

**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-000882

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

**Date:** 01-Nov-2010

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

**NCR #:** ZPMC-0844

### Type of problem:

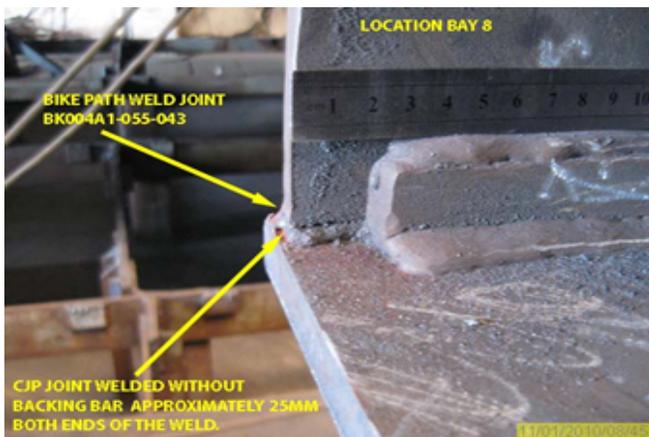
|                     |                   |                     |  |
|---------------------|-------------------|---------------------|--|
| <b>Welding</b>      | <b>Concrete</b>   | <b>Other</b>        |  |
| <b>Welding</b>      | <b>Curing</b>     | <b>Procedural</b>   | <b>Bridge No:</b> 34-0006                    |
| <b>Joint fit-up</b> | <b>Coating</b>    | <b>Other</b>        | <b>Component:</b> Bikepath Assemblies BK004A |
| <b>Procedural</b>   | <b>Procedural</b> | <b>Description:</b> |  |

**Reference Description:** Steel backing bars are not continuous for the full length of some welds in Bikepath Assemblies

### Description of Non-Conformance:

During the Quality Assurance (QA) in process observations of Fabrication of OBG Bike Path BK4A-055, 58, & 61, this QA Inspector discovered the following issue:

- ZPMC welded the root pass of a weld detailed as Complete Joint Penetration (CJP) with backing.
- ZPMC personnel welded the CJP Joint without approximately 25mm of backing at both ends.
- The weld is joining the Bearing Plate and End Plate (side plate) of bike path.
- AWS D1.5 specifies steel backing shall be continuous for the full length of the each weld made with backing.
- The weld is identified as: BK004A1-055-043, BK004A1-058-043 & BK004A1-061-043.
- The material thickness for this backing bar plate is 10 mm.
- This OBG Bike Path is located in Sub assembly Bay #08.



### Applicable reference:

AWS D1.5 2002, Section 3.13.2: "Groove welds made with the use of steel backing shall have the weld metal thoroughly fused with the backing. Steel backing shall be continuous for the full length of each weld made with

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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backing.”

**Who discovered the problem:** T.Raghavendra Reddy

**Name of individual from Contractor notified:** Liu Hua Jie

**Time and method of notification:** 15:00\_11/01/10\_Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 07:00\_11/02/10\_Verbal

**QC Inspector's Name:** Liu Fa Wen

**Was QC Inspector aware of the problem:** Yes No

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

**Comments:**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Tsang, Eric | SMR |
|----------------------|-------------|-----|

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|                     |               |     |
|---------------------|---------------|-----|
| <b>Reviewed By:</b> | Wahbeh, Mazen | SMR |
|---------------------|---------------|-----|

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## NCR PROPOSED RESOLUTION

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

**Attention:** Siegenthaler, Peter  
Resident Engineer

**Ref:** 05.03.06-000840

**Subject:** NCR No. ZPMC-0844

**Dated:** 14-Dec-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000880 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:**

Please see ZPMC's response"

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000880R00;

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**Caltrans' comments:**

**Status:** REJ

**Date:** 15-Dec-2010

It is not clear which TC-RFI is discussed in the response. Please note that TC-RFI 146R1 addresses Tower Grillage. TC-RFI 199 is approved as fit-for-purpose specifically to the attached incident report (IR 1643) written on 10/27/2010. The situation for this NCR is different. TC-RFI ZPMC personnel placed a backing bar that is not continuous for the full length of the weld. There is no access issue to install a continuous backing on this bikepath assembly.

**Submitted by:** Chao, Ching

**Date:** 15-Dec-2010

**Attachment(s):**



No. B-942

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-12-14**

**REGARDING: NCR-000882(ZPMC-0844)**

Rectification was performed as the approved TC-RFI response. ZPMC is providing the NDT records to show the acceptance of these area after grinding. Based on this, please consider closure of this NCR.

**ATTACHMENT:**

NCR-000882(ZPMC-0844)

SK-2099R0-I

B787-MT-34129

A handwritten signature in blue ink, appearing to be "J. M. W.", is located below the attachment list.

12/14/2010



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:** 04-Nov-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:** 05.03.06-000840

**Subject:** NCR No. ZPMC-0844

**Reference Description:** Steel backing bars are not continuous for the full length of some welds in Bikepath Assemblies

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:** Bike Path

**Lift:**

### Remarks:

During the Quality Assurance (QA) in process observations of Fabrication of OBG Bike Path BK4A-055, 58, & 61, Caltrans QA Inspector discovered the following issue:

- ZPMC welded the root pass of a weld detailed as Complete Joint Penetration (CJP) with backing.
- ZPMC personnel welded the CJP Joint without approximately 25mm of backing at both ends.
- The weld is joining the Bearing Plate and End Plate (side plate) of bike path.
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- The weld is identified as: BK004A1-055-043, BK004A1-058-043 & BK004A1-061-043.
- The material thickness for this backing bar plate is 10 mm.
- This OBG Bike Path is located in Sub assembly Bay #08.

### Action Required and/or Action Taken:

Proposed 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-0844

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

**File:** 05.03.06

**DEPARTMENT OF TRANSPORTATION**  
 DIVISION OF ENGINEERING SERVICES  
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Contract #: 04-0120F4  
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9  
 File #: 69.25B

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

**Location:** Changxing Island, Shanghai, P.R. China

**Report No:** NCR-000882

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

**Date:** 01-Nov-2010

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

**NCR #:** ZPMC-0844

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural

Joint fit-up  Coating  Other

Procedural  Procedural  Description:

**Bridge No:** 34-0006

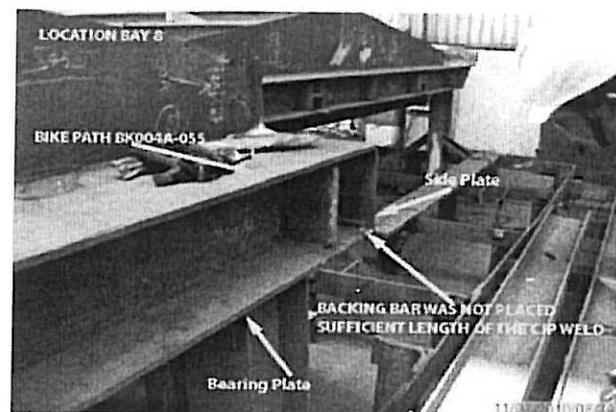
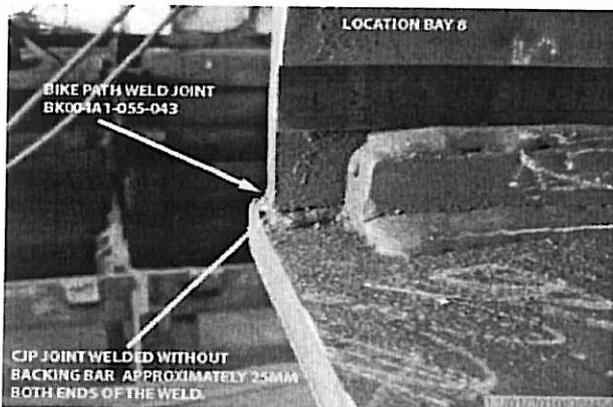
**Component:** Bikepath Assemblies BK004A

**Reference Description:** Steel backing bars are not continuous for the full length of some welds in Bikepath Assemblies

### Description of Non-Conformance:

During the Quality Assurance (QA) in process observations of Fabrication of OBG Bike Path BK4A-055, 58, & 61, this QA Inspector discovered the following issue:

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- This OBG Bike Path is located in Sub assembly Bay #08.



### Applicable reference:

AWS D1.5 2002, Section 3.13.2: "Groove welds made with the use of steel backing shall have the weld metal thoroughly fused with the backing. Steel backing shall be continuous for the full length of each weld made with

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Who discovered the problem:** T.Raghavendra Reddy

**Name of individual from Contractor notified:** Liu Hua Jie

**Time and method of notification:** 15:00\_11/01/10\_Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 07:00\_11/02/10\_Verbal

**QC Inspector's Name:** Liu Fa Wen

**Was QC Inspector aware of the problem:**  Yes  No

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

**Comments:**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Tsang, Eric

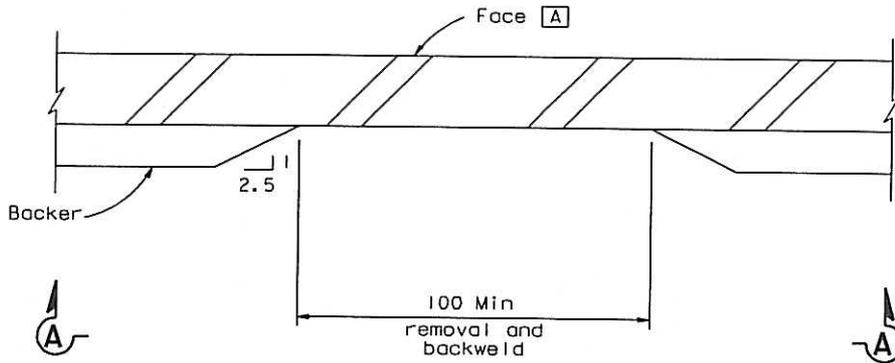
SMR

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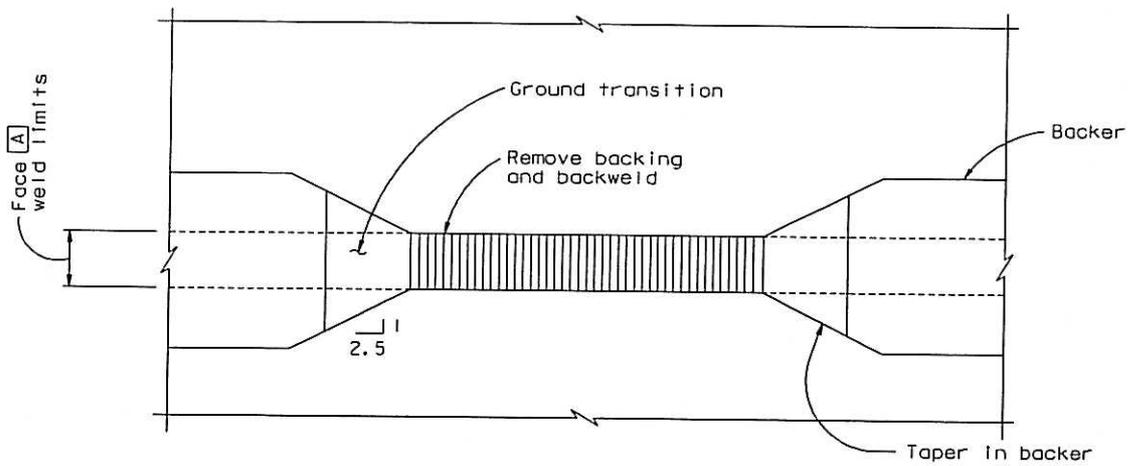
**Reviewed By:** Wahbeh, Mazen

SMR

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**OPTION 1**  
1:1



**VIEW A-A**  
1:1

SFOBB SAS (SAS) Project #04-0120F4  
RFI: # 2099R0

Date: 2010-03-26  
File Name: SK-2099R0-1



## NCR PROPOSED RESOLUTION

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

**Attention:** Siegenthaler, Peter  
Resident Engineer

**Ref:** 05.03.06-000840

**Subject:** NCR No. ZPMC-0844

**Dated:** 12-Jan-2011

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000880 Rev: 01

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC is providing NDT of the areas to show that the absences of backing bar in the areas did not adversely affect the weld.

"ZPMC is providing NDT of the areas to show that the absences of backing bar in the areas did not adversely affect the weld. A RFI will be submitted to allow the condition to remain as is."

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000880R01;

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### Caltrans' comments:

**Status:** REJ

**Date:** 12-Jan-2011

Please address the following comments regarding the NCR/NPR:

1) The response did not acknowledge the issue of violating the code requirement: AWS D1.5 2002, Section 3.13.2: "Groove welds made with the use of steel backing shall have the weld metal thoroughly fused with the backing. Steel backing shall be continuous for the full length of each weld made with backing."

2) 2 existing RFIs could resolve the issue but none was used. (TC-RFI199R0 backing bar smooth transition requirement; TC-RFI114R0 weld with PJP or keep backing bar full length.)

3) When the backing bar was placed, ZPMC noted that the backing bar was short and had placed it at the middle so that both ends of the weld has no continuous backing. QA Inspector pointed this issue out immediately during fit-up.

4) No revised procedure to prevent future occurrence is noted in the response.

**Submitted by:** Eagen, Sean

**Date:** 12-Jan-2011

**Attachment(s):**



No. B-963

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2011-01-12**

**REGARDING: NCR-000882(ZPMC-0844)**

ZPMC is providing both the UT and MT records to show the acceptability of these welds. Based on this, ZPMC is requesting closure of this NCR.

**ATTACHMENT:**

NCR-000882(ZPMC-0844)

B787-MT-34129

B787-UT-17648

*f*  
*2/12/2011*



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

## NON-CONFORMANCE REPORT TRANSMITTAL

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375 BURMA ROAD  
OAKLAND CA 95607

**Date:** 04-Nov-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:** 05.03.06-000840

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**Attachments:** ZPMC-0844

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Contract Files, Ching Chao, Bill Casey  
**File:** 05.03.06

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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**NCR #:** ZPMC-0844

### Type of problem:

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**Bridge No:** 34-0006

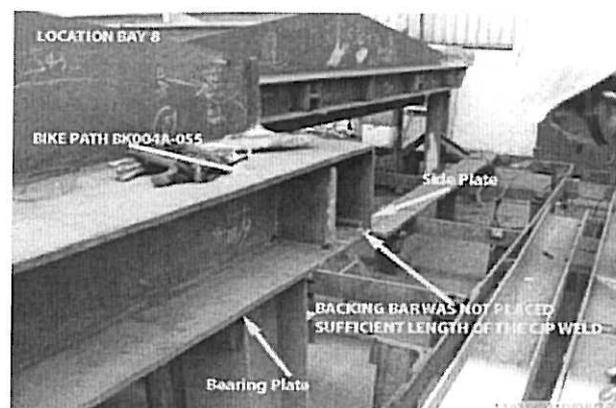
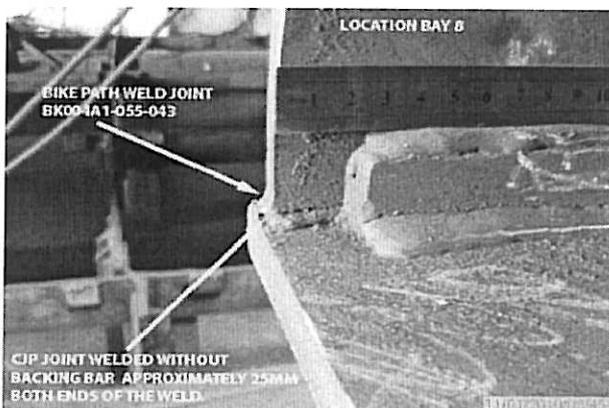
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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**QC Inspector's Name:** Liu Fa Wen

**Was QC Inspector aware of the problem:**  Yes  No

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

**Comments:**

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**Inspected By:** Tsang, Eric SMR

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**Reviewed By:** Wahbeh, Mazen SMR

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# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

| REPORT NO. 报告编号 B787-MT-34129                                 |   | DATE 日期 2010.12.03               |  | PAGE OF 页码 1/1 | Revision No: 0 |               |
|---|---|----------------------------------|--|----------------|----------------|---------------|
| PROJECT NO. 工程编号: ZP06-787                                    |   |                                  | CONTRACTOR: 用户: CALTRANS                                     |                |                |               |
| DRAWING NO. 图号: BK004A1<br>BIKE PATH                          |   |                                  | CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4                      |                |                |               |
| REFERENCING CODE 参考规范编码<br>AWS D1.5-2002                      | ACCEPTANCE STANDARD 接受标准<br>AWS D1.5-2002   | PROCEDURE NO. 程序编号<br>ZPQC-MT-01 | CALIBRATION DUE DATE 仪器校正有效期<br>Dec. 28 <sup>ST</sup> , 2010 |                |                |               |
| EQUIPMENT 设备<br>MT YOKE                                       | MANUFACTURER 制造商<br>PARKER  | MODEL NO. 样式编号<br>DA-400S        | SERIAL NO. 连续编号<br>17371                                     |                |                |               |
| MAGNETIZING METHOD 磁化方法                                       | Continuous magnetic yoke<br>磁轭式连续法  | CURRENT 电流                       | AC   |                |                |               |
| PARTICLE TYPE 磁粉类型  | Dry magnet powder<br>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<br><input type="checkbox"/> CASTING 铸件<br><input type="checkbox"/> FORGING 锻造 | Material & thickness 母材, 厚度      | A709M-345T2<br>16 mm   |                |                |               |
| WELDING PROCESS 焊接方法  | FCAW  | TYPE OF JOINT 焊缝类型               | CORNER JOINT   |                |                |               |
| WELD I.D.<br>焊缝编号   | DISCONTINUITY 不连续性  |                                  |  | ACCEPT<br>接受   | REJECT<br>拒收   | REMARKS<br>备注 |
|   | INDICATION<br>指示  | TYPE<br>类型                       | LENGTH IN mm<br>长度   |                |                |               |
| BK004A1-055-043   |   |                                  |  | ACC.           |                | 100%MT        |
| BK004A1-058-043   |   |                                  |  | ACC.           |                | 100%MT        |
| BK004A1-061-043   |   |                                  |  | ACC.           |                | 100%MT        |
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|   |   |                                  |  |                |                |               |
| EXAMINED BY 主探<br>Fu Zhiqiang <i>Fu Zhiqiang</i> 2010.12.03   |   |                                  | REVIEWED BY 审核<br><i>Wang Wai</i> 2010.12.03                 |                |                |               |
| LEVEL - II SIGN 签名 / DATE 日期<br>质量经理 / QCM <i>[Signature]</i> |   |                                  | LEVEL-II SIGN / DATE 日期<br>用户 CUSTOMER                       |                |                |               |
| 签字 SIGN / 日期 DATE<br>(FORM# ZPQC-MT01)                        |   |                                  | 签字 SIGN / 日期 DATE  |                |                |               |



# REPORT OF ULTRASONIC EXAMINATION

## UT探伤报告

REPORT NO. 报告编号 B787-UT-17648      DATE 2010.11.26      PAGE 1 OF 1      Revision No: 0

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

ITEMS NAME: BIKE PATH      DRAWING NO.: BK004A1      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  
 FCAW      BUTT      Dec. 28<sup>ST</sup>, 2010

EQUIPMENT 设备      MANUFACTURER 制造商      MODEL NO. 样式编号      SERIAL NO. 序列编号  
 UT SCOPE      GE      USM33      0712060B

CALIBRATION BLOCK 试块      COUPLANT 耦合剂      MATERIAL/THICKNESS 材料厚度  
 AWS IIW BLOCK TYPE II      C.M.C      A709M-345T2      16mm

### TRANSDUCER 探头

| MANUFACTURER<br>制造商   | ANGLE<br>角度 | FREQUENCY<br>频率 | SIZE<br>尺寸    | MANUFACTURER<br>制造商 | ANGLE<br>角度 | FREQUENCY<br>频率 | SIZE<br>尺寸 |
|-----------------------|-------------|-----------------|---------------|---------------------|-------------|-----------------|------------|
| AMERICA               | 70°         | 2.25MHz         | 0.75×0.625 in |                     |             |                 |            |
| 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<br>焊缝部件编号 | INDICATION NO.<br>指示号 | PROBE ANGLE<br>探测角度 | FROM FACE<br>检测面 | LEG (次数) | DECIBELS分贝       |                 |                    |                   | DISCONTINUITY 不连续性                     |   |   |   |              | Discontinuity Evaluation<br>缺陷估计 | Remark<br>备注 |
|-------------------------------|-----------------------|---------------------|------------------|----------|------------------|-----------------|--------------------|-------------------|--|---|---|---|--------------|----------------------------------|--------------|
|                               |                       |                     |                  |          | Indication Level | Reference Level | Attenuation Factor | Indication Rating | LOCATION OF DISCONTINUITY<br>不连续位置(mm) |   |   |   |              |                                  |              |
|                               |                       |                     |                  |          |                  |                 |                    |                   | a                                      | b | c | d | Length<br>长度 |                                  |              |
| BK004A1-055-043               |                       | 70                  |                  |          |                  | 42              |                    |                   |  |   |   |   |              | ACC.                             | 100%         |
| BK004A1-058-043               |                       | 70                  |                  |          |                  | 42              |                    |                   |  |   |   |   |              | ACC.                             | 100%         |
| BK004A1-061-043               |                       | 70                  |                  |          |                  | 42              |                    |                   |  |   |   |   |              | ACC.                             | 100%         |
| BLANK                         |                       |                     |                  |          |                  |                 |                    |                   |  |   |   |   |              |                                  |              |
|                               |                       |                     |                  |          |                  |                 |                    |                   |  |   |   |   |              |                                  |              |
|                               |                       |                     |                  |          |                  |                 |                    |                   |  |   |   |   |              |                                  |              |
|                               |                       |                     |                  |          |                  |                 |                    |                   |  |   |   |   |              |                                  |              |
|                               |                       |                     |                  |          |                  |                 |                    |                   |  |   |   |   |              |                                  |              |
|                               |                       |                     |                  |          |                  |                 |                    |                   |  |   |   |   |              |                                  |              |

EXAMINED BY 主探 Wang Ting      REVIEWED BY 审核 Li Ming

LEVEL - II SIGN / DATE 2010.11.26      LEVEL - II SIGN / DATE 2010.11.26

质量经理 / QCM Lu Jianhua      用户CUSTOMER

签字 SIGN / 日期 DATE 2010.11.26      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:** 05.03.06-000840

**Subject:** NCR No. ZPMC-0844

**Dated:** 14-Jan-2011

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000880 Rev: 02

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC acknowledges that the backing bar was not continuous for the full length of the weld.

ZPMC acknowledges that the backing bar was not continuous for the full length of the weld. In this case ZPMC used the smooth transition outlined in TC-RF1114R0 to rectify this issue, please refer to ABF-NPR-000880R0 where this RFI was referenced as being used to address the issue. The inspector and production team involved have been fined to reinforce the importance of adhering to the code. This particular type of NCR is not prevalent, with the large fine imposed on the inspector and production team, this incident should serve as a example to others and prevent future occurrences?

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000880R02

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**Caltrans' comments:**

**Status:** CLO

**Date:** 16-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0844 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 16-Jan-2011

**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-000932**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0844**Type of problem:**

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

**Date the Non-Conformance Report was written:** 01-Nov-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) in process observations of Fabrication of OBG Bike Path BK4A-055, 58, & 61, this QA Inspector discovered the following issue:

- ZPMC welded the root pass of a weld detailed as Complete Joint Penetration (CJP) with backing.
- ZPMC personnel welded the CJP Joint without approximately 25mm of backing at both ends.
- The weld is joining the Bearing Plate and End Plate (side plate) of bike path.
- AWS D1.5 specifies steel backing shall be continuous for the full length of the each weld made with backing.
- The weld is identified as: BK004A1-055-043, BK004A1-058-043 & BK004A1-061-043.
- The material thickness for this backing bar plate is 10 mm.
- This OBG Bike Path is located in Sub assembly Bay #08.

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

Contractor propose to repair the backing bar as per per TC-RFI114R0. Contractor will discipline and fine the production team and inspectors involved to reinforce the importance of adhering to the code to prevent future occurrence.

**Corrective action taken:**

Contractor repaired the welds as per TC-RFI114R0, and provided the documents confirming the welds are acceptable. The involved production team and inspectors were heavily fined, setting an example to others to prevent future occurrences.

**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 of Structural Materials for your project.

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**Inspected By:** Ng,Michael

Quality Assurance Inspector

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**Reviewed By:** Wahbeh,Mazen

QA Reviewer