

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000746**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0709**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 10CE Floorbeam
Procedural	Procedural	Description: Missed UT Indication by QC	

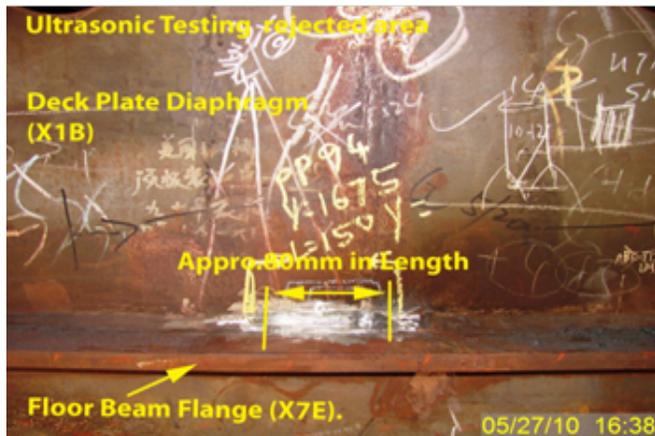
Reference Description: Missed UT indication by QC on OBG Segment 10CE Upper Floorbeam Flange (PP94)

Description of Non-Conformance:

- One (1) longitudinal linear indication measuring approximately 80mm in length.
 - The indication dB rating is a +4.
 - Material thickness is 14mm.
 - The depth of the indication is approximately 10mm.
 - The weld is identified as SSD-PP94-001/002 at Crossbeam side, Panel Point (PP) 94.
 - According to the approved shop drawing and due to excessive root gap ZPMC has changed the joint to a Complete Joint Penetration (CJP) "T" joint.
 - This joint joins the Deck Plate Diaphragm (X1B) to Floor Beam Flange (X7E).
 - The weld is designated as Non-Seismic Performance Critical Material (Non SPCM).
 - The indication is clearly marked on or near the weld.
 - The Y distance for this indication is 1675 mm from the Corner Assembly diaphragm at the Crossbeam side.
 - Segment 10CE is located outside of the Paint shop.
- The Notice of Witness Inspection (NWIT) No. is 005832. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5-02 Section 6; Table 6.3 specifies a class “A” indication as having a rating of 10dBs and under for material thicknesses 8mm through 20mm.

Special Provisions Section 8.3; “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Li Man Kit

Time and method of notification: 1630 hours, 05/27/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0930 hours, 05/29/10, Verbal

QC Inspector's Name: Zhang Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	Devey, Jim	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: 28-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: 05.03.06-000703

Subject: NCR No. ZPMC-0709

Reference Description: Missed UT indication by QC on OBG Segment 10CE Upper Floorbeam Flange (PP94)

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:

- One (1) longitudinal linear indication measuring approximately 80mm in length.
 - The indication dB rating is a +4.
 - Material thickness is 14mm.
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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-0709

NCT

(*Continued Page 2 of 2*)

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: 05.03.06-000703

Subject: NCR No. ZPMC-0709

Dated: 11-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000705 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will provide NDT to show these welds are acceptable after the repairs are complete. Based on this proposal ZPMC requests that this NCR be approved, with actions pending.

ZPMC will provide NDT to show these welds are acceptable after the repairs are complete. Based on this proposal ZPMC requests that this NCR be approved, with actions pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000705R00

Caltrans' comments:

Status: AAP

Date: 14-Jun-2010

This proposed resolution is accepted, action pending. Please provide NDT results for these welds upon completion of the repairs.

Submitted by: Eagen, Sean

Attachment(s):

Date: 14-Jun-2010

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000703

Subject: NCR No. ZPMC-0709

Dated: 30-Aug-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000705 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indication found during the Department's inspection and tested it to ensure it is acceptable. ZPMC has repaired the indication found during the Department's inspection and tested it to ensure it is acceptable. The original weld was changed from a fillet weld to CJP and given a new weld identification number, SSD18-PP94-303. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000705R01;

Caltrans' comments:

Status: CLO
Date: 08-Sep-2010

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

Submitted by: Woo, Laraine

Attachment(s):

Date: 08-Sep-2010



No. B-862

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-8-28

REGARDING: NCR-000746(ZPMC-0709)

For this case, ZPMC has issue an internal NCR to address this issue and ZPMC QA personnel have talked with the head of the NDT department. The missed indications have been repaired and were tested to be acceptable. ZPMC is providing the WRR and NDT record for review. Based on this, please consider closure of this NCR.

P.S: The fillet weld SSD-PP94-001/002 has been changed to CJP(SSD18-PP94-303)

ATTACHMENT:

NCR-000746(ZPMC-0709)

B-WR13992

B787-UT-13273R1

Zhao Jianqiang

2010/8/28



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: 28-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: 05.03.06-000703

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(Continued Page 2 of 2)

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao, Bill Casey
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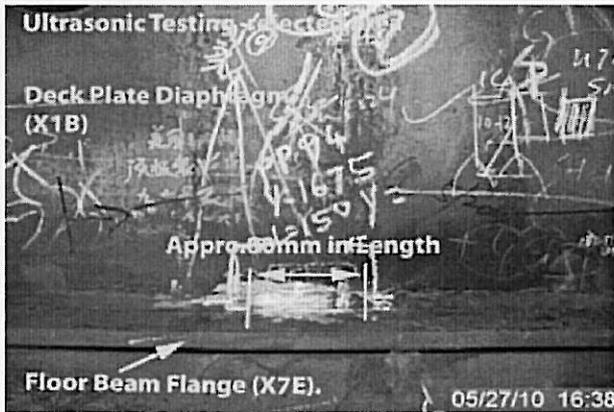
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Time and method of notification: 1630 hours, 05/27/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0930 hours, 05/29/10, Verbal

QC Inspector's Name: Zhang Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

SMR



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	SSD18	报告编号 Report No.	B-WR13992
合同号 Contract No.:	04-0120F4	部件名称 Items Name	10CE DECK PLATE	NDT报告编号 Report No.of NDT	B787-UT-13273
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

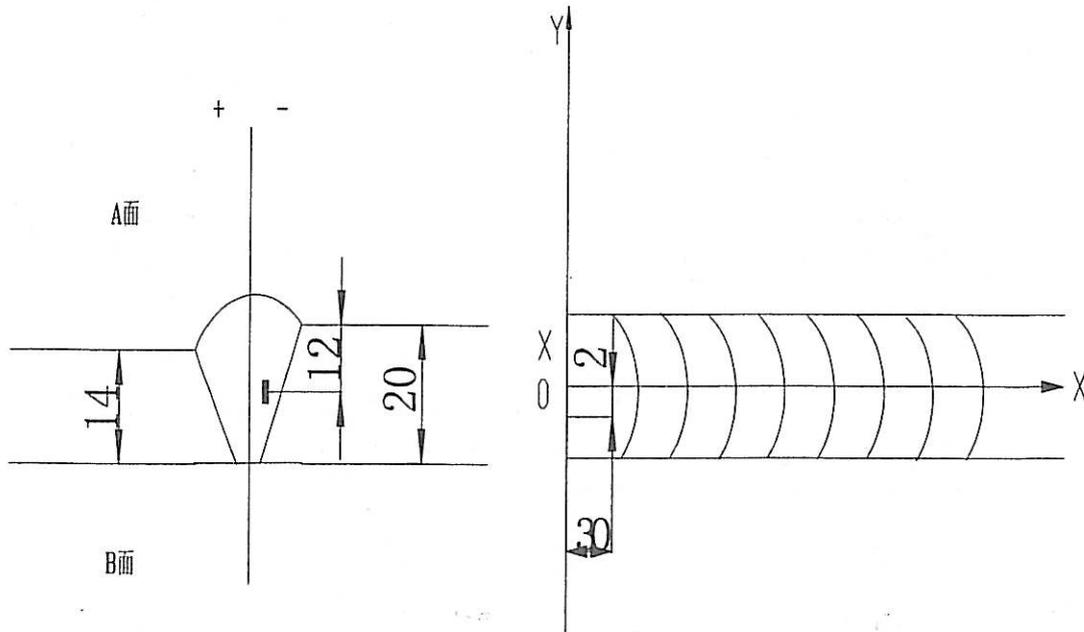
Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

(UT探伤发现的缺陷总长度小于最大允许长度。) SSD18-PP94-303

检验员 (Inspector) Huang Jin 日期(Date): 2010.07.13

焊缝返修位置示意图:

Draft of welding discontinuity:



WELD NUMBER: SSD18-PP94-303

产生原因:

Caused:

1、焊道未及时处理干净。

1. Did not clear the weld pass completely in time.

车间负责人(Foreman): *Li Zhigang* 日期(Date): *2010-07-13*

处理意见

Disposition :

1. 从缺陷距离端面较近一侧 ($D \leq 0.65T$, D 为缺陷深度, T 为板厚) 采用碳刨或打磨的方法去除焊缝缺陷;

2. 参照返修焊接工艺规程 (WPS) 准备正确的接头型式, 预热和焊接;

3. 焊前对修补区域进行VT检测保证缺陷完全被清除;

4. 将修补区域打磨到与母材或邻近焊缝平齐;

5. 根据批准的车间图纸检查焊缝.

1. Gouge or grind from nearer side from metal edge ($D \leq 0.65T$, "D" is depth of defects, "T" is thickness of metal) to remove all defects;

2. Follow repair WPS for joint preparation, preheat, and weld deposit;

3. Verify with VT no defects remain in the weld joint prior to welding;

4. Grind the repaired area flush with base metal or the adjacent weld;

5. Check the welds according to the working drawings.

工 艺: *Xu Dong kai*
Technical engineer

审核: *Jiang Yongbo*
Approved by

日期 *2010-07-13*
Date



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	SSD18	报告编号 Report No.	B-WR13992
合同号 Contract No.:	04-0120F4	部件名称 Items Name	10CE DECK PLATE	NDT报告编号 Report No.of NDT	B787-UT-13273
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

1. 加强焊接监控和道间清理。

1. Improve monitoring of welding and interpass cleaning.

车间负责人(Foreman):

日期(Date):

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair WPS-345-FCAW-1 G(1F)-Repair-1 WPS-345-SMAW-2 G(2F)-Repair WPS-345-FCAW-2 G(2F)-Repair-1 WPS-345-SMAW-3 G(3F)-Repair WPS-345-SMAW-4 G(4F)-Repair WPS-345-SMAW-1 G(1F)-FCM-Repair WPS-345-SMAW-2 G(2F)-FCM-Repair WPS-345-SMAW-3 G(3F)-FCM-Repair WPS-345-SMAW-4 G(4F)-FCM-Repair	工艺员 technologist	<i>Xu Douf/Car</i>
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返修(碳刨)前预热温度 Preheat temperature before gouging	68°C	返修的缺陷 Description of discontinuity	I-F
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焊前处理检查 Inspection before welding	Acc	焊前预热温度 Preheat temperature before welding	102°C
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最大碳刨深度 Max. depth of gouging	10mm	碳刨总长 Total length of gouging	130mm
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焊工 welder	044772	焊接类型 welding type	SMAW	焊接位置 position	2G
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焊接电流 Current	171	焊接电压 Voltage	25-1	焊接速度 Speed	157
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**返修后检查
Inspection After repairing:**

外观检查 VT result	Acc	检验员 Inspector	Liyanhua 07120701	日期 Date	2010.08.27
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NDT复检 NDT result	Acc	探伤员 NDT person	Huang Jin	日期 Date	2010.08.27
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见证:
Witness/Review:备注:
Remark:



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-13273R1 DATE 2010.08.27 PAGE 1 OF 1 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787		CONTRACTOR: CALTRANS	
ITEMS NAME: 部件名称 10CE DECK PLATE	DRAWING NO.: 图号 SSD18	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 SMAW	JOINT TYPE 焊缝类型 BUTT	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 IIW BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X 20/14mm	

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	

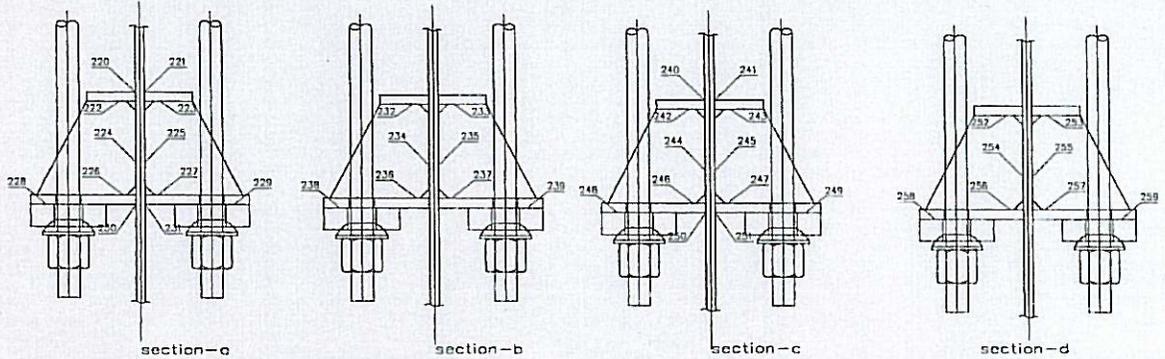
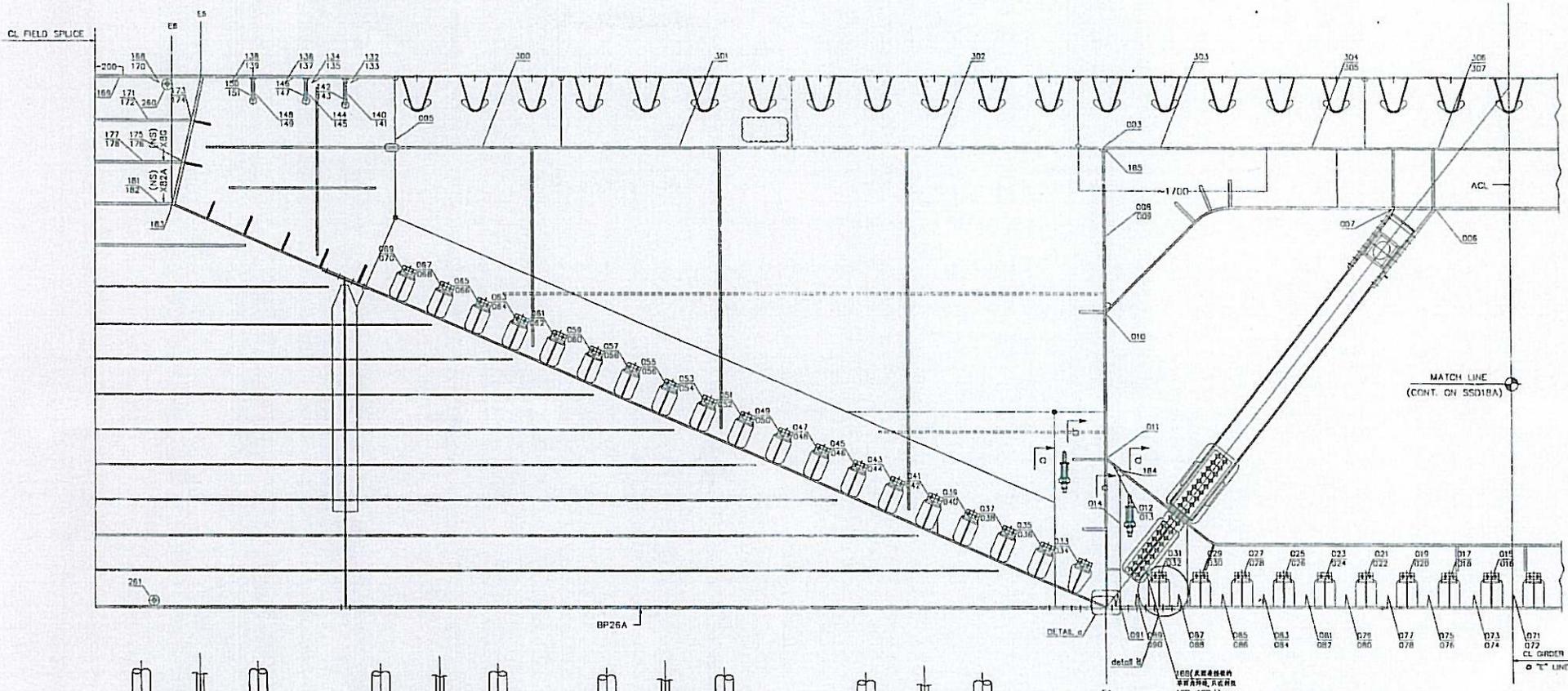
Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

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
SSD18-PP94-303	1R1	70				34									ACC.	100%

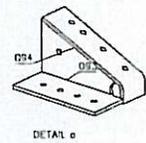
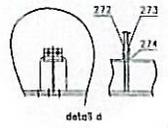
AFTER B-WR13992

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EXAMINED BY 主探 <i>Kuangjin 2010.08.27</i> LEVEL II SIGN / DATE	REVIEWED BY 审核 <i>WV CHAO 2010.08.27</i> LEVEL II SIGN / DATE
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



SECTION 18A-18A
SECTION 18B-18B
SECTION 18C-18C
SECTION 18E-18E
SECTION 18F-18F
SECTION 18G-18G
SECTION 18H-18H
SECTION 18J-18J



注意：
1. 如有遗漏或重复标注的焊缝，请QC人员通知工艺进行补标或删减。

- 注意：
- 300~307焊缝编号仅用于PP94处。
 - 原角焊缝 140/141 在SSD18-PP094由CJP焊缝号140替代，但在SSD18其余PP点位置不作修改。
 - 焊缝272、273、274在PP58、64，其他位置不存在。
 - 原角焊缝144\145在SSD18-PP70由CJP焊缝号144替代其他位置不作修改

This document is APPROVED AS NOTED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Date: 7/5/10

焊缝编号说明：SSD18 PP000 XXX
零件车间图纸号

ZPMC
SHANGHAI ZHENHUA PORT MACHINERY CO., LTD.
WELDING MAP
DRAWN: [] CHECKED: [] SHEET NO: SSD 18 PAGES: 1/1

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
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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-000751**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0709**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: 27-May-2010**Description of Non-Conformance:**

- One (1) longitudinal linear indication measuring approximately 80mm in length.
 - The indication dB rating is a +4.
 - Material thickness is 14mm.
 - The depth of the indication is approximately 10mm.
 - The weld is identified as SSD-PP94-001/002 at Crossbeam side, Panel Point (PP) 94.
 - According to the approved shop drawing and due to excessive root gap ZPMC has changed the joint to a Complete Joint Penetration (CJP) "T" joint.
 - This joint joins the Deck Plate Diaphragm (X1B) to Floor Beam Flange (X7E).
 - The weld is designated as Non-Seismic Performance Critical Material (Non SPCM).
 - The indication is clearly marked on or near the weld.
 - The Y distance for this indication is 1675 mm from the Corner Assembly diaphragm at the Crossbeam side.
 - Segment 10CE is located outside of the Paint shop.
- The Notice of Witness Inspection (NWIT) No. is 005832. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

Contractor's proposal to correct the problem:

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

Corrective action taken:

Contractor supplied post repair NDT documentation verifying weld is in conformance with Contract weld quality requirements. Contractor has also taken action directly with NDT Technicians to avoid similar issues in the future.

Did corrective action require Engineer's approval?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer