

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: Chanxing Island, Shanghai, China

Report No: NCR-000810

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 21-Jun-2010

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

NCR #: ZPMC-0772

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

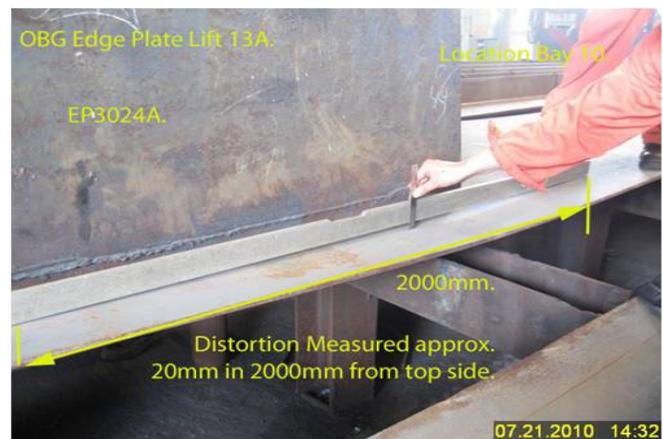
Reference Description: Heat Straightening without Engineer's Prior Approval

Description of Non-Conformance:

During the Caltrans Quality Assurance in-process observations of the fabrication of Edge Plate EP3017B, and EP3024A, QA discovered the following issue:

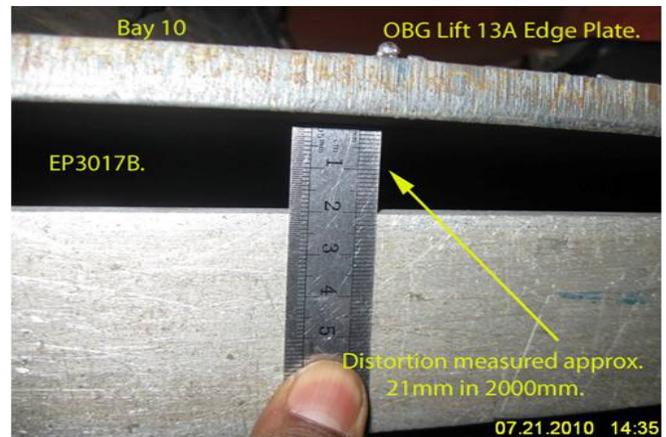
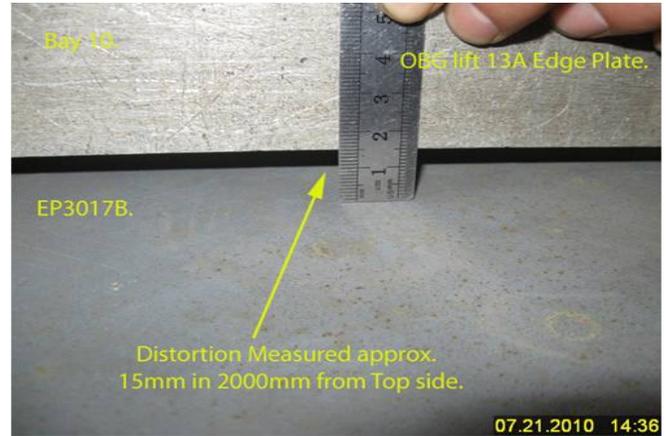
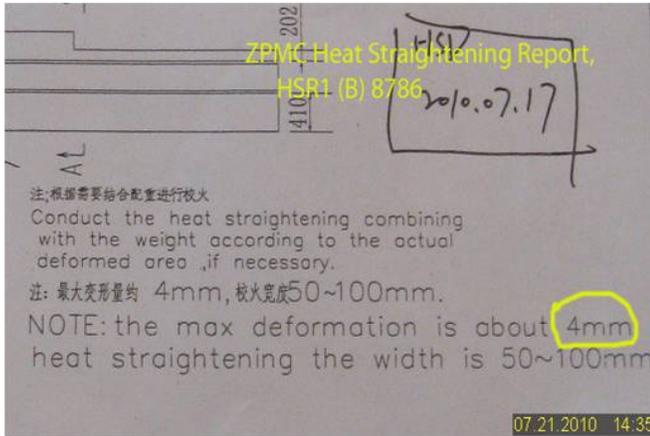
- ZPMC personnel heat straightening excessive distortion on non Seismic Performance Critical Material (NON SPCM) material distorted by welding without the Engineers approval.
- The effected Edge Plates are identified as EP3017B (PL3209A) and EP3024A (PL3353A).
- The deviation from flat as measured by this QA inspector is 35mm per 2000mm in Edge Plate (EP3024A).
- The deviation from flat as measured by this QA inspector is 21mm per 2000mm in Edge Plate (EP3017B).
- The Material thickness for both panels is 12 mm.
- This Edge Plate is located in Sub assembly Bay#10.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



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".

Caltrans Special Provisions Section 8-3: "For material up to 16 mm, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer".

Who discovered the problem: Shailesh Gaikwad

Name of individual from Contractor notified: Liu Chen

Time and method of notification: 14:30 hours_07-21-2010_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 18:10 hours_07-22-2010_Email

QC Inspector's Name: Sun Tian Liang

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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
 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: 23-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-0772

Job Name: SAS Superstructure
Document No: 05.03.06-000767

Reference Description: Heat Straightening without Engineer's Prior 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 Edge Plate EP3017B, and EP3024A, QA discovered the following issue:
- ZPMC personnel heat straightening excessive distortion on non Seismic Performance Critical Material (NON SPCM) material distorted by welding without the Engineers approval.
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 - The Material thickness for both panels is 12 mm.
 - This Edge Plate is located in Sub assembly Bay#10.

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-0772

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: 05.03.06-000767

Subject: NCR No. ZPMC-0772

Dated: 02-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000761 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the approved HSRs that accurately show the work that was being performed at the time of heat straightening.

ZPMC is providing the approved HSRs that accurately show the work that was being performed at the time of heat straightening. ZPMC QA talked with the production team leader and determined that he believed the HSR was approved at the commencement of work. ZPMC QA instructed him to call them next time to ensure that was the case on not assume that the work had been approved. Based on these documents, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000761R00;

Caltrans' comments:

Status: CLO

Date: 14-Sep-2010

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

Submitted by: Woo, Laraine

Date: 14-Sep-2010

Attachment(s):



No. B-847 64

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-09-02

REGARDING: NCR-000810(ZPMC-0772)

ZPMC has released the approved HSRs as attached. The measurement by utilizing 2000mm templeted in NCR was not specified. ZPMC has recorded the correct distortions on panel in the HSRs. ZPMC QA have instruct the production of the requirment of engineer's approval prior to performed any heat straightening when the distortion of panel exceeding 6/1000mm in length. Based on this and the provided documentations, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000810(ZPMC-0772)

HSR(B)-387 R0

B787-MT-25566

HSR(B)-388 R0

B787-MT-25567

Jay W

9/2/10



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: 23-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: 05.03.06-000767

Subject: NCR No. ZPMC-0772

Reference Description: Heat Straightening without Engineer's Prior Approval

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690 Walnut Ave. St. 150
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

NCR #: ZPMC-0772

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Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component:
 Procedural Procedural Description:

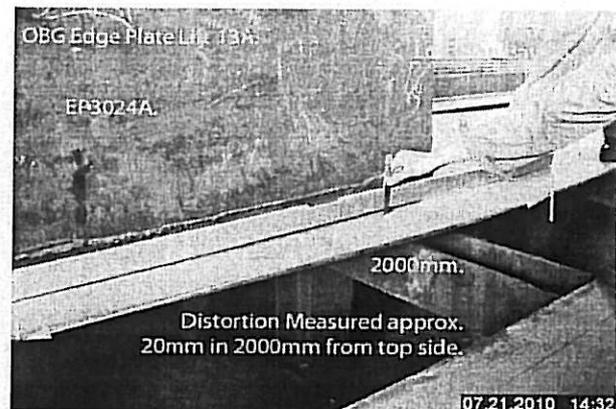
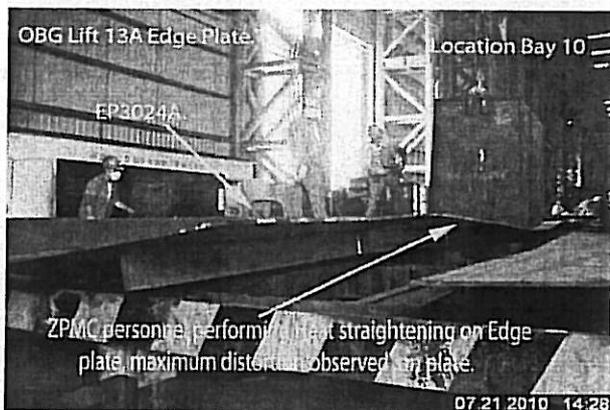
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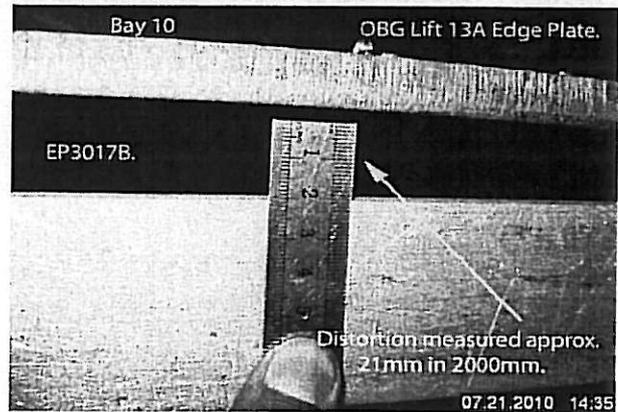
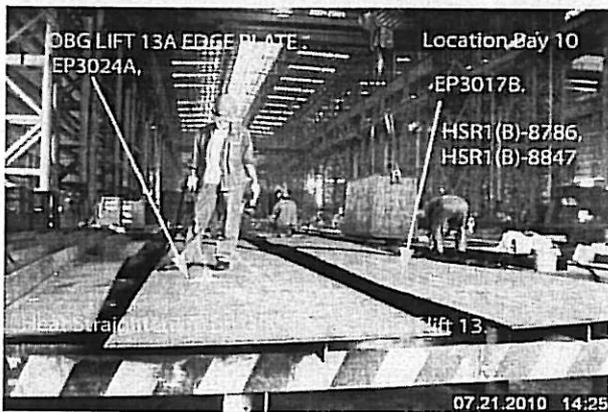
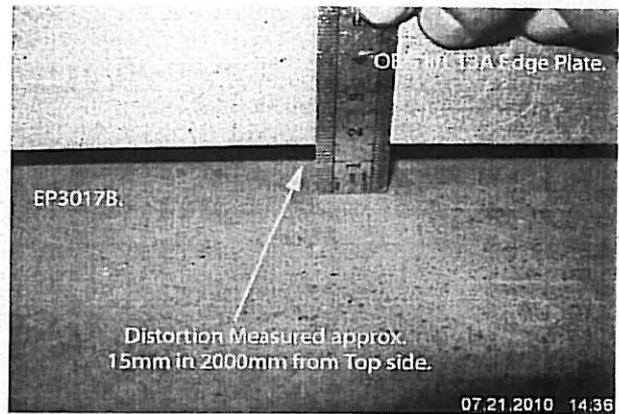
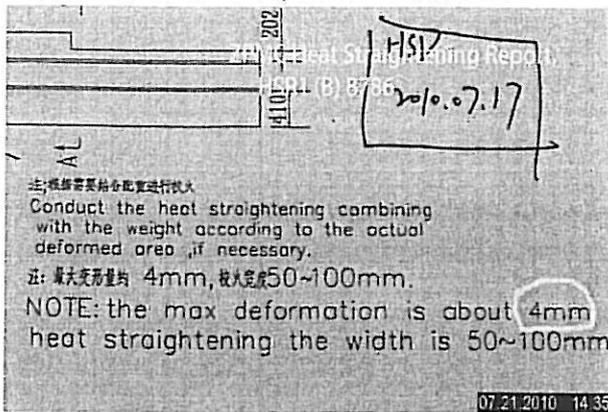
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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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VT-68227, 68228, MT-25566



火工校正报告

Heat Straightening Report(HSR)

报告号 Report #	HSR(B)-387
版本号 Revision #	0
日期 Date	2010.07.21

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4 工程编号 JOB#: ZP06-787

装配 Assembly:

部装 Sub-Assembly:

梁段 Gird: The 13 lift EP3017A

塔段 Tower:

焊缝号 Weld No: ~~004-076~~ (024, 025, 028, 029, 032, 033, 036, 037, 040, 041, 044~047, 050, 051,

焊缝地图号 Weld Map No: EP3017-001 (053, 054, 057, 058, 061, 062, 065, 066, 069, 070, 071, 072, 075, 076)

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

质检代表/Quality Control Representative

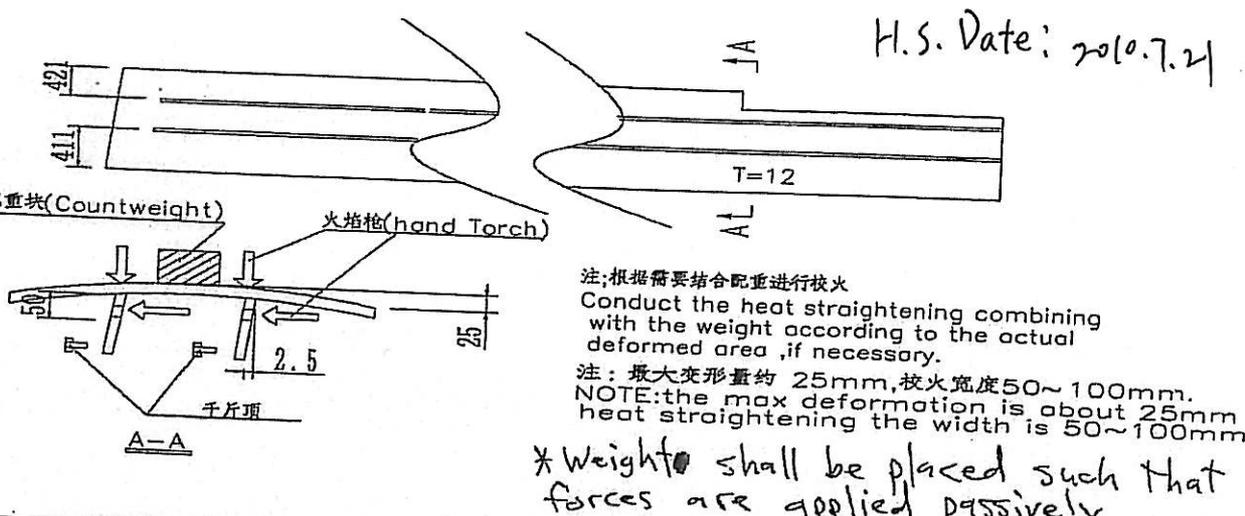
质检经理/Quality Assurance Manager-Approval

Yu Dongping 2010.7.27

缺陷去除方法(Defect Removal Method): Using hand torch and Countweight., 使用火焰枪以及配重块进行校火,
 后续NDE(Post-Removal NDE): After finishing heat straightening, the weld of the heat area shall perform 100% VT, MT and UT according to the approved shop drawing 校火后, 根据图纸要求对热影响区域进行100% VT, MT and UT 检测.

纠正措施(Corrective Action(s)): Increase the flange anti-deformation allowance during the course of fit-up, and Control the welding parameters according to associated WPS. 在装配的过程中增加反变形余量。根据相关WPS控制焊接参数。
 实施次数(Number of application): 1~3
 最高温度(Maximum temperature): 650°C

简图 Sketch



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

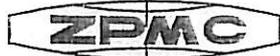
检验员 Inspector:	Yu Dongping	签字 Signature:	于东平
CWI #	07121254	Closing Date:	2010.7.29
II 级探伤 NDE Certification:	Level II		

质检经理 QC Manager: [Signature] 审核日期 Review Date: 8/2/10

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

#R787-QCP-1100

This document is APPROVED as noted
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant to Section 5-1.02 of the
 Standard Specifications
 Initial: JW Date: 7/27/10



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25566 - DATE日期 2010.07.30 PAGE OF页码 2/3 Revision No: 0

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

DRAWING NO. EP3017-001 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 13th lifting edge plate 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 EXAMINED √ WELDING 焊接件 Material & thickness A709M-345T2-X
 检测材料 CASTING 铸件 母材, 厚度 16/12/25mm
 FORGING 锻造

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			
EP3017-001-050				ACC.		100%MT
EP3017-001-051				ACC.		100%MT
EP3017-001-053				ACC.		100%MT
EP3017-001-054				ACC.		100%MT
EP3017-001-057				ACC.		100%MT
EP3017-001-058				ACC.		100%MT
EP3017-001-061				ACC.		100%MT
EP3017-001-062				ACC.		100%MT
EP3017-001-065				ACC.		100%MT
EP3017-001-066				ACC.		100%MT
EP3017-001-069				ACC.		100%MT
EP3017-001-070				ACC.		100%MT
EP3017-001-071				ACC.		100%MT
EP3017-001-072				ACC.		100%MT

EXAMINED BY主探 Xu Bing 2010.7.30 REVIEWED BY 审核 Cai Xinxin 2010.7.30
 LEVEL - II SIGN 签名 / DATE日期

质量经理 / QCM Leizhenhua 用户CUSTOMER
 签字 SIGN / 日期 DATE 2010.07.30 签字 SIGN / 日期 DATE

VT-68225, 68226, MT-25567



火工校正报告
Heat Straightening Report(HSR)

报告号 Report # HSR(B)-388
版本号 Revision # 0
日期 Date 2010.07.21

美国海湾大桥 San Francisco Oakland Bay Bridge
CALTRANS #04-0120F4 工程编号 JOB#: ZP06-787
装配 Assembly:
部装 Sub-Assembly:
梁段 Gird: The 13 lift EP3024A
塔段 Tower: N/A
焊缝号 Weld No: 001~030
焊缝地图号 Weld Map No: EP3024A-001

质检代表/Quality Control Representative
质检经理/Quality Assurance Manager-Approval

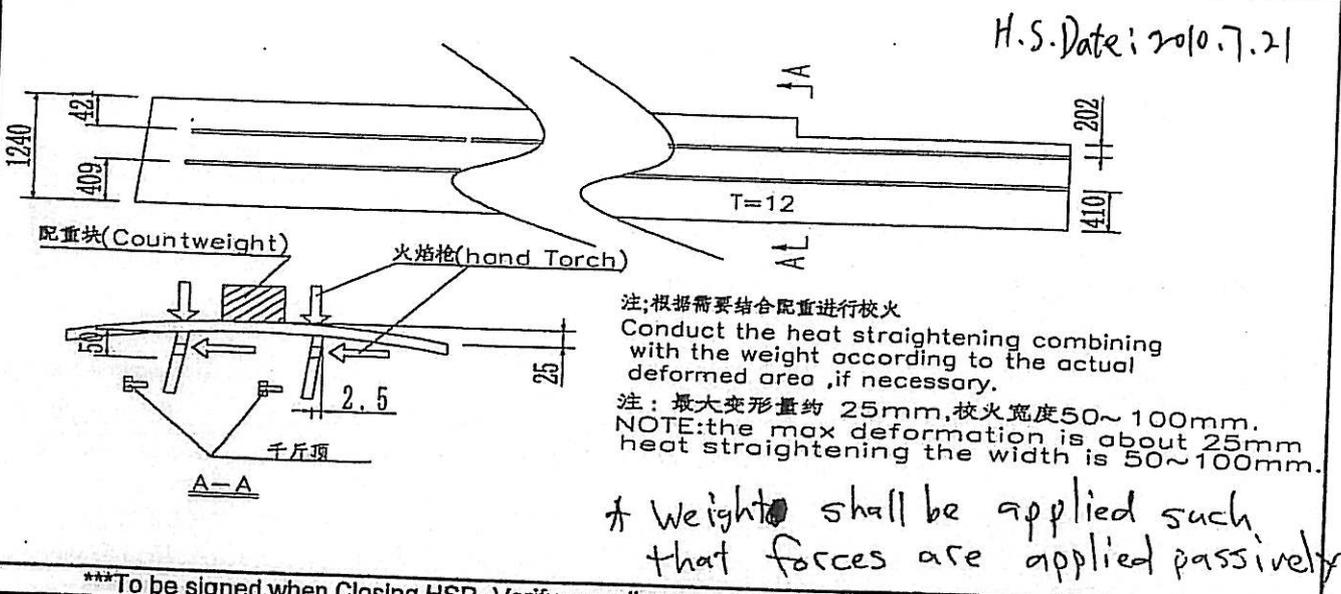
情况描述 Description of Condition

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): Using hand torch and Countweight. 使用火焰枪以及配重块进行校火。
后续NDE(Post-Removal NDE): After finishing heat straightening, the weld of the heat area shall perform 100% VT, MT and UT according to the approved shop drawing 校火后, 根据图纸要求对热影响区域进行100% VT, MT and UT 检测。
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实施次数(Number of application): 1~3
最高温度(Maximum temperature): <650°C

简图 Sketch



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

检验员 Inspector: Yu Dongping 签字 Signature: 于东平
CWI # 07121251
II 级探伤 NDE Certification: Level II
质检经理 QC Manager: [Signature] 审核日期 Review Date: 2010.7.29
8/3/10

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

#R787-QCP-1100

孙天亮
This document is APPROVED as noted
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial [Signature] Date: 7/27/10



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25567		DATE 日期 2010.07.30		PAGE OF 页码 1/3		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: EP3024-001 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 16/12mm	
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				
EP3024-001-001				ACC.		100%MT	
EP3024-001-002				ACC.		100%MT	
EP3024-001-003				ACC.		100%MT	
EP3024-001-004				ACC.		100%MT	
EP3024-001-005				ACC.		100%MT	
EP3024-001-006				ACC.		100%MT	
EP3024-001-007				ACC.		100%MT	
EP3024-001-008				ACC.		100%MT	
EP3024-001-009				ACC.		100%MT	
EP3024-001-010				ACC.		100%MT	
EP3024-001-011				ACC.		100%MT	
EP3024-001-012				ACC.		100%MT	
EP3024-001-013				ACC.		100%MT	
EP3024-001-014				ACC.		100%MT	
EXAMINED BY 主探 Xu Bing Xia Bing				REVIEWED BY 审核 Cui Xim Xim			
LEVEL - II SIGN 签名 / DATE 日期 2010.7.30				LEVEL-II SIGN / DATE 日期 2010.7.30			
质量经理 / QCM Lujianhua				用户 CUSTOMER			
签字 SIGN / 日期 DATE 2010.07.30				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-25567 DATE日期 2010.07.30 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: EP3024-001 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 16/12mm
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			
EP3024-001-015				ACC.		100%MT
EP3024-001-016				ACC.		100%MT
EP3024-001-017				ACC.		100%MT
EP3024-001-018				ACC.		100%MT
EP3024-001-019				ACC.		100%MT
EP3024-001-020				ACC.		100%MT
EP3024-001-021				ACC.		100%MT
EP3024-001-022				ACC.		100%MT
EP3024-001-023				ACC.		100%MT
EP3024-001-024				ACC.		100%MT
EP3024-001-025				ACC.		100%MT
EP3024-001-026				ACC.		100%MT
EP3024-001-027				ACC.		100%MT
EP3024-001-028				ACC.		100%MT

EXAMINED BY 主探 Xu Bing <u>Xu Bing</u>	REVIEWED BY 审核 <u>Lu Jianhua</u>
LEVEL - II SIGN 签名 / DATE日期 2010.07.30	LEVEL-II SIGN / DATE日期 2010.07.30
质量经理 / QCM <u>Lu Jianhua</u>	用户CUSTOMER
签字 SIGN / 日期 DATE 2010.07.30	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-25567 DATE日期 2010.07.30 PAGE OF页码 3/3 Revision No: 0

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

DRAWING NO. EP3024-001 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
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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 16/12mm
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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			
EP3024-001-029				ACC.		100%MT
EP3024-001-030				ACC.		100%MT

AFTER HSR(B)-388

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EXAMINED BY主探 Xu Bing Xu Bing	REVIEWED BY 审核 Cai Xin Xian
LEVEL - II SIGN 签名 / DATE日期 2010.07.30	LEVEL-II SIGN / DATE日期 2010.07.30
质量经理 / QCM Lu Jianhua	用户CUSTOMER
签字 SIGN / 日期 DATE 2010.07.30	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:** Chanxing Island, Shanghai, China**Report No:** NCS-000765**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0772**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 21-Jun-2010**Description of Non-Conformance:**

During the Caltrans Quality Assurance in-process observations of the fabrication of Edge Plate EP3017B, and EP3024A, QA discovered the following issue:

- ZPMC personnel heat straightening excessive distortion on non Seismic Performance Critical Material (NON SPCM) material distorted by welding without the Engineers approval.
- The effected Edge Plates are identified as EP3017B (PL3209A) and EP3024A (PL3353A).
- The deviation from flat as measured by this QA inspector is 35mm per 2000mm in Edge Plate (EP3024A).
- The deviation from flat as measured by this QA inspector is 21mm per 2000mm in Edge Plate (EP3017B).
- The Material thickness for both panels is 12 mm.
- This Edge Plate is located in Sub assembly Bay#10.

For further information, please see the attached pictures below.

Contractor's proposal to correct the problem:

Provide an HSR1 detailing the actual methods used in the field and perform NDT required to verify weld quality.

Corrective action taken:

Contractor has made the appropriate changes to the HSR used on site detailing the work which was actually performed and has submitted subsequent NDT reports verifying the affected welds meet Contract weld quality requirements.

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.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer