

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-000637

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Jan-2010

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

NCR #: ZPMC-0610

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: West Tower Lift 4
Procedural	Procedural	Description:	

Reference Description: ZPMC used different type filler wires performing the weld repair at the joint connecting 345 grade to 485 grade material located at West Tower Lift 4

Description of Non-Conformance:

During the random Quality Assurance(QA) in process verification of West Tower lift 4, this QA Inspector observed the following issues:

- ZPMC welding personnel performing weld repair of B/C corner seam of West tower lift 4 using Flux Cored Arc Welding (FCAW) process.
- The weld numbers are identified as WSTL4-2L/L-3A/B for 485 grade material and WSTL4-2B/L-58A/B for 345 grade material.
- ZPMC personnel performing the weld repair at the joint connecting 345 grade to 485 grade material using WPS-345-FCAW-1G(1F)-REPAIR with Supercored 71H filler wire.
- The required filler wire for welding of these joints is K-71TSR with WPS-345+485-FCAW-1G-REPAIR.
- The weld joint is a Complete Joint Penetration (CJP) weld.
- The material is designated as non Seismic Performance Critical Member (non SPCM).
- The member is located at Tower bay no. 11.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

1. AWS D1.5 2002 section 6.3.1: "The Inspector shall make certain that all WPSs are qualified in conformance with Section 5 of this code. The Inspector shall make certain that each welding operation is covered by a written WPS and that such WPSs are available to the welders and Inspectors for reference".
2. AWS D1.5 2002 section 12.17.1.1: "The Contractor may use preapproved repair WPSs as soon as the QA inspector has verified the discontinuity to be repaired is covered by the WPS".
3. Approved WPS: WPS-345+485-FCAW-1G-REPAIR.

Who discovered the problem: Umesh Gaikwad

Name of individual from Contractor notified: You Yuan Mao

Time and method of notification: 1040 Hrs, 01/17/10, Verbal

Name of Caltrans Engineer notified: Ken Lee

Time and method of notification: 1815 Hrs, 01/17/10, Verbal

QC Inspector's Name: Peng Guo

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

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: Ng,Michael

QA Inspector

Reviewed By: Wahbeh,Mazen

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 19-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-0610

Job Name: SAS Superstructure
Document No: 05.03.06-000597

Reference Description: Incorrect WPS/ West Shaft Lift 4/ B/C Corner Seam

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: Tower **Lift:** 04

Remarks:

- During the random Quality Assurance(QA) in process verification of West Tower lift 4, this QA Inspector observed the following issues:
- ZPMC welding personnel performing weld repair of B/C corner seam of West tower lift 4 using Flux Cored Arc Welding (FCAW) process.
 - The weld numbers are identified as WSTL4-2L/L-3A/B for 485 grade material and WSTL4-2B/L-58A/B for 345 grade material.
 - ZPMC personnel performing the weld repair at the joint connecting 345 grade to 485 grade material using WPS-345-FCAW-1G(1F)-REPAIR with Supercored 71H filler wire.
 - The required filler wire for welding of these joints is K-71TSR with WPS-345+485-FCAW-1G-REPAIR.
 - The weld joint is a Complete Joint Penetration (CJP) weld.
 - The material is designated as non Seismic Performance Critical Member (non SPCM).
 - The member is located at Tower bay no. 11.

AWS D1.5 2002 section 6.3.1: "The Inspector shall make certain that all WPSs are qualified in conformance with Section 5 of this code. The Inspector shall make certain that each welding operation is covered by a written WPS and that such WPSs are available to the welders and Inspectors for reference".

AWS D1.5 2002 section 12.17.1.1: "The Contractor may use preapproved repair WPSs as soon as the QA inspector has verified the discontinuity to be repaired is covered by the WPS".

Approved WPS: WPS-345+485-FCAW-1G-REPAIR.

Action Required and/or Action Taken:

The above referenced weld repair is rejected. In accordance with Section 5-1.09, "Removal of Rejected And Unauthorized Work", of the Standard Specifications, this weld repair is to be removed and replaced with the proper filler wire utilizing the correct WPS.

In addition, to the material/workmanship non-conformance, propose a resolution for the identified non-conformance that addresses the

NCT

(Continued Page 2 of 2)

failure of Quality Control to identify the deficiency.

Provide documentation of the steps/actions taken by the Quality Control Manager with regard to both Production and Quality Control to prevent future occurrences.

Transmitted by: Ken Lee Transportation Engineer

Attachments: ZPMC-0610

cc: Rick Morrow, Gary Pursell, Mark Woods, Scott Kennedy

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000597

Subject: NCR No. ZPMC-0610

Dated: 09-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000588 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has completely removed the weld in question and rewelded it using the correct filler metal. NDT documentation will be provided at a later date, based on this ZPMC request closure of this NCR.

ZPMC has completely removed the weld in question and rewelded it using the correct filler metal. NDT documentation will be provided at a later date, based on this ZPMC request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000588R00;

Caltrans' comments:

Status: AAP

Date: 09-Feb-2010

The Department will consider closure of this NCR once NDT documentation is submitted and reviewed.

Submitted by: Lee, Ken

Attachment(s):

Date: 09-Feb-2010



No. T-127

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-2-09

REGARDING: NCR-000637(ZPMC-0610)

ZPMC received NCR-000637(ZPMC-0610), it mentioned that CT inspector observed ZPMC welding personnel performed the weld repair of B/C corner seam of West tower lift 4 using FCAW process during random QA in process inspection, which the required filler wire for welding of these joints is K-71TSR with WPS-345+485-FCAW-1G-repair.

ZPMC acknowledged this problem. Due to a repairing area at the joint of 345+485, the filler material should be cooperated with the 485 material. The welder did not noticed the conversion of material and repaired wrongly along with gouging groove. After notified by CT inspector, ZPMC took the action right away that the wrong filler metal was removed by gouging. And ZPMC NDT technician performed the MT for the gouging area. Under the verification of no indication, ZPMC resumed the repairing.

Late, ZPMC will provide the relevant NDT reports after all work done, hoping CT could close this NCR at that time.

ATTACHMENT:

NCR-000637(ZPMC-0610)


2010-2-9

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



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 690 Walnut Ave. St. 150
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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000637

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Jan-2010

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

NCR #: ZPMC-0610

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

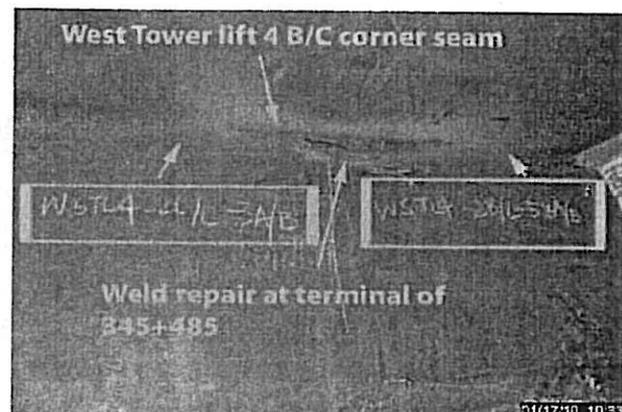
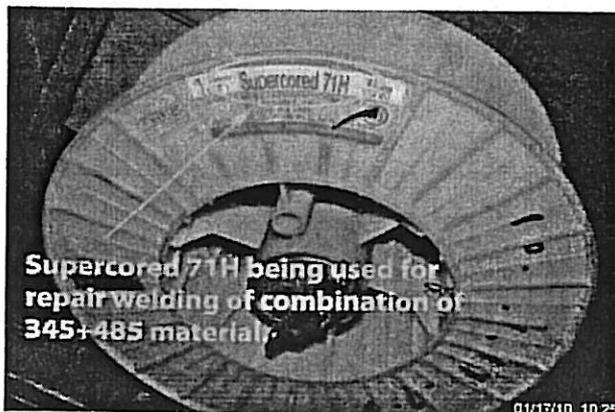
Component: West Tower Lift 4

Reference Description: ZPMC used different type filler wires performing the weld repair at the joint connecting 345 grade to 485 grade material located at West Tower Lift 4

Description of Non-Conformance:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Who discovered the problem: Umesh Gaikwad

Name of individual from Contractor notified: You Yuan Mao

Time and method of notification: 1040 Hrs, 01/17/10, Verbal

Name of Caltrans Engineer notified: Ken Lee

Time and method of notification: 1815 Hrs, 01/17/10, Verbal

QC Inspector's Name: Peng Guo

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

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: Ng, Michael

QA Inspector

Reviewed By: Wahbeh, Mazen

SMR

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000597

Subject: NCR No. ZPMC-0610

Dated: 18-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000588 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: Per the Department's comments ZPMC is providing NDT documentation of the new weld which shows that it is acceptable. Based on this ZPMC requests closure of this NCR.

Per the Department's comments ZPMC is providing NDT documentation of the new weld which shows that it is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000588R01;

Caltrans' comments:

Status: CLO

Date: 18-Mar-2010

This proposed resolution is acceptable. The Department concurs that Non-conformance ZPMC-0610 is closed.

Submitted by: Lee, Ken

Date: 18-Mar-2010

Attachment(s):



No. T-133

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-3-18

REGARDING: NCR-000637(ZPMC-0610)

ZPMC received NCR-000637(ZPMC-0610), it mentioned that CT inspector observed ZPMC welding personnel performed the weld repair of B/C corner seam of West tower lift 4 using FCAW process during random QA in process inspection, which the required filler wire for welding of these joints is K-71TSR with WPS-345+485-FCAW-1G-repair.

According to ZPMC's last Response letter No. T-127 and CT's comments in ABF-NPR-000588 Rev00: The Department will consider closure of this NCR once NDT documentation is submitted and reviewed, herewith ZPMC provide the relevant NDT reports after all work done, hoping CT could close this NCR.

ATTACHMENT:

NCR-000637(ZPMC-0610)

ABF-NPR-000588 Rev00

T787-MT-8135

T787-UT-2684

Zhang Jiaoli

2010-3-18



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 19-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-0610

Job Name: SAS Superstructure
Document No: 05.03.06-000597

Reference Description: Incorrect WPS/ West Shaft Lift 4/ B/C Corner Seam

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: Tower

Lift: 04

Remarks:

During the random Quality Assurance(QA) in process verification of West Tower lift 4, this QA Inspector observed the following issues:

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AWS D1.5 2002 section 6.3.1: "The Inspector shall make certain that all WPSs are qualified in conformance with Section 5 of this code. The Inspector shall make certain that each welding operation is covered by a written WPS and that such WPSs are available to the welders and Inspectors for reference".

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Approved WPS: WPS-345+485-FCAW-1G-REPAIR.

Action Required and/or Action Taken:

The above referenced weld repair is rejected. In accordance with Section 5-1.09, "Removal of Rejected And Unauthorized Work", of the Standard Specifications, this weld repair is to be removed and replaced with the proper filler wire utilizing the correct WPS.

In addition, to the material/workmanship non-conformance, propose a resolution for the identified non-conformance that addresses the

NCT

(Continued Page 2 of 2)

failure of Quality Control to identify the deficiency.

Provide documentation of the steps/actions taken by the Quality Control Manager with regard to both Production and Quality Control to prevent future occurrences.

Transmitted by: Ken Lee Transportation Engineer

Attachments: ZPMC-0610

cc: Rick Morrow, Gary Pursell, Mark Woods, Scott Kennedy

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
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 Quality Assurance and Source Inspection

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Jan-2010

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

NCR #: ZPMC-0610

Type of problem:

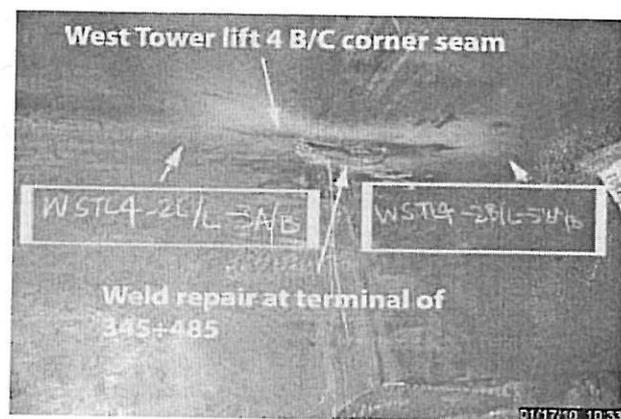
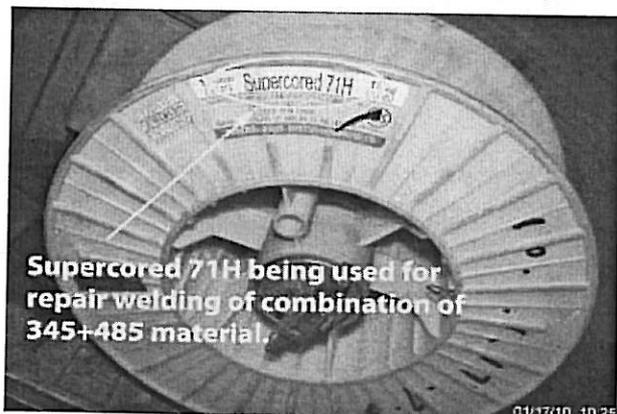
Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: West Tower Lift 4
 Procedural Procedural Description:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Name of Caltrans Engineer notified: Ken Lee

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Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

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Inspected By: Ng, Michael

QA Inspector

Reviewed By: Wahbeh, Mazen

SMR



AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 23223 Oakland, CA 94623

Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

to: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607
Attention: Pursell, Gary
Resident Engineer
Ref: 05.03.06-000597
Subject: NCR No. ZPMC-0610

Dated: 09-Feb-2010
Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9
Job Name: SAS Superstructure
Document No.: ABF-NPR-000588 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has completely removed the weld in question and rewelded it using the correct filler metal. NDT documentation will be provided at a later date, based on this ZPMC request closure of this NCR.

ZPMC has completely removed the weld in question and rewelded it using the correct filler metal. NDT documentation will be provided at a later date, based on this ZPMC request closure of this NCR.

Submitted by: Ishibashi, Joshua
Attachment(s): ABF-NPR-000588R00;

Caltrans' comments:

Status: AAP

Date: 09-Feb-2010

The Department will consider closure of this NCR once NDT documentation is submitted and reviewed.

Submitted by: Lee, Ken
Attachment(s):

Date: 09-Feb-2010

RECEIVED
FEB 10 2010
AMERICAN BRIDGE/FLUOR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-8135 DATE日期 2010.03.14 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: WSTL4-2B/L L/L CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
FOURTH LIFTING TOWER(W)

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: 5620 5395 5617

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-Z/A709M-HPS-485WT2-Z 90mm

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			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
WSTL4-2B/L-58A/B				ACC.		AFTER REPAIRED
WSTL4-2L/L-3A/B				ACC.		AFTER REPAIRED

AFTER T-WR3032

BLANK

EXAMINED BY 主探: Xu bing *Xu bing*

LEVEL - II SIGN 签名 / DATE日期: 2010.03.16

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核: *Caixin dia*

LEVEL-II SIGN / DATE日期: 2010.03.16

用户CUSTOMER

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-2684 DATE 2010.02.01 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: FOURTH LIFTING TOWER(W) DRAWING NO.: WSTL4-2B/L L/L CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

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

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

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709M-HPS-485T2-Z /A709M-345T2-Z 90mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm	Changchao	45°	2.5MHz	18×18mm
Changchao	0°	2.5MHz	20mm				

Reference Level 参考灵敏度

20dB

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									a	b	c	d	Length 长度			Sound Path 声程
WSTL4-2B/L-58A/B		70					34								ACC.	100%
		45					32								ACC.	100%
WSTL4-2L/L-3A/B		70					34								ACC.	100%
		45					32								ACC.	100%

AFTER T-WR3032

BLANK

EXAMINED BY 主探 <i>Dai Gang Shang</i>	REVIEWED BY 审核 <i>Zhuoqi</i>
LEVEL - II SIGN / DATE <i>2010.02.01</i>	LEVEL - II SIGN / DATE <i>2010.02.01</i>
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
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000542**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0610**Type of problem:**

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

Date the Non-Conformance Report was written: 17-Jan-2010**Description of Non-Conformance:**

During the random Quality Assurance(QA) in process verification of West Tower lift 4, this QA Inspector observed the following issues:

- ZPMC welding personnel performing weld repair of B/C corner seam of West tower lift 4 using Flux Cored Arc Welding (FCAW) process.
- The weld numbers are identified as WSTL4-2L/L-3A/B for 485 grade material and WSTL4-2B/L-58A/B for 345 grade material.
- ZPMC personnel performing the weld repair at the joint connecting 345 grade to 485 grade material using WPS-345-FCAW-1G(1F)-REPAIR with Supercored 71H filler wire.
- The required filler wire for welding of these joints is K-71TSR with WPS-345+485-FCAW-1G-REPAIR.
- The weld joint is a Complete Joint Penetration (CJP) weld.
- The material is designated as non Seismic Performance Critical Member (non SPCM).
- The member is located at Tower bay no. 11.

Contractor's proposal to correct the problem:

Remove incorrect weld material, reweld, and verify with NDT.

Corrective action taken:

Weld material was removed and rewelded with the correct filler material. Weld was verified by MT (T787-MT-8135) and UT (T787-UT-2684).

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 Skyler Guest, 15000422360, who represents the Office of

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Structural Materials for your project.

Inspected By: Guest,Skylar

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer
