

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-000674

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Feb-2010

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

NCR #: ZPMC-0642

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Suspender Bracket for Lift 6 West
Procedural	Procedural	Description:	

Reference Description: New welds built up were performed by ZPMC in 2 Suspender Brackets for Lift 6 West. The operation was done without Engineer's Approval

Description of Non-Conformance:

During random in process observation of the fabrication of the OBG suspenders brackets, this Quality Assurance Inspector (QA) discovered the following issue:

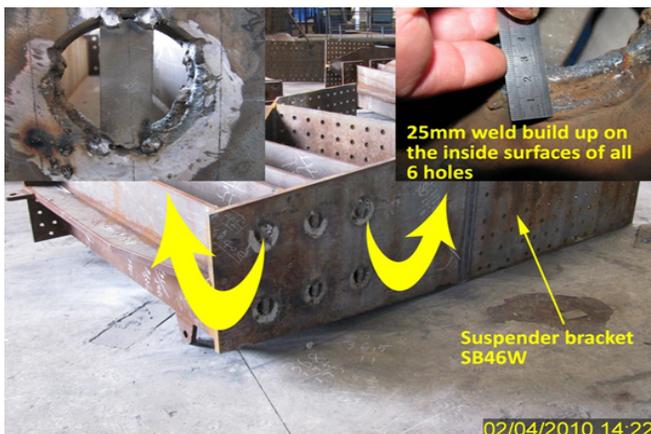
ZPMC personnel have performed weld built up the inside surfaces of suspender rod holes with weld metal without the approval of the Engineer. ZPMC introduced new welds that were not specified in the approved shop drawings.

-The suspender brackets are designated as Tension Member/Stress Reversal Members (TM/SRM) in the contract documents.

-The suspender brackets affected are identified on the material as SB42W (for Segment 6BW) and SB46W (for Segment 6CW).

-This condition exists on all six (6) rod holes on both of the above mentioned brackets.

-Both of the above mentioned suspender brackets are located in OBG bay 19.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5 2002 section 3.7.4 specifies "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies."

AWS D1.5 2002 section 3.7.7.2 specifies "Base metal subject to dynamic tensile stress may be restored by welding providing the following apply:

(1) The Engineer approves both repair by welding and the repair WPS"

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 02-04-10_18:30_Email

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 02-05-10_12:00_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, +(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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NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000632

Subject: NCR No. ZPMC-0642

Dated: 23-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000632 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC acknowledges that a CWR should have been issued in this case. ZPMC is providing the WRR that was sued at the time as well as the NDT after to show that the base metal repair was successful.

ZPMC acknowledges that a CWR should have been issued in this case. ZPMC is providing the WRR that was sued at the time as well as the NDT after to show that the base metal repair was successful. In the future, ZPMC acknowledges that greater attention must be paid to avoid these types of NCRs. Based on this, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000632R00;

Caltrans' comments:

Status: CLO

Date: 05-Apr-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0642 is closed.

Submitted by: Eagen, Sean

Attachment(s): NPR CT Comments

Date: 05-Apr-2010



No. B-707

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-22

REGARDING: NCR-000674 (ZPMC-0642)

ZPMC acknowledged this problem and ZPMC QA has instructed production department and QC department of the requirement of AWS D1.5 2002 section 3.7.7.2 that "Base metal subject to dynamic tensile stress may be restored by welding providing the following apply: (1) The Engineer approves both repair by welding and the repair WPS." ZPMC will pay more attention on such base metal repair. ZPMC is providing the WRRs and NDT records show the repair procedure and the soundness of base metal after repair. This issue has been confirmed and removed from punchlist by CT's representative. Based on this ZPMC is requesting this NCR to be closed.

ATTACHMENT:

NCR-000674 (ZPMC-0642)

B-WR10612

B787-MT-19540

B787-UT-11266

B-WR10613

B787-MT-19541

B787-UT-11267

A handwritten signature in black ink, appearing to be 'J. M. W.' or similar, written in a cursive style.

3/22/10



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: 06-Feb-2010

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

Job Name: SAS Superstructure

Document No: 05.03.06-000632

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0642

Reference Description: New welds built up were performed by ZPMC in 2 Suspender Brackets for Lift 6 West. The operation was done without Engi

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: 06

Remarks:

During random in process observation of the fabrication of the OBG suspenders brackets, this Quality Assurance Inspector (QA) discovered the following issue:

ZPMC personnel have performed weld built up the inside surfaces of suspender rod holes with weld metal without the approval of the Engineer. ZPMC introduced new welds that were not specified in the approved shop drawings.

- The suspender brackets are designated as Tension Member/Stress Reversal Members (TM/SRM) in the contract documents.
- The suspender brackets affected are identified on the material as SB42W (for Segment 6BW) and SB46W (for Segment 6CW).
- This condition exists on all six (6) rod holes on both of the above mentioned brackets.
- Both of the above mentioned suspender brackets are located in OBG bay 19.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0642

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

02.02:15.04
05.03.06-000632,NCT

Received
NCT-000632 08 Feb 10 Page 1 of 1

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 #: 04-0120F4
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-000674

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Feb-2010

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

NCR #: ZPMC-0642

Type of problem:

Welding Concrete Other
Welding Curing Procedural
Joint fit-up Coating Other
Procedural Procedural Description:

Bridge No: 34-0006

Component: Suspender Bracket for Lift 6 West

Reference Description: New welds built up were performed by ZPMC in 2 Suspender Brackets for Lift 6 West. The operation was done without Engineer's Approval

Description of Non-Conformance:

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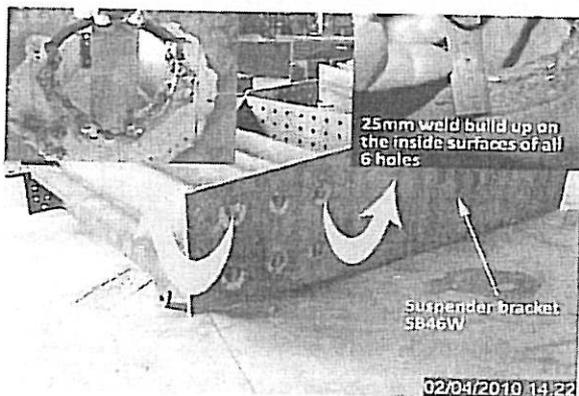
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5 2002 section 3.7.4 specifies "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies."

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Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 02-04-10_18:30_Email

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 02-05-10_12:00_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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric	SMR
Reviewed By: Wahbeh, Mazen	SMR



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	SB42W	报告编号 Report No.	B-WR10612
合同号 Contract No.:	04-0120F4	部件名称 Items Name	悬索支架 Suspending Bracke t	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

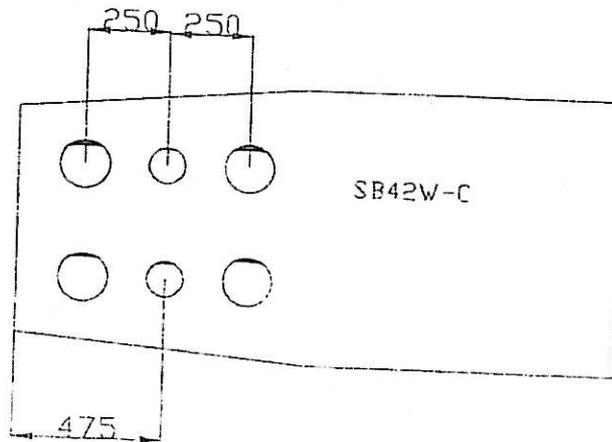
根据检查报告 ZP06-787-J-B-1361 工艺处理意见, 悬索支架 SB42W-C 如图阴影部分所示的孔的位置需堆焊 15mm.

Suspending bracket (SB42W-C) was needed to build-up 15mm according to inspection report (ZP06-787-J-B-1361).

检验员 (Inspector): Zhou Cheng 日期(Date): 10.01.30

焊缝返修位置示意图:

Draft of welding discontinuity:



产生原因:

Caused:

焊接变形和制作误差。

Weld distortion and fabricate error.

车间负责人(Foreman): *Hu Yushu* 日期(Date): 10.01.30

处理意见

Disposition:

1. 将孔采用碳刨的方法拓宽，并打磨平滑，拓宽的孔应符合修补WPS中的接头细节。碳刨前应根据相应的WPS进行预热；
 2. 焊接前采用VT检测确保无缺陷存在；
 3. 贴加钢衬垫，根据返修WPS进行预热及焊接，焊接时采用线状纵向进行补焊；
 4. 去除衬垫，根部焊道反面碳刨清根焊接；
 5. 焊后将焊缝打磨与周围母材齐平；
 6. 采用进行VT、UT、MT对返修区域进行检测；
 7. 按照图纸及检查报告ZP06-787-J-B-1361处理意见重新钻孔；
1. Elongate the hole by arc gouging, and grind smooth the surface. The elongated hole should conform to the joint detail in Repair WPS. Preheat before gouging according to relevant WPS.
 2. Perform VT to ensure no defects exist.
 3. Add steel backing. Preheat and weld according to the repair WPS, weld stringers longitudinally along the elongated direction of the hole.
 4. Remove steel backing and back gouge the root pass, and complete the welding.
 5. Grind the repair area flush with adjacent base metal.
 6. Check with VT, UT, MT after welding to the repair area.
 7. Drill new holes according to work drawings and disposition of Inspection Report ZP06-787-J-B-1361.

工艺:
Technical engineer

He Xiaolin

审核:
Approved by

Lu Tianhua

日期
Date

10.01.31



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	SB42W	报告编号 Report No.	B-WR10612
合同号 Contract No.:	04-0120F4	部件名称 Items Name	悬索支架 Suspending Bracke t	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

加强制作过程中的监控, 减少误差。

Enhance supervision in process of fabrication to reduce error.

车间负责人(Foreman): He Yushan 日期(Date): 10.01.30

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair	工艺员 technologist	<u>He Xiaolin</u> <u>10.01.30</u>
返修(碳刨)前预热温度 Preheat temperature before gouging	<u>NA</u>	返修的缺陷 Description of discontinuity	<u>defect</u>
焊前处理检查 Inspection before welding	<u>Am</u>	焊前预热温度 Preheat temperature before welding	<u>115</u>
最大碳刨深度 Max. depth of gouging	<u>NA</u>	碳刨总长 Total length of gouging	<u>NA</u>
焊工 welder	<u>0627x6</u>	焊接类型 welding type	<u>SMAW</u>
焊接电流 Current	<u>158</u>	焊接电压 Voltage	<u>24.6</u>
返修后检查 Inspection After repairing:		焊接位置 position	<u>14</u>
外观检查 VT result	<u>Am</u>	焊接速度 Speed	<u>146</u>
NDT复检 NDT result	<u>up Am</u> <u>MT Acc</u>	检验员 Inspector	<u>Zhu zhanghan</u> <u>57072101</u>
见证: Witness/Review:		日期 Date	<u>10.02.28</u>
备注: Remark:		探伤员 NDT person	<u>Sun X</u> <u>Xu Hua Yang</u>
		日期 Date	<u>10.02.25</u> <u>2010-02-25</u>

#R787-QCP-900



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-11266 DATE 2010.02.25 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: SUPPORT BEAM DRAWING NO.: SB46W-C 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
 NA NA Dec. 28ST, 2010

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

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2-X 35mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	Reference Level 参考灵敏度		20dB	

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

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SB46W-C		70				32								ACC.	100%
		0				20								ACC.	100%

BASE METAL PER B-WR10613

BLANK

EXAMINED BY 主探 Sun Yin REVIEWED BY 审核 Huang Jing

LEVEL - II SIGN / DATE 10.02.25 LEVEL - II SIGN / DATE 10.02.25

质量经理 / QCM 用户CUSTOMER

签字 SIGN / 日期 DATE 签字 SIGN / 日期 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	SB46W	报告编号 Report No.	B-WR10613
合同号 Contract No.:	04-0120F4	部件名称 Items Name	悬索支架 Suspending bracke t	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

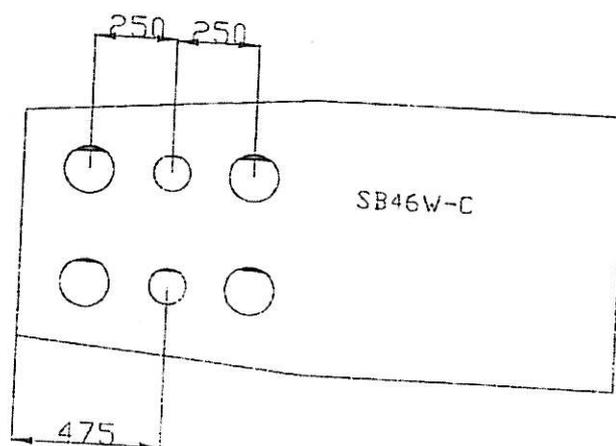
根据检查报告 ZP06-787-J-B-1361 工艺处理意见, 悬索支架 SB46W-C 如图阴影部分所示的孔的位置堆焊 15mm.

Suspending bracket (SB46W-C) was needed to build-up 15mm according to inspection report (ZP06-787-J-B-1361).

检验员 (Inspector): Zhou Cheng 日期 (Date): 10.01.30

焊缝返修位置示意图:

Draft of welding discontinuity:



产生原因:

Caused:

焊接变形和制作误差。

Weld distortion and fabricate error.

车间负责人(Foreman): *Hu Yuntang* 日期(Date): 10.01.30

处理意见

Disposition:

1. 将孔采用碳刨的方法拓宽，并打磨平滑，拓宽的孔应符合修补WPS中的接头细节。碳刨前应根据相应的WPS进行预热；
 2. 焊接前采用VT检测确保无缺陷存在；
 3. 贴加钢衬垫，根据返修WPS进行预热及焊接，焊接时采用线状纵向进行补焊；
 4. 去除衬垫，根部焊道反面碳刨清根焊接；
 5. 焊后将焊缝打磨与周围母材齐平；
 6. 采用进行VT、UT、MT对返修区域进行检测；
 7. 按照图纸及检查报告ZP06-787-J-B-1361重新钻孔；
1. Elongate the hole by arc gouging, and grind smooth the surface. The elongated hole should conform to the joint detail in Repair WPS. Preheat before gouging according to relevant WPS.
 2. Perform VT to ensure no defects exist.
 3. Add steel backing. Preheat and weld according to the repair WPS, weld stringers longitudinally along the elongated direction of the hole.
 4. Remove steel backing and back gouge the root pass, and complete the welding.
 5. Grind the repair area flush with adjacent base metal.
 6. Check with VT, UT, MT after welding to the repair area.
 7. Drill new holes according to work drawings and disposition of Inspection Report ZP06-787-J-B-1361.

工艺:
Technical engineer

Hexianbin

审核:
Approved by

Wu Jianhua

日期
Date 10.01.30



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	SB46W	报告编号 Report No.	B-WR10613
合同号 Contract No.:	04-0120F4	部件名称 Items Name	悬索支架 Suspending bracket	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

加强制作过程中的监控, 减少误差。

Enhance supervision in process of fabrication to reduce error.

车间负责人(Foreman): *Hu Yu sheng* 日期(Date): 10.01.30

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair	工艺员 technologist	<i>He Xianlin</i> 10.01.30
返修(破刨)前预热温度 Preheat temperature before gouging	<i>NA</i>	返修的缺陷 Description of discontinuity	<i>defect</i>
焊前处理检查 Inspection before welding	<i>Am</i>	焊前预热温度 Preheat temperature before welding	<i>120</i>
最大破刨深度 Max. depth of gouging	<i>NA</i>	破刨总长 Total length of gouging	<i>NA</i>
焊工 welder	<i>062746</i>	焊接类型 welding type	<i>SMAW</i>
焊接电流 Current	<i>160</i>	焊接电压 Voltage	<i>24-8</i>
		焊接位置 position	<i>14</i>
		焊接速度 Speed	<i>50</i>
返修后检查 Inspection After repairing:			
外观检查 VT result	<i>Acc</i>	检验员 Inspector	<i>Zhu Zhong Han</i> 07072101
NDT复检 NDT result	<i>With Aw</i> <i>MAAC</i>	探伤员 NDT person	<i>Sm Y</i> <i>Xi Hua Xiang</i>
见证: Witness/Review:		日期 Date	<i>10.02.24</i>
备注: Remark:		日期 Date	<i>10.01.25</i> <i>2010.02.25</i>

#R787-QCP-900



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-11267 DATE 2010.02.25 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: SUPPORT BEAM DRAWING NO.: SB42W-C 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
 NA NA Dec. 28ST, 2010

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

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2-X 35mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	Reference Level 参考灵敏度		20dB	

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

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y		
SB42W-C		70												ACC.	100%
		0												ACC.	100%

BASE METAL PER B-WR10612

BLANK

EXAMINED BY 主探 Sun Yin REVIEWED BY 审核 Huang Jing

LEVEL - II SIGN / DATE 10.02.25 LEVEL - II SIGN / DATE 10.02.25

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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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-000594**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0642**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-Feb-2010**Description of Non-Conformance:**

During random in process observation of the fabrication of the OBG suspenders brackets, this Quality Assurance Inspector (QA) discovered the following issue:

ZPMC personnel have performed weld built up the inside surfaces of suspender rod holes with weld metal without the approval of the Engineer. ZPMC introduced new welds that were not specified in the approved shop drawings.

-The suspender brackets are designated as Tension Member/Stress Reversal Members (TM/SRM) in the contract documents.

-The suspender brackets affected are identified on the material as SB42W (for Segment 6BW) and SB46W (for Segment 6CW).

-This condition exists on all six (6) rod holes on both of the above mentioned brackets.

-Both of the above mentioned suspender brackets are located in OBG bay 19.

Contractor's proposal to correct the problem:

Perform NDT required to verify weld quality.

Corrective action taken:

Contractor submitted WRR used during welding along with subsequent NDT reports verifying repair quality complies with Contract specifications.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?** Yes No**Comments:**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis 152.1675.3703, who represents the Office of

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Structural Materials for your project.

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer
