

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-000751**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0714**Type of problem:**

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

Reference Description: Missed UT indications found by QA after's QC acceptance on these welds in Segment 10CE and 10CW

Description of Non-Conformance:

During the Quality Assurance (QA) Ultrasonic Testing (UT) review of weld located on Segment 10CE and 10CW, these QA Inspectors discovered the following issue:

On May 29, 2010 in Segment 10CE

- One (1) Class "A" indications measuring approximately 15mm in length.
- The weld is identified as SEG064-036.
- The indication D-rating is +6dB
- The Thickness of the plate is 18mm and depth of the indication approximately 3mm.
- The weld is a Complete Joint Penetration (CJP) corner joint joining edge plate 153B (PL1340B) to Floor beam FB024A(X25B)
- The indication is clearly marked by QA on/near the weld.
- OBG Segment 10CE is located in outside yard (in-front of blast shop).

The Notice of Witness Inspection Number (NWIT) is 005832. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.

On May 30, 2010 in Segment 10CW

- One (1) Class "A" indication measuring approximately 20mm in length.
- The weld is a Complete Joint Penetration (CJP) butt weld joining Deck panel diaphragm (X1H) to Floor beam web (X12D).
- The dB rating is +2.
- The Thickness of the Web plate and diaphragm plate are 18mm and 14mm respectively.
- The "Y" location is approximately 400mm measured from the deck plate.
- The weld is identified as SSD12A-PP94-005.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

-The indication is clearly marked near the weld.

-Segment 10CW is located in the segment repair yard north of the fabrication bay 14.

-This weld joint is designated as Seismic performance critical weld member (SPCM).

The Notice of Witness Inspection Number (NWIT) is 005839. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.

Applicable reference:

AWS D1.5-2002, Section 6, Table 6.3 specifies a class A indication as having a dBs rating of +10 and lower for weld 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: Tim Murphy & Chandra Sudalaimuthu

Name of individual from Contractor notified: Mr. Li Man Kit & Bao Qian

Time and method of notification: 1030 hours_05/30/10_Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1400 hours_5/31/10_Email

QC Inspector's Name: Zhang Wei & Wang Wei Ming

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: 01-Jun-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0714

Job Name: SAS Superstructure
Document No: 05.03.06-000709

Reference Description: Missed UT indications found by QA after's QC acceptance on these welds in Segment 10CE and 10CW

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) Ultrasonic Testing (UT) review of weld located on Segment 10CE and 10CW, these QA Inspectors discovered the following issue:

On May 29, 2010 in Segment 10CE

- One (1) Class "A" indications measuring approximately 15mm in length.
- The weld is identified as SEG064-036.
- The indication D-rating is +6dB
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- The indication is clearly marked by QA on/near the weld.
- OBG Segment 10CE is located in outside yard (in-front of blast shop).

The Notice of Witness Inspection Number (NWIT) is 005832. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.

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- One (1) Class "A" indication measuring approximately 20mm in length.
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- The dB rating is +2.
- The Thickness of the Web plate and diaphragm plate are 18mm and 14mm respectively.
- The "Y" location is approximately 400mm measured from the deck plate.
- The weld is identified as SSD12A-PP94-005.
- The indication is clearly marked near the weld.
- Segment 10CW is located in the segment repair yard north of the fabrication bay 14.
- This weld joint is designated as Seismic performance critical weld member (SPCM).

NCT

(Continued Page 2 of 2)

The Notice of Witness Inspection Number (NWIT) is 005839. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.

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-0714

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: 05.03.06-000709
Subject: NCR No. ZPMC-0714

Dated: 11-Jun-2010
Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9
Job Name: SAS Superstructure
Document No.: ABF-NPR-000707 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-000707R00

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: 05.03.06-000709

Subject: NCR No. ZPMC-0714

Dated: 21-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000707 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT of the weld joint in question after repair to show that they are acceptable and the defect has been removed.

ZPMC is providing NDT of the weld joint in question after repair to show that they are acceptable and the defect has been removed. ZPMC has written and internal NCR. In addition, ABFJV and ZPMC's QA Manager are having a meeting to discuss the issues of missed indications in the OBG and determine a better way to prevent the missed indications.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000707R01;

Caltrans' comments:

Status: CLO

Date: 23-Jun-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0714 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 23-Jun-2010



No. B-793

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-6-21

REGARDING: NCR-000751(ZPMC-0714)

ZPMC acknowledges two indications were missed and is providing the NDT records show the indications have been removed, repaired and are now acceptable. Based on this, please consider closure of this NCR.

ATTACHMENT:

NCR-000751(ZPMC-0714)

B787-UT-13212 R1

B787-UT-13357 R1

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

6/21/10



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: 01-Jun-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: 05.03.06-000709

Subject: NCR No. ZPMC-0714

Reference Description: Missed UT indications found by QA after's QC acceptance on these welds in Segment 10CE and 10CW

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- OBG Segment 10CE is located in outside yard (in-front of blast shop).

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- The "Y" location is approximately 400mm measured from the deck plate.
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NCT

(Continued Page 2 of 2)

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Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0714

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



Bay Area Branch
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(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-000751**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0714**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Segment 10CE and 10CWProcedural Procedural Description: Missed UT Indications by QC**Reference Description:** Missed UT indications found by QA after's QC acceptance on these welds in Segment 10CE and 10CW**Description of Non-Conformance:**

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-The weld is a Complete Joint Penetration (CJP) butt weld joining Deck panel diaphragm (X1H) to Floor beam web (X12D).

-The dB rating is +2.

-The Thickness of the Web plate and diaphragm plate are 18mm and 14mm respectively.

-The "Y" location is approximately 400mm measured from the deck plate.

-The weld is identified as SSD12A-PP94-005.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

-The indication is clearly marked near the weld.

-Segment 10CW is located in the segment repair yard north of the fabrication bay 14.

-This weld joint is designated as Seismic performance critical weld member (SPCM).

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Applicable reference:

AWS D1.5-2002, Section 6, Table 6.3 specifies a class A indication as having a dBs rating of +10 and lower for weld 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: Tim Murphy & Chandra Sudalaimuthu

Name of individual from Contractor notified: Mr. Li Man Kit & Bao Qian

Time and method of notification: 1030 hours_05/30/10_Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1400 hours_5/31/10_Email

QC Inspector's Name: Zhang Wei & Wang Wei Ming

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



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-13212R1 DATE 2010.06.07 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 10CE DECK PLATE SPlice DRAWING NO.: SEG064* CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 SMAW T-JOINT/BUTT 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 14/18mm

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		
SEG064A-036	1R1	70				34								ACC.	100%

AFTER B-WR13283

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EXAMINED BY 主探 <i>Huang Jin 20/06.07</i> LEVEL - II SIGN / DATE	REVIEWED BY 审核 <i>Wu Chao 20/06.07</i> LEVEL - II SIGN / DATE
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质量经理 / QCM 签字 SIGN / 日期 DATE	用户 CUSTOMER 签字 SIGN / 日期 DATE
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2PMC-0714



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-13357R1 DATE 2010.06.08 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 10CW CORNER ASSEMBLY AND FLOOR BEAM DRAWING NO.: SSD12A CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 SMAW BUTT 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 18/14mm

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
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					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		
SSD12A-PP094-005	1R1	70				34								ACC.	100%

AFTER B-WR13521

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EXAMINED BY 主探 Jin Feng 2010.06.08 REVIEWED BY 审核 WU Chao 2010.06.08
 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

DEPARTMENT OF TRANSPORTATION

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Bay Area Branch
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(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-000701**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0714**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: 30-May-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Ultrasonic Testing (UT) review of weld located on Segment 10CE and 10CW, these QA Inspectors discovered the following issue:

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