

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-000801

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 14-Jul-2010

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

NCR #: ZPMC-0763

Type of problem:

Welding

Concrete

Other

Welding

Curing

Procedural

Bridge No: 34-0006

Joint fit-up

Coating

Other

Component: Side & Edge Plates, Lift 13

Procedural

Procedural

Description:

Reference Description: Side and Edge Plates Unapproved Wrapped Welds - Lift 13

Description of Non-Conformance:

During the Caltrans Quality Assurance in-process observations of the fabrication of Side Plate and Edge Plate for Lift 13, Quality Assurance discovered the following issue:

-ZPMC personnel have wrapped the fillet welds around the ends of the I-rib stiffeners on Side plate and Edge plates.

-The affected members are identified as follows:

1) Side Plate SP3069-001, this member joined with two web plates PL3249A {Non-SPCM} and PL3249B {Seismic Performance Critical Member (SPCM)}. Welds#1~8 on PL3249A and Welds#9~44 on PL3249B located at fabrication Bay#10.

2) Edge Plate EP3023-001, Welds#3~6 and 15~18 located at fabrication Bay#11.

3) Side Plate SP3081-001, Welds#3; 4; 15; 16; 21; 22; 31~34 located at fabrication Bay#11. The member found to be Seismic Performance Critical Member (SPCM).

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 1002, Section 3.1.5: Welds shall be prohibited on the work except as follows: (1) Base-metal repair performed in conformance with AASHTO... (2) All welds detailed on approved shop drawings. (3) Repair welds authorized by this code (4) Other welds approved by the Engineer.

ABF-RFI-001786R00 dated June 12, 2009: ...terminate welds in accordance with the contract plans and the approved shop drawings.

Who discovered the problem: Naddi Sandeep Kumar / Shailesh Gaikwad

Name of individual from Contractor notified: Mr. Shen Jian

Time and method of notification: 1730 hours, 07/14/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 18:00 hours, 07/15/10, Email

QC Inspector's Name: Mr. Sun Tian Liang- Bay#10 / Mr. Ma Qian Li -Bay#11

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

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



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
 375 BURMA ROAD
 OAKLAND CA 95607

Date: 16-Jul-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: 05.03.06-000758

Subject: NCR No. ZPMC-0763

Reference Description: Side and Edge Plates Unapproved Wrapped Welds - Lift 13

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 Side Plate and Edge Plate for Lift 13, Quality Assurance discovered the following issue:

-ZPMC personnel have wrapped the fillet welds around the ends of the I-rib stiffeners on Side Plate and Edge plates.

-The affected members are identified as follows:

- 1) Side Plate SP3069-001, this member joined with two web plates PL3249A {Non-SPCM} and PL3249B {Seismic Performance Critical Member (SPCM)}. Welds#1~8 on PL3249A and Welds#9~44 on PL3249B located at fabrication Bay#10.
- 2) Edge Plate EP3023-001, Welds#3~6 and 15~18 located at fabrication Bay#11.
- 3) Side Plate SP3081-001, Welds#3; 4; 15; 16; 21; 22; 31~34 located at fabrication Bay#11. The member found to be Seismic Performance Critical Member (SPCM).

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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0763

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: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000758

Subject: NCR No. ZPMC-0763

Dated: 21-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000780 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has removed the wrapped welds from the identified locations by grinding and is providing NDT of the welds to show that no indications were found after the grinding.

ZPMC has removed the wrapped welds from the identified locations by grinding and is providing NDT of the welds to show that no indications were found after the grinding. In the future, ZPMC production is aware that wrapped welds are only allowed in locations specified by the shop drawings. To prevent future occurrences the ABFJV QCM has met with all lead inspectors on the projects for all areas and it is clear that wrapped welds are not acceptable and if welds are wrapped in locations where they are not specified they should be removed and the area tested after. ZPMC requests closure of this NCR based on these actions.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000780R00;

Caltrans' comments:

Status: CLO

Date: 26-Sep-2010

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

Submitted by: Woo, Laraine

Attachment(s):

Date: 26-Sep-2010



No. B-888

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-9-18

REGARDING: NCR-000801(ZPMC-0763)

ZPMC QA has issue an internal NCR to address this problem. The unsepcified wrapping have been removed by grinding. ZPMC is providing the NDT records to show the acceptances of these welds. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000801(ZPMC-0763)

B787-MT-25398

B787-MT-25766

B787-MT-26151

B787-MT-26152

A handwritten signature in black ink, appearing to be 'Ley' followed by a flourish.

9/18/10



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
 375 BURMA ROAD
 OAKLAND CA 95607

Date: 16-Jul-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-0763

Job Name: SAS Superstructure
 Document No: 05 03.06-000758

Reference Description: Side and Edge Plates Unapproved Wrapped Welds - Lift 13

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 Side Plate and Edge Plate for Lift 13, Quality Assurance discovered the following issue:

-ZPMC personnel have wrapped the fillet welds around the ends of the I-rib stiffeners on Side Plate and Edge plates

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1) Side Plate SP3069-001, this member joined with two web plates PL3249A (Non-SPCM) and PL3249B (Seismic Performance Critical Member (SPCM)), Welds#1-8 on PL3249A and Welds#9-44 on PL3249B located at fabrication Bay#10.

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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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0763

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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 DIVISION OF ENGINEERING SERVICES
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Contract #: 04-0120F4
 City: 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-000801

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 14-Jul-2010

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

NCR #: ZPMC-0763

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: Side & Edge Plates, Lift 13

Reference Description: Side and Edge Plates Unapproved Wrapped Welds - Lift 13

Description of Non-Conformance:

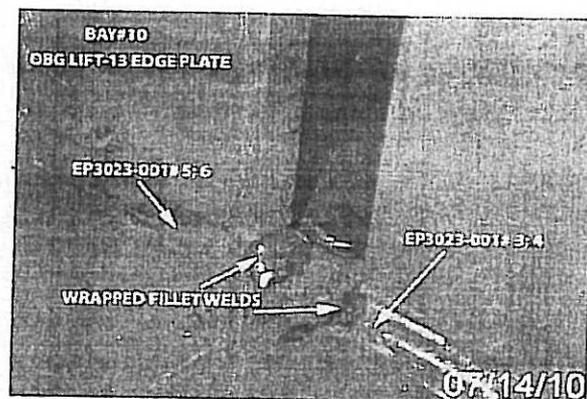
During the Caltrans Quality Assurance in-process observations of the fabrication of Side Plate and Edge Plate for Lift 13, Quality Assurance discovered the following issue:

-ZPMC personnel have wrapped the fillet welds around the ends of the I-rib stiffeners on Side plate and Edge plates.

-The affected members are identified as follows:

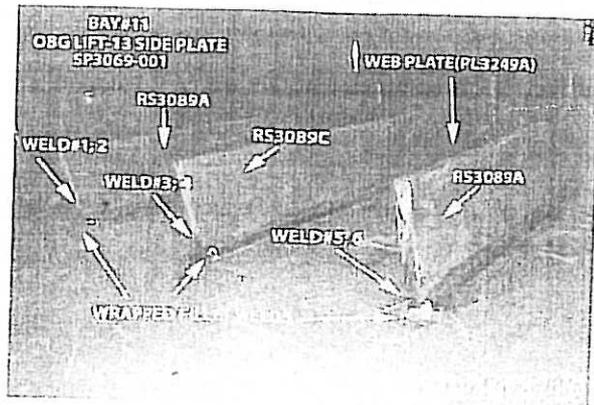
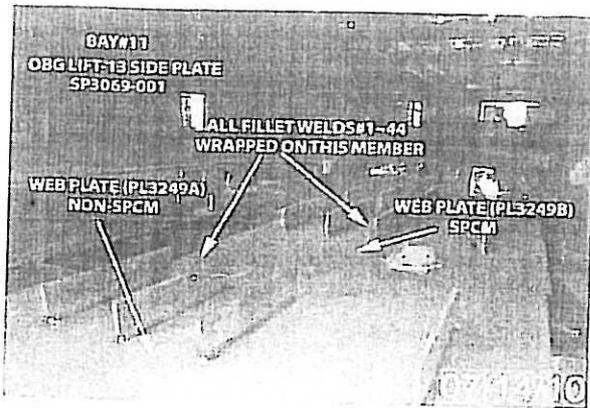
- 1) Side Plate SP3069-001, this member joined with two web plates PL3249A {Non-SPCM} and PL3249B {Seismic Performance Critical Member (SPCM)}. Welds#1~8 on PL3249A and Welds#9~44 on PL3249B located at fabrication Bay#10.
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For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 1002, Section 3.1.5: Welds shall be prohibited on the work except as follows: (1) Base-metal repair performed in conformance with AASHTO... (2) All welds detailed on approved shop drawings. (3) Repair welds authorized by this code (4) Other welds approved by the Engineer.

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Who discovered the problem: Naddi Sandeep Kumar / Shailesh Gaikwad

Name of individual from Contractor notified: Mr Shen Jian

Time and method of notification: 1730 hours, 07/14/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 18:00 hours, 07/15/10, Email

QC Inspector's Name: Mr. Sun Tian Liang- Bay#10 / Mr. Ma Qian Li -Bay#11

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

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



ZPMC-0763

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25398		DATE 日期 2010.07.26	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: SP3069 side plate and l-rib		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 18/22/25mm		
WELDING PROCESS 焊接方法 FCAW/SAW		TYPE OF JOINT 焊缝类型 CORNER 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			
SP3069-001-001				ACC.		100%MT
SP3069-001-002				ACC.		100%MT
SP3069-001-003				ACC.		100%MT
SP3069-001-004				ACC.		100%MT
SP3069-001-005				ACC.		100%MT
SP3069-001-006				ACC.		100%MT
SP3069-001-007				ACC.		100%MT
SP3069-001-008				ACC.		100%MT
SP3069-001-009				ACC.		100%MT
SP3069-001-010				ACC.		100%MT
SP3069-001-011				ACC.		100%MT
SP3069-001-012				ACC.		100%MT
SP3069-001-013				ACC.		100%MT
SP3069-001-014				ACC.		100%MT

EXAMINED BY 主探 Cai Xinxin <u>Cai Xinxin</u> 10.27.26	REVIEWED BY 审核 <u>XU Biny</u> 10.27.26
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-25398 DATE日期 2010.07.26 PAGE OF页码 2/4 Revisión No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3069 side plate and I-rib		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 18/22/25mm
WELDING PROCESS 焊接方法	FCAW/SAW	TYPE OF JOINT 焊缝类型	CORNER 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			
SP3069-001-015				ACC.		100%MT
SP3069-001-016				ACC.		100%MT
SP3069-001-017				ACC.		100%MT
SP3069-001-018				ACC.		100%MT
SP3069-001-019				ACC.		100%MT
SP3069-001-020				ACC.		100%MT
SP3069-001-021				ACC.		100%MT
SP3069-001-022				ACC.		100%MT
SP3069-001-023				ACC.		100%MT
SP3069-001-024				ACC.		100%MT
SP3069-001-025				ACC.		100%MT
SP3069-001-026				ACC.		100%MT
SP3069-001-027				ACC.		100%MT
SP3069-001-028				ACC.		100%MT

EXAMINED BY主探 Cai Xinxin <i>Cai Xinxin</i> 10.7.26	REVIEWED BY审核 <i>XU Bing</i> 10.7.26
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



REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 B787-MT-25398 DATE日期 2010.07.26 PAGE OF页码 4/4 Revision No: 0

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

DRAWING NO. SP3069 CALTRANS CONTRACT NO.:
图号: side plate and I-rib 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
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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 18/22/25mm
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WELDING PROCESS 焊接方法	FCAW/SAW	TYPE OF JOINT 焊缝类型	CORNER 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			
SP3069-001-043				ACC.		100%MT
SP3069-001-044				ACC.		100%MT

AFTER HSR1(B)-8828

BLANK

EXAMINED BY主探 Cai Xinxin <i>Cai Xinxin</i> 10.27.26	REVIEWED BY审核 XU Bing <i>XU Bing</i> 10.27.26
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-25766 DATE日期 2010.08.05 PAGE OF页码 1/3 Revision No: 0

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

DRAWING NO. EP3023-001 CALTRANS CONTRACT NO.:
 图号: 13th lifting edge plate 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
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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
----------------------------	------------------------------------	---------------	----

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-X 22/18mm
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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			
EP3023-001-001				ACC.		100%MT
EP3023-001-002				ACC.		100%MT
EP3023-001-003				ACC.		100%MT
EP3023-001-004				ACC.		100%MT
EP3023-001-005				ACC.		100%MT
EP3023-001-006				ACC.		100%MT
EP3023-001-007				ACC.		100%MT
EP3023-001-008				ACC.		100%MT
EP3023-001-009				ACC.		100%MT
EP3023-001-010				ACC.		100%MT
EP3023-001-011				ACC.		100%MT
EP3023-001-012				ACC.		100%MT
EP3023-001-013				ACC.		100%MT
EP3023-001-014				ACC.		100%MT

EXAMINED BY 主探
 Xu Bing Xu Bing 10.08.05
 LEVEL - II SIGN 签名 / DATE 日期
 质量经理 / QCM

REVIEWED BY 审核
 Cai Xiaxin Cai Xiaxin 10.08.05
 LEVEL-II SIGN / DATE 日期

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-25766		DATE 日期 2010.08.05		PAGE OF 页码 2/3		Revision No. 0-	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: EP3023-001 13th lifting edge plate				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 22/18mm	
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			
EP3023-001-015				ACC.		100%MT
EP3023-001-016				ACC.		100%MT
EP3023-001-017				ACC.		100%MT
EP3023-001-018				ACC.		100%MT
EP3023-001-019				ACC.		100%MT
EP3023-001-020				ACC.		100%MT
EP3023-001-021				ACC.		100%MT
EP3023-001-022				ACC.		100%MT
EP3023-001-023				ACC.		100%MT
EP3023-001-024				ACC.		100%MT
EP3023-001-025				ACC.		100%MT
EP3023-001-026				ACC.		100%MT
EP3023-001-027				ACC.		100%MT
EP3023-001-028				ACC.		100%MT

EXAMINED BY 主探 Xu Bing <i>Xu Bing</i> 12.08.05		REVIEWED BY 审核 <i>Cui Xun Xun</i> 12.08.05	
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	



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-26151 DATE日期 2010.08.26 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: SP3081B-001 13 LIFTING		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 12/16mm
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			
SP3081B-001-031				ACC		100%MT
SP3081B-001-065				ACC		100%MT
SP3081B-001-074				ACC		100%MT
SP3081B-001-081				ACC		100%MT
SP3081B-001-100				ACC		100%MT
SP3081B-001-107				ACC		100%MT
BLANK						

EXAMINED BY主探 CaiXinxin CaiXinxin 12.08.26 LEVEL-II SIGN 签名 / DATE日期 质量经理 / QCM	REVIEWED BY 审核 Xian Bing 12.08.26 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-26152 DATE日期 2010.08.26 PAGE OF页码 1/9 Revision No: 0

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

DRAWING NO. 图号: SP3081B-001 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
13 LIFTING

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-X 12/16/25/14mm
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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			
SP3081B-001-108				ACC		100%MT
SP3081B-001-109				ACC		100%MT
SP3081B-001-110				ACC		100%MT
SP3081B-001-111				ACC		100%MT
SP3081B-001-112				ACC		100%MT
SP3081B-001-113				ACC		100%MT
SP3081B-001-114				ACC		100%MT
SP3081B-001-115				ACC		100%MT
SP3081B-001-116				ACC		100%MT
SP3081B-001-117				ACC		100%MT
SP3081B-001-118				ACC		100%MT
SP3081B-001-119				ACC		100%MT
SP3081B-001-120				ACC		100%MT
SP3081B-001-121				ACC		100%MT

EXAMINED BY 主探 CaiXinxin CaiXinxin 2008.26 LEVEL - II SIGN 签名 / DATE日期	REVIEWED BY 审核 Van Bing 2008.26 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-26152 DATE日期 2010.08.26 PAGE OF页码 2/9 Revision No.: 0#

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

DRAWING NO. 图号: SP3081B-001 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
13 LIFTING

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 12/16/25/14mm
 FORGING 锻造

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			
SP3081B-001-122				ACC		100%MT
SP3081B-001-123				ACC		100%MT
SP3081B-001-124				ACC		100%MT
SP3081B-001-125				ACC		100%MT
SP3081B-001-126				ACC		100%MT
SP3081B-001-127				ACC		100%MT
SP3081B-001-128				ACC		100%MT
SP3081B-001-129				ACC		100%MT
SP3081B-001-130				ACC		100%MT
SP3081B-001-131				ACC		100%MT
SP3081B-001-132				ACC		100%MT
SP3081B-001-133				ACC		100%MT
SP3081B-001-134				ACC		100%MT
SP3081B-001-135				ACC		100%MT

EXAMINED BY主探: CaiXinxin REVIEWED BY审核: Yan Bing
LEVEL - II SIGN 签名 / DATE日期: 2010.08.26

LEVEL-II SIGN / DATE日期: 10.08.26

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-26152

DATE日期 2010.08.26

PAGE OF页码 3/9

Revision No: 0

PROJECT NO.

ZP06-787

CONTRACTOR:

CALTRANS

工程编号:

用户:

DRAWING NO.

SP3081B-001

CALTRANS CONTRACT NO.:

04-0120F4

图号:

13 LIFTING

加州工程编号

REFERENCING CODE

ACCEPTANCE STANDARD

PROCEDURE NO.

CALIBRATION DUE DATE

参考规范编码

接受标准

程序编号

仪器校正有效期

AWS D1.5-2002

AWS D1.5-2002

ZPQC-MT-01

Dec. 28ST, 2010

EQUIPMENT 设备

MANUFACTURER 制造商

MODEL NO. 样式编号

SERIAL NO. 连续编号

MT YOKE

PARKER

B310S

5395 5617 5620

MAGNETIZING METHOD

Continuous magnetic yoke

CURRENT

AC

磁化方法

磁轭式连续法

电流

PARTICLE TYPE

Dry magnet powder

YOKE SPACING

70~150mm

磁粉类型

干磁粉

磁轭间距

MATERIAL TO BE

√ WELDING 焊接件

Material & thickness

A709M-345T2-X

EXAMINED

 CASTING 铸件

母材, 厚度

检测材料

 FORGING 锻造

12/16/25/14mm

WELDING PROCESS

FCAW

TYPE OF JOINT

T-JOINT

焊接方法

焊缝类型

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			
SP3081B-001-136				ACC		100%MT
SP3081B-001-137				ACC		100%MT
SP3081B-001-138				ACC		100%MT
SP3081B-001-139				ACC		100%MT
SP3081B-001-140				ACC		100%MT
SP3081B-001-141				ACC		100%MT
SP3081B-001-142				ACC		100%MT
SP3081B-001-143				ACC		100%MT
SP3081B-001-144				ACC		100%MT
SP3081B-001-145				ACC		100%MT
SP3081B-001-146				ACC		100%MT
SP3081B-001-147				ACC		100%MT
SP3081B-001-148				ACC		100%MT
SP3081B-001-149				ACC		100%MT

EXAMINED BY主探

CaiXinxin

Cai Xinxin 12.08.26

LEVEL - II SIGN 签名 / DATE日期

质量经理 / QCM

REVIEWED BY 审核

Xin Bing

12.08.26

LEVEL-II SIGN / DATE日期

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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-26152

DATE 日期 2010.08.26

PAGE OF 页码 4/9

Revision No: 0

PROJECT NO.

ZP06-787

CONTRACTOR:

CALTRANS

工程编号:

用户:

DRAWING NO.

SP3081B-001

CALTRANS CONTRACT NO.:

04-0120F4

图号:

13 LIFTING

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. 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

CASTING 铸件

FORGING 锻造

Material & thickness

母材, 厚度

A709M-345T2-X

12/16/25/14mm

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			
SP3081B-001-150				ACC		100%MT
SP3081B-001-151				ACC		100%MT
SP3081B-001-152				ACC		100%MT
SP3081B-001-153				ACC		100%MT
SP3081B-001-154				ACC		100%MT
SP3081B-001-155				ACC		100%MT
SP3081B-001-156				ACC		100%MT
SP3081B-001-157				ACC		100%MT
SP3081B-001-158				ACC		100%MT
SP3081B-001-159				ACC		100%MT
SP3081B-001-160				ACC		100%MT
SP3081B-001-161				ACC		100%MT
SP3081B-001-162				ACC		100%MT
SP3081B-001-163				ACC		100%MT

EXAMINED BY 主探

CaiXinxin

Cai Xinxin 10.08.26

LEVEL - II SIGN 签名 / DATE 日期

质量经理 / QCM

REVIEWED BY 审核

Van Bing

10.08.26

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-26152 DATE日期 2010.08.26 PAGE OF 页码 5/9 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3081B-001 13 LIFTING		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 12/16/25/14mm
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			
SP3081B-001-021				ACC		100%MT
SP3081B-001-022				ACC		100%MT
SP3081B-001-023				ACC		100%MT
SP3081B-001-024				ACC		100%MT
SP3081B-001-025				ACC		100%MT
SP3081B-001-026				ACC		100%MT
SP3081B-001-027				ACC		100%MT
SP3081B-001-028				ACC		100%MT
SP3081B-001-029				ACC		100%MT
SP3081B-001-030				ACC		100%MT
SP3081B-001-057				ACC		100%MT
SP3081B-001-058				ACC		100%MT
SP3081B-001-063				ACC		100%MT
SP3081B-001-064				ACC		100%MT

EXAMINED BY 主探 CaiXinxin <i>Cai Xinxin 11.08.26</i>	REVIEWED BY 审核 <i>[Signature]</i> 11.08.26
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-26152		DATE 日期 2010.08.26	PAGE OF 页码 6/9	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3081B-001 13 LIFTING		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 12/16/25/14mm	
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			
SP3081B-001-075				ACC		100%MT
SP3081B-001-076				ACC		100%MT
SP3081B-001-092				ACC		100%MT
SP3081B-001-093				ACC		100%MT
SP3081B-001-094				ACC		100%MT
SP3081B-001-095				ACC		100%MT
SP3081B-001-001				ACC		100%MT
SP3081B-001-002				ACC		100%MT
SP3081B-001-003				ACC		100%MT
SP3081B-001-004				ACC		100%MT
SP3081B-001-005				ACC		100%MT
SP3081B-001-006				ACC		100%MT
SP3081B-001-007				ACC		100%MT
SP3081B-001-008				ACC		100%MT

EXAMINED BY 主探 CaiXinxin <i>Cai Xinxin</i> 2008.26 LEVEL - II SIGN 签名 / DATE 日期	REVIEWED BY 审核 <i>Va Bey</i> 2008.26 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-26152

DATE日期 2010.08.26

PAGE OF页码 7/9

Revision No: 0

PROJECT NO.

ZP06-787

CONTRACTOR:

CALTRANS

工程编号:

用户:

DRAWING NO.

SP3081B-001

CALTRANS CONTRACT NO.:

图号:

13 LIFTING

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

CASTING 铸件

FORGING 锻造

Material & thickness

母材,厚度

A709M-345T2-X

TYPE OF JOINT

焊缝类型

T-JOINT

WELDING PROCESS

焊接方法

FCAW

12/16/25/14mm

WELD I.D.

焊缝编号

DISCONTINUITY不连续性

INDICATION
指示

TYPE
类型

LENGTH IN mm
长度

ACCEPT
接受

REJECT
拒收

REMARKS
备注

SP3081B-001-009

SP3081B-001-010

SP3081B-001-011

SP3081B-001-012

SP3081B-001-013

SP3081B-001-014

SP3081B-001-015

SP3081B-001-016

SP3081B-001-017

SP3081B-001-018

SP3081B-001-019

SP3081B-001-020

SP3081B-001-059

SP3081B-001-060

ACC

100%MT

EXAMINED BY主探

CaiXinxin Cai Xinxin 12.08.26

LEVEL-II SIGN 签名 / DATE日期

质量经理 / QCM

REVIEWED BY 审核

Van Bing 12.08.26

LEVEL-II SIGN / DATE日期

用户CUSTOMER

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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-26152

DATE 日期 2010.08.26

PAGE OF 页码 8/9

Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3081B-001 13 LIFTING		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 12/16/25/14mm
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			
SP3081B-001-061				ACC		100%MT
SP3081B-001-062				ACC		100%MT
SP3081B-001-077				ACC		100%MT
SP3081B-001-078				ACC		100%MT
SP3081B-001-079				ACC		100%MT
SP3081B-001-080				ACC		100%MT
SP3081B-001-096				ACC		100%MT
SP3081B-001-097				ACC		100%MT
SP3081B-001-098				ACC		100%MT
SP3081B-001-099				ACC		100%MT
SP3081B-001-084				ACC		100%MT
SP3081B-001-085				ACC		100%MT
SP3081B-001-086				ACC		100%MT
SP3081B-001-087				ACC		100%MT

EXAMINED BY 主探
CaiXinxin *Cai Xin Xin* 08.26
LEVEL-II SIGN 签名 / DATE 日期
质量经理 / QCM
签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

REVIEWED BY 审核
Xia Bing 08.26
LEVEL-II SIGN / DATE 日期
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-26152

DATE 日期 2010.08.26

PAGE OF 页码 9/9

Revision No: 0

PROJECT NO.

工程编号: ZP06-787

CONTRACTOR:

用户: CALTRANS

DRAWING NO.

SP3081B-001

CALTRANS CONTRACT NO.:

加州工程编号 04-0120F4

图号:

13 LIFTING

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

CASTING 铸件

FORGING 锻造

Material & thickness

母材, 厚度

A709M-345T2-X

WELDING PROCESS

焊接方法

FCAW

TYPE OF JOINT

焊缝类型

T-JOINT

DISCONTINUITY 不连续性

WELD I.D. 焊缝编号	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度	ACCEPT 接受	REJECT 拒收	REMARKS 备注
SP3081B-001-088				ACC		100%MT
SP3081B-001-089				ACC		100%MT
SP3081B-001-090				ACC		100%MT
SP3081B-001-091				ACC		100%MT
SP3081B-001-105				ACC		100%MT
SP3081B-001-106				ACC		100%MT
SP3081B-001-031				ACC		100%MT
SP3081B-001-065				ACC		100%MT
SP3081B-001-074				ACC		100%MT
SP3081B-001-081				ACC		100%MT
SP3081B-001-100				ACC		100%MT
SP3081B-001-107				ACC		100%MT
				ACC		100%MT

AFTER HSR1(B)-8856

BLANK

EXAMINED BY 主探

CaiXinxin *Cai Xinxin* 2010.08.26

LEVEL-II SIGN 签名 / DATE 日期

质量经理 / QCM

REVIEWED BY 审核

Van Bing 2010.08.26

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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-000807**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0763**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: 14-Jul-2010**Description of Non-Conformance:**

During the Caltrans Quality Assurance in-process observations of the fabrication of Side Plate and Edge Plate for Lift 13, Quality Assurance discovered the following issue:

-ZPMC personnel have wrapped the fillet welds around the ends of the I-rib stiffeners on Side plate and Edge plates.

-The affected members are identified as follows:

1) Side Plate SP3069-001, this member joined with two web plates PL3249A {Non-SPCM} and PL3249B {Seismic Performance Critical Member (SPCM)}. Welds#1~8 on PL3249A and Welds#9~44 on PL3249B located at fabrication Bay#10.

2) Edge Plate EP3023-001, Welds#3~6 and 15~18 located at fabrication Bay#11.

3) Side Plate SP3081-001, Welds#3; 4; 15; 16; 21; 22; 31~34 located at fabrication Bay#11. The member found to be Seismic Performance Critical Member (SPCM).

For further information, please see the attached pictures below.

Contractor's proposal to correct the problem:

Contractor will remove the wrapped welds from the identified locations by grinding. Contractor will submit the NDT report to prove the welds are acceptable after grinding. Contractor will notify the lead inspectors regarding the wrapped welds are not acceptable and if welds are wrapped in locations where the shop drawings do not specify. Contractor will remove the wrapped welds, and perform NDT after removal.

Corrective action taken:

Contractor removed the wrapped welds by grinding, and performed the NDT. The NDT report shows that the welds are acceptable. Contractor notified the lead inspectors who are responsible of the project regarding the wrapped welds are not acceptable and if welds are wrapped in locations where the shop drawings do not specify. Lead inspectors have to remove the wrapped welds, and perform the NDT testing after removal.

