

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-000617**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0590**Type of problem:**

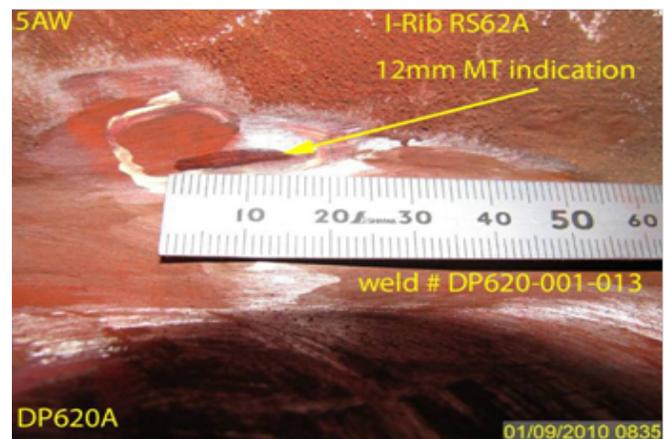
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 5AW Deck Panel
Procedural	Procedural	Description: Missed MT indication by QC	

Reference Description: Missed MT Indication by QC on 5AW Deck Panel**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5AW, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Longitudinal linear indication measuring approximately 12mm in length.
- The weld is identified as: DP620-001-013.
- This Fillet Weld joins I-Rib RS62A to Deck Plate DP620A in Corner Assembly CA15A.
- These welds are designated as Non-Seismic Performance Critical Member (SPCM).

The Notice of Witness Inspection Number (NWIT) is 005016. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

**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.”

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

-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: Dan Hernandez

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 1020 hours, 01-09-10, Email

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 2300 hours, 01-09-10, Email

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
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Reviewed By:	Wahbeh, Mazen	SMR
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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: 10-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: 05.03.06-000580

Subject: NCR No. ZPMC-0590

Reference Description: Missed MT Indication by QC on 5AW Deck Panel

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

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG **Lift:** 05

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5AW, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Longitudinal linear indication measuring approximately 12mm in length.
- The weld is identified as: DP620-001-013.
- This Fillet Weld joins I-Rib RS62A to Deck Plate DP620A in Corner Assembly CA15A.
- These welds are designated as Non-Seismic Performance Critical Member (SPCM).

The Notice of Witness Inspection Number (NWIT) is 005016. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Missed MT indications have become a chronic issue. Provide training and equipment such that the ZPMC MT technician can recognize 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-0590

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: 05.03.06-000580

Subject: NCR No. ZPMC-0590

Dated: 18-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000506 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: As a means of preventing future occurrences, the ABF QCM has performed refresher MT training. See attached MT 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 MT training. See attached MT training agenda and attendance roster. The ABF QCM has been discussing missed MT indications with the ZPMC QCM and related NDT supervisory personnel. The ZPMC level III is in the process of assessing personnel, techniques and equipment. Preliminary findings have resulted in ZPMC taking immediate action by performing 100% overchecks of the previously tested areas beginning the week of 18 January 09 as a means of preventing future NCR's for missed indications. ABF has purchased powder dispensers for all the ZPMC MT technicians as a means to help control the amount of powder applied during MT testing. 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-000506R00;

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

Date: 25-Jan-2010

Attachment(s):

Tool Box Training Agenda

Subject: MT Techniques

Reason for Training: Several CT NCR's of indications missed during ZPMC NDT inspection.

1. Safety

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

2. Tools

- a. Lighting
- b. MT Powder. Red for ambient, Yellow for High Temperature.
- c. Powder Bulb
- d. Powder Blower
- e. MT Yoke Adequate working condition
- f. Pie Gage

3. Inspection Techniques

- a. Lighting
- b. Position of body (distance of eyes to the weld surface)
- c. Application of Powder removal of Powder
- d. Continuous method
- e. Two directions
- f. Both sides of weld
- g. Clean and dry surface



教育培训纪录

培训编号: MT-22-Dec-09

培训内容:	MT Techniques
培训对象:	项目质检
授课人员:	Steve Lawton
培训类型:	内部培训
培训时间:	22-Dec-09 5:00 PM
计划培训地点:	ZPMC QC office

人员签到:

姓名	部门	姓名	部门
孙力杰 Sunlei	钢桥	狄坤伦 Di Kunlun	钢桥
孙广强 Sun Guangqiang	钢桥	蔡新鑫 Cai Xinxin	钢桥
徐海 Xu Hai	钢桥	傅春强 Fu Chunqiang	钢桥
卞源源 Bian Yuanyuan	钢桥	顾云武 Gu Yunwu	钢桥
许兵 Xu Bing	钢桥	金建廷 Jin Jianting	钢桥 MT
李振华 Li Zhenhua	钢桥	常方杰 Chang Fangjie	钢桥
李坤阳 Li Xunyang	QA	袁俊 Yuan Jun	钢桥
王威 Wang Wei	钢桥	刘章敏 Liu Zhangmin	
孙林 Sun Lin	钢桥 MT	徐华祥 Xu Huaxiang	钢桥
丁阿成 Ding A Cheng	钢桥 MT	周东超 Zhou Dongchao	钢桥
贺佳佳 He Jiajia	钢桥	赵成功 Zhao Cheng Gong	钢桥
黄瑞 Huang Rui	钢桥	孙广强 Sun Guangqiang	钢桥
李黎明 Li Liming	钢桥	徐辉 Xu Hui	钢桥
李昌涛 Li Changtao		刘宏斌 Liu Hongbin	

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000580

Subject: NCR No. ZPMC-0590

Dated: 01-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000506 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: This item has been closed on the punchlist and the attached documentation shows it is acceptable.

ZPMC has repaired the indication noted in the NCR and issued an internal NCR to make the production and QA team responsible aware of the non conformance. This item has been closed on the punchlist and the attached documentation shows it is acceptable. In addition, the MT inspectors have been equipped with magnetic powder bulbs to improve the application of powder and have attended training both internally with ZPMC and ABFJV. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000506R01;

Caltrans' comments:

Status: CLO

Date: 08-Mar-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Attachment(s):

Date: 08-Mar-2010



No. B-625

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-2-28

REGARDING: NCR-000617 (ZPMC-0590)

With this letter of response, ZPMC requests closure of CT NCR-000617 (ZPMC-0590) what mentioned that Missed MT indications were observed by CT inspector.

- ZPMC acknowledged this problem and has issued internal NCR.
- CWR was issued reflecting to this deflection. The deflections has been removed, repaired, tested and accepted after then.
- The punch list item 386 what mentioned this NCR has been confirmed and closed by CT inspector.
- To improve the MT method, refresh training was performed to ZPMC's MT personnel by ABF QCM.

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

ATTACHMENT:

NCR-000617 (ZPMC-0590)

NCR-B-387(ZPMC-0590)

B-CWR1113

B787-MT-18030 R1

A handwritten signature in black ink, appearing to be "Jing W", is located below the attachment list.

2/28/10



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: 10-Jan-2010
Contract No: 04-0120F4
04-SF-80-13.2 / 13.9
Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Job Name: SAS Superstructure
Document No: 05.03.06-000580
Subject: NCR No. ZPMC-0590
Reference Description: Missed MT Indication by QC on 5AW Deck Panel

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Material Location: OBG

Lift: 05

Remarks:

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Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0590

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-000617**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0590**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Segment 5AW Deck PanelProcedural Procedural Description: Missed MT indication by QC**Reference Description:** Missed MT Indication by QC on 5AW Deck Panel**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5AW, this Quality Assurance Inspector (QA) discovered the following issues:

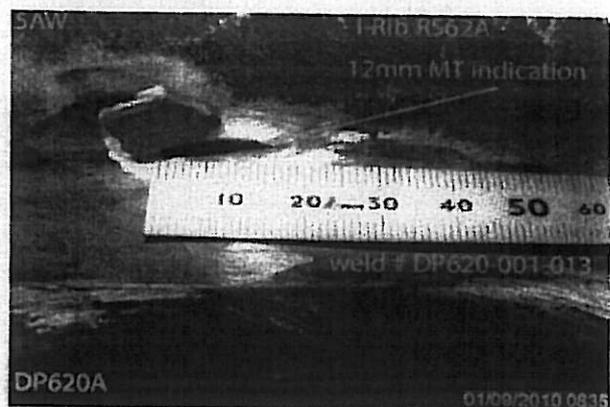
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

-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: Dan Hernandez

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 1020 hours, 01-09-10, Email

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 2300 hours, 01-09-10, Email

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



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-387(ZPMC-0590)
Item: Welding without run-off tabs 名称描述: 焊接未使用引熄弧板	Item Number: 件号: 5AW	Drawing: 图号: N/A
Location: OBG Trial Assembly Yard 位置: OBG 外场拼装场地		Date: 日期: 2010-01-15

Description of Nonconformance:

During QA MT review of welds located on Segment 5AW, this QA discovered the following issues:

- One Longitudinal linear indication measuring approximately 12mm in length.
- The weld is identified as: DP620-001-013.
- This Fillet Weld joins I-Rib RS62A to Deck Plate DP620A in Corner Assembly CA15A.
- These welds are designated as Non-SPCM.

The notice of Witness Inspection Number is 005016. The indication is located inside the area that has been previously tested and accepted by ZPMC QC personnel.

加州检验员在对箱体 5AW 进行检验时发现以下情况:

- 发现一线性缺陷长约 12mm
 - 焊缝为 DP620-001-013
 - 角焊缝涉及 I 肋 RS62A, 顶板 DP620A, 位于角单元 CA15A
 - 这些焊缝为非 SPCM
- 预约单为 005016, 缺陷在之前 ZPMC 的检验范围内。

Work By: <u>L. Liming</u> 施工方: <u>2010.02.27</u>	Prepared by: 准备:	Reviewed by QCE: 质量工程师批准:
<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:

复检, 返修. Re-inspection and repair.

Prepared by: <u>L. Liming</u> 准备: <u>2010.02.27</u>	Approved by QCA: _____ 质量经理批准
--	----------------------------------

Reason for Nonconformance:

不符合原因:

线性缺陷漏检.
Discover linear defect.

Prevention of Re-occurrence:

预防措施:

加强现场检验, 提高检验能力.

Enhance inspection on-site to improve inspection ability

Approved by/批准: L. Liming 10/22/17

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: _____



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.:	OBW5	报告编号 Report No.:	B-CWR1113
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	5AW CORNER ASSE MBLY I-RIB	NDT 报告编号 NDT Report No.:	B787-MT-18030
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对DP620-001-013检测时, 发现1处纵向裂纹. L1=10mm

Welder ID No. (焊工编号): 066261

Position:(位置): 4F

One longitudinal crack was found by use of MT on DP620-001-013.

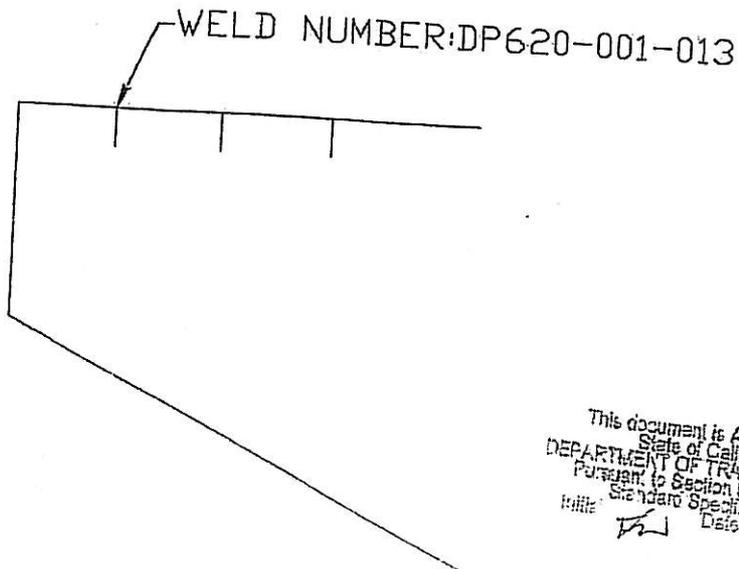
Please see the detail data from MT report!

检验员 (Inspector): Ding Acheng

日期 (Date): 2010-01-16

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 6-1.02 of the
Standard Specifications
Date: 1/21/10

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):

Ma Ruiqun

日期 (Date):

10.01.17

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。
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 > 5mm 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.

工艺:

Technical Engineer:

审核:

Approved By:

日期:

Date:



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.:	OBW5	报告编号 Report No.:	B-CWR1113
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	5AW CORNER ASSE MBLY I-RIB	NDT 报告编号 NDT Report No.:	B787-MT-18030
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):

Ma Puquan

日期 (Date):

10.01.17

参照的 WPS 编号 Repair WPS No.:	WPS-345+485-SMAW-4G(4F) -Repair -1	工艺员 Technologist:	Xu Donghai 10.01.18
返修 (碳刨) 前预热温度 Preheat Temperature Before Gouging:	170°C	返修的缺陷 Description of Discontinuity:	etching
焊前处理检查 Inspection Before Welding:	Am	焊前预热温度 Preheat Temperature Before Welding:	174°C
最大碳刨深度 Max. Depth of Gouge:	3.2m	碳刨总长 Total Length of Gouge:	120m
焊工 Welder:	066261	焊接类型 Welding Type:	Smjsw
焊接电流 Current:	124	焊接电压 Voltage:	23
		焊接位置 Position:	4F
		焊接速度 Speed:	146

返修后检查
Inspection After Repair:

外观检查 VT Result:	Am	检验员 Inspector:	Lu Jie	日期 Date:	2010.01.23
NDT 复检 NDT Result:	MT: Acc	探伤员 NDT Person:	Yang Aicheng	日期 Date:	2010-01-23

见证:
Witness/Review:备注:
Remark:

#R787-QCP-900

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
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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-000532**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0590**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: 09-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5AW, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Longitudinal linear indication measuring approximately 12mm in length.
- The weld is identified as: DP620-001-013.
- This Fillet Weld joins I-Rib RS62A to Deck Plate DP620A in Corner Assembly CA15A.
- These welds are designated as Non-Seismic Performance Critical Member (SPCM).

The Notice of Witness Inspection Number (NWIT) is 005016. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

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?** 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
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Reviewed By:	Wahbeh, Mazen	QA Reviewer
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