

**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-000752**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 31-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0715**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Suspender Brackets for OBG Lift 7**Procedural****Procedural****Description:****Reference Description:** ZPMC performed repair not in conformance with the approved CWRs**Description of Non-Conformance:**

During Quality Assurance (QA) random in-process observations of the fabrication of OBG components Suspender Brackets, this QA inspector discovered the following issue:

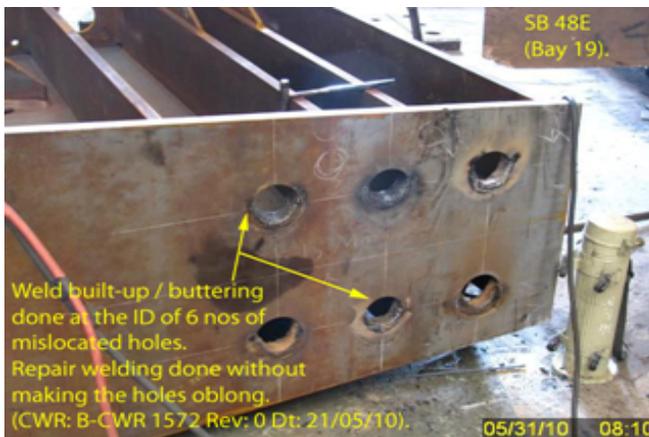
-ZPMC welding personnel performing base metal restoration of the mis-located suspender rod holes on suspender bracket identified as SB48E.

-The repairs did not comply with the approved Critical Welding Report (CWR): B-CWR1572 and B-CWR1578.

-ZPMC welder was buttering (build up with weld) the cross-sectional surface along the full circumference of the mis-drilled holes.

-This manner of repair appears to have been performed on all 6 suspender rod holes on the following suspender brackets: SB48E (Segment 7AE), SB48W (Segment 7AW), and SB54W (Segment 7CW).

-The Suspender Brackets are located in Bay 19.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )



## Applicable reference:

B-CWR 1572 & B-CWR 1578: Issued for the repair of the mis-located holes on SB48E, SB48W and SB54W.

Special Provisions 8-3 Welding: "The QC inspector shall inspect and approve each joint preparation, assembly practice, welding technique, joint fit-up and the performance of each welder, welding operator and tack welder to make certain that the applicable requirements of the code and the approved WPS are met. The QC inspector shall examine the work to make certain that it meets the requirements of section 3 and 6.26.

**Who discovered the problem:** Shailesh Wadkar

**Name of individual from Contractor notified:** Zeng Wen Jun

**Time and method of notification:** 08:30\_5/31/10\_Verbal

**Name of Caltrans Engineer notified:** Sean Eagen

**Time and method of notification:** 14:00\_5/31/10\_Email

**QC Inspector's Name:** Zhou Cheng

**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.

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**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  
**Job Name:** SAS Superstructure

**Attention:** Mr. Thomas Nilsson Project/Fabrication Manager  
**Document No:** 05.03.06-000710

**Subject:** NCR No. ZPMC-0715

**Reference Description:** ZPMC performed repair not in conformance with the approved CWRs

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:** 07

**Remarks:**

- During Quality Assurance (QA) random in-process observations of the fabrication of OBG components Suspender Brackets, this QA inspector discovered the following issue:
- ZPMC welding personnel performing base metal restoration of the mis-located suspender rod holes on suspender bracket identified as SB48E.
  - The repairs did not comply with the approved Critical Welding Report (CWR): B-CWR1572 and B-CWR1578.
  - ZPMC welder was buttering (build up with weld) the cross-sectional surface along the full circumference of the mis-drilled holes.
  - This manner of repair appears to have been performed on all 6 suspender rod holes on the following suspender brackets: SB48E (Segment 7AE), SB48W (Segment 7AW), and SB54W (Segment 7CW).
  - The Suspender Brackets are located in Bay 19.

**Action Required and/or Action Taken:**

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

**Transmitted by:** Sean Eagen Transportation Engineer

**Attachments:** ZPMC-0715

**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:** 05.03.06-000710

**Subject:** NCR No. ZPMC-0715

**Dated:** 15-Jun-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000713 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC will build up the base metal and rebore the holes, after ZPMC will perform 100% UT and MT of the area to show that weld is sound.

ZPMC will build up the base metal and rebore the holes, after ZPMC will perform 100% UT and MT of the area to show that weld is sound. Based on this course of action ZPMC requests that this proposal be accepted with action pending.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000713R00;

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**Caltrans' comments:**

**Status:** REJ

**Date:** 20-Jun-2010

The original buttering that was noted in the NCR was performed without Engineer's approval. A CWR was submitted after the fact and the disposition of this CWR stated that the repair would be performed in accordance with Submittal #200. However, the work as it was actually performed was not in accordance with this. The buttered weld material added needs to be removed and replaced in accordance with Submittal #200R3. It is not necessary to completely fill the holes but edges need to be beveled and NDT performed prior to redrilling the holes.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 20-Jun-2010



No. B-791

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-6-13**

**REGARDING: NCR-000752(ZPMC-0715)**

ZPMC acknowledged the Wrong Repair Procedure was applied in B-CWR1572 & 1578. These repairs were not performing by following the repair procedure in CWR.

These repairs are to rectify the edges' axiality. Please be noticed these holes on Suspender Brackets' flange are fabricated by machining. So the miss-drilled hole repair procedure (Submittal 200) is not compatible with this case. These holes will be fixed as following.

ZPMC performed buttering and will re-boring to fix the axiality issue. (Beveling was not necessary for the building up of edges as the holes are big enough.) 100% UT & MT will be performed after welding to warrant the soundness of the buttering welds. Notification for NDT cross-check will be sent to department's inspector prior to re-boring.

Based on this, ZPMC is request that this NCR be approved, with actions pending, and please consider closing this NCR when the sequent NDT records are submitted.

**ATTACHMENT:**

NCR-000752(ZPMC-0715)

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

6/13/10



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:** 05.03.06-000710

**Subject:** NCR No. ZPMC-0715

**Reference Description:** ZPMC performed repair not in conformance with the approved CWRs

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:** 07

### Remarks:

- During Quality Assurance (QA) random in-process observations of the fabrication of OBG components Suspender Brackets, this QA inspector discovered the following issue:
- ZPMC welding personnel performing base metal restoration of the mis-located suspender rod holes on suspender bracket identified as SB48E.
  - The repairs did not comply with the approved Critical Welding Report (CWR): B-CWR1572 and B-CWR1578.
  - ZPMC welder was buttering (build up with weld) the cross-sectional surface along the full circumference of the mis-drilled holes.
  - This manner of repair appears to have been performed on all 6 suspender rod holes on the following suspender brackets: SB48E (Segment 7AE), SB48W (Segment 7AW), and SB54W (Segment 7CW).
  - The Suspender Brackets are located in Bay 19.

### Action Required and/or Action Taken:

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

**Transmitted by:** Sean Eagen Transportation Engineer

**Attachments:** ZPMC-0715

**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**  
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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-000752

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 31-May-2010

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

**NCR #:** ZPMC-0715

**Type of problem:**

Welding  Concrete  Other

Welding  Curing  Procedural

Joint fit-up  Coating  Other

Procedural  Procedural  Description:

**Bridge No:** 34-0006

**Component:** Suspender Brackets for OBG Lift 7

**Reference Description:** ZPMC performed repair not in conformance with the approved CWRs

**Description of Non-Conformance:**

During Quality Assurance (QA) random in-process observations of the fabrication of OBG components Suspender Brackets, this QA inspector discovered the following issue:

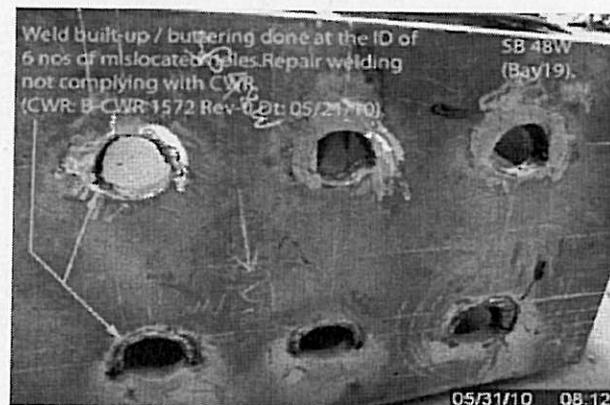
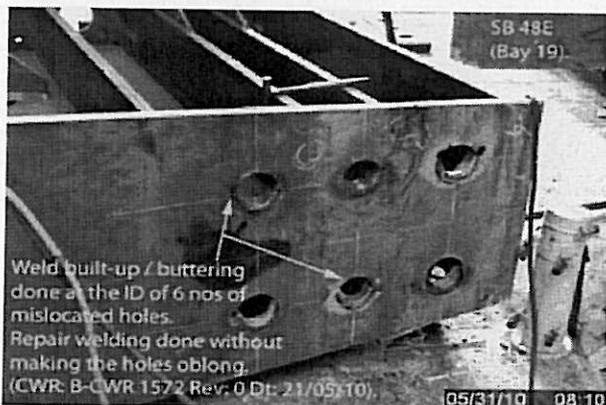
-ZPMC welding personnel performing base metal restoration of the mis-located suspender rod holes on suspender bracket identified as SB48E.

-The repairs did not comply with the approved Critical Welding Report (CWR): B-CWR1572 and B-CWR1578.

-ZPMC welder was buttering (build up with weld) the cross-sectional surface along the full circumference of the mis-drilled holes.

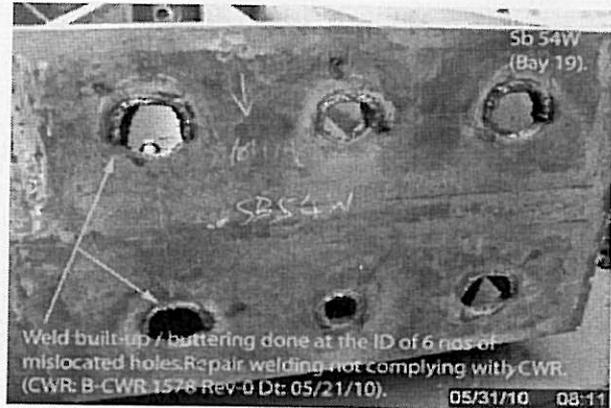
-This manner of repair appears to have been performed on all 6 suspender rod holes on the following suspender brackets: SB48E (Segment 7AE), SB48W (Segment 7AW), and SB54W (Segment 7CW).

-The Suspender Brackets are located in Bay 19.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



### Applicable reference:

B-CWR 1572 & B-CWR 1578: Issued for the repair of the mis-located holes on SB48E, SB48W and SB54W.

Special Provisions 8-3 Welding: "The QC inspector shall inspect and approve each joint preparation, assembly practice, welding technique, joint fit-up and the performance of each welder, welding operator and tack welder to make certain that the applicable requirements of the code and the approved WPS are met. The QC inspector shall examine the work to make certain that it meets the requirements of section 3 and 6.26.

Who discovered the problem: Shailesh Wadkar

Name of individual from Contractor notified: Zeng Wen Jun

Time and method of notification: 08:30\_5/31/10\_Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 14:00\_5/31/10\_Email

QC Inspector's Name: Zhou Cheng

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.

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Inspected By: Tsang, Eric

SMR

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Reviewed By: Devey, Jim

SMR

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000710

**Subject:** NCR No. ZPMC-0715

**Dated:** 28-Jun-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000713 Rev: 01

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC requests that these NCRs be closed as any potential issues with the fit up will have to be resolved in Oakland by ABFJV and ZPMC will be unable to perform any corrective actions to close the NCR.

ZPMC requests that these NCRs be closed as any potential issues with the fit up will have to be resolved in Oakland by ABFJV and ZPMC will be unable to perform any corrective actions to close the NCR. If a potential issues arises a subsequent NCR should be issued at the jobsite where actions there can resolve the issue. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000713R01

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**Caltrans' comments:**

**Status:** REJ

**Date:** 07-Jul-2010

This NCR pertains to a welding issue not a fit up issue. The repair was not performed in conformance with the approved CWRs. Corrective actions and preventive measures are required to close this NCR.

**Submitted by:** Woo, Laraine

**Attachment(s):**

**Date:** 07-Jul-2010

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000710

**Subject:** NCR No. ZPMC-0715

**Dated:** 16-Aug-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000713 Rev: 02

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC had submitted the referenced CWRs and they have been approved by the Department. Based on the accepted revisions to the CWRs and the acceptable NDT, ZPMC requests closure of this NCR.

ZPMC had submitted the referenced CWRs and they have been approved by the Department. Based on the accepted revisions to the CWRs and the acceptable NDT, ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000713R02;

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### Caltrans' comments:

**Status:** AAP

**Date:** 17-Aug-2010

The proposed resolution is acceptable. However, please submit the NDT data for the repairs to the suspender bracket rod holes.

**Submitted by:** Woo, Laraine

**Date:** 17-Aug-2010

**Attachment(s):**



No. B-841

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-08-16**

**REGARDING: NCR-000752(ZPMC-0715)**

ZPMC has submitted the revised CWRs B-CWR1572 R3 & B-CWR1578 R3 what show the correct repair procedure applied on site. Based on the approved CWRs and the previously submitted NDT records, ZPMC is requesting closure of this NCR.

**ATTACHMENT:**

NCR-000752(ZPMC-0715)

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

8/16/10



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:** 05.03.06-000710

**Subject:** NCR No. ZPMC-0715

**Reference Description:** ZPMC performed repair not in conformance with the approved CWRs

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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- 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:** 07

### Remarks:

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  - The Suspender Brackets are located in Bay 19.

### Action Required and/or Action Taken:

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

**Transmitted by:** Sean Eagen Transportation Engineer

**Attachments:** ZPMC-0715

**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

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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-000752**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 31-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0715**Type of problem:**Welding  Concrete  Other Welding  Curing  Procedural Joint fit-up  Coating  Other Procedural  Procedural  Description:**Bridge No:** 34-0006**Component:** Suspender Brackets for OBG Lift 7**Reference Description:** ZPMC performed repair not in conformance with the approved CWRs**Description of Non-Conformance:**

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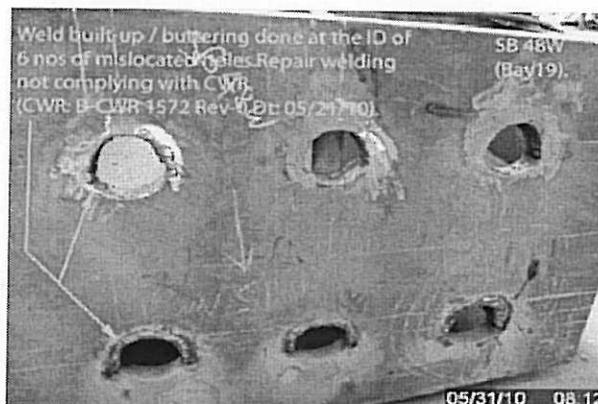
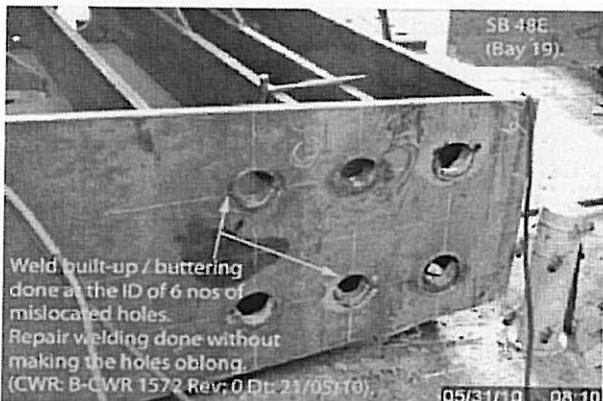
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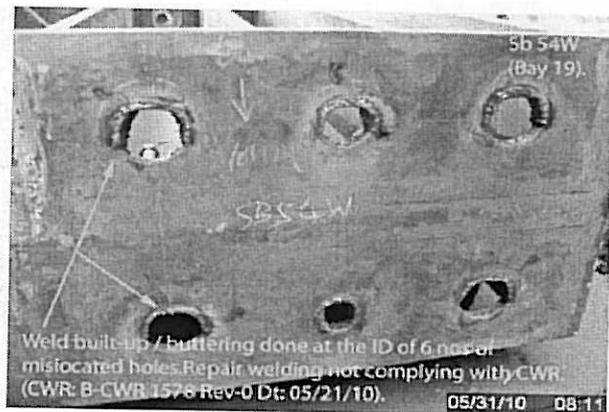
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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



### Applicable reference:

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Name of individual from Contractor notified: Zeng Wen Jun

Time and method of notification: 08:30\_5/31/10\_Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 14:00\_5/31/10\_Email

QC Inspector's Name: Zhou Cheng

Was QC Inspector aware of the problem:  Yes  No

Contractor's proposal to correct the problem:

N/A

### Comments:

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Inspected By: Tsang, Eric

SMR

---

Reviewed By: Devey, Jim

SMR

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000710

**Subject:** NCR No. ZPMC-0715

**Dated:** 19-Aug-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000713 Rev: 03

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC is submitting the NDT records to show that the welds are acceptable. Based on this, ZPMC requests closure of this NCR.

ZPMC is submitting the NDT records to show that the welds are acceptable. Based on this, ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000713R03;

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**Caltrans' comments:**

**Status:** CLO

**Date:** 23-Aug-2010

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

**Submitted by:** Woo, Laraine

**Date:** 23-Aug-2010

**Attachment(s):**









# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-23666		DATE日期 2010.06.03		PAGE OF页码 1/1		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SB48 SUSPENDER BRACKET				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 <sup>ST</sup> , 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  35mm	
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				
SB48W-C				ACC.		BASE METAL	
SB48E-C				ACC.		BASE METAL	
BASE METAL PER B-CWR1572 REV0							
BLANK							
EXAMINED BY主探 Chang fang jie <i>Chang Fangjie</i> 2010.06.03 LEVEL - II SIGN 签名 DATE日期				REVIEWED BY 审核 <i>SU Wen</i> 2010.06.03 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			

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Aug-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0715**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 31-May-2010**Description of Non-Conformance:**

During Quality Assurance (QA) random in-process observations of the fabrication of OBG components Suspenders Brackets, this QA inspector discovered the following issue:

-ZPMC welding personnel performing base metal restoration of the mis-located suspender rod holes on suspender bracket identified as SB48E.

-The repairs did not comply with the approved Critical Welding Report (CWR): B-CWR1572 and B-CWR1578.

-ZPMC welder was buttering (build up with weld) the cross-sectional surface along the full circumference of the mis-drilled holes.

-This manner of repair appears to have been performed on all 6 suspender rod holes on the following suspender brackets: SB48E (Segment 7AE), SB48W (Segment 7AW), and SB54W (Segment 7CW).

-The Suspender Brackets are located in Bay 19.

**Contractor's proposal to correct the problem:**

Correct CWRs detailing actual methods used for repair work and perform NDT required to verify weld quality.

**Corrective action taken:**

Contractor has resubmitted CWRs detailing methods used to perform repair work along with post repair NDT documentation verifying weld repairs meet Contract weld quality requirements. Any fit up issues arising from these repairs will be addressed by ABF in Oakland.

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

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

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# QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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**Inspected By:** Simonis,Jim

Quality Assurance Inspector

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**Reviewed By:** Wahbeh,Mazen

QA Reviewer