

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-000737

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-May-2010

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

NCR #: ZPMC-0700

Type of problem:

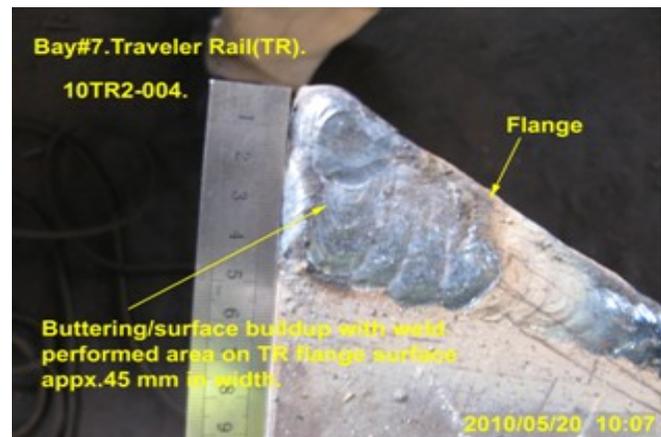
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Traveler Rail
Procedural	Procedural	Description:	

Reference Description: Buttering of the flange surfaces of 2 Traveler Rails for thickness build-up

Description of Non-Conformance:

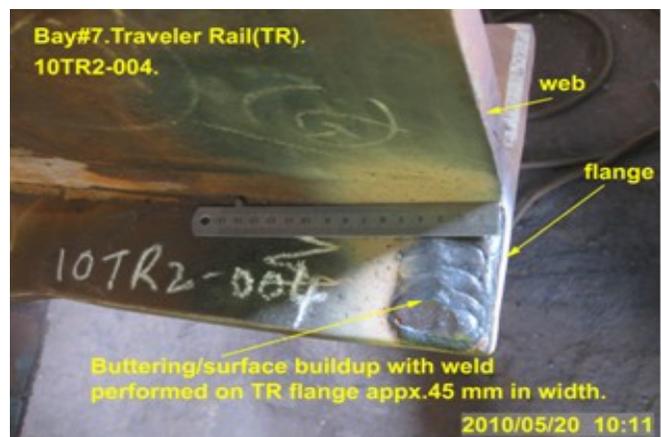
During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Traveler Rails, this QA inspector discovered the following issues:

- ZPMC welding personnel were buttering (build up weld) on the existing base metal surfaces for thickness build-up.
- The work prescribed above was performed without prior Engineer's approval.
- The affected Traveler Rails are identified as: 10TR3-006 and 10TR2-004.
- The repair area is located on the Traveler Rail flanges.
- Welding process used was Shielded Metal Arc Welding (SMAW).
- The material is A709 Grade 345.
- OBG Traveler Rails are located in the Bay 7.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

AWS D1.5 2002 section 3.1.5 – “Welds shall be prohibited on the work except as follows:

- (1) Base-metal repair performed in conformance with AASHTO M160/M160M (ASTM A 6/A 6M), Specification for General Requirements for Rolled Steel Plates, Shapes, Sheet Piling, and Bars for Structural Use, Article 9, by the mill or fabricator
- (2) All welds detailed on approved shop drawings
- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer”

AWS D1.5 2002 section 3.4.3 – “The Contractor shall prepare a welding sequence for a member or structure which, in conjunction with the WPSs and overall fabrication methods, will produce members or structures meeting the quality requirements specified. The welding sequence and distortion control program shall be submitted to the Engineer, for information and comment, before the start of welding on a member or structure in which shrinkage or distortion is likely to affect the adequacy of the member or structure.”

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Mike Williams

Time and method of notification: 15:00_05/20/10_Email

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 15:15_5/20/10_Verbal

QC Inspector's Name: Wang Li Yang

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
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Reviewed By:	Wahbeh, Mazen	SMR
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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: 21-May-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: 05.03.06-000695

Subject: NCR No. ZPMC-0700

Reference Description: Buttering of the flange surfaces of 2 Traveler Rails for thickness build-up

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:** 10

Remarks:

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Traveler Rails, this QA inspector discovered the following issues:

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- The repair area is located on the Traveler Rail flanges.
- Welding process used was Shielded Metal Arc Welding (SMAW).
- The material is A709 Grade 345.
- OBG Traveler Rails are located in the Bay 7.

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: Sean Eagen Transportation Engineer

Attachments: ZPMC-0700

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000695

Subject: NCR No. ZPMC-0700

Dated: 24-May-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000674 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the CWR for the work observed by the CT inspector. To remind ZPMC's QC and Production departments the QA department has written an internal NCR.

ZPMC is providing the CWR for the work observed by the CT inspector. To remind ZPMC's QC and Production departments the QA department has written an internal NCR. ZPMC requests that this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000674R00;

Caltrans' comments:

Status: REJ

Date: 30-May-2010

The CWR provided with this NPR pertains to buttering to accommodate shrinkage in terms of the overall length of the traveler rail and not the thickness of the flange as noted in the NCR. Please provide a CWR applicable to the condition noted in the NCR.

Submitted by: Eagen, Sean

Date: 30-May-2010

Attachment(s):



No. B-771

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-5-24

REGARDING: NCR-000737(ZPMC-0700)

ZPMC had an approved CWR on this issue, a misunderstanding occurred to this inspector. ZPMC QA personnel has written an internal note to ZPMC production & quality departments emphasized the requirement of the present of WRR & CWR prior to welding. Based on this, ZPMC is providing the CWR and is requesting closure of this NCR.

ATTACHMENT:

NCR-000737(ZPMC-0700)

B-CWR1100

Jm

5/24/10



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: 21-May-2010

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

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Attachments: ZPMC-0700

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

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Quality Assurance and Source Inspection



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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-000737**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0700**Type of problem:**Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description: **Bridge No:** 34-0006**Component:** OBG Traveler Rail**Reference Description:** Buttering of the flange surfaces of 2 Traveler Rails for thickness build-up**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Traveler Rails, this QA inspector discovered the following issues:

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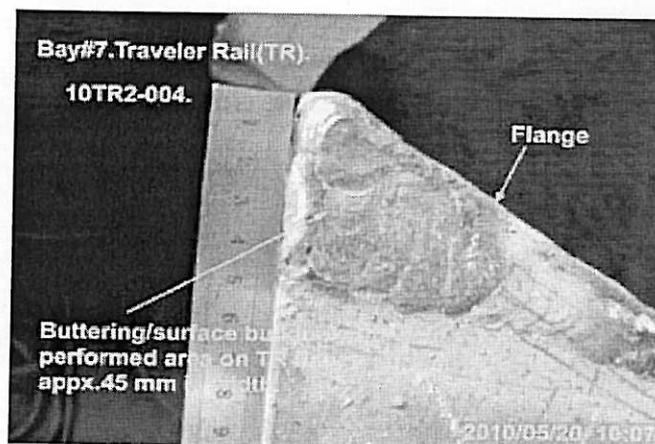
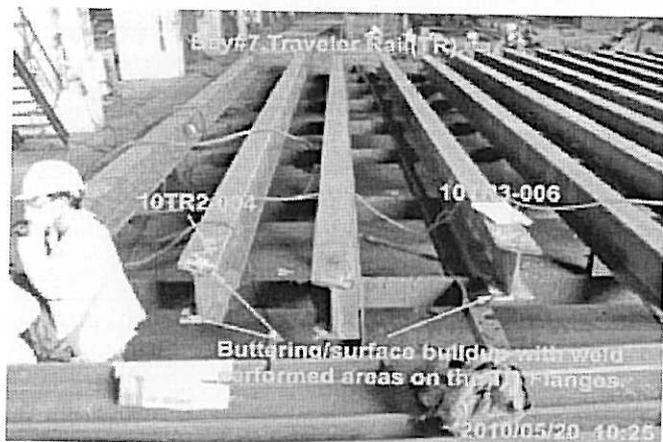
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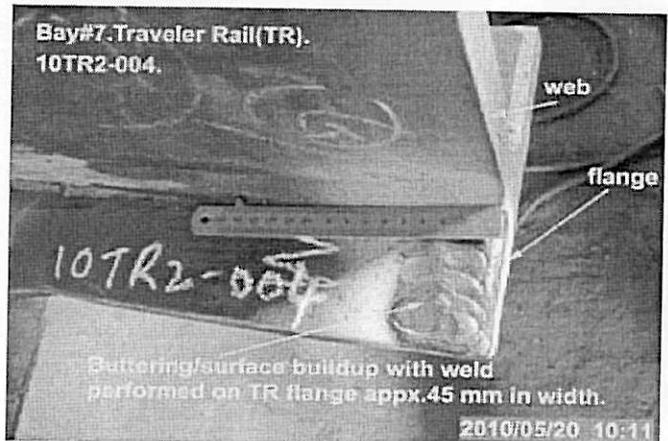
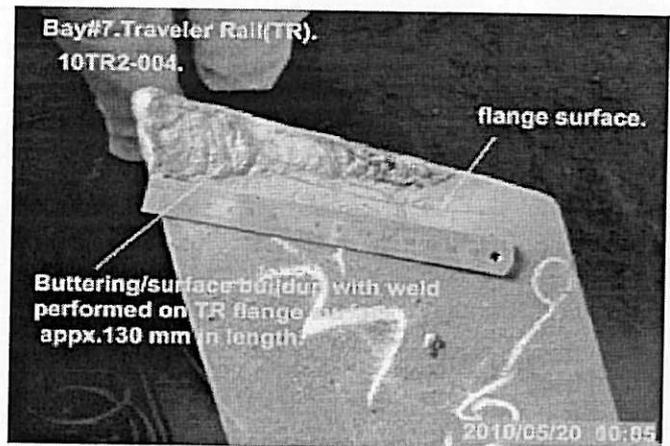
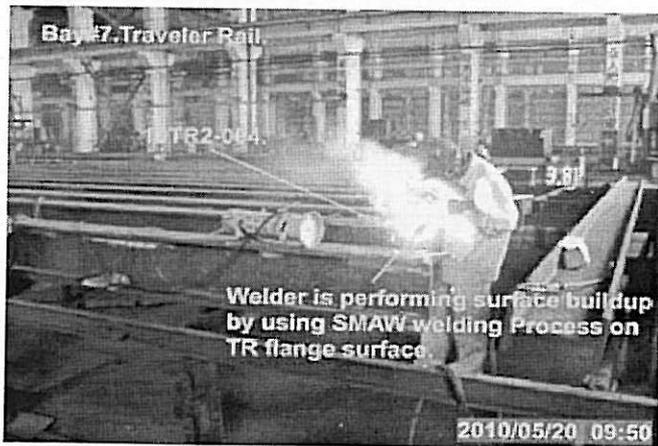
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



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Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Mike Williams

Time and method of notification: 15:00_05/20/10_Email

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 15:15_5/20/10_Verbal

QC Inspector's Name: Wang Li Yang

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



关键性焊缝返修报告

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	TR10.11	报告编号 Report No.	B-CWR1100
合同号 Contract No.:	04-0120F4	部件名称 Items Name	维护行车轨道 Maintenance travel Way	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

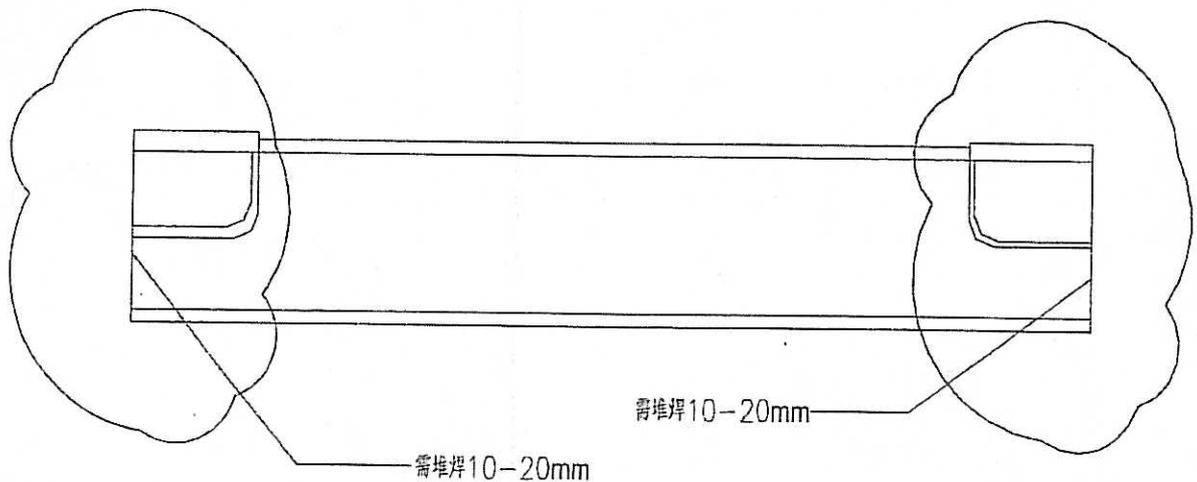
Description of welding discontinuity:

郑喜芝施工队制作的维护行车轨道第二、三船10TR1(005.007.009.012.014).10TR2(003.004.006.007.008.021).10TR3(003.004.006.026). 11TR1(016). 11TR3(005.006.007.009.010.011.012.013.017.018.020.021.022.025).共30件焊接完工后尺寸比图纸尺寸短15-27mm,需对其进行两边堆焊。

Maintenance travel way fabricated by work team: Zhen Xizhi, part No, 10TR1 (005.007.009.012.014).10TR2(003.004.006.007.008.021).10TR3(003.004.006.026). 11TR1 (016). 11TR3 (005.006.007.009.010.011.012.013.017.018.020.021.022.025). the size was 15-27mm shorter than drawing requirement after welding and needed to build up.

检验员 (Inspector): Cuijunjie 日期(Date): 2010-1-16

焊缝返修位置示意图:

Draft of welding discontinuity:

THE CUSTOMER IS APPROVED
BY: [Signature]
DATE: [Date]

产生原因:

Caused:

1. 焊接变形和制作误差。
1. Fabricated error and fabricated error.

车间负责人(Foreman)

日期(Date):

Ma Ruiqian
2010.01.05

处理意见

Disposition :

1. 腹板堆焊之前先对法兰堆焊。
 2. 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;
 3. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
 4. 准备一个正确的接头型式, 具体参照相应的返修WPS;
 5. 清理焊接区域, 并进行100%的VT;
 6. 贴钢衬垫, 根据批准的返修焊接工艺规程(WPS)进行预热及焊接;
 7. 去除钢衬垫, 将修补焊缝打磨至与周围母材平齐;
 8. 对修补区域作100%VT, MT和UT检测;
-
1. Perform buttering on flanges prior to buttering web.
 2. 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
 3. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
 4. Prepare excavation according to the approved repair WPS.
 5. Clean area and perform 100%VT.
 6. Add steel backing , preheat and weld according to the relevant repair WPS.
 7. Remove the steel backing and grind the weld flush with around metal;
 8. Perform VT, MT and UT over 100% of the repair area.

工艺:
Technical engineer

Lu Dongkai
2010.02.05

审核:
Approved by

Lu Zankun

日期
Date

2/5/10

The document is approved
by the responsible
personnel and is
valid for the
duration of the
project.



关键性焊缝返修报告

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.	TR10.11	报告编号 Report No.	B-CWR1100
合同号 Contract No.:	04-0120F4	部件名称 Items Name	维护行车轨道 Maintenance travel Way	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective action to prevent re occurrence;

1. 加强焊接过程中的监控, 减少误差。

1. Enhance supervision in process of welding to reduce error.

车间负责人(Foreman): *Ma Rwiguan* 日期(Date): 2010.2.5

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair WPS-345-FCAW-1 G(1F)-Repair WPS-345-SMAW-2 G(2F)-Repair WPS-345-FCAW-2 G(2F)-Repair	工艺员 technologist	<i>Xu Dongkai</i> 2010.2.5
返修(碳刨)前预热温度 Preheat temperature before gouging		返修的缺陷 Description of discontinuity	
焊前处理检查 Inspection before welding		焊前预热温度 Preheat temperature before welding	
最大碳刨深度 Max. depth of gouging		碳刨总长 Total length of gouging	
焊工 welder	焊接类型 welding type	焊接位置 position	
焊接电流 Current	焊接电压 Voltage	焊接速度 Speed	
返修后检查 Inspection After repairing:			
外观检查 VT result	检验员 Inspector	日期 Date	
NDT复检 NDT result	探伤员 NDT person	日期 Date	
见证: Witness/Review:			
备注: Remark:			

#R787-QCP-900

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000695

Subject: NCR No. ZPMC-0700

Dated: 27-Aug-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000674 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing a revised weld repair report which includes the weld build up on the flange of the traveler rail. ZPMC is providing a revised weld repair report which includes the weld build up on the flange of the traveler rail. Included is the NDT performed after the repair to show that the repair was free of defect. Based on these documents and previously submitted responses ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000674R01;

Caltrans' comments:

Status: AAP

Date: 31-Aug-2010

The CWR mentioned in the proposed resolution was returned for correction. Please resubmit once the CWR has been approved.

Submitted by: Woo, Laraine

Date: 31-Aug-2010

Attachment(s):



No. B-853

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-8-27

REGARDING: NCR-000737(ZPMC-0700)

The revised CWR, B-CWR1100 R0-1 has been submitted to department for review, what shows all the affected area with buttering in NCR. ZPMC is providing the NDT records show these area has been tested to be acceptable. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000737(ZPMC-0700)

B-CWR1100 R0-1

B787-UT-12376

B787-UT-12377

B787-UT-12378

B787-UT-12379

B787-MT-22107

B787-MT-22108

B787-MT-22109

B787-MT-22110

Jay W
8/27/10



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: 21-May-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

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Material Location: OBG

Lift: 10

Remarks:

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Action Required and/or Action Taken:

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Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0700

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

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Cty: SF/ALA Rte: 80 PM: 13.2/13.9
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000737

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-May-2010

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

NCR #: ZPMC-0700

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

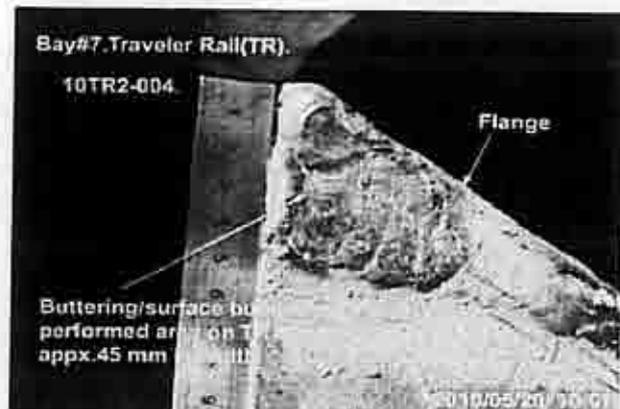
Component: OBG Traveler Rail

Reference Description: Buttering of the flange surfaces of 2 Traveler Rails for thickness build-up

Description of Non-Conformance:

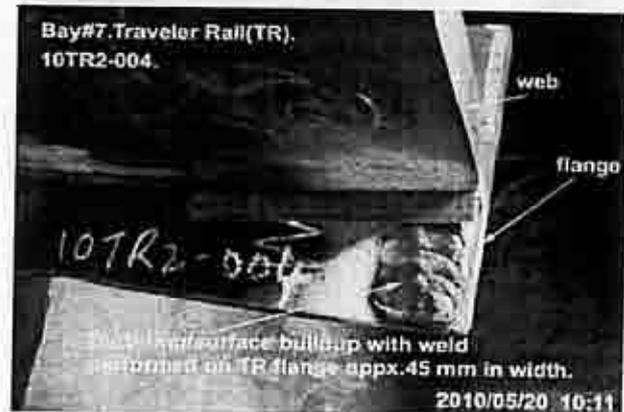
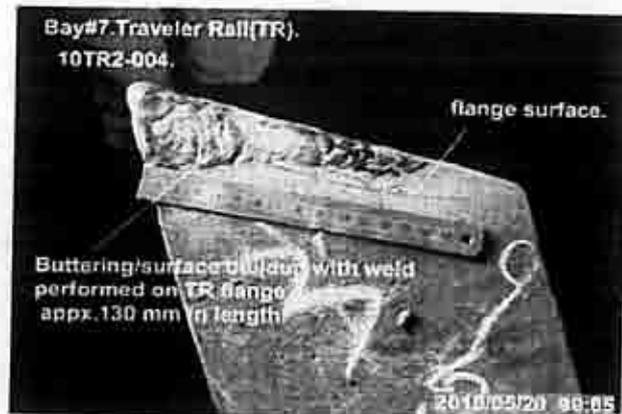
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- The affected Traveler Rails are identified as: 10TR3-006 and 10TR2-004.
- The repair area is located on the Traveler Rail flanges.
- Welding process used was Shielded Metal Arc Welding (SMAW).
- The material is A709 Grade 345.
- OBG Traveler Rails are located in the Bay 7.



QUALITY ASSURANCE – NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

AWS D1.5 2002 section 3.1.5 – “Welds shall be prohibited on the work except as follows:

- (1) Base-metal repair performed in conformance with AASHTO M160/M160M (ASTM A 6/A 6M), Specification for General Requirements for Rolled Steel Plates, Shapes, Sheet Piling, and Bars for Structural Use, Article 9, by the mill or fabricator
- (2) All welds detailed on approved shop drawings
- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer”

AWS D1.5 2002 section 3.4.3 – “The Contractor shall prepare a welding sequence for a member or structure which, in conjunction with the WPSs and overall fabrication methods, will produce members or structures meeting the quality requirements specified. The welding sequence and distortion control program shall be submitted to the Engineer, for information and comment, before the start of welding on a member or structure in which shrinkage or distortion is likely to affect the adequacy of the member or structure.”

Who discovered the problem: Surendra Prabhu
Name of individual from Contractor notified: Mike Williams
Time and method of notification: 15:00_05/20/10_Email

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Name of Caltrans Engineer notified: Scan Eagen

Time and method of notification: 15:15_5/20/10_Verbal

QC Inspector's Name: Wang Li Yang

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



关键性焊缝返修报告

版本 Rev. No.

Welding Repair Report

0-1

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	TR10.11	报告编号 Report No.	B-CWR1100
合同号 Contract No.:	04-0120F4	部件名称 Items Name	维护行车轨道 Maintenance travel Way	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:

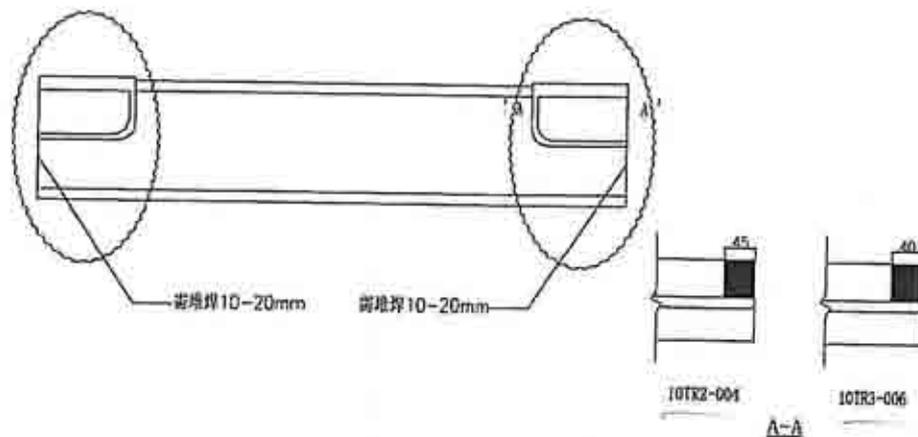
郑喜芝施工队制作的维护行车轨道第二、三船10TR1(005.007.009.012.014).10TR2(003.004.006.007.008.021).10TR3(003.004.006.026). 11TR1(016). 11TR3(005.006.007.009.010.011.012.013.017.018.020.021.022.025).共30件焊接完工后尺寸比图纸尺寸短15-27mm,需对其进行两边堆焊。

Maintenance travel way fabricated by work team: Zhen Xizhi, part No, 10TR1 (005.007.009.012.014).10TR2(003.004.006.007.008.021).10TR3(003.004.006.026). 11TR1 (016). 11TR3 (005.006.007.009.010.011.012.013.017.018.020.021.022.025). the size was 15-27mm shorter than drawing requirement after welding and needed to build up.

检验员 (Inspector): Cui Junjie 日期(Date): 2010-1-16

焊缝返修位置示意图:

Draft of welding discontinuity:



产生原因:

Caused:

1. 焊接变形和制作误差。
1. Fabricated error and fabricated error.

车间负责人(Foreman) *Hu Foly* 日期(Date): 12.1.16

处理意见

Disposition:

翼缘板端部堆焊, 以增加长度, 翼缘板表面堆焊增加厚度.

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. 准备一个正确的接头型式, 具体参照相应的返修WPS;
4. 将修补区域打磨光滑, 开始和结束的接头交错布置;
5. 对修补区域进行VT与MT检测;
6. 贴钢衬垫, 根据批准的返修焊接工艺规程(WPS)进行预热及焊接;
7. 去除钢衬垫, 将修补焊缝打磨至与周围母材平齐;
8. 对修补区域作100%VT与MT检测;

BUTTER FLANGE END TO BUILD UP LENGTH ,BUTTER FLANGE SURFACE TO BUILD UP THICKNESS .

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. Prepare excavation according to the approved repair WPS.
4. Grind the repaired area to a smooth and shiny finish, with tapered ends, to ensure staggered starts and stops.
5. VT and MT the repair area.
6. Add steel backing , preheat and weld according to the relevant repair WPS.
7. Remove the steel backing and grind the weld flush with around metal;
8. Perform VT and MT over 100% of the repair area.

工艺:
Technical engineer

Xu Dajun

审核:
Approved by

Lu Jianhua

日期
Date 12.1.16



关键性焊缝返修报告

版本 Rev. No.

Welding Repair Report

0-1

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	TR10.11	报告编号 Report No.	B-CWR1100
合同号 Contract No.:	04-0120F4	部件名称 Items Name	维护行车轨道 Maintenance travel Way	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective action to prevent re occurrence:

1. 加强焊接过程中的监控, 减少误差。
1. Enhance supervision in process of welding to reduce error.

车间负责人(Foreman): *HL Yin* 日期(Date): *12.01.16*

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair WPS-345-FCAW-1 G(1F)-Repair WPS-345-SMAW-2 G(2F)-Repair WPS-345-FCAW-2 G(2F)-Repair	工艺员 technologist	<i>Xu Danyuan</i> <i>12.1.16</i>
返修(碳刨)前预热温度 Preheat temperature before gouging		返修的缺陷 Description of discontinuity	
焊前处理检查 Inspection before welding		焊前预热温度 Preheat temperature before welding	
最大碳刨深度 Max. depth of gouging		碳刨总长 Total length of gouging	
焊工 welder	焊接类型 welding type	焊接位置 position	
焊接电流 Current	焊接电压 Voltage	焊接速度 Speed	
返修后检查 Inspection After repairing:			
外观检查 VT result	检验员 Inspector	日期 Date	
NDT复检 NDT result	探伤员 NDT person	日期 Date	
见证: Witness/Review:			
备注: Remark:			

#R787-QCP-900



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-12376 DATE 2010.06.01 PAGE 1 OF 2 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787		CONTRACTOR: CALTRANS	
ITEMS NAME: 部件名称 TRAVELER RAIL	DRAWING NO.: 图号 TR10	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号	
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01	
WELDING PROCESS 焊接方法 NA	JOINT TYPE 焊缝类型 NA	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2010	
EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311, 061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 AWS IIV BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X 25/16/12mm	

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
TRX1H		0				22									ACC.	100%
TRX1B		0				22									ACC.	100%
TR10A		0				22									ACC.	100%
TR10G		0				22									ACC.	100%
TRX1H		0				22									ACC.	100%
TRX1B		0				22									ACC.	100%
TR10A		0				22									ACC.	100%
TR10G		0				22									ACC.	100%

EXAMINED BY 主探 <i>Wu chow 2010.06.01</i>	REVIEWED BY 审核 <i>Zeng Xiang shan 2010.06.01</i>
LEVEL - II SIGN / DATE	LEVEL - II SIGN / DATE
质量经理 / QCM	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-12376 DATE 2010.06.01 PAGE 2 OF 2 Revision No: 0

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		
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%

BASE METAL PER B-CWR1100 REV0

BLANK

EXAMINED BY主探
Wu Chen 2010.06.01

REVIEWED BY审核
Tang Xing Chen 2010.06.01

LEVEL - II SIGN / DATE

LEVEL - II SIGN / DATE

质量经理 / QCM

用户CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-12377 DATE 2010.06.01 PAGE 1 OF 2 Revision No: 0

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

ITEMS NAME: TRAVELER RAIL DRAWING NO.: TR10 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 IIV BLOCK TYPE II C.M.C A709M-345T2-X 25/16/12mm

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
TRX1H		0				22									ACC.	100%
TRX1B		0				22									ACC.	100%
TR10A		0				22									ACC.	100%
TR10G		0				22									ACC.	100%
TRX1H		0				22									ACC.	100%
TRX1B		0				22									ACC.	100%
TR10A		0				22									ACC.	100%
TR10G		0				22									ACC.	100%

EXAMINED BY 主探 Wu Chao 2010.06.01 REVIEWED BY 审核 Tang Xiang Shun 2010.06.01

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

质量经理 / QCM 用户CUSTOMER

签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-12377 DATE 2010.06.01 PAGE 2 OF 2 Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探头角度	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		
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR10A		0				22								ACC.	100%
TR10G		0				22								ACC.	100%

BASE METAL PER B-CWR1100 REV0

BLANK

EXAMINED BY 主探 <i>Wu Chen 2010.06.01</i> LEVEL - II SIGN / DATE	REVIEWED BY 审核 <i>Jiang Xing Chen 2010.06.01</i> LEVEL - II SIGN / DATE
质量经理 / QCM 签字 SIGN / 日期 DATE	用户 CUSTOMER 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-12379 DATE 2010.04.26 PAGE 1 OF 4 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787		CONTRACTOR: CALTRANS	
ITEMS NAME: 部件名称 TRAVELER RAIL	DRAWING NO.: 图号 11TR3	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号	
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01	
WELDING PROCESS 焊接方法 FCAW	JOINT TYPE 焊缝类型 NA	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2010	
EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311, 061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 AWS IIV BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X 25/12/16mm	

TRANSDUCER 探头

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

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

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				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		
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%

EXAMINED BY 主探 <i>Henry Tian</i> 2010.4.26	REVIEWED BY 审核 <i>Tony Long Chen</i> 2010.4.26
LEVEL - II SIGN / DATE	LEVEL - II SIGN / DATE
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-12379 DATE 2010.04.26 PAGE 2 OF 4 Revision No: 0

WELD IDENTIFICATION 焊接部件编号	INDICATION NO. 指示号	PROBE ANGLE 探伤角度	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		
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%

EXAMINED BY 主探
Henry King 2010.04.26
 LEVEL - II SIGN / DATE

REVIEWED BY 审核
Tang King 2010.04.26
 LEVEL - II SIGN / DATE

质量经理 / QCM

 签字 SIGN / 日期 DATE

用户 CUSTOMER

 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-12379 DATE 2010.04.26 PAGE 3 OF 4 Revision No: 0

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		
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%
TRX1H		0				22								ACC.	100%
TRX1B		0				22								ACC.	100%
TR11B		0				22								ACC.	100%
TR11Y		0				22								ACC.	100%

EXAMINED BY主探
Huang Jing 2010. 4.26
 LEVEL - II SIGN / DATE

REVIEWED BY审核
Tang Xing Chen 2010. 04.26
 LEVEL - II SIGN / DATE

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 B787-MT-22107		DATE 日期 2010.06.04	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: TR10 TRAVELER RAIL		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 母材, 厚度	A709M-345T2-X 25/16/12mm	
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	NA	

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			
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10A				ACC.		AFTER REPAIRED
TR10G				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10A				ACC.		AFTER REPAIRED
TR10G				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10A				ACC.		AFTER REPAIRED
TR10G				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10A				ACC.		AFTER REPAIRED
TR10G				ACC.		AFTER REPAIRED

EXAMINED BY 主探 Jin Jian ting <i>Jin Jian ting</i> 2010.06.04	REVIEWED BY 审核 <i>San Guo cheng</i> 2010.06.04
LEVEL - II SIGN 签名 / DATE 日期	LEVEL - II SIGN / DATE 日期
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 B787-MT-22107 DATE日期 2010.06.04 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: TR10 TRAVELER RAIL		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 ST , 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 母材, 厚度	A709M-345T2-X 25/16/12mm
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	NA

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			
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10A				ACC.		AFTER REPAIRED
TR10G				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10A				ACC.		AFTER REPAIRED
TR10G				ACC.		AFTER REPAIRED

BASE METAL PER B- CWR1100 REV0

BLANK

EXAMINED BY 主探 Jin lian ting <i>Jin Lian ting</i> 2010. 6. 04	REVIEWED BY 审核 <i>Sun Gong deng</i> 2010. 6. 04
LEVEL - II SIGN 签名 / DATE 日期	LEVEL-II SIGN N DATE 日期
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 B787-MT-22108 DATE日期 2010.06.04 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: TR10 TRAVELER RAIL		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 母材, 厚度	A709M-345T2-X 25/16/12mm
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	NA

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			
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED

EXAMINED BY 主探 Jin Jian ting Jin Jian-fing 2010.06.04	REVIEWED BY 审核 Sean Gang cheng 2010.06.04
LEVEL - II SIGN 签名 / DATE 日期	LEVEL-II SIGN / DATE 日期
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 B787-MT-22108		DATE 日期 2010.06.04	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: TR10 TRAVELER RAIL		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 母材, 厚度	A709M-345T2-X 25/16/12mm	
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	NA	

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			
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED

BASE METAL PER B- CWR1100 REV0

BLANK

EXAMINED BY 主探 Jin Jian ting <i>Jin Jian ting</i> 2010.06.04	REVIEWED BY 审核 <i>Sun Guang cheng</i> 2010.06.04
LEVEL - II SIGN 签名 / DATE 日期	LEVEL-II SIGN / DATE 日期
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 B787-MT-22109		DATE日期 2010.06.04	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: TR10 TRAVELER RAIL		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 ST , 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 母材, 厚度	A709M-345T2-X 25/16/12mm	
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	NA	

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			
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED
TRX1H				ACC.		AFTER REPAIRED
TRX1B				ACC.		AFTER REPAIRED
TR10B				ACC.		AFTER REPAIRED
TR10H				ACC.		AFTER REPAIRED

EXAMINED BY 主操 Jin Jian ting <i>Jin Jian ting</i> 2010.06.04	REVIEWED BY 审核 Sun Gang cheng <i>Sun Gang cheng</i> 2010.06.06
LEVEL-II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
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 B787-MT-22110 DATE日期 2010.05.06 PAGE OF页码 1/4 Revision No: 0

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

DRAWING NO. 图号: 005/006/007/009/010/011/012/013/017/018/020/021/022/025
OBG TRAVELER RAIL 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. 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 12/16/25 mm
 FORGING 锻造

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: NA

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			
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT

EXAMINED BY主探: Jin Jianting REVIEWED BY审核: Susan Energy change 2010.05.06

LEVEL - II SIGN 签名 / DATE日期 LEVEL-II SIGN / DATE日期

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 B787-MT-22110		DATE 日期 2010.05.06		PAGE OF 页码 2/4		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: 005/005/007/009/010/011/012/013/017/018/020/021/022 11TR3-2/025 OBG TRAVELER RAIL				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 ST , 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 母材, 厚度		A709M-345T2-X 12/16/25 mm	
WELDING PROCESS 焊接方法 FCAW				TYPE OF JOINT 焊缝类型 NA			

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			
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT

EXAMINED BY 主探 Jin Jianting <i>Jin Jianting</i> 2010.05.06		REVIEWED BY 审核 Savi Goh Goh <i>Savi Goh Goh</i> 2010.05.06	
LEVEL - II SIGN 签名 / DATE 日期		LEVEL - II SIGN / DATE 日期	
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 B787-MT-22110 DATE日期 2010.05.06 PAGE OF页码 4/4 Revision No: 0

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

DRAWING NO. 图号: 005/006/007/009/010/011/012/013/017/018/020/021/022/025 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 Material & thickness 母材, 厚度: A709M-345T2-X

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: NA

WELD I.D. 焊缝编号: DISCONTINUITY 不连续性: ACCEPT 接受: REJECT 拒收: REMARKS 备注:

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			
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT
TRX1H				ACC.		100%MT
TRX1B				ACC.		100%MT
TR11B				ACC.		100%MT
TR11Y				ACC.		100%MT

BASE METAL PER B-CWR 1100

BLANK

EXAMINED BY 主探 Jin Jianting <i>Jin Jianting</i> 2010.05.06	REVIEWED BY 审核 Sun Guoqiang <i>Sun Guoqiang</i> 2010.05.06
LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	LEVEL - II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000695

Subject: NCR No. ZPMC-0700

Dated: 20-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000674 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: The CWR that was revised has now been approved by the Department. Based on this approval and previously acceptable NDT results. ZPMC requests closure of this NCR.

The CWR that was revised has now been approved by the Department. Based on this approval and previously acceptable NDT results. ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000674R02;

Caltrans' comments:

Status: CLO

Date: 26-Sep-2010

The proposed resolution is acceptable. This NCR is considered closed.

Submitted by: Woo, Laraine

Attachment(s): NPR CT Comments

Date: 26-Sep-2010



No. B-886

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-9-18

REGARDING: NCR-000737(ZPMC-0700)

The corrected CWR has been submitted to department and was approved by engineer. Based on this and the previously submitted report, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000737(ZPMC-0700)

[Handwritten signature]

9/18/10



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: 21-May-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

Subject: NCR No. ZPMC-0700

Document No: 05.03.06-000695

Reference Description: Buttering of the flange surfaces of 2 Traveler Rails for thickness build-up

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: 10

Remarks:

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Traveler Rails, this QA inspector discovered the following issues:

- ZPMC welding personnel were buttering (build up weld) on the existing base metal surfaces for thickness build-up.
- The work prescribed above was performed without prior Engineer's approval.
- The affected Traveler Rails are identified as: 10TR3-006 and 10TR2-004.
- The repair area is located on the Traveler Rail flanges.
- Welding process used was Shielded Metal Arc Welding (SMAW).
- The material is A709 Grade 345.
- OBG Traveler Rails are located in the Bay 7.

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: Sean Eagen Transportation Engineer

Attachments: ZPMC-0700

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

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-000737

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-May-2010

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

NCR #: ZPMC-0700

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

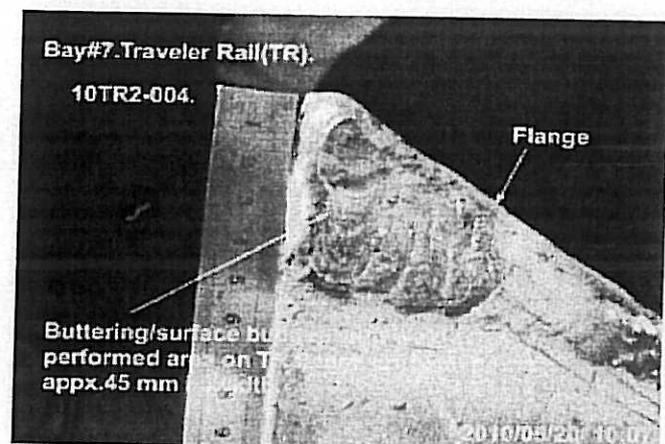
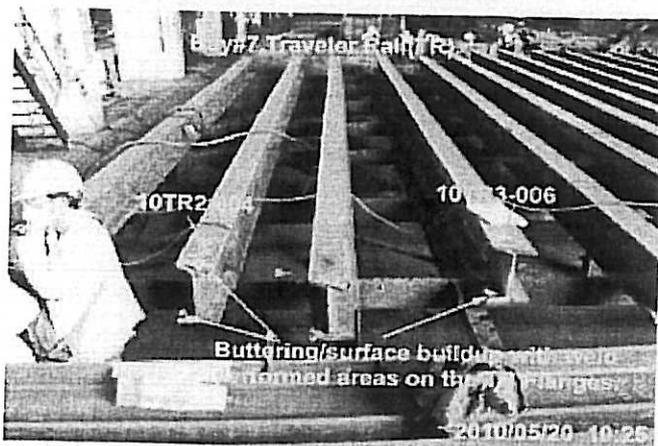
Component: OBG Traveler Rail

Reference Description: Buttering of the flange surfaces of 2 Traveler Rails for thickness build-up

Description of Non-Conformance:

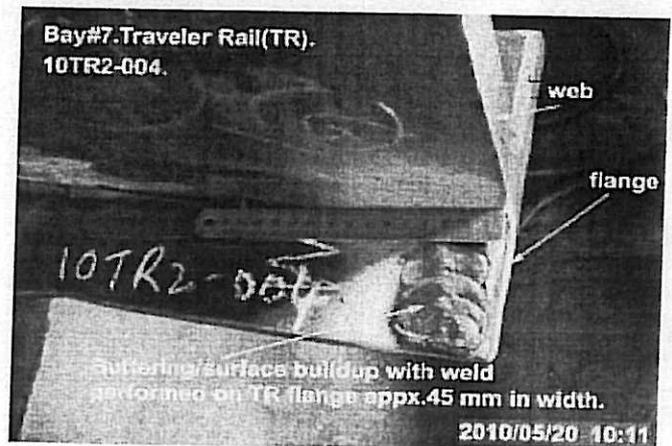
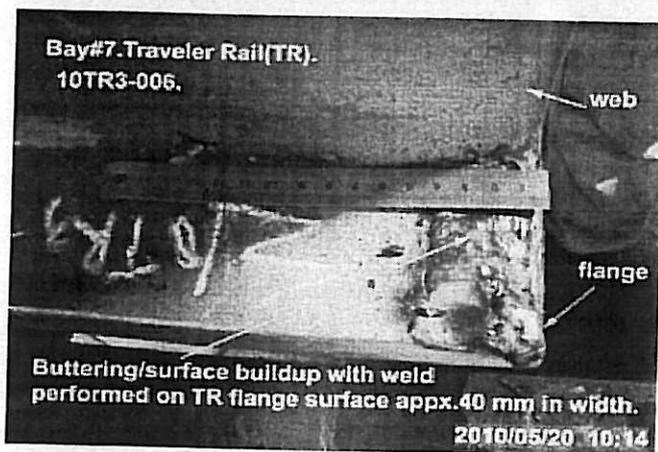
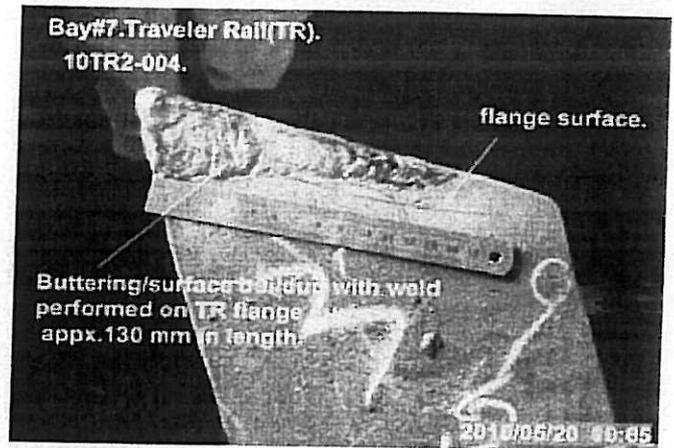
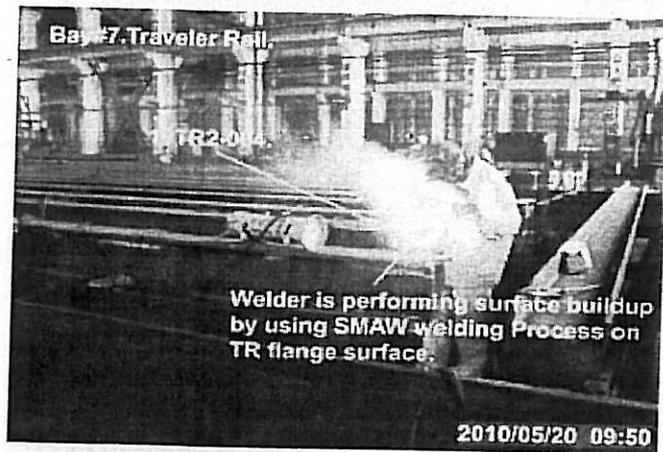
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

AWS D1.5 2002 section 3.1.5 – “Welds shall be prohibited on the work except as follows:

- (1) Base-metal repair performed in conformance with AASHTO M160/M160M (ASTM A 6/A 6M), Specification for General Requirements for Rolled Steel Plates, Shapes, Sheet Piling, and Bars for Structural Use, Article 9, by the mill or fabricator
- (2) All welds detailed on approved shop drawings
- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer”

AWS D1.5 2002 section 3.4.3 – “The Contractor shall prepare a welding sequence for a member or structure which, in conjunction with the WPSs and overall fabrication methods, will produce members or structures meeting the quality requirements specified. The welding sequence and distortion control program shall be submitted to the Engineer, for information and comment, before the start of welding on a member or structure in which shrinkage or distortion is likely to affect the adequacy of the member or structure.”

Who discovered the problem: Surendra Prabhu
Name of individual from Contractor notified: Mike Williams
Time and method of notification: 15:00_05/20/10_Email

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 15:15_5/20/10_Verbal

QC Inspector's Name: Wang Li Yang

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

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
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Contract #: 04-0120F4Cty: 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-000805**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0700**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: 20-May-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Traveler Rails, this QA inspector discovered the following issues:

-ZPMC welding personnel were buttering (build up weld) on the existing base metal surfaces for thickness build-up.

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-The repair area is located on the Traveler Rail flanges.

-Welding process used was Shielded Metal Arc Welding (SMAW).

-The material is A709 Grade 345.

-OBG Traveler Rails are located in the Bay 7.

Contractor's proposal to correct the problem:

Contractor will submit a CWR for repair approval. NDT will perform after repair.

Corrective action taken:

Contractor submitted the CWR, and approved by Engineer. NDT performed after repaired, and NDT report shows the weld is acceptable.

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer