号 Report No.:	B-CWR1043
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG FLOOR BEAM AND BOTTOM PLAT E	NDT 报告编号 NDT Report No.:	B767-MT-17605
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

1. 返修前, QC确认有效的预热, 以将水汽全部去除。

1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.

车间负责人 (Foreman):

Li Zhigang

日期 (Date):

10.1.7

参照的WPS编号 Repair WPS No.:	WPS-345-SMAW-2G(2F)-FCM -Repair	工艺员 Technologist:	Xu Dongkai 10.1.7
返修(碳刨)前预热温度 Preheat Temperature Before Gouging:	178°C	返修的缺陷 Description of Discontinuity:	SLUG
焊前处理检查 Inspection Before Welding:	Acc	焊前预热温度 Preheat Temperature Before Welding:	164°C
最大碳刨深度 Max. Depth of Gouge:	NA	碳刨总长 Total Length of Gouge:	NA
焊工 Welder:	045133	焊接类型 Welding Type:	SMAW
焊接电流 Current:	152	焊接电压 Voltage:	23.6
		焊接位置 Position:	2F
		焊接速度 Speed:	107

返修后检查
Inspection After Repair:

外观检查 VT Result:	Acc	检验员 Inspector:	Li Yanhua 07120701	日期 Date:	2010.01.29
NDT复检 NDT Result:	Acc	探伤员 NDT Person:	Sun Yongchun	日期 Date:	2010.1.31

见证:
Witness/Review:备注:
Remark:

#5767-20F-200



Visual Weld Inspection Report
焊缝目视检查报告

Caltrans Contract No. 加州合同编号 04-0120F4		Girder/梁: OBG Plate Panel Splice		周数 117H									
Project No.: 项目名称 San Francisco Oakland Bay Bridge 海湾大桥		Tower/塔:		日期 2010.01.29									
Project No.: 项目编号 ZP06-787		Representative: 质检代表: CWI: 检验员: LiYanhua 070-5701											
Quality Assurance Manager-Approval 质量控制经理:													
Weld No. 缝编号	Welder I.D.# 工识别号	Location 位置	Welding consumables 焊接材料	Undercut t 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike电 弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或 拒收	Repair 返修	or Reject after repair 返修后
SSD10-PP56-108	045133	2F	TL508H4 (Φ4.0)	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
<input type="checkbox"/> After root weld <input checked="" type="checkbox"/> After CWR or WRR No.: B-CWR1043 #R787-QCP-603													
											<input type="checkbox"/> After cover pass <input type="checkbox"/> After HSR No.: <input type="checkbox"/> Others		

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

CWR1044-



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-393(ZPMC-0576)
Item: Missed MT indication 名称描述: MT 漏检	Item Number: 件号: 7DW	Drawing: 图号:
Location: Outside yard 位置: 外场	Date: 日期: 2010-01-18	

Description of Nonconformance:

During Magnetic Particle Testing (MT) review of welds on OBG Segment 7DW deck panel diaphragm components, this Quality Assurance Inspector (QA) discovered the following issues:

One (1) longitudinal linear indication measuring approximately 10mm in length.

The member is identified as FL2-2 Floor Beam FB005-025.

The weld is a fillet weld T-joint, joining FB005-025 to Seismic Performance Critical Material (SPCM) bottom panel identified as BP092A.

The weld is identified as SSD11A-PP57-084.

The approved shop drawings, detail this weld as a Fracture Critical Weld (FCW).

The Notice of Witness Inspection Number (NWIT) is 004993. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.

在进行对 7DW 顶板部分 MT 随机检验时, 加州检验员发现以下问题:

一条纵向长度接近 10mm 的线性缺陷。

该板式 FL2-2 隔板 FB005-025。

该焊缝是一角焊缝, 连接 FB005-025 和 SPCM 底板 BP092A。

按照图纸要求, 该焊缝是 FCW 焊缝。

预约单编号是 004993。该缺陷之前已经被 ZPMC MT 人员检验并接收。

Work By: <u>Li Liang</u> 施工方: <u>2010.1.20</u>	Prepared by: <u>Zhangwei</u> 准备: <u>2010.1.18</u>	Reviewed by QCE: <u>Lu Jieming</u> 质量工程师批准: <u>1/19/10</u>
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input 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
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Recommendation:

建议:

现场确认后再报告处理。

Prepared by: <u>Li Liang</u> 准备: <u>2010.1.20</u>	Approved by QCA: _____ 质量经理批准
--	----------------------------------

Reason for Nonconformance:

不符合原因:

线性缺陷未被检测出。

Prevention of Re-occurrence:

预防措施:

及时检测报险. 加强复检

Approved by/批准:

Li Ling 2020.1.20

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:

确认:

Acceptable

可接受

Unacceptable

不可接受

Verified by QCI/质检确认:

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:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 06-Jan-2010

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

Denr: Mr. Charles Kaspicki
Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Document No: 05.03.06-000566

Subject: NCR No. ZPMC-0576

Reference Description: Missed MT indication by QC on Segment 7CW Floorbeam

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: 07

Remarks:

During Magnetic Particle Testing (MT) review of welds on OBG Segment 7DW deck panel diaphragm components, this Quality Assurance Inspector (QA) discovered the following issues:

One (1) longitudinal linear indication measuring approximately 10 mm in length.

-The member is identified as FL2-2 Floor Beam FB005-025

-The weld is a fillet weld T-joint, joining FB005-025 to Seismic Performance Critical Material (SPCM) bottom panel identified as BP092A.

-The weld is identified as SSD11A-PP57-084.

-The approved shop drawings, detail this weld as a Fracture Critical Weld (FCW).

-Segment 7DW is located at outside yard, north end of bays 13 and 14.

The Notice of Witness Inspection Number (NWIT) is 004993. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide the required training and equipment to the ZPMC MT technician such that indications such as this are found. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0576

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

N: 05.03.06-000566,NCT

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, PRC

Report No: NCR-000603

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 05-Jan-2010

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

NCR #: ZPMC-0576

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Segment 7CW Floorbeam
 Procedural Procedural Description: Missed MT indication by QC

Reference Description: Missed MT indication by QC on Segment 7CW Floorbeam

Description of Non-Conformance:

During Magnetic Particle Testing (MT) review of welds on OBG Segment 7DW deck panel diaphragm components, this Quality Assurance Inspector (QA) discovered the following issues:

One (1) longitudinal linear indication measuring approximately 10 mm in length.

-The member is identified as FL2-2 Floor Beam FB005-025

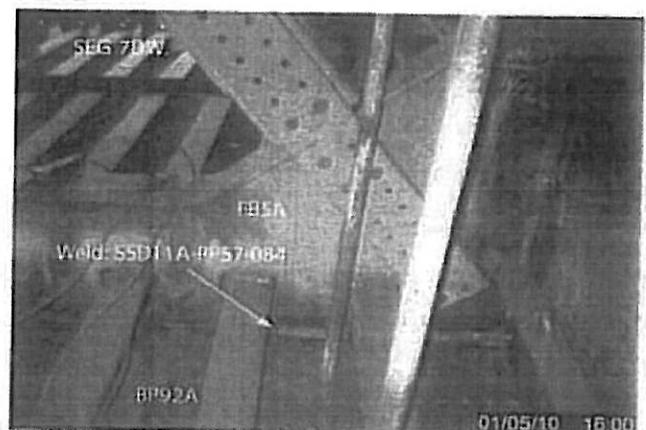
-The weld is a fillet weld T-joint, joining FB005-025 to Seismic Performance Critical Material (SPCM) bottom panel identified as BP092A.

-The weld is identified as SSD11A-PP57-084.

-The approved shop drawings, detail this weld as a Fracture Critical Weld (FCW).

-Segment 7DW is located at outside yard, north end of bays 13 and 14.

The Notice of Witness Inspection Number (NWIT) is 004993. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Who discovered the problem: Shailesh Vasant Wadkar

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1/5/2010, 17:00; Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 01/06/10, 09:00; Verbal

QC Inspector's Name: Wang Xian Pin

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: Sinevod,Serge

ASMR

Reviewed By: Wahbeh,Mazen

SMR



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

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SSD11	报告编号 Report No.:	B-CWR1044
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG FLOOR BEAM AND BOTTOM PLAT E 7DW	NDT 报告编号 NDT Report No.:	B787-MT-1760
项目编号 Project No.:	ZP06-7B7				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对SSD11-PP57-0B4检测时, 发现1处纵向裂纹, L1=10mm

Welder ID No. (焊工编号): 037705

Position: (位置): 2F

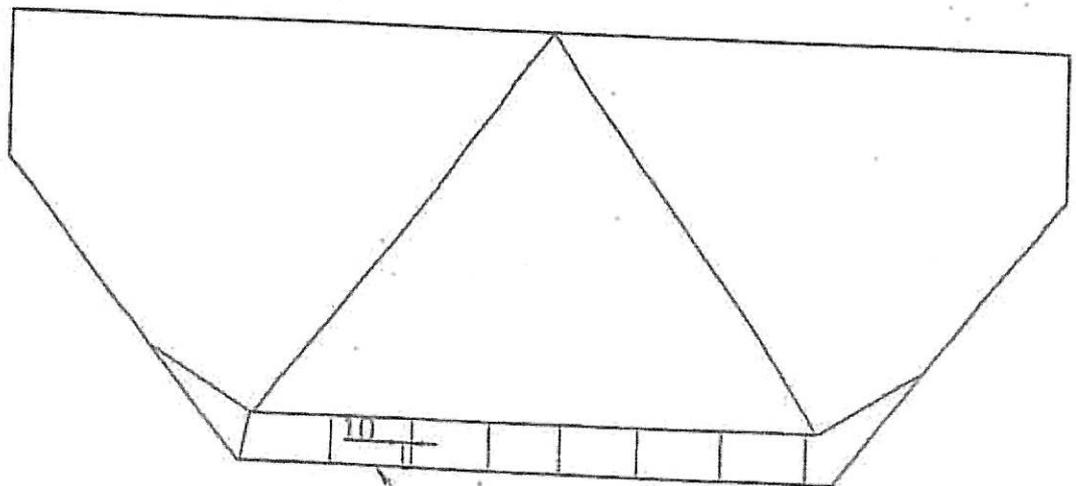
One longitudinal crack was found by use of MT on SSD11-PP57-0B4.

检验员 (Inspector): Sun Gongchang

日期 (Date): 2010-01-07

焊缝返修位置示意图:

Draft of Welding Discontinuity:



WELD NUMBER: SSD11-PP57-0B4

THE QUALITY DEPARTMENT

产生原因:

Cause:

1. 火焰加热时,水汽没有完全的去掉或者这个区域预热不够;

1. Moisture wasn't completely removed during drying operation (preheating) or the area wa sn't preheated sufficiently.

车间负责人 (Foreman):

Li Zhigang

日期 (Date):

2010.1.7

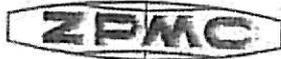
处理意见

Disposition:

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
3. 去除热影响区域上在各个方向上不小于25mm范围内的油漆;
4. 将杂物以及MT检测遗留的残留物清理干净。然后采用打磨的方法去除裂纹, 打磨前预热至65° C。对于单个裂纹返修, 打磨返修范围清除长度为沿裂纹长度加上超出其每一端50mm;
5. 如果打磨时母材损伤, 则在返修前将损伤区域打磨干净; 如果打磨时或打磨后根部间隙大于5mm, 则在继续返修前另需递交文件给工程师予以审核批准, 并按照被批准的方法将角焊缝改成CJP焊缝;
6. 焊接前按照新的焊接返修工艺准备各焊接接头形式;
7. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在, 同时靠近裂纹的母材也要做MT, 保证没有裂纹延伸到母材。如果在母材上发现裂纹, 则另外需CWR, 且只有当这份另出的CWR批准后才能继续返修;
8. 将杂物以及MT检测遗留的残留物清理干净。按照WPS进行预热和焊接, 预热温度为160° C-230° C;
9. 焊接后WPS要求进行后热, 后热温度为230° C-315° C, 后热时间至少1个小时;
10. 后热后将焊缝逐渐冷却到周围环境温度, 并控制冷却速率不超过50° C每小时;
11. 后热后将修补区域打磨与母材或相邻焊缝平齐;
12. 在焊缝冷却至环境温度至少经过48小时以后进行NDT检查;
13. 返修后根据图纸进行MT检测, 并按照合同10-1.59 "钢结构" 中的 "检测和试验" 要求进行附加MT检测。对于CJP焊缝, NDT为VT, MT和UT。

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial: [Signature] Date: 1/11/10

1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements
2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
3. Remove paint ≥ 25 mm in all direction of HAZ prior to MT.
4. Clean the excavation area of all loose debris including MT powder. Preheat to 65° C before removing cracks by grinding, repair area shall extend a minimum of 50mm beyond each end of single crack repairs.
5. If base metal is damaged by grinding, the damaged area shall be ground clean prior to performing weld repair. If gap > 5 mm is found during or after grinding, comply with the notification on changing fillet weld to CJP which is submitted for Engineer's review and approval form.
6. Prepare excavation in accordance with the New Repair Procedure prior to welding.
7. Before this repair, Verify with VT and MT repair areas are defects free, and also MT shall be performed on the base metal laying abroad cracks to ensure that no cracks were propagated to the base metal. Separate CWR approval is needed if cracks are found in the base metal, and only after this new CWR's approval can continue the repair.
8. Clean excavation area of all loose debris including MT powder after excavation. Preheat and weld according to repair WPS, the preheat shall between 160° C-230° C
9. Perform post weld heating according to repair WPS, the postheat shall between 230° C-315° C and for one hour minimum.
10. Allow the weld to cool to ambient temperature gradually. Control cooling rate after PWHT to no more than 50° C per hour.
11. Grind the repaired area flush with base metal or the adjacent weld after post weld heating.
12. Wait 48 hours at least after the repair area has cooled to ambient temperature before performing NDT.
13. Perform MT inspection to all repair area according to Contract Drawings along with all additional NDT required by the applicable notes Special Provision Section 10-1.59 'Steel Structure', subsection 'Inspection testing'. NDT include VT, MT and UT if it is a CJP weld.



关键焊缝返修报告

Critical Welding Repair Report (CWR)

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SSD11	报告编号 Report No.:	B-CWR1044
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG FLOOR BEAM AND BOTTOM PLAT E	NDT 报告编号 NDT Report No.:	B787-MT-17606
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

1. 返修前, QC确认有效的预热, 以将水汽全部去除。

1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.

车间负责人 (Foreman):

Li Zhiqiang

日期 (Date):

2010.1.7

参照的WPS编号 Repair WPS No.:	WPS-345-SMAW-2G(2F)-FCM -Repair	工艺员 Technologist:	He Xiaoli 2010.1.8
返修(碳刨)前预热温度 Preheat Temperature Before Gouging:	NA	返修的缺陷 Description of Discontinuity:	2F
焊前处理检查 Inspection Before Welding:	Acc	焊前预热温度 Preheat Temperature Before Welding:	197°C
最大碳刨深度 Max. Depth of Gouge:	4mm	碳刨总长 Total Length of Gouge:	110mm
焊工 Welder:	045133	焊接类型 Welding Type:	SMAW
焊接电流 Current:	169	焊接电压 Voltage:	25
		焊接位置 Position:	2F
		焊接速度 Speed:	152

返修后检查

Inspection After Repair:

外观检查 VT Result:	Acc	检验员 Inspector:	Li Yanhua 07120701	日期 Date:	2010.01.29
NDT复检 NDT Result:	Acc	探伤员 NDT Person:	Sun Yongchun	日期 Date:	2010.1.31

见证:
Witness/Review:

备注:
Remark:

THIS DOCUMENT IS APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 17000 of the
California Public Contract Code



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-408(ZPMC-0599)
Item: Missed MT indication 名称描述: MT 漏检	Item Number: 件号:	Drawing: 图号:
Location: 位置:		Date: 日期: 2010-01-28

Description of Nonconformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance Inspector (QA) discovered the following issues:

Four (4) Transverse linear indications measuring approximately from 2mm to 6mm in length. The weld is identified as: SSD11-PP69-004. This weld was turned into a Complete Joint Penetration (CJP) T-joint weld joining the upper floor beam flange to the deck panel diaphragm previously. The indication is located in an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. According to the contract documents ZPMC Quality Control (QC) is required to perform 100% Magnetic particle Testing (MT) of this weld.

在随机检验 8CW MT 时, 加州检验员发现以下问题:
4 条横向线性缺陷长度将近 2mm 至 6mm。焊缝是: SSD11-PP69-004。这条焊缝是 CJP 焊缝。缺陷所在位置先前已经被 ZPMC MT 人员所检验并接受。

Work By: <u>[Signature]</u> 施工方: <u>2010.02.23</u>	Prepared by: <u>[Signature]</u> 准备: <u>2010.1.28</u>	Reviewed by QCE: <u>[Signature]</u> 质量工程师批准: <u>1/28/10</u>
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: <input type="checkbox"/> Use as is 处理措施: 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
---	---------------------------------------	---------------------------------------

Recommendation:
建议:

现场确认出具报告即可。

Prepared by: <u>[Signature]</u> 准备: <u>2010.02.23</u>	Approved by QCA: _____ 质量经理批准
--	----------------------------------

Reason for Nonconformance:
不符合原因:

线性缺陷没有检测到。

Prevention of Re-occurrence:
预防措施: 及时检测, 加强复检。

Approved by/批准: Lo Zhen 2010.02.03

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: _____

#R787-QCP-1300



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: 13-Jan-2010
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: 05.03.06-000589
Subject: NCR No. ZPMC-0599

Reference Description: Four Transverse linear indications discovered with MT after ZPMC NDT had previously tested and accepted this weld in Segment 8CW. 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: 08

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance Inspector (QA) discovered the following issues:

- Four (4) Transverse linear indications measuring approximately from 2 mm to 6 mm in length.
- The weld is identified as: SSD11-PP69-004 @ Panel Point 069.
- This weld was turned into a Complete Joint Penetration (CJP) T-joint weld joining the upper floor beam flange to the deck panel diaphragm previously.
- This OBG Segment is located at outside yard.
- The Notice of Witness Inspection Number (NWIT) is 005037.
- The indication is located in an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. According to the contract documents ZPMC Quality Control (QC) is required to perform 100% Magnetic particle Testing (MT) of this weld.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide the required training and equipment to the ZPMC MT technician in order to recognize these sorts of indications. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer
Attachments: ZPMC-0599

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-000626

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 11-Jan-2010

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

NCR #: ZPMC-0599

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Segment 8CW DP Diaphragm to FB flange weld
 Procedural Procedural Description: Missed MT indications by QC

Reference Description: Four Transverse linear indications discovered with MT after ZPMC NDT had previously tested and accepted this weld in Segment 8CW

Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance Inspector (QA) discovered the following issues:

- Four (4) Transverse linear indications measuring approximately from 2 mm to 6 mm in length.
- The weld is identified as: SSD11-PP69-004 @ Panel Point 069.
- This weld was turned into a Complete Joint Penetration (CJP) T-joint weld joining the upper floor beam flange to the deck panel diaphragm previously.
- This OBG Segment is located at outside yard.
- The Notice of Witness Inspection Number (NWIT) is 005037.
- The indication is located in an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. According to the contract documents ZPMC Quality Control (QC) is required to perform 100% Magnetic particle Testing (MT) of this weld.



QUALITY ASSURANCE – NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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.”

-AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.

Who discovered the problem: Larry Viars

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 1830 hours, 01-11-10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 0700 hours, 01-12-10, Verbal

QC Inspector's Name: Zhang Wei

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, +(866) 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



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

版本
Rev. 1
0

项目名称 Project Name:	美国梅湾大桥 SFOBB	部件图号 Drawing No.:	SSD11	报告编号 Report No.:	B-CWR1
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	BCW FLOOR BEAM SPLICE	NDT 报告编号 NDT Report No.:	B787-MT-1
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对SSD11-PP69-004检测时, 发现1处纵向裂纹, L1=8mm

Welder ID No. (焊工编号): 058551

Position: (位置): 3G

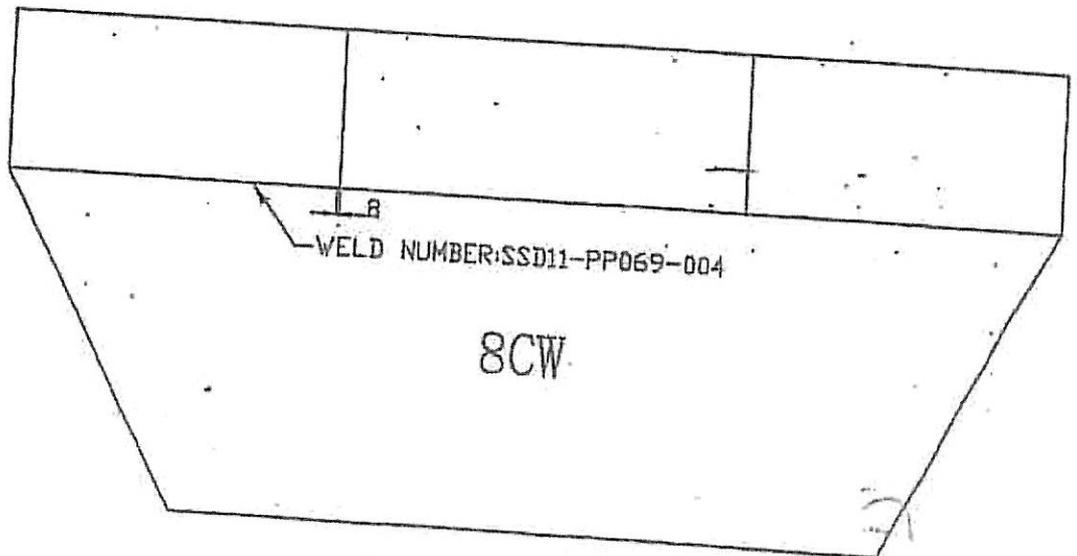
One longitudinal crack was found by use of MT on SSD11-PP69-004.

检验员 (Inspector): Sun Gongchang

日期 (Date): 2010-01

焊缝返修位置示意图:

Draft of Welding Discontinuity:



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State of Delaware
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial [Signature] Date: 1/19/10

产生原因:

Cause:

1. 火焰加热时, 水汽没有完全的去掉或者这个区域预热不够;

1. Moisture wasn't completely removed during drying operation (preheating) or the area wasn't preheated sufficiently.

车间负责人 (Foreman):

Li Zhigang

日期 (Date):

10.01.16

处理意见

Disposition:

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
3. 去除热影响区域上在各个方向上不小于25mm范围内的油漆;
4. 将杂物以及MT检测遗留的残留物清理干净。然后采用打磨的方法去除裂纹, 打磨前预热至85° C。对于单个裂纹返修, 打磨返修范围为沿缺陷焊缝每一端增加50mm;
5. 如果打磨时母材损伤, 则在返修前将损伤区域打磨干净; 如果打磨时或打磨后根部间隙大于5mm, 则在继续返修前另需递交文件给工程师予以审核批准, 并按照被批准的方法将角焊缝改成CJP焊缝;
6. 焊接前按照新的焊接返修工艺准备焊缝接头形式;
7. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在, 同时靠近裂纹的母材也要做MT, 保证没有裂纹延伸到母材。如果在母材上发现裂纹, 则另外需CWR, 且只有当这份另出的CWR批准后才能继续返修;
8. 将杂物以及MT检测遗留的残留物清理干净。按照WPS进行预热和焊接, 预热温度为160° C-230° C;
9. 焊接后WPS要求进行后热, 后热温度为230° C-315° C, 后热时间至少1个小时;
10. 后热后将焊缝逐渐冷却到周围环境温度, 并控制冷却速率不超过50° C每小时;
11. 后热后将修补区域打磨与母材或相邻焊缝平齐;
12. 在焊缝冷却至环境温度至少经过48小时以后后进行NDT检查;
13. 返修后根据图纸进行MT检测, 并按照合同10-1.59 "钢结构" 中的 "检测和试验" 要求进行附加MT检测。对于CJP焊缝, NDT为VT, MT和UT。

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial *[Signature]* Date 1/19/10

1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements
2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
3. Remove paint ≥ 25 mm in all direction of HAZ prior to MT.
4. Clean the excavation area of all loose debris including MT powder. Preheat to 85° C before removing cracks by grinding, repair area shall extend a minimum of 50mm beyond each end of single crack repairs.
5. If base metal is damaged by grinding, the damaged area shall be ground clean prior to performing weld repair. If gap > 5 mm is found during or after grinding, comply with the notification on changing fillet weld to CJP which is submitted for Engineer's review and approval form.
6. Prepare excavation in accordance with the New Repair Procedure prior to welding.
7. Before this repair, Verify with VT and MT repair areas are defects free, and also MT shall be performed on the base metal laying abroad cracks to ensure that no cracks were propagated to the base metal. Separate CWR approval is needed if cracks are found in the base metal, and only after this new CWR's approval can continue the repair.
8. Clean excavation area of all loose debris including MT powder after excavation. Preheat and weld according to repair WPS, the preheat shall between 160° C-230° C.
9. Perform post weld heating according to repair WPS, the postheat shall between 230° C-315° C and for one hour minimum.
10. Allow the weld to cool to ambient temperature gradually. Control cooling rate after PWHT to no more than 50° C per hour.
11. Grind the repaired area flush with base metal or the adjacent weld after post weld heating.
12. Wait 48 hours at least after the repair area has cooled to ambient temperature before performing NDT.
13. Perform MT inspection to all repair area according to Contract Drawings along with all additional NDT required by the applicable notes Special Provision Section 10-1.59 'Steel Structure', subsection 'Inspection testing'. NDT include VT, MT and UT if it is a CJP weld.

工管:

Technical Engineer:

[Signature]

审核:

Approved By:

[Signature]

日期:

Date: 10.01.18



关键焊缝返修报告

版本
Rev. No.:

Critical Welding Repair Report (CWR)

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SSD11	报告编号 Report No.:	B-CWR1106
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	8CW FLOOR BEAM SPlice	NDT 报告编号 NDT Report No.:	B787-MT-17898
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

1. 返修前, QC确认有效的预热, 以将水汽全部去除。

1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.

车间负责人 (Foreman):

Li zhigang

日期 (Date):

10.01.16

参照的 WPS 编号 Repair WPS No.:	WPS-345-SMAW-2G(2F)-Repa ir	工艺员 Technologist:	Xu Daylev 10.07.16
返修 (碳刨) 前预热温度 Preheat Temperature Before Gouging:	NA	返修的缺陷 Description of Discontinuity:	CR
焊前处理检查 Inspection Before Welding:	An	焊前预热温度 Preheat Temperature Before Welding:	180°C
最大碳刨深度 Max. Depth of Gouge:	NA	碳刨总长 Total Length of Gouge:	NA
焊工 Welder:	043661	焊接类型 Welding Type:	SMAW
焊接电流 Current:	160A	焊接电压 Voltage:	25.9V
		焊接位置 Position:	2G
		焊接速度 Speed:	1/0 mm/min

返修后检查
Inspection After Repair:

外观检查 VT Result:	An	检验员 Inspector:	Li kanhua	日期 Date:	2010.01.20
NDT 复检 NDT Result:	AC	探伤员 NDT Person:	Sungong cheng	日期 Date:	2010.1.24

见证:
Witness/Review:备注:
Remark:

#R787-QCP-900

THIS DOCUMENT IS APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pertinent to Section 2-102 of the
Standard Specifications
Issue: [Signature] Date: 2/19/10



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B7B7-MT-17999R1 DATE日期 2010.01.24 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: SSD11 CALTRANS CONTRACT NO.: 04-0120F4
 OBG FLOOR BEAM SPLICE 加州工程编号

REFERENCING CODE 参考规范编码: AWS D1.5-2002 ACCEPTANCE STANDARD 接受标准: AWS D1.5-2002 PROCEDURE NO. 程序编号: ZPQC-MT-01 CALIBRATION DUE DATE 仪器校正有效期: Dec. 28th, 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 Material & thickness 母材, 厚度: A709M-345F2-X
 CASTING 铸件 14/20mm
 FORGING 锻造

WELDING PROCESS 焊接方法: SMAW TYPE OF JOINT 焊缝类型: T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD11-PP069-004	1R1			ACC.		

AFTER B-CWR1106

BLANK

EXAMINED BY 主操: Sun Gongchang REVIEWED BY 审核: Jin Jian ting
 LEVEL-II SIGN 签名 / DATE 日期: 2010.01.24 LEVEL-II SIGN 签名 / DATE 日期: 2010.01.24
 质量经理 / QCM 用户 CUSTOMER
 签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE



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-429(ZPMC-0615)
Item: Miss indication 名称描述: 探伤漏检	Item Number: 件号:	Drawing: 7DW 图号:
Location: 位置: 外场		Date: 日期: 2010-02-03

Description of Nonconformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector discovered the following issue:

One (1) Transverse linear crack measuring approximately 15mm in length. The Y location is 4500mm from corner of the PP57 at Cross Beam side. The weld is identified as :SSD11A-PP57-003. This weld is a Complete Joint Penetration (CJP) weld joining the Deck Panel Diaphragm (X1H) to Floor Beam Flange (X7G). The Deck Panel Diaphragm (X1H) is identified as Non-Seismic Performance Critical Member (SPCM). The Floor Beam Flange (X7G) is identified as Non-SPCM. The indication is located inside an area that has been previously tested 100% and accepted by ZPMC Quality Control (QC) personnel.

在对 7DW 进行 MT 检验过程中, 加州检验员发现以下问题:

一条横向线性缺陷长度将近 15mm.Y 值是 4500mm 从 PP57 标准横梁侧开始。焊缝是:SSD11A-PP57-003.这条焊缝是 CJP 焊缝连接 X1H 和 X7G。X1H, X7G 都是非 SPCM。缺陷位置之前已经被 ZPMC MT 人员所检验并接受。

Work By: <u>Li Liming</u> 施工方: <u>2010.02.03</u>	Prepared by: <u>Zhangwei</u> 准备: <u>2010.2.3</u>	Reviewed by QCE: <u>Li Junhua</u> 质量工程师批准: <u>1/3/10</u>
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: <input type="checkbox"/> Use as is 处理措施: 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
---	---------------------------------------	---------------------------------------

Recommendation:
建议: 现场确认后报告返修。

Prepared by: <u>Li Liming</u> 准备: <u>2010.02.03</u>	Approved by QCA: _____ 质量经理批准
--	----------------------------------

Reason for Nonconformance:
不符合原因: 线性缺陷未被检测到。

Prevention of Re-occurrence:
预防措施: 加强复检及时检测及报告。

	Approved by/批准: <u>Whiring</u> 2010.02.23	
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
Reviewed /批准: _____		
Verification: 确认:	<input type="checkbox"/> Acceptable 可接受	<input type="checkbox"/> Unacceptable 不可接受
Verified by QCI/质检确认: _____ Reviewed by QCA/质检主任审核: _____		

#R787-QCP-1300



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: 24-Jan-2010

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

Dear: Mr. Charles Kannpicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0615

Job Name: SAS Superstructure
Document No: 05.03.06-000606

Reference Description: MT Transverse Crack discovered after ZPMC tested and accepted this weld (7DW floorbeam to deck panel diaphragm joint)

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: 07

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector discovered the following issue:

- One (1) Transverse linear crack measuring approximately 15mm in length.
- The Y location is 4500mm from corner of the Panel Point PP57 at Cross Beam side.
- The indication is clearly marked on the material near the weld.
- The weld is identified as: SSD11A-PP57-003.
- This weld is a Complete Joint Penetration (CJP) weld joining the Deck Panel Diaphragm (X1H) to Floor Beam Flange (X7G).
- The Deck Panel Diaphragm (X1H) is identified as Non-Seismic Performance Critical Member (SPCM).
- The Floor Beam Flange (X7G) is identified as Non-SPCM.
- OBG segment 7DW is located outside North side of Bay 13.

The Notice of Witness Inspection Number (NWT) is 005086. The indication is located inside an area that has been previously tested 100% and accepted by ZPMC Quality Control (QC) personnel.

Please see attached NCR ZPMC-615 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-0615

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

NCT

(Continued Page 2 of 2)

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-000644

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-Jan-2010

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

NCR #: ZPMC-0615

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

Joint fit-up Coating Other Component: 7DW Floor Beam to Deck Panel Diaphragm

Procedural Procedural Description: Missed MT transverse indication by QC

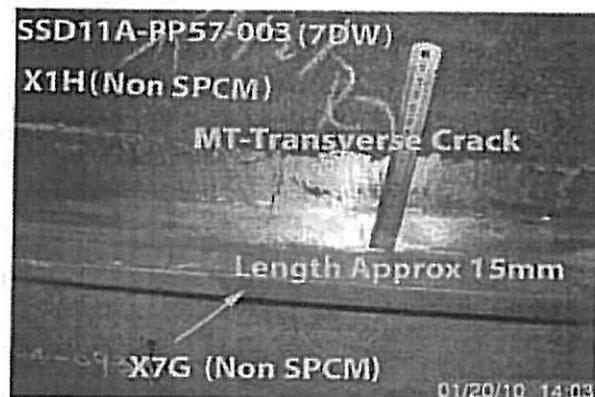
Reference Description: MT Transverse Crack discovered after ZPMC tested and accepted this weld (7DW floorbeam to deck panel diaphragm joint)

Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7DW, this Quality Assurance Inspector discovered the following issue:

- One (1) Transverse linear crack measuring approximately 15mm in length.
- The Y location is 4500mm from corner of the Panel Point PP57 at Cross Beam side.
- The indication is clearly marked on the material near the weld.
- The weld is identified as: SSD11A-PP57-003.
- This weld is a Complete Joint Penetration (CJP) weld joining the Deck Panel Diaphragm (X1H) to Floor Beam Flange (X7G).
- The Deck Panel Diaphragm (X1H) is identified as Non-Seismic Performance Critical Member (SPCM).
- The Floor Beam Flange (X7G) is identified as Non-SPCM.
- OBG segment 7DW is located outside North side of Bay 13.

The Notice of Witness Inspection Number (NWIT) is 005086. The indication is located inside an area that has been previously tested 100% and accepted by ZPMC Quality Control (QC) personnel.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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."

AWS D1.5 (02) Section 6.26.2 – "Welds that are subject to MT in addition to visual inspection shall have no cracks.

Who discovered the problem: Vibin Kumar Selvanayahan

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1415 hours, 01-20-10, Verbal

Name of Caltrans Engineer notified: Bill Howe and Ching Chao

Time and method of notification: 1230 hours, 01-21-10, Email

QC Inspector's Name: Wnag Xian Pin

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



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

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SEG039	报告编号 Report No.:	B-CWR1167
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	DBG DECK PLATE SPlice 7BW	NDT 报告编号 NDT Report No.:	B787-MT-18475
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对SSD11A-PP57-003检测时, 发现1处横向裂纹, 1、L=15mm

Welder ID No. (焊工编号): 047858

Position:(位置): 2F

One transverse crack was found by use of MT on SSD11A-PP57-003.

检验员 (Inspector): Wang Wei

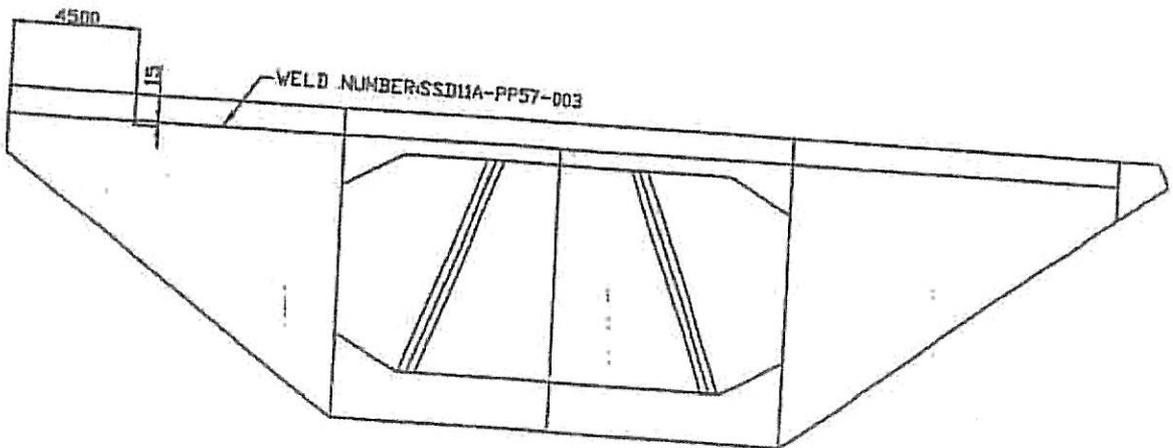
Wang Wei

日期 (Date): 2010-01-22

1001-72

焊缝返修位置示意图:

Draft of Welding Discontinuity:



This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications

Initial *[Signature]* Date 1/27/10

产生原因: Cause:

1. 火焰加热时, 水汽没有完全的去除或者这个区域预热不够;
1. Moisture wasn't completely removed during drying operation (preheating) or the area wasn't preheated sufficiently.

车间负责人 (Foreman):

Lizhigang

日期 (Date): 10.01.23

处理意见

Disposition:

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
 2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
 3. 去除热影响区域上在各个方向上不小于25mm范围内的油漆;
 4. 将杂物以及MT检测遗留的残留物清理干净, 然后采用打磨的方法去除裂纹, 整个过程中打磨前预热需至65° C. 对于单个裂纹返修, 打磨返修范围为沿缺陷焊缝每一端增加50mm.
 5. 如果打磨时母材损伤, 则在返修前将损伤区域打磨干净;
 6. 焊接前按照母材的接返修工艺准备焊接头形式;
 7. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在, 同时靠近裂纹的母材也要做MT, 保证没有裂纹延伸到母材. 如果在母材上发现裂纹, 则另外需CWR, 且只有当这份另出的CWR批准后才能继续返修;
 8. 将杂物以及MT检测遗留的残留物清理干净, 按照WPS进行预热和焊接, 预热温度为160° C-230° C;
 9. 如果打磨深度达到(2/3T+2)mm, 但是缺陷仍然存在, 则停止打磨, 将坡口打磨平滑, 且挖出的凹槽部分两个端头要有1:1的斜势过渡, 然后按照批准的WPS进行第一个面的焊接, 焊接前需至少160° C的预热. 从反面进行打磨直至露出金属光泽, 并对打磨后坡口位置进行100%MT检测, 确保裂纹清除干净, 然后将坡口打磨平滑, 确保来两个端头有1:1的斜势过渡, 并按照WPS的要求进行反面的焊接.
 10. 焊接后WPS要求进行后热, 后热温度为230° C-315° C, 后热时间至少1个小时;
 11. 后热后将焊缝逐渐冷却到周围环境温度, 并控制冷却速率不超过50° C每小时;
 12. 后热后将修补区域打磨与母材或相邻焊缝平齐;
 13. 在焊缝冷却至环境温度至少经过48小时以后进行NDT检查;
 14. 返修后根据图纸进行VT, UT和MT检测, 并按照合同10-1.59 "钢结构" 中的 "检测和试验" 要求进行附加MT检测.
1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements.
 2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
 3. Remove paint ≥ 25 mm in all direction of HAZ prior to MT.
 4. Clean the excavation area of all loose debris including MT powder. Preheat to 65° C before removing cracks by grinding and it applied to all the repair process. Repair area shall extend a minimum of 50mm beyond each end of single crack repairs,
 5. If base metal is damaged by grinding, the damaged area shall be ground clean prior to performing weld repair.
 6. Prepare excavation in accordance with the New Repair Procedure prior to welding.
 7. Before this repair, Verify with VT and MT repair areas are defects free, and also MT shall be performed on the base metal laying around cracks to ensure that no cracks were propagated to the base metal. Separate CWI approval is needed if cracks are found in the base metal, and only after this new CWR's approval can continue the repair.
 8. Clean excavation area of all loose debris including MT powder after excavation. Preheat and weld according to repair WPS, the preheat shall between 160° C-230° C.
 9. If a crack still present and excavation have reached (2/3T+2)mm maximum, the grinding work shall be ceased. Prepare excavation that all metal is ground clean to a smooth, shiny metal finish and starts and stops are tapered to a 1:1 slope. Weld first side of repair according to approved WPS, and the preheat temperature be 160° C at least. Grind from the opposite side until sound weld metal is reached and perform 100% MT of excavation to ensure no crack exists. Prepare excavation that all metal is ground clean to a smooth, shiny metal finish and starts and stops are tapered to a 1:1 slope. Weld opposite side of repair according to approved WPS.
 10. Perform post weld heating according to repair WPS, the postheat shall between 230° C-315° C and for one hour minimum.
 11. Allow the weld to cool to ambient temperature gradually. Control cooling rate after PWHT to no more than 50° C per hour.
 12. Grind the repaired area flush with base metal or the adjacent weld after post weld heating.
 13. Wait 48 hours at least after the repair area has cooled to ambient temperature before performing NDT.
 14. Perform VT, UT and MT inspection to all repair area according to Contract Drawings along with all additional NDT required by the applicable notes Special Provision Section 10-1.59 'Steel Structure', subsection 'inspection testing'.

This document is Approved by
 State of Guangdong
 DEPARTMENT OF INDUSTRIAL AND INFORMATION TECHNOLOGY
 Pursuant to Section 8-1.02 of the
 Standard Specifications
 Initial: *[Signature]* Date: 1/27/10

工艺:

Technical Engineer:

He Xianlin

审核:

Approved By:

[Signature]

日期:

Date:

10.01.23



关键焊缝返修报告

Critical Welding Repair Report (CWR)

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SEG039	报告编号 Report No.:	B-CWR1167
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG DECK PLATE SPLICE	NDT 报告编号 NDT Report No.:	B787-MT-18475
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

1. 返修前, QC确认有效的预热, 以将水汽全部去除。

1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.

车间负责人 (Foreman):

Li Jiyang

日期 (Date):

10.01.23

参照的WPS编号 Repair WPS No.:	WPS-345-SMAW-2G(2F)-Repair	工艺员 Technologist:	Hexiaoben 10.01.23
返修(碳割)前预热温度 Preheat Temperature Before Gouging:	470°C	返修的缺陷 Description of Discontinuity:	2-F
焊前处理检查 Inspection Before Welding:	ACU	焊前预热温度 Preheat Temperature Before Welding:	180°C
最大碳割深度 Max. Depth of Gouge:	4 mm	碳割总长 Total Length of Gouge:	50 mm
焊工 Welder:	043661	焊接类型 Welding Type:	SMAW
焊接电流 Current:	160A	焊接电压 Voltage:	25.9V
		焊接位置 Position:	2G
		焊接速度 Speed:	110mm/min

返修后检查
Inspection After Repair:

外观检查 VT Result:	ACU	检验员 Inspector:	Li Jiyang	日期 Date:	2023.01.31
NDT复检 NDT Result:	ACU	探伤员 NDT Person:	Sungongchao	日期 Date:	2023.01.31

见证:
Witness/Review:

备注:
Remark:

#R787-QCP-900

This document is APPROVED
State of CA
DEPARTMENT OF THE STATE
BUREAU OF SAFETY
STANDARD CONTRACTS
DATE: 1/31/23

CWR-1151



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-426(ZPMC-0622)
---	---

Item: Miss MT indication 名称描述: MT 漏检	Item Number: 件号:	Drawing: 7EW 图号:
---	---------------------	---------------------

Location: 位置: Bay 2	Date: 日期: 2010-02-03
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Description of Nonconformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on LD3022-001, this Quality Assurance (QA) discovered the following issues:

One (1) linear indication measuring approximately 6mm in length. The weld is identified as :LD3022-001-014 for Lift 12. The area was previously repaired by ZPMC using Critical Weld Repair (CWR) 1151. The fillet weld size is 12mm. This Fillet Weld joins longitudinal diaphragm stiffener to longitudinal diaphragm web plate. This weld is designated as Non-Seismic Performance Critical Member. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC Quality Control (QC) has performed 100% Magnetic particle Testing (MT) of this weld.

在对 LD3022-001 进行 MT 检验过程中, 加州检验员发现以下问题:

一条纵向线性缺陷长度将近 6mm。该焊缝是 12 段的 LD3022-001-014。该区域之前已经被 ZPMC 修复。角焊缝尺寸是 12mm, 连接纵桁加强筋至纵桁腹板。该焊缝是非 SPCM 构件, 缺陷位置之前已经被 ZPMC MT 人员所检验并接受。

Work By: <u>Li Liang</u> 施工方: <u>2010.02.04</u>	Prepared by: <u>Zhuangwei</u> 准备: <u>2010.2.3</u>	Reviewed by QCE: <u>Lu Jiansheng</u> 质量工程师批准: <u>2/3/10</u>
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: <input type="checkbox"/> Use as is 处理措施: 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
---	---------------------------------------	---------------------------------------

Recommendation:

建议: 现场确认认可书, 报告存档。

Prepared by: <u>Li Liang</u> 准备	Approved by QCA: _____ 质量经理批准
------------------------------------	----------------------------------

Reason for Nonconformance:

不符合原因: 该处焊缝未进行检测。

Prevention of Re-occurrence:

预防措施: 及时检测, 报检, 加强复检。

			Approved by/批准: <u>2010-02-24</u> <i>Li to ming</i>
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	
Reviewed /批准: _____			
Verification: 确认:	<input type="checkbox"/> Acceptable 可接受	<input type="checkbox"/> Unacceptable 不可接受	
Verified by QCI/质检确认: _____		Reviewed by QCA/质检主任审核: _____	

#R787-QCP-1300



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: 26-Jan-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0622

Job Name: SAS Superstructure
Document No: 05.03.06-000615

Reference Description: Missed MT Indication by QC for a weld joint on the Lift 12 Longitudinal Shear Plate

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: 12

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on LD3022-001, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) linear indication measuring approximately 6mm in length.
- The weld is identified as: LD3022-001-014 for Lift 12.
- The area was previously repaired by ZPMC using Critical Weld Repair (CWR) 1151.
- The fillet weld size is 12mm.
- This Fillet Weld joins longitudinal diaphragm stiffener to longitudinal diaphragm web plate.
- This weld is designated as Non-Seismic Performance Critical Member.
- The Notice of Witness Inspection Number (NWIT) is 005124. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC Quality Control (QC) has performed 100% Magnetic particle Testing (MT) of this weld.

Please see attached NCR ZPMC-622 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-0622

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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
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-000651

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 24-Jan-2010

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

NCR #: ZPMC-0622

Type of problem:

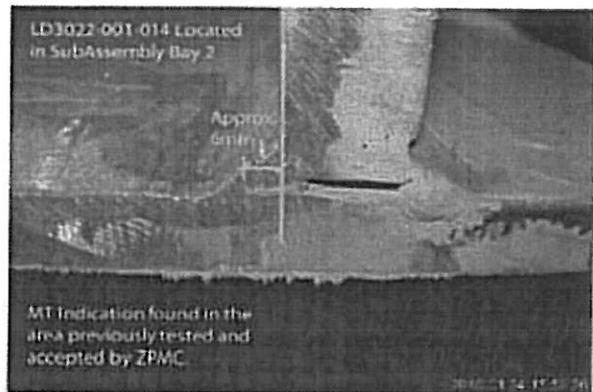
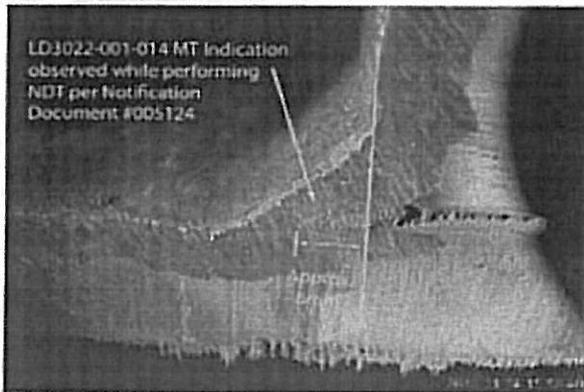
- Welding Concrete Other
- Welding Curing Procedural Bridge No: 34-0006
- Joint fit-up Coating Other Component: Lift 12 Longitudinal Shear Plate
- Procedural Procedural Description: Missed MT indication by QC

Reference Description: Missed MT Indication by QC for a weld joint on the Lift 12 Longitudinal Shear Plate

Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on LD3022-001, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) linear indication measuring approximately 6mm in length.
- The weld is identified as: LD3022-001-014 for Lift 12.
- The area was previously repaired by ZPMC using Critical Weld Repair (CWR) 1151.
- The fillet weld size is 12mm.
- This Fillet Weld joins longitudinal diaphragm stiffener to longitudinal diaphragm web plate.
- This weld is designated as Non-Seismic Performance Critical Member.
- The Notice of Witness Inspection Number (NWIT) is 005124. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC Quality Control (QC) has performed 100% Magnetic particle Testing (MT) of this weld.



Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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.”

AWS D1.5 2002, Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.

Who discovered the problem: Stefan Holmes

Name of individual from Contractor notified: Chen Ji Wei

Time and method of notification: 1600 hours, 01/24/10, Verbal

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 1400 hours, 01/25/10, 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:

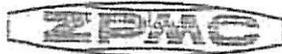
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134,7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



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

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	LD3022	报告编号 Report No.:	B-CWR1151
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	12 th lifting longitudinal diaphragm	NDT 报告编号 NDT Report No.:	B787-MT-17930
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对LD3022-001-006检测时,发现1处气孔和2处横向裂纹。
在对LD3022-001-007检测时,发现1处纵向裂纹和4处横向裂纹。
在对LD3022-001-010检测时,发现1处气孔和1处横向裂纹。
在对LD3022-001-013检测时,发现1处气孔和2处横向裂纹。
在对LD3022-001-014检测时,发现1处纵向裂纹和1处横向裂纹。
在对LD3022-001-019检测时,发现1处气孔和1处横向裂纹。

Welder ID No. (焊工编号): 045209 Position:(位置): 2F

One pore and two transverse cracks were found by use of MT on LD3022-001-006.
One longitudinal crack and four transverse cracks were found by use of MT on LD3022-001-007.
One pore and one transverse crack were found by use of MT on LD3022-001-010.
One pore and two transverse cracks were found by use of MT on LD3022-001-013.
One longitudinal crack and one transverse crack were found by use of MT on LD3022-001-014.
One pore and one transverse crack were found by use of MT on LD3022-001-019.

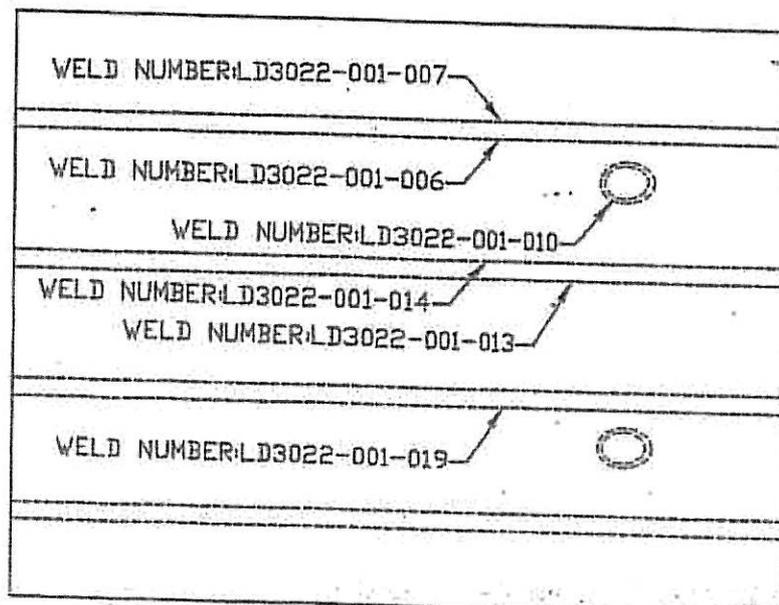
Please see the detail data from MT report!

检验员 (Inspector): Jin Jianting

日期 (Date): 2010-01-19

焊缝返修位置示意图:

Draft of Welding Discontinuity:



产生原因:

Cause:

1. 火焰加热时, 水汽没有完全的去除或者这个区域预热不够;
1. Moisture wasn't completely removed during drying operation (preheating) or the area wasn't preheated sufficiently.

车间负责人 (Foreman):

Z. Zhang

日期 (Date):

10. 01. 19

处理意见

Disposition:

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
3. 去除热影响区域上在各个方向上不小于25mm范围内的油漆;
4. 将杂物以及MT检测遗留的残留物清理干净。然后采用打磨的方法去除裂纹, 打磨前预热至65° C。对于单个裂纹返修, 打磨返修范围为沿缺陷焊缝每一端加50mm, 对于多个裂纹的返修, 打磨返修范围为多个裂纹最外端的返修加长50mm;
5. 如果打磨时母材损伤, 则在返修前将损伤区域打磨干净; 如果打磨时或打磨后根部间隙大于5mm, 则在继续返修前另需提交文件给工程师予以审核批准, 并按照被批准的方法将角焊缝改成CJP焊缝;
6. 焊接前按照新的焊接返修工艺准备焊缝接头形式;
7. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在, 同时靠近裂纹的母材也要做MT, 保证没有裂纹延伸到母材。如果在母材上发现裂纹, 则另外需CWR, 且只有当这份另出的CWR批准后才能继续返修;
8. 将杂物以及MT检测遗留的残留物清理干净。按照WPS进行预热和焊接, 预热温度为160° C-230° C;
9. 焊接后WPS要求进行后热, 后热温度为230° C-315° C, 后热时间至少1个小时;
10. 后热后将焊缝逐渐冷却到周围环境温度, 并控制冷却速率不超过50° C每小时;
11. 后热后将修补区域打磨与母材或相邻焊缝平齐;
12. 在焊缝冷却至环境温度至少经过48小时以后进行NDT检查;
13. 返修后根据图纸进行MT检测, 并按照合同10-1.59“钢结构”中的“检测和试验”要求进行附加MT检测。对于CJP焊缝, NDT为VT, MT和UT。

1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements
2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
3. Remove paint ≥ 25 mm in all direction of HAZ prior to MT.
4. Clean the excavation area of all loose debris including MT powder. Preheat to 65° C before removing cracks by grinding, repair area shall extend a minimum of 50mm beyond each end of single crack repairs, and 50mm beyond the outermost cracks for multiple crack repairs
5. If base metal is damaged by grinding, the damaged area shall be ground clean prior to performing weld repair. If gap > 5 mm is found during or after grinding, comply with the notification on changing fillet weld to CJP which is submitted for Engineer's review and approval form.
6. Prepare excavation in accordance with the New Repair Procedure prior to welding.
7. Before this repair, Verify with VT and MT repair areas are defect free, and also MT shall be performed on the base metal laying abroad cracks to ensure that no cracks were propagated to the base metal. Separate CWR approval is needed if cracks are found in the base metal, and only after this new CWR's approval can continue the repair.
8. Clean excavation area of all loose debris including MT powder after excavation. Preheat and weld according to repair WPS, the preheat shall between 160° C-230° C
9. Perform post weld heating according to repair WPS, the postheat shall between 230° C-315° C and for one hour minimum.
10. Allow the weld to cool to ambient temperature gradually. Control cooling rate after PWHT to no more than 50° C per hour.
11. Grind the repaired area flush with base metal or the adjacent weld after post weld heating.
12. Wait 48 hours at least after the repair area has cooled to ambient temperature before performing NDT.
13. Perform MT inspection to all repair area according to Contract Drawings along with all additional NDT required by the applicable notes Special Provision Section 10-1.59 'Steel Structure', subsection 'inspection testing'. NDT includes VT, MT and UT if it is a CJP weld.

工艺:

Technical Engineer: *Y. J. Jia*

审核:

Approved By: *L. J. Jia*

日期:

Date:



关键焊缝返修报告

版本
Rev. No.:

Critical Welding Repair Report (CWR)

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	LD3022	报告编号 Report No.:	B-CWR1151
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	12 th lifting longitudinal diaphragm.	NDT 报告编号 NDT Report No.:	B787-MT-17930
项目编号 Project No.:	ZP06-787				

纠正措施:**Corrective Action to Prevent Re-occurrence:**

1. 返修前, QC确认有效的预热; 以将水汽全部去除。

1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.

车间负责人 (Foreman):

Li Zhigang

日期 (Date):

10.01.19

参照的WPS编号 Repair WPS No.:	WPS-345-SMAW-2G(2F)-Repair	工艺员 Technologist:	Xu Dongkai 10.01.19
返修(碳刨)前预热温度 Preheat Temperature Before Gouging:	70℃	返修的缺陷 Description of Discontinuity:	crack
焊前处理检查 Inspection Before Welding:	fa	焊前预热温度 Preheat Temperature Before Welding:	250℃
最大碳刨深度 Max. Depth of Gouge:	4mm	碳刨总长 Total Length of Gouge:	150mm
焊工 Welder:	045206	焊接类型 Welding Type:	SMAW
焊接电流 Current:	175A	焊接电压 Voltage:	25.1V
		焊接位置 Position:	2F
		焊接速度 Speed:	128 mm/min

返修后检查**Inspection After Repair:**

外观检查 VT Result:	Acc	检验员 Inspector:	chen xi	日期 Date:	20/01/26
NDT复检 NDT Result:	Acc	探伤员 NDT Person:	Tin Jianting	日期 Date:	1/26

见证:**Witness/Review:****备注:****Remark:**

#R787-QCP-900



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-17930R1		DATE日期 2010.01.26	PAGE OF页码 1/2	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: LD3022 12th lifting longitudinal diaphragm		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4		
REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 th , 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	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 材料, 厚度	A709M-345T2-X 22/25/14/18mm	
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT	

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
LD3022-001-006	1R1			ACC.		
	2R1			ACC.		
	3R1			ACC.		
LD3022-001-007	1R1			ACC.		
	2R1			ACC.		
	3R1			ACC.		
	4R1			ACC.		
	5R1			ACC.		
LD3022-001-010	1R1			ACC.		
	2R1			ACC.		
LD3022-001-013	1R1			ACC.		
	2R1			ACC.		
	3R1			ACC.		
LD3022-001-014	1R1			ACC.		

EXAMINED BY 主操 Jin Jianting <u>Jin Jianting</u>	REVIEWED BY 审核 Sun Gongchang <u>Sun Gongchang</u>
LEVEL - II SIGN 签名 / DATE日期 2010.01.26	LEVEL-II SIGN / DATE日期 2010.01.26
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B7B7-MT-17930R1 DATE日期 2010.01.26 PAGE OF页码 2/2 Revision No: 0

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

DRAWING NO. 图号: LD3022 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
 12th lifting longitudinal diaphragm

REFERENCING CODE 参考规范编码: AWS D1.5-2002 ACCEPTANCE STANDARD 接受标准: AWS D1.5-2002 PROCEDURE NO. 程序编号: ZPQC-MT-01 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 Material & thickness 母材,厚度: A709M-345T2-X
 CASTING 铸件 22/25/14/18mm
 FORGING 锻造

WELDING PROCESS 焊接方法: SMAW TYPE OF JOINT 焊缝类型: T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
	2R1			ACC.		
LD3022-001-019	1R1			ACC.		
	2R1			ACC.		
LD3022-001-020	1R1			ACC.		
LD3022-001-024	1R1			ACC.		
LD3022-001-027	1R1			ACC.		

AFTER B-WR10082,CWR1151

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EXAMINED BY 主检 Jin Jianting <i>Jin Jianting</i>	REVIEWED BY 审核 Sun Hongchong <i>Sun Hongchong</i>
LEVEL - II SIGN 签名 / DATE日期 2010.01.26	LEVEL-II SIGN / DATE日期 2010.01.26
质量经理 / QCM	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
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(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-000533**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0567**Type of problem:**

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

Date the Non-Conformance Report was written: 04-Jan-2010**Description of Non-Conformance:**

During random 10% verification Ultrasonic Testing (UT) of OBG Crossbeam 16, this Quality Assurance Inspector (QA) discovered the following issue:

One (1) Class "A" non conforming longitudinal indication measuring approximately 30 mm in length.

-The weld is a complete joint penetration (CJP) corner joint, joining Side Plate SP203A to Deck Plate DP204A and is identified as CB202A-016-002.

-The discontinuity rating is +3, Class "A" reject

-Depth of the discontinuity from face A is approximately 13 mm, and Y location was 1920mm when measured from the north end of the crossbeam.

-The Material thickness is 18 mm.

-The member is located in fabrication Bay 5.

-The indication is in an area previously tested and accepted by ZPMC QC UT technicians.

-The Notice of Witness Inspection Number (NWIT) is 004990.

Contractor's proposal to correct the problem:

Repair said indication and perform NDT required to verify weld quality.

Corrective action taken:

Contractor has submitted CWR along with subsequent NDT records verifying the weld is now in conformance with Contract specifications. An internal NCR was also issued by the Contractor in regards to this issue.

Did corrective action require Engineer's approval? Yes No

If so, name of Engineer providing approval:

Date:

Is Engineer's approval attached?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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
