

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, P.R. China

Report No: NCR-000821

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-Jul-2010

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

NCR #: ZPMC-0783

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 9BW Deck Stiffeners
Procedural	Procedural	Description:	

Reference Description: ZPMC performed repair on Segment 9BW without following the CWR and shop drawings

Description of Non-Conformance:

During random in process observation of the trial assembly for OBG Crossbeam 11 and Segment 9BW, this Quality Assurance (QA) Inspector discovered the following issues:

- ZPMC personnel have used acetylene/oxygen torches to remove the edge plate (EP144B) to deck plate stiffener (X8E) weld joints in Segment 9BW without following the repair procedure in the CWR.
- The B-CWR1731 states that the welds will be removed using Gouging or Grinding methods.
- ZPMC did not remove the welds, rather, cutting the stiffeners approximately 10mm to 15mm away from the welds.
- After the cutting of stiffeners, ZPMC introduced a new weld joint by welding over the flame cut surfaces. This additional weld joint is not detailed on the approved shop drawings and welding details.
- ZPMC has not documented the completion of visual or magnetic particle inspections of the weld grooves prior to welding as required by B-CWR1731.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

-CWR B-CWR1731 states: Remove the welds between stiffeners and EP on both 9CW and 9CE ... on the CB1 side by grinding or gouging.

-CWR B-CWR1731 states: Perform 100% VT and MT to the groove to ensure no defects exist prior to welding.

-AWS D1.5 2002 section 3.1.5 states: Welds shall be prohibited on the work except as follows:

- (1) Base metal repair performed in conformance with AASHTO M160 (ASTM A6/A 6M)
- (2) All welds detailed on approved shop drawings.
- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer.

-AWS D1.5 2002 section 3.2.1 states: Surfaces and edges to be welded shall be smooth, uniform and free from fins, tears, cracks and other discontinuities which would adversely affect the quality or strength of the weld.

Who discovered the problem: Paul Dawson

Name of individual from Contractor notified: Kelvin Cheung

Time and method of notification: 07-29-2010_00:40_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 07-29-2010_10:30_Verbal

QC Inspector's Name: Liu Hua Jie and Zhou Peng

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 Jim Devey, (86) 150-0002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	Devey, Jim	SMR
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NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000778

Subject: NCR No. ZPMC-0783

Dated: 20-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000779 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT documentation to show the welds are acceptable.

The areas repaired using an inaccurate CWR have been removed and repaired in accordance with a revised CWR, ZPMC is providing NDT documentation to show the welds are acceptable. In the future, inspectors have been warned to ensure the CWR is being adhered to during the entire process or face disciplinary actions. Based on this ZPMC request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000779R00;

Caltrans' comments:

Status: CLO

Date: 07-Oct-2010

The proposed resolution is acceptable. This NCR is considered closed.
Please note that the CWR was not resubmitted as stated in the NPR.

Submitted by: Woo, Laraine

Attachment(s):

Date: 07-Oct-2010



No. B-883

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-9-17

REGARDING: NCR-000821(ZPMC-0783)

For this case, ZPMC has issue an internal NCR to address this issue. The places which were repaired without following CWR and shop drawings have been all removed and repair according to the homologous CWR report. ZPMC is providing the NDT records which are included MT after removing welds and UT after welding for review. Based on this, please consider closure of this NCR.

ATTACHMENT:

NCR-000821(ZPMC-0783)

B787-MT-26068 R0

B787-MT-26069 R0

B787-UT-14287 R0

B787-UT-14287 R1

B787-UT-14395 R0

Zhangwei
9/17/10



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: 30-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: 05.03.06-000778
Subject: NCR No. ZPMC-0783

Reference Description: ZPMC performed repair on Segment 9BW without following the CWR and shop drawings

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: Xbeam **Lift:** 11

Remarks:

During random in process observation of the trial assembly for OBG Crossbeam 11 and Segment 9BW, this Quality Assurance (QA) Inspector discovered the following issues:

-ZPMC personnel have used acetylene/oxygen torches to remove the edge plate (EP144B) to deck plate stiffener (X8E) weld joints in Segment 9BW without following the repair procedure in the CWR.

-The B-CWR1731 states that the welds will be removed using Gouging or Grinding methods.

-ZPMC did not remove the welds, rather, cutting the stiffeners approximately 10mm to 15mm away from the welds.

-After the cutting of stiffeners, ZPMC introduced a new weld joint by welding over the flame cut surfaces.

This additional weld joint is not detailed on the approved shop drawings and welding details.

-ZPMC has not documented the completion of visual or magnetic particle inspections of the weld grooves prior to welding as required by B-CWR1731.

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-0783

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-Jul-2010

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

NCR #: ZPMC-0783

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: Segment 9BW Deck Stiffeners

Reference Description: ZPMC performed repair on Segment 9BW without following the CWR and shop drawings

Description of Non-Conformance:

During random in process observation of the trial assembly for OBG Crossbeam 11 and Segment 9BW, this Quality Assurance (QA) Inspector discovered the following issues:

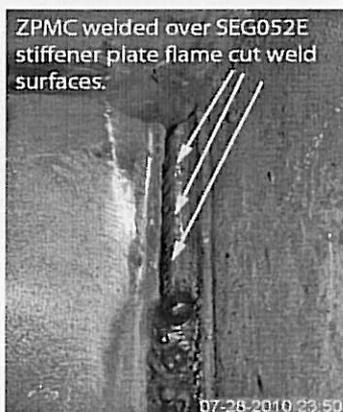
-ZPMC personnel have used acetylene/oxygen torches to remove the edge plate (EP144B) to deck plate stiffener (X8E) weld joints in Segment 9BW without following the repair procedure in the CWR.

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

-CWR B-CWR1731 states: Remove the welds between stiffeners and EP on both 9CW and 9CE ... on the CB11side by grinding or gouging.

-CWR B-CWR1731 states: Perform 100% VT and MT to the groove to ensure no defects exist prior to welding.

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Time and method of notification: 07-29-2010_00:40_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 07-29-2010_10:30_Verbal

QC Inspector's Name: Liu Hua Jie and Zhou Peng

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 Jim Devey, (86) 150-0002-6784, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-26068 DATE日期 2010.08.02 PAGE OF页码 1/2 Revision No: 0

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

DRAWING NO. SEG052 CALTRANS CONTRACT NO.:
 图号: 9BE CORNER ASSEMBLY 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 18/25mm
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WELDING PROCESS 焊接方法	NA	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			
SEG052D-013				ACC.		after excavation
SEG052D-022				ACC.		after excavation
SEG052D-031				ACC.		after excavation
SEG052D-040				ACC.		after excavation
SSD24-PP74.5-168				ACC.		after excavation
SEG052E-019				ACC.		after excavation
SEG052E-042				ACC.		after excavation
SEG052E-065				ACC.		after excavation
SEG052E-074				ACC.		after excavation
SEG052E-083				ACC.		after excavation
SEG052E-092				ACC.		after excavation
SEG052E-101				ACC.		after excavation
SEG052E-110				ACC.		after excavation
SEG052E-119				ACC.		after excavation

EXAMINED BY 主探 Gu Yunwu Gu Yunwu	REVIEWED BY 审核 Xin Hai
LEVEL - II SIGN 签名 / DATE日期 2010.08.02	LEVEL-II SIGN / DATE日期 2010.08.02
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-26068 DATE日期 2010.08.02 PAGE OF页码 2/2 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SEG052 9BE CORNER ASSEMBLY		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 18/25mm
WELDING PROCESS 焊接方法	NA	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			
SEG052E-128				ACC.		after excavation
SEG052E-137				ACC.		after excavation
SEG052E-155				ACC.		after excavation
SEG052E-164				ACC.		after excavation
SEG052E-173				ACC.		after excavation
SSD24-PP75.5-168				ACC.		after excavation

AFTER B-CWR1731

BLANK

EXAMINED BY 主操 Gu Yunwu <i>Gu Yunwu</i>	REVIEWED BY 审核 <i>Tu Hai</i>
LEVEL - II SIGN 签名 / DATE日期 20/0.08.02	LEVEL-II SIGN / DATE日期 20/0.08.02
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-26069 DATE日期 2010.08.02 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: SEG051 9BW CORNER ASSEMBLY		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 18/25mm
WELDING PROCESS 焊接方法	NA	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			
SEG051E-049				ACC.		after excavation
SEG051E-040				ACC.		after excavation
SEG051E-013				ACC.		after excavation
SEG051E-031				ACC.		after excavation
SEG051E-022				ACC.		after excavation
SEG051D-065				ACC.		after excavation
SEG051D-155				ACC.		after excavation
SEG051D-146				ACC.		after excavation
AFTER B-CWR1731						
BLANK						

EXAMINED BY主探 Gu Yunwu <i>Gu Yunwu</i>	REVIEWED BY 审核 <i>Xu Hai</i>
LEVEL - II SIGN 签名 / DATE日期 2010.08.02	LEVEL-II SIGN / DATE日期 2010.08.02
质量经理 / QCM	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-14287 DATE 2010.08.07 PAGE 1 OF 2 Revision No: 0

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

ITEMS NAME: 9BE CORNER ASSEMBLY DRAWING NO.: SEG052 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

WELDING PROCESS 焊接方法 SMAW JOINT TYPE 焊缝类型 T-JOINT CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST, 2010

EQUIPMENT 设备 UT SCOPE MANUFACTURER 制造商 PANAMETRICS MODEL NO. 样式编号 EPOCH-4B SERIAL NO. 序列编号 071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块 AWS IIV BLOCK TYPE II COUPLANT 耦合剂 C.M.C MATERIAL/THICKNESS 材料厚度 A709M-345T2/F2-X 18/25mm

TRANSDUCER 探头

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

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

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y			
SEG052D-013		70				34									ACC.	100%
SEG052D-022	1	70	A	1	43	34	2	+7	30	52	17	-10	170	REJ.	100%	
SEG052D-031		70				34								ACC.	100%	
SEG052D-040		70				34								ACC.	100%	
SSD24-PP74.5-168		70				34								ACC.	100%	
SEG052E-019		70				34								ACC.	100%	
SEG052E-042		70				34								ACC.	100%	
SEG052E-065		70				34								ACC.	100%	

EXAMINED BY 主探 Tang Xingshan REVIEWED BY 审核 Xu Rong gang
 LEVEL - II SIGN / DATE 2010.08.07 LEVEL - II SIGN / DATE 2010.08.07

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



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-14395 DATE 2010.09.01 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 9BW CORNER ASSEMBLY DRAWING NO.: SEG051 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

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

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2/F2-X 18/25mm

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
GAMMA	70°	2.25MHz	0.75"×0.625" in				
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
SEG051E-049		71.6					47								ACC.	100%
SEG051E-040		71.6					47								ACC.	100%
SEG051E-013		71.6					47								ACC.	100%
SEG051E-031		71.6					47								ACC.	100%
SEG051E-022		71.6					47								ACC.	100%
SEG051D-065		71.6					47								ACC.	100%
SEG051D-155		71.6					47								ACC.	100%
SEG051D-146		71.6					47								ACC.	100%

AFTER B-CWR1731

EXAMINED BY 主探 <i>Tang Xing shan</i> LEVEL - II SIGN / DATE 2010.09.01	REVIEWED BY 审核 <i>Xu Rong gang</i> LEVEL - II SIGN / DATE 2010.09.01
质量经理 / QCM _____ 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-14287R1 DATE 2010.08.30 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 9BE CORNER ASSEMBLY DRAWING NO.: SEG052 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

WELDING PROCESS 焊接方法 SMAW JOINT TYPE 焊缝类型 T-JOINT CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 PANAMETRICS MODEL NO. 样式编号 EPOCH-4B SERIAL NO. 序列编号 071565311, 061488510, 061495811, 070152011, 18/25mm

CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE II COUPLANT 耦合剂 C.M.C MATERIAL/THICKNESS 材料厚度 A709M-345T2/F2-X

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
SEG052D-022	1R1	70						34							ACC.	100%
SEG052E-155	1R1	70						34							ACC.	100%
SEG052E-173	1R1	70						34							ACC.	100%

AFTER B-WR14476~14478

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EXAMINED BY 主探 Tang Xing shan REVIEWED BY 审核 Xu Rong gong
 LEVEL - II SIGN / DATE 2010.08.30 LEVEL - II SIGN / DATE 2010.08.30

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-000816**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0783**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: 28-Jul-2010**Description of Non-Conformance:**

During random in process observation of the trial assembly for OBG Crossbeam 11 and Segment 9BW, this Quality Assurance (QA) Inspector discovered the following issues:

-ZPMC personnel have used acetylene/oxygen torches to remove the edge plate (EP144B) to deck plate stiffener (X8E) weld joints in Segment 9BW without following the repair procedure in the CWR.

-The B-CWR1731 states that the welds will be removed using Gouging or Grinding methods.

-ZPMC did not remove the welds, rather, cutting the stiffeners approximately 10mm to 15mm away from the welds.

-After the cutting of stiffeners, ZPMC introduced a new weld joint by welding over the flame cut surfaces. This additional weld joint is not detailed on the approved shop drawings and welding details.

-ZPMC has not documented the completion of visual or magnetic particle inspections of the weld grooves prior to welding as required by B-CWR1731.

Contractor's proposal to correct the problem:

Contractor will remove the inaccurate CWR repair area, and repair the area with approved CWR. Contractor will provide the NDT report to show the welds are acceptable. Contractor will discuss with the inspectors to aware the Critical welding repair procedure and process. Disciplinary action will be taken, if the inspectors violate the procedure and process.

Corrective action taken:

Contractor removed the inaccurate CWR weld, and repair the weld accordance with a revised CWR. Contractor discussed with the inspectors the proper CWR procedure and process, and what consequence if the inspectors violated the procedures and process.

Did corrective action require Engineer's approval?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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 of Structural Materials for your project.

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer