

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, China

Report No: NCR-000777

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Jun-2010

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

NCR #: ZPMC-0739

Type of problem:

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

Bridge No: 34-0006

Component: FB3126A Floorbeam on Lift 13AE

Reference Description: Heat Straightening without Engineer's Approval

Description of Non-Conformance:

During the Caltrans Quality Assurance in-process observations of the fabrication of Floorbeam FB3126A, QA discovered the following issue:

- ZPMC personnel heat straightening Seismic Performance Critical Material (SPCM) material distorted by welding without the Engineers approval.
- The Floorbeam is identified as FB3126A.
- The plate is identified as X3380B (SPCM).
- The deviation from flat as measured by this QA was 10mm per 1000mm.
- The Material thickness is 20 mm.



Applicable reference:

AWS D1.5/2002 Section 3.7.3: "Members distorted by welding shall be heat straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the engineer".

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Caltrans Special Provisions Section 8-3: "For material more than 16 mm, the Contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer".

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Mr.Wang wen bin

Time and method of notification: 10:00 hours, 06-27-2010, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 14:50, 6/28/10, Email

QC Inspector's Name: Zhan Hai Feng

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:	Devey,Jim	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: 29-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: 05.03.06-000735

Subject: NCR No. ZPMC-0739

Reference Description: Heat Straightening without Engineer's Approval

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:** 13

Remarks:

During the Caltrans Quality Assurance in-process observations of the fabrication of Floorbeam FB3126A, QA discovered the following issue:

- ZPMC personnel heat straightening Seismic Performance Critical Material (SPCM) material distorted by welding without the Engineers approval.
- The Floorbeam is identified as FB3126A.
- The plate is identified as X3380B (SPCM).
- The deviation from flat as measured by this QA was 10mm per 1000mm.

See attached NCR No. ZPMC-0739 for details.

- The Material thickness is 20 mm.

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: Ching Chao

Attachments: ZPMC-0739

cc: Gary Pursell, Peter Siegenthaler, Stanley Ku, 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: 05.03.06-000735

Subject: NCR No. ZPMC-0739

Dated: 30-Aug-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000752 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is submitting the HSR used at the time of heat straightening along with the NDT performed after to show that the welds are still acceptable after heat straightening.

ZPMC is submitting the HSR used at the time of heat straightening along with the NDT performed after to show that the welds are still acceptable after heat straightening. ZPMC will verify that the HSR matches the conditions present before beginning work. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000752R00;

Caltrans' comments:

Status: AAP

Date: 08-Sep-2010

The NDT submitted is acceptable. However, preventive measures must be taken by the contractor before this NCR can be closed.

Submitted by: Woo, Laraine

Date: 08-Sep-2010

Attachment(s):



No. B-855

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-8-28

REGARDING: NCR-000777(ZPMC-0739)

For this issue, ZPMC has released the approved HSRs as attached. Also, ZPMC is providing the NDT record for review. Based on this, please consider closure of this NCR.

ATTACHMENT:

NCR-000777(ZPMC-0739)

HSR1(B)-8687

B787-UT-14127

B787-MT-25269

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: 29-Jun-2010
Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

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Transmitted by: Ching Chao

Attachments: ZPMC-0739

cc: Gary Pursell, Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

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Contract #: 04-0120F4
City: SF/ALA Rte: 80 PM: 13.2/13.9
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Report No: NCR-000777

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Jun-2010

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

NCR #: ZPMC-0739

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

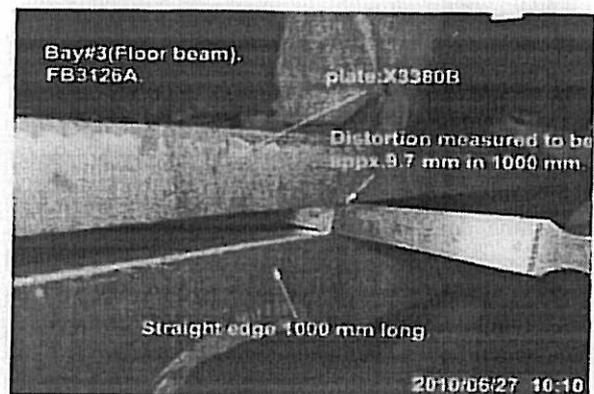
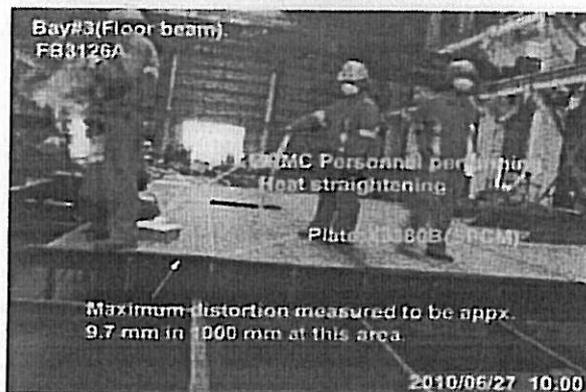
Component: FB3126A Floorbeam on Lift 13AE

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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QC Inspector's Name: Zhan Hai Feng

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: Devey, Jim

SMR

Reviewed By: Wahbeh, Mazen

SMR



火工校正记录

Heat Straightening Record(HSR1)

报告号 Record#

HSR1(B)-8687

版本号 Revision #

1

日期 Date

2010.08.27

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:

质检代表/Quality Control Representative

部装 Sub-Assembly:

Xu Jian 6/28/10

梁段 Gird: 13LIFT

质检经理/Quality Assurance Manager-Approval

塔段 Tower:

N/A

Xu Jian 6/28/10

焊缝号 Weld No:

001,003,012~42

焊缝地图号 Weld Map No:

FB3126-001

情况描述 Description of Condition

Cause原因

Welding distortion 焊接变形

Type of Defect缺陷类型

Welding distortion 焊接变形

Inspection Method检查方法

Visual 目检

处置方法 Disposition

缺陷去除方法(Defect Removal Method):

Flame Straightening by oxygen acetylene 运用氧乙炔进行校火

后续NDE(Post-Removal NDE):

After finishing heat straightening, the weld of the heat area shall perform NDT according to the approved shop drawing 校火后, 根据图纸要求对热影响区域进行 NDT 检测

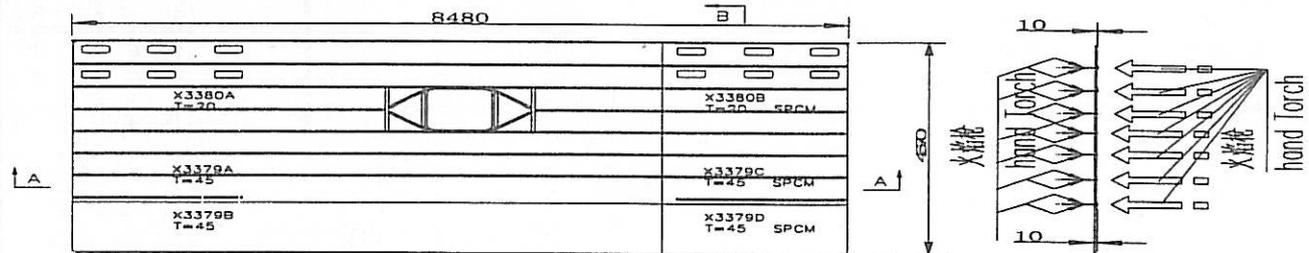
纠正措施(Corrective Action(s)):

Control current, voltage and weld speed according to relevant WPS. If necessary anti-deformation or hold down device can be added. 依据相应的WPS的要求控制电流, 电压和焊接速度. 如有必要, 可使用反变形设施进行校正.

实施次数(Number of application): 1~3

最高温度(Maximum temperature): <600°C

简图 Sketch



"I" 型钢校火区域: "▽" 宽度约50~150mm
 "I" shapes heat straightening areas: "▽" width is about 50~150mm

Countweight

注: 最大变形量约10mm, 纵向校火宽度50~150mm.
 NOTE: the max deformation is about 10mm, longitudinal heat straightening the width is 50~150mm.

Heat Straightening
 2010.7.26

To be signed when Closing HSR~Verify compliance and all necessary reports are ready to attach

检验员 Inspector:	chen xi	签字 Signature:	Chen Xi
CWI #	07072021	Closing Date:	2010.7.26
II 级探伤 NDE Certification:	Level II		
质检经理 QC Manager	Xu Jian	审核日期 Review Date:	2010.07.26

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787-QCP-1101

张亚旭

Approved by Xu Jian
 6/28/10



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-14127 DATE 2010.07.26 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: THE 13 LIFTING FLOOR BEAM DRAWING NO.: FB3126 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
 SAW 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/F2-X 20/35mm

TRANSDUCER 探头

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

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

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									a	b	c	d	Length 长度			Sound Path 声程
FB3126-001-001		70				32									ACC.	100%
FB3126-001-003		70				32									ACC.	100%

AFTER HSR1(B)-8687

BLANK

EXAMINED BY 主探 <i>Xuwei</i> LEVEL - II SIGN / DATE <i>2010.07.26</i>	REVIEWED BY 审核 <i>Tang xingshan</i> LEVEL - II SIGN / DATE <i>2010.07.26</i>
质量经理 / QCM 签字 SIGN / 日期 DATE	用户 CUSTOMER 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-25269 DATE日期 2010.07.25 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: FB3126 13th lifting floor beam		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/F2-X 35/20mm
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	T-JOINT

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			
FB3126-001-008				ACC.		50%MT
FB3126-001-009				ACC.		100%MT
FB3126-001-010				ACC.		100%MT
FB3126-001-011				ACC.		100%MT
FB3126-001-127						*
FB3126-001-128						*
FB3126-001-123						*
FB3126-001-124						*
FB3126-001-139				ACC.		100%MT
FB3126-001-140				ACC.		100%MT
FB3126-001-127						*
FB3126-001-128						*
FB3126-001-121						*
FB3126-001-122						*

EXAMINED BY主探 Jin Jianting LEVEL - II SIGN 签名 / DATE日期 2010.07.25	REVIEWED BY 审核 Sun Junchang LEVEL-II SIGN / DATE日期 2010.07.25
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-25269		DATE 日期 2010.07.25		PAGE OF 页码 2/4	Revision No: 0	
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS			
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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/F2-X 35/20mm			
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	T-JOINT			
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			
FB3126-001-119						*
FB3126-001-120						*
FB3126-001-131				ACC.		100%MT
FB3126-001-132				ACC.		100%MT
FB3126-001-125						*
FB3126-001-126						*
<p>* FB3126-001-008、FB3126-001-009、FB3126-001-010、FB3126-001-011、FB3126-001-139、FB3126-001-140、FB3126-001-131、FB3126-001-132 were MT inspection and ACC, which is the result of required 25% MT.</p> <p>* FB3126-001-008、FB3126-001-009、FB3126-001-010、FB3126-001-011、FB3126-001-139、FB3126-001-140、FB3126-001-131、FB3126-001-132 焊缝经MT检测合格, 累积检测长度已经达到了此批要求的25%检测长度。</p>						
FB3126-001-036				ACC.		100%MT
FB3126-001-037				ACC.		100%MT
FB3126-001-038				ACC.		50%MT
FB3126-001-039				ACC.		50%MT
FB3126-001-040				ACC.		100%MT
EXAMINED BY 主探 Jin Jianting LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM			REVIEWED BY 审核 Sun Jianting LEVEL-II SIGN / DATE 日期 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-25269 DATE日期 2010.07.25 PAGE OF页码 3/4 Revision No: 0

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

DRAWING NO. FB3126 CALTRANS CONTRACT NO.: 04-0120F4
图号: 13th lifting floor beam 加州工程编号

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
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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/F2-X 35/20mm
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	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
FB3126-001-041				ACC.		100%MT
FB3126-001-042				ACC.		100%MT
FB3126-001-024				ACC.		100%MT
FB3126-001-025				ACC.		100%MT
FB3126-001-026				ACC.		50%MT
FB3126-001-027				ACC.		50%MT
FB3126-001-028				ACC.		100%MT
FB3126-001-029				ACC.		100%MT
FB3126-001-030				ACC.		50%MT
FB3126-001-031				ACC.		50%MT
FB3126-001-032				ACC.		100%MT
FB3126-001-033				ACC.		100%MT
FB3126-001-034				ACC.		50%MT
FB3126-001-035				ACC.		50%MT

EXAMINED BY主探 Jin Jianting LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM 签字 SIGN / 日期 DATE	<i>Jin Jianting</i> 2010.07.25	REVIEWED BY 审核 Sun Gangchang LEVEL-II SIGN / DATE日期 用户CUSTOMER 签字 SIGN / 日期 DATE	<i>Sun Gangchang</i> 2010.07.25
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REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25269 DATE日期 2010.07.25 PAGE OF页码 4/4 Revision No: 0

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

DRAWING NO. FB3126 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 13th lifting floor beam 加州工程编号:

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
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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
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MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
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PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
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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/F2-X 35/20mm
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WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	T-JOINT
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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			
FB3126-001-012				ACC.		50%MT
FB3126-001-013				ACC.		50%MT
FB3126-001-014				ACC.		100%MT
FB3126-001-015				ACC.		100%MT
FB3126-001-016				ACC.		50%MT
FB3126-001-017				ACC.		50%MT
FB3126-001-018				ACC.		100%MT
FB3126-001-019				ACC.		100%MT
FB3126-001-020				ACC.		50%MT
FB3126-001-021				ACC.		50%MT
FB3126-001-022				ACC.		50%MT
FB3126-001-023				ACC.		50%MT

AFTER HSR1 (B) -8687

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EXAMINED BY主探 Jin Jianting <i>Jin Jianting</i>	REVIEWED BY 审核 <i>Sun J. y. chang</i>
LEVEL - II SIGN 签名 / DATE日期 <i>2010.07.25</i>	LEVEL-II SIGN / DATE日期 <i>2010.07.25</i>
质量经理 / QCM	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: 05.03.06-000735

Subject: NCR No. ZPMC-0739

Dated: 21-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000752 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: The responsible inspector is reprimanded and it is noted if preventable non conformances continue to occur in the inspector's area of responsibility.

Both ABFJV and ZPMC have in place a program to track when non conformances occur and who the responsible inspector was at the time it occurred that could have stopped the non conformance from occurring. The responsible inspector is reprimanded and it is noted if preventable non conformances continue to occur in the inspector's area of responsibility. In addition, the Production teams responsible have been warned again that repair documents must be followed and changes must be documented in revised documents. Based on these actions and previously submitted NDT, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000752R01

Caltrans' comments:

Status: CLO

Date: 26-Sep-2010

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

Submitted by: Woo, Laraine

Date: 26-Sep-2010

Attachment(s):

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, China**Report No:** NCS-000806**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0739**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-Jun-2010**Description of Non-Conformance:**

During the Caltrans Quality Assurance in-process observations of the fabrication of Floorbeam FB3126A, QA discovered the following issue:

- ZPMC personnel heat straightening Seismic Performance Critical Material (SPCM) material distorted by welding without the Engineers approval.
- The Floorbeam is identified as FB3126A.
- The plate is identified as X3380B (SPCM).
- The deviation from flat as measured by this QA was 10mm per 1000mm.
- The Material thickness is 20 mm.

Contractor's proposal to correct the problem:

Contractor will perform NDT to prove the weld is acceptable. Contractor will identify the inspectors who performed heat straightening, and educate him. The inspector's performance will be monitored by the Contractor. Contractor will warn the production teams regarding the repair documents must be followed and changes must be documented in revised documents.

Corrective action taken:

Contractor provided the NDT report to prove the weld is acceptable. Contractor also identified the inspector who is responsible, and educated him. Contractor warned the production team regarding the repair documents must be followed and changes must be documented in revised documents.

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 Wahbeh, Mazen 818-292-0659, who represents the Office

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

of Structural Materials for your project.

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer
