

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 #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000893**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0855**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Bikepath BK004A-053
Procedural	Procedural	Description: Missed MT indication by QC	

Reference Description: QA found a missed MT indication after ZPMC had tested and accepted the plug weld on bikepath BK004A-053

Description of Non-Conformance:

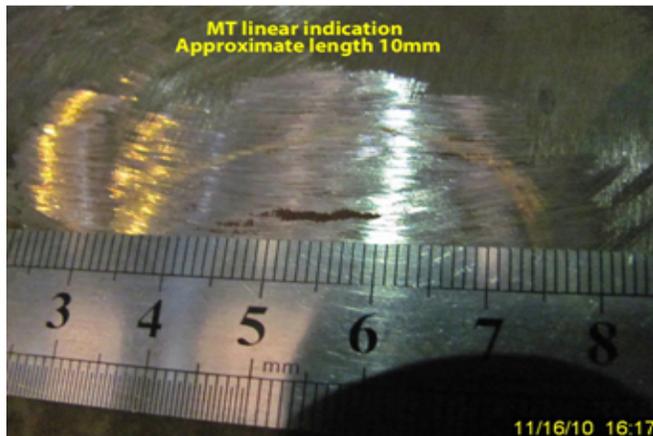
During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of plug welds located on OBG bike path BK004A-053, this QA Inspector discovered the following issues:

- One (1) MT linear indication found on the plug weld of bottom cover plate (BKPL4A) measuring approximately 10mm in length.
- Y location of the indication is measured to be 650mm from bottom cover diaphragm plate (BKPL6A) as shown in picture.
- The weld is identified as: BK004A2-053-014.
- The hole is identified as fifth hole from bottom cover diaphragm plate BKPL6A.
- The thickness of the bottom cover plate is measured to be 6mm.
- This weld is a plug weld joining the bottom cover plate (BKPL4A) to the stringer plate flange (BKX7F).
- This member is located in Bay 11.

The Notice of Witness Inspection Number (NWIT) is 07379. This indication is located within the area that has been previously tested and accepted by ABF Quality Control (QC) personnel. ABF's QC personnel performed 100% MT inspection of this weld.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Who discovered the problem: Umesh D. Gaikwad
Name of individual from Contractor notified: Zhao Xian He
Time and method of notification: 1630 Hrs, 11/16/10, Verbal
Name of Caltrans Engineer notified: Laraine Woo
Time and method of notification: 1345 Hrs, 11/17/10, Verbal
QC Inspector's Name: Wang Chuang Xin
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.

Inspected By:	Tsang, Eric	SMR
Reviewed By:	Wahbeh, Mazen	SMR

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000850

Subject: NCR No. ZPMC-0855

Dated: 13-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000879 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

"Please see ZPMC's response."

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000879R00;

Caltrans' comments:

Status: REJ

Date: 13-Dec-2010

The MT report does not document the Y location of indications. The information shall be provided both in this NPR closure and on the QA database.

Submitted by: Woo, Laraine

Date: 13-Dec-2010

Attachment(s):



No. B-940

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-12-09

REGARDING: NCR-000893(ZPMC-0855)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC has repaired the indications noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed. ABFJV has noted which inspector was responsible for this missed indications and is monitoring his performance as well as all inspector performance, if he continues to miss indications disciplinary action will be undertaken. Based on these actions, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-000893(ZPMC-0855)

B787-MT-31724 R3

[Handwritten signature]
[Handwritten date: 12/9/2010]



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: 18-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: 05.03.06-000850
Subject: NCR No. ZPMC-0855

Reference Description: QA found a missed MT indication after ZPMC had tested and accepted the plug weld on bikepath BK004A-053

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) Magnetic Particle Testing (MT) review of plug welds located on OBG bike path BK004A-053, Caltrans QA Inspector discovered the following issues:

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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-0855

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
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
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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-000893

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 16-Nov-2010

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

NCR #: ZPMC-0855

Type of problem:

Welding Concrete Other

Welding Curing Procedural **Bridge No:** 34-0006

Joint fit-up Coating Other **Component:** Bikepath BK004A-053

Procedural Procedural **Description:** Missed MT indication by QC

Reference Description: QA found a missed MT indication after ZPMC had tested and accepted the plug weld on bikepath BK004A-053

Description of Non-Conformance:

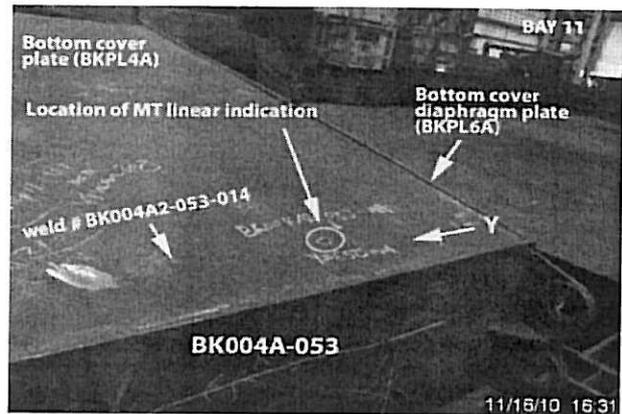
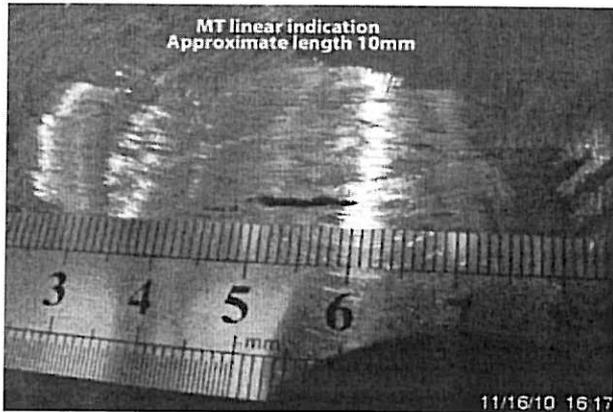
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

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Time and method of notification: 1630 Hrs, 11/16/10, Verbal
Name of Caltrans Engineer notified: Laraine Woo
Time and method of notification: 1345 Hrs, 11/17/10, Verbal
QC Inspector's Name: Wang Chuang Xin
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.

Inspected By: Tsang, Eric	SMR
Reviewed By: Wahbeh, Mazen	SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-31724R3 DATE日期 2010.11.19 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: BK004A-053 bike path		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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234
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 16/6mm
WELDING PROCESS 焊接方法	SMAW	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			
BK004A2-053-014	1R3			ACC.		100%MT
	2R3			ACC.		100%MT
	3R3			ACC.		100%MT
	4R3			ACC.		100%MT
	5R3			ACC.		100%MT
	6R3			ACC.		100%MT
	7R3			ACC.		100%MT
BK004A2-053-015	1R3			ACC.		100%MT
	2R3			ACC.		100%MT
	3R3			ACC.		100%MT
	4R3			ACC.		100%MT
	5R3			ACC.		100%MT
	6R3			ACC.		100%MT
	7R3			ACC.		100%MT
BK004A2-053-017	1R3			ACC.		100%MT

EXAMINED BY 主探 You Yilin <u>You Yilin</u>	REVIEWED BY 审核 <u>Yao Chunping</u>
LEVEL - II SIGN 签名 / DATE 日期 <u>2010.11.19</u>	LEVEL-II SIGN / DATE 日期 <u>2010.11.19</u>
质量经理 / QCM <u>[Signature]</u>	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000850

Subject: NCR No. ZPMC-0855

Dated: 27-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000879 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indications noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed.

ZPMC has repaired the indications noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed. ABFJV has noted which inspector was responsible for this missed indications and is monitoring his performance as well as all inspector performance, if he continues to miss indications disciplinary action will be undertaken. Based on these actions, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000879R01;

Caltrans' comments:

Status: CLO

Date: 29-Dec-2010

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

Submitted by: Woo, Laraine

Date: 29-Dec-2010

Attachment(s):



TRANSMITTAL LETTER

PROJECT: S.F.O.B.B.

DATE:2010-12-23

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: OBG NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

(01) LR: No. B-949

(02) NCR-000893(ZPMC-0855)

B787-MT-31724

B787-MT-31724 R1

B787-MT-31724 R2

B787-MT-31724 R3

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

Rosemary

COMPANY:



DATE: 12:56
RECEIVED 23 DEC 2010

PHONE NO.

PLAN NUMBER:N/A
#R787-QCP-102



No. B-949

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-12-23

REGARDING: NCR-000893(ZPMC-0855)

ZPMC is providing the NDT reports from the initial UT test to the final UT test, from which it clearly record all the locations of the defects. Based on this, ZPMC is request closure of this NCR.

ATTACHMENT:

NCR-000893(ZPMC-0855)

B787-MT-31724

B787-MT-31724 R1

B787-MT-31724 R2

B787-MT-31724 R3

LM
12/23/2010



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: 18-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: 05.03.06-000850

Subject: NCR No. ZPMC-0855

Reference Description: QA found a missed MT indication after ZPMC had tested and accepted the plug weld on bikepath BK004A-053

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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- Recurring QC issue that constitutes a systematic problem in quality control.
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Material Location: Bike Path

Lift:

Remarks:

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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-0855

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
 Office of Structural Materials
 Quality Assurance and Source Inspection



Contract #: 04-0120F4

Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

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-000893**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0855**Type of problem:**

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Bikepath BK004A-053
 Procedural Procedural Description: Missed MT indication by QC

Reference Description: QA found a missed MT indication after ZPMC had tested and accepted the plug weld on bikepath BK004A-053

Description of Non-Conformance:

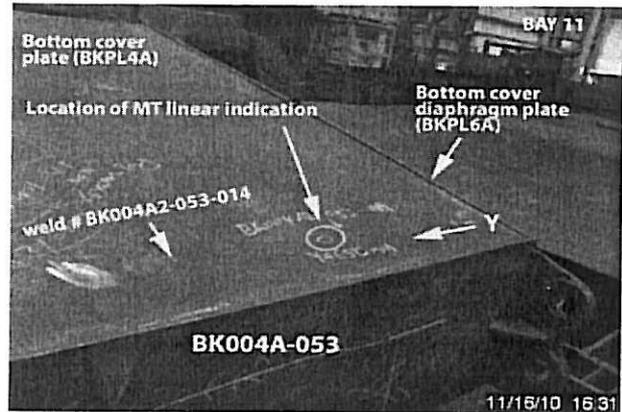
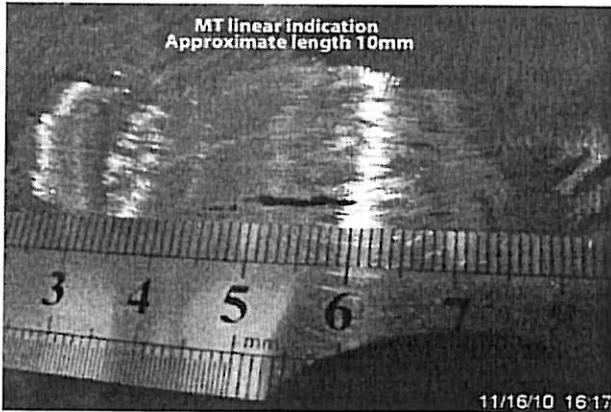
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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QC Inspector's Name: Wang Chuang Xin
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
Reviewed By: Wahbeh, Mazen	SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-31724		DATE 日期 2010.11.03		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: BK004A-053 bike path			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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234			
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 16/6mm			
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			
BK004A2-053-014	1	linear indication	21		REJ.	Y=100
	2	linear indication	32		REJ.	Y=410
	3	linear indication	23		REJ.	Y=530
	4	linear indication	27		REJ.	Y=1000
	5	linear indication	19		REJ.	Y=1100
	6	linear indication	15		REJ.	Y=1250
	7	linear indication	17		REJ.	Y=2000
	8	linear indication	26		REJ.	Y=2440
	9	linear indication	23		REJ.	Y=2580
	10	linear indication	25		REJ.	Y=3430
	11	linear indication	21		REJ.	Y=3600
	12	linear indication	30		REJ.	Y=3750
	13	linear indication	17		REJ.	Y=3890
	14	linear indication	21		REJ.	Y=4040
	15	linear indication	19		REJ.	Y=4440
EXAMINED BY 主探 Guo Qiming <i>Guo Qiming</i> 2010.11.03			REVIEWED BY 审核 <i>Yao Chun ping</i> 2010.11.03			
LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM <i>Cujianhua</i> 2010.11.03			LEVEL - II SIGN 签名 / 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-31724		DATE 日期 2010.11.03		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: BK004A-053 bike path			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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234			
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 16/6mm			
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			
	16	linear indication	30		REJ.	Y=5040
	17	linear indication	17		REJ.	Y=5340
	18	linear indication	27		REJ.	Y=5500
	19	linear indication	23		REJ.	Y=5620
	20	linear indication	25		REJ.	Y=5780
	21	linear indication	16		REJ.	Y=6350
	22	linear indication	20		REJ.	Y=6640
	23	linear indication	23		REJ.	Y=6950
	24	linear indication	15		REJ.	Y=7210
	25	linear indication	21		REJ.	Y=7380
	26	linear indication	26		REJ.	Y=7530
	27	linear indication	17		REJ.	Y=7660
	28	linear indication	28		REJ.	Y=7810
	29	linear indication	19		REJ.	Y=7950
	30	linear indication	20		REJ.	Y=8250
EXAMINED BY 主探 Guo Qiming <i>Guo Qiming</i>			REVIEWED BY 审核 <i>Yao Chun ping</i>			
LEVEL - II SIGN 签名 / DATE 日期 2010.11.3			LEVEL-II SIGN / DATE 日期 2010.11.03			
质量经理 / QCM <i>Lu Jianhua</i>			用户 CUSTOMER			
签字 SIGN / 日期 DATE 2010.11.3			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-31724		DATE日期 2010.11.03		PAGE OF页码 3/3	Revision No: 0	
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: BK004A-053 bike path			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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234			
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 16/6mm			
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			
	31	linear indication	15		REJ.	Y=8380
	32	linear indication	16		REJ.	Y=8540
	33	linear indication	25		REJ.	Y=8820
	34	linear indication	27		REJ.	Y=9100
BLANK						
EXAMINED BY 主探 Guo Qiming <i>Guo Qiming</i>			REVIEWED BY 审核 <i>Yao Chun ping</i>			
LEVEL - II SIGN 签名 / DATE日期 2010.11.03			LEVEL-II SIGN / DATE日期 2010.11.03			
质量经理 / QCM <i>Lu Jianhua</i>			用户CUSTOMER			
签字 SIGN / 日期 DATE 2010.11.03			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-31724R1		DATE日期 2010.11.08		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: BK004A-053 bike path			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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234			
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 16/6mm			
WELDING PROCESS 焊接方法	SMAW	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			
BK004A2-053-014	1R1	linear indication	5		REJ.	Y=1000
	2R1	linear indication	3		REJ.	Y=1250
	3R1	linear indication	12		REJ.	Y=1600
	4R1	linear indication	10		REJ.	Y=2200
	5R1	linear indication	5		REJ.	Y=2580
	6R1	linear indication	9		REJ.	Y=3430
	7R1	linear indication	3		REJ.	Y=3600
	8R1	linear indication	4		REJ.	Y=3750
	9R1	linear indication	6		REJ.	Y=3890
	10R1	linear indication	7		REJ.	Y=4230
	11R1	linear indication	10		REJ.	Y=5000
	12R1	linear indication	6		REJ.	Y=5480
	13R1	linear indication	7		REJ.	Y=6310
	14R1	linear indication	4		REJ.	Y=6370
	15R1	linear indication	4		REJ.	Y=7530
EXAMINED BY 主探 Guo Qiming <i>Guo Qiming</i>			REVIEWED BY 审核 <i>Yao Chun ping</i>			
LEVEL - II SIGN 签名 / DATE 日期 2010.11.08			LEVEL-II SIGN / DATE 日期 2010.11.08			
质量经理 / QCM <i>Lujianhua</i>			用户CUSTOMER			
签字 SIGN / 日期 DATE 2010.11.08			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-31724R1		DATE 日期 2010.11.08		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: BK004A-053 bike path			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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234			
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 16/6mm			
WELDING PROCESS 焊接方法	SMAW	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			
	16R1	linear indication	6		REJ.	Y=7650
	17R1	linear indication	9		REJ.	Y=8500
	18R1			ACC.		100%MT
	19R1			ACC.		100%MT
	20R1			ACC.		100%MT
	21R1			ACC.		100%MT
	22R1			ACC.		100%MT
	23R1			ACC.		100%MT
	24R1			ACC.		100%MT
	25R1			ACC.		100%MT
	26R1			ACC.		100%MT
	27R1			ACC.		100%MT
	28R1			ACC.		100%MT
	29R1			ACC.		100%MT
	30R1			ACC.		100%MT
EXAMINED BY 主探 Guo Qiming <i>Guo Qiming</i>			REVIEWED BY 审核 <i>Yao Chun ping</i>			
LEVEL - II SIGN 签名 / DATE 日期 2010. 11. 08			LEVEL - II SIGN / DATE 日期 2010. 11. 08			
质量经理 / QCM <i>Cui Jianhua</i>			用户 CUSTOMER			
签字 SIGN / 日期 DATE 2010. 11. 08			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-31724R2		DATE日期 2010.11.11	PAGE OF页码 1/2	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: BK004A-053 bike path		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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234	
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 16/6mm	
WELDING PROCESS 焊接方法	SMAW	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			
BK004A2-053-014	1R2	linear indication	10		REJ.	Y=3320
	2R2	linear indication	8		REJ.	Y=3750
	3R2	linear indication	5		REJ.	Y=4140
	4R2	linear indication	7		REJ.	Y=4390
	5R2	linear indication	8		REJ.	Y=6060
	6R2	linear indication	15		REJ.	Y=7940
	7R2	linear indication	12		REJ.	Y=4930
	8R2			ACC.		100%MT
	9R2			ACC.		100%MT
	10R2			ACC.		100%MT
	11R2			ACC.		100%MT
	12R2			ACC.		100%MT
	13R2			ACC.		100%MT
	14R2			ACC.		100%MT
	15R2			ACC.		100%MT

EXAMINED BY主探 Guo Qiming <i>Guo Qiming</i> LEVEL - II SIGN 签名 / DATE日期 2010.11.11 质量经理 / QCM <i>[Signature]</i> 签字 SIGN / 日期 DATE 2010.11.11	REVIEWED BY 审核 <i>Yao Chun ping</i> LEVEL-II SIGN / DATE日期 2010-11-08 用户CUSTOMER 签字 SIGN / 日期 DATE
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REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-31724R2		DATE日期 2010.11.11		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: BK004A-053 bike path		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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234			
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 16/6mm			
WELDING PROCESS 焊接方法	SMAW	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			
	16R2			ACC.		100%MT
	17R2			ACC.		100%MT
BLANK						
EXAMINED BY 主探 Guo Qiming <i>Guo Qiming</i> LEVEL - II SIGN 签名 / DATE日期 2010.11.08 质量经理 / QCM			REVIEWED BY 审核 <i>Yao Chun Ping</i> LEVEL-II SIGN / DATE日期 2010.11.08 用户CUSTOMER			
签字 SIGN / 日期 DATE <i>[Signature]</i> 2010.11.08			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-31724R3		DATE日期 2010.11.19	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: BK004A-053 bike path		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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14234	
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 16/6mm	
WELDING PROCESS 焊接方法	SMAW	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			
BK004A2-053-014	1R3			ACC.		100%MT
	2R3			ACC.		100%MT
	3R3			ACC.		100%MT
	4R3			ACC.		100%MT
	5R3			ACC.		100%MT
	6R3			ACC.		100%MT
	7R3			ACC.		100%MT
BLANK						

EXAMINED BY 主探 You Yilin <i>You Yilin</i> LEVEL - II SIGN 签名 / DATE日期 2010.11.19	REVIEWED BY 审核 <i>Yao Chunping</i> LEVEL-II SIGN / DATE日期 2010.11.19
质量经理 / QCM <i>[Signature]</i> 签字 SIGN / 日期 DATE 2010.11.19	用户CUSTOMER _____ 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: 05.03.06-000850

Subject: NCR No. ZPMC-0855

Dated: 15-Feb-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000879 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution:

See attached NDT results to show the weld is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000879R02;

Caltrans' comments:

Status: CLO

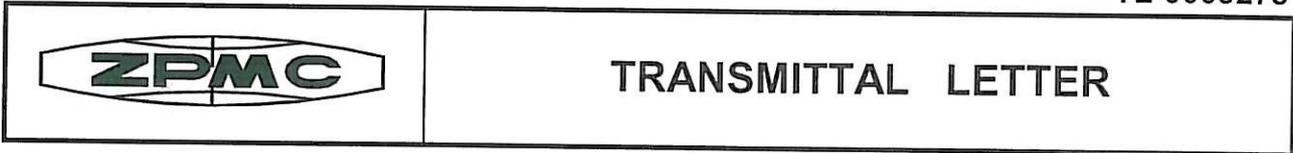
Date: 15-Feb-2011

NCR ZPMC-0855 has already been resolved and closed. Based on the attachments, this NPR was intended to be in response to NCR ZPMC-0885. The provided documentation is acceptable for NCR ZPMC-0885, however it needs to be submitted for the correct NCR in PMIV. Once that is done, NCR ZPMC-0885 will be closed. NCR ZPMC-0855 will remain closed.

Submitted by: Eagen, Sean

Date: 15-Feb-2011

Attachment(s):



PROJECT: S.F.O.B.B.

DATE:2011-02-14

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: TOWER NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

- (01) LR: No. T-190
- (02) NCR-000923(ZPMC-0885)
- NCR-000900(ZPMC-0862)
- NCR-000922(ZPMC-0884)
- T787-MT-12379
- T787-MT-11526
- T787-MT-12395

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

Rosemary

COMPANY:



DATE: 15:11
 RECEIVED 14 FEB 2011

PHONE NO.

PLAN NUMBER:N/A
 #R787-QCP-102



No. T-190

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2011-02-14

REGARDING:

NCR-000923(ZPMC-0885),NCR-000900(ZPMC-0862),NCR-000922(ZPMC-0884)

ZPMC received captioned NCRs, it mentioned that ZPMC didn't following the required preheating temperature of Weld Procedure Requirements for New Welds.

Here we attached related reports to show the welds were fine, hope CT could take a review and close these NCR.

ATTACHMENT:

NCR-000923(ZPMC-0885)

NCR-000900(ZPMC-0862)

NCR-000922(ZPMC-0884)

T787-MT-12379

T787-MT-11526

T787-MT-12395

zhang waeli 2011.2.14.

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. Chin

Report No: NCR-000923

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 25-Nov-2010

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

NCR #: ZPMC-0885

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: Lift 6 Skin D to stiffener welding

Reference Description: Preheat and welding do not follow the WELD PROCEDURE REQUIREMENTS FOR NEW WELDS (Rager/ McQuaid)

Description of Non-Conformance:

ZPMC welding personnel did not appear to be following the WELD PROCEDURE REQUIREMENTS FOR NEW WELDS (Rager/McQuaid) (THE PROCEDURE).

- 1) Preheat not applied as per section 2-f.
- 2) Preheat not applied as per section 3-m.
- 3) Preheat not applied as per Section 4-e.

- The weld is identified as WSD1- FDSA6- 4 - 5
- The welding process used was FCAW
- The area was being preheated using Electric strip heaters
- The weld is a Fillet joining Skin D to Stiffener
- The member is not SPCM
- Component/Member is located in Bay no. 11



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

WELD PROCEDURE REQUIREMENTS FOR NEW WELDS (Rager/McQuaid)

Section 1. This procedure is to be used for all new and totally replaced welds that are being made in conformance with the AWS D1.5 Bridge Welding Code, the Caltrans Special Provisions and this Welding Procedure.

Section 2. Assembly

f. Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165°C.

Section 3. Preparation for Welding

k. Preheating using electric strip heaters to provide a continual preheat before and during welding are preferred.

l. Alternatively, preheating using gas preheating torches shall be applied to the weld joint and surrounding area in such a way that the entire area to be welded and all adjacent material out to a distance of 75mm in any direction is heated to the value shown in AWS D1.5, clause 12.14 (Table 12.4 as appropriate). Preheat temperature is always stated as a minimum value.

m. Preheat shall utilize the use of electric heaters and blankets and be applied in such a manner to provide a minimum temperature of 140°C at all times until the weld joint is post weld thermal treated. (This includes applying preheat for CJP welds made from both sides and backgouged.)

n. Preheat temperatures to be checked by Tempilstik: crayon or calibrated digital thermometer.

Section 4. Welding

e. Preheat shall be maintained in accordance with Section 3.k.~ 3.n. of this procedure.

Who discovered the problem: Baskar Govindarajan

Name of individual from Contractor notified: Xin Xiao Guang

Time and method of notification: 1510 hrs, 11/25/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1230hrs, 11/26/10, email

QC Inspector's Name: Shao Hai Long

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: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR

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-000900

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Nov-2010

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

NCR #: ZPMC-0862

Type of problem:

Welding **Concrete** **Other**
Welding **Curing** **Procedural** **Bridge No:** 34-0006
Joint fit-up **Coating** **Other** **Component:** Tower Facade Plate
Procedural **Procedural** **Description:** Lift 4 Tower Facade Plate

Reference Description: Preheat doesn't follow the WELD PROCEDURE REQUIREMENTS for New Welds

Description of Non-Conformance:

During Caltrans QA in process observations of the fabrication of SD1-SFSA4-71, the QA discovered the following issue:

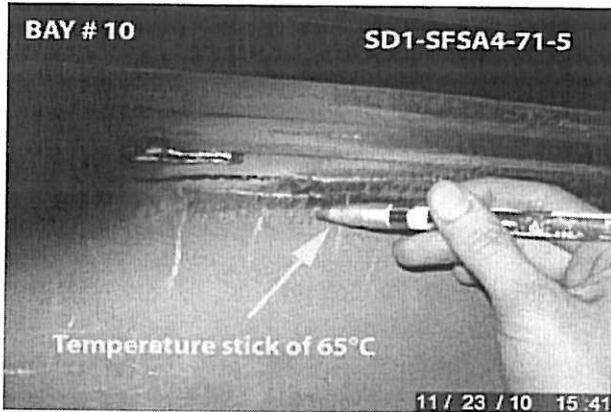
ZPMC welding personnel did not appear to be following the WELD PROCEDURE REQUIREMENTS FOR NEW WELDS (Rager/ McQuaid), i.e. Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165 degree Celsius.

- The weld is identified as: SD1-SFSA4-71-5
- The welding process used was SMAW
- The area was being preheated using torch
- The weld is as Fillet joining top plate to side plate
- The component is not SPCM
- The component (SD1-SFSA4-71_ is located in Bay 10.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

WELD PROCEDURE REQUIREMENTS FOR NEW WELDS

Section 2. Assembly

f. Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165 degree Celsius.

Who discovered the problem: Robin Sharma

Name of individual from Contractor notified: Lu Yi Jun

Time and method of notification: 1600, 11/23/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1000, 11/24/10, Verbal

QC Inspector's Name: Jiang Xiao Bo

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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

Inspected By: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR

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-000922

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 25-Nov-2010

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

NCR #: ZPMC-0884

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No.: 34-0006

Component: East Tower Lift 6 Skin plate F

Reference Description: Preheat doesn't follow the WELD PROCEDURE REQUIREMENTS for New Welds

Description of Non-Conformance:

During Caltrans QA in process observations of the fabrication of ESD1-FFSA6-2, the QA discovered the following issue:

ZPMC welding personnel did not appear to be following the WELD PROCEDURE REQUIREMENTS FOR NEW WELDS (Rager/ McQuaid), i.e. Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165 degree Celsius.

-The welds are identified as: ESD1-FFSA6-2-1, 2, 3, 4, 5, 6, 7, 8.

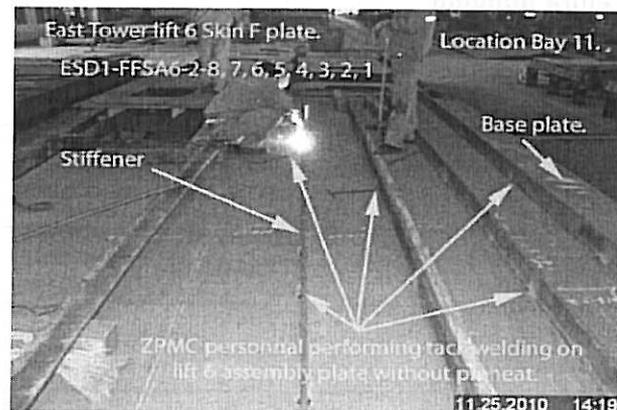
-The welding process used was SMAW

-The area was not preheated.

-The welds are Fillet Welds joining stiffener plates to skin plate

-The member is not SPCM

-ESD1-FFSA6-2 is located in Bay 11.



Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

WELD PROCEDURE REQUIREMENTS FOR NEW WELDS (Rager / McQuaid)

2. Assembly:f: Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165°C.

Who discovered the problem: Shailesh Gaikwad

Name of individual from Contractor notified: Xin Xiao Guang

Time and method of notification: 15:30, 11-25-2010, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1230hrs, 11-26-2010, email

QC Inspector's Name: Mr. Libin

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: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-12379 DATE日期 2010.12.31 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: WSD1-FDSA6-4 TOWER(W) SIXTH LIFTING D-SKIN STIFFENER 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. 28ST, 2011

EQUIPMENT 设备: MT YOKE MANUFACTURER 制造商: PARKER MODEL NO. 样式编号: da400S SERIAL NO. 连续编号: 17371

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 20/16mm

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			
WSD1-FDSA6-4-1				ACC.		10%MT
WSD1-FDSA6-4-2				ACC.		10%MT
WSD1-FDSA6-4-3				ACC.		10%MT
WSD1-FDSA6-4-4				ACC.		10%MT
WSD1-FDSA6-4-5				ACC.		10%MT
WSD1-FDSA6-4-6				ACC.		10%MT
WSD1-FDSA6-4-7				ACC.		10%MT
WSD1-FDSA6-4-8				ACC.		10%MT

AFTER HSR1(T)-11635

BLANK

EXAMINED BY 主探 Fu Zhi qiang <i>Fu Zhiqiang</i>	REVIEWED BY 审核 <i>Wang Wei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>2010.12.31</i>	LEVEL-II SIGN / DATE日期 <i>2010.12.31</i>
质量经理 / QCM <i>Wang Wei</i> <i>2010.12.31</i>	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 T787-MT-11526 DATE日期 2010.12.03 PAGE OF页码 1/6 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SD1-SFSA4 FAÇADE		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 DA-400S	SERIAL NO. 连续编号 17371
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 10/14/12mm
WELDING PROCESS 焊接方法	SMAW 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			
SD1-SFSA4-80-1				ACC.		10%MT
SD1-SFSA4-80-2				ACC.		10%MT
SD1-SFSA4-80-3				ACC.		10%MT
SD1-SFSA4-80-4				ACC.		10%MT
SD1-SFSA4-80-5				ACC.		10%MT
SD1-SFSA4-80-6				ACC.		10%MT
SD1-SFSA4-80-7				ACC.		10%MT
SD1-SFSA4-80-8				ACC.		10%MT
SD1-SFSA4-80-9				ACC.		10%MT
SD1-SFSA4-80-10				ACC.		10%MT
SD1-SFSA4-71-11				ACC.		10%MT
SD1-SFSA4-71-12				ACC.		10%MT
SD1-SFSA4-71-13				ACC.		10%MT
SD1-SFSA4-71-14				ACC.		10%MT

EXAMINED BY 主探 Fu Zhiqiang <i>Fu Zhiqiang</i>	REVIEWED BY 审核 <i>Wang Wei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>2010.12.03</i>	LEVEL-II SIGN / DATE日期 <i>2010.12.03</i>
质量经理 / QCM <i>Lu Jia</i>	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 T787-MT-11526		DATE日期 2010.12.03	PAGE OF页码 2/6	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SD1-SFSA4 FAÇADE		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 DA-400S	SERIAL NO. 连续编号 17371	
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 10/14/12mm	
WELDING PROCESS 焊接方法	SMAW 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			
SD1-SFSA4-71-15				ACC.		10%MT
SD1-SFSA4-71-16				ACC.		10%MT
SD1-SFSA4-71-1				ACC.		10%MT
SD1-SFSA4-71-2				ACC.		10%MT
SD1-SFSA4-71-5				ACC.		10%MT
SD1-SFSA4-71-6				ACC.		10%MT
SD1-SFSA4-71-19				ACC.		10%MT
SD1-SFSA4-71-20				ACC.		10%MT
SD1-SFSA4-71-21				ACC.		10%MT
SD1-SFSA4-71-22				ACC.		10%MT
SD1-SFSA4-94-1				ACC.		10%MT
SD1-SFSA4-94-2				ACC.		10%MT
SD1-SFSA4-94-3				ACC.		10%MT
SD1-SFSA4-94-4				ACC.		10%MT

EXAMINED BY 主探 Fu Zhiqiang <i>Fu Zhiqiang</i>	REVIEWED BY 审核 <i>Wang Wei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>2010.12.03</i>	LEVEL-II SIGN / DATE日期 <i>2010.12.03</i>
质量经理 / QCM <i>[Signature]</i>	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 T787-MT-11526		DATE日期 2010.12.03	PAGE OF页码 3/6	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SD1-SFSA4 FAÇADE		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 DA-400S	SERIAL NO. 连续编号 17371	
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 10/14/12mm	
WELDING PROCESS 焊接方法	SMAW 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			
SD1-SFSA4-94-5				ACC.		10%MT
SD1-SFSA4-94-6				ACC.		10%MT
SD1-SFSA4-94-7				ACC.		10%MT
SD1-SFSA4-94-8				ACC.		10%MT
SD1-SFSA4-94-9				ACC.		10%MT
SD1-SFSA4-94-10				ACC.		10%MT
SD1-SFSA4-94-11				ACC.		10%MT
SD1-SFSA4-94-12				ACC.		10%MT
SD1-SFSA4-94-13				ACC.		10%MT
SD1-SFSA4-94-14				ACC.		10%MT
SD1-SFSA4-84-1				ACC.		10%MT
SD1-SFSA4-84-2				ACC.		10%MT
SD1-SFSA4-84-3				ACC.		10%MT
SD1-SFSA4-84-4				ACC.		10%MT

EXAMINED BY主探 Fu Zhiqiang <i>Fu Zhiqiang</i>	REVIEWED BY 审核 <i>Wang Wei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>20/10/2010</i>	LEVEL-II SIGN / DATE日期 <i>20/10/2010</i>
质量经理 / QCM <i>[Signature]</i>	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 T787-MT-11526		DATE日期 2010.12.03	PAGE OF页码 4/6	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SD1-SFSA4 FAÇADE		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 DA-400S	SERIAL NO. 连续编号 17371	
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 10/14/12mm	
WELDING PROCESS 焊接方法	SMAW 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			
SD1-SFSA4-84-5				ACC.		10%MT
SD1-SFSA4-84-6				ACC.		10%MT
SD1-SFSA4-84-7				ACC.		10%MT
SD1-SFSA4-84-8				ACC.		10%MT
SD1-SFSA4-84-9				ACC.		10%MT
SD1-SFSA4-84-10				ACC.		10%MT
SD1-SFSA4-500-1				ACC.		10%MT
SD1-SFSA4-500-2				ACC.		10%MT
SD1-SFSA4-500-3				ACC.		10%MT
SD1-SFSA4-500-4				ACC.		10%MT
SD1-SFSA4-500-5				ACC.		10%MT
SD1-SFSA4-500-6				ACC.		10%MT
SD1-SFSA4-500-7				ACC.		10%MT
SD1-SFSA4-500-8				ACC.		10%MT

EXAMINED BY 主探 Fu Zhiqiang <i>Fu Zhiqiang</i>	REVIEWED BY 审核 <i>Wang Wei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>2010.12.03</i>	LEVEL-II SIGN / DATE日期 <i>2010.12.03</i>
质量经理 / QCM <i>[Signature]</i>	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 T787-MT-11526 DATE日期 2010.12.03 PAGE OF页码 5/6 Revision No: 0

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

DRAWING NO. 图号: SD1-SFSA4 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
 FAÇADE

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: DA-400S SERIAL NO. 连续编号: 17371

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
 CASTING 铸件 FORGING 锻造

WELDING PROCESS 焊接方法: SMAW 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			
SD1-SFSA4-500-9				ACC.		10%MT
SD1-SFSA4-500-10				ACC.		10%MT
SD1-SFSA4-500-11				ACC.		10%MT
SD1-SFSA4-500-12				ACC.		10%MT
SD1-SFSA4-500-13				ACC.		10%MT
SD1-SFSA4-500-14				ACC.		10%MT
SD1-SFSA4-81-1				ACC.		10%MT
SD1-SFSA4-81-2				ACC.		10%MT
SD1-SFSA4-81-3				ACC.		10%MT
SD1-SFSA4-81-4				ACC.		10%MT
SD1-SFSA4-81-5				ACC.		10%MT
SD1-SFSA4-81-6				ACC.		10%MT
SD1-SFSA4-81-7				ACC.		10%MT
SD1-SFSA4-81-8				ACC.		10%MT

EXAMINED BY 主探: Fu Zhiqiang *Fu Zhiqiang*

LEVEL - II SIGN 签名 / DATE日期: *20/12/03*

质量经理 / QCM: *[Signature]*

签字 SIGN / 日期 DATE

REVIEWED BY 审核: Wang Wei *Wang Wei*

LEVEL-II SIGN / DATE日期: *20/12/03*

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 T787-MT-12395 DATE日期 2011.01.05 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: ESD1-FFSA6-2 TOWER (E) LIFTING 6 SKIN F AND STIFFENER
 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. 28ST, 2011

EQUIPMENT 设备: MT YOKE MANUFACTURER 制造商: PARKER MODEL NO. 样式编号: DA-400S SERIAL NO. 连续编号: 17371

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 16/20mm

WELDING PROCESS 焊接方法: FCAW TYPE OF JOINT 焊缝类型: T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
ESD1-FFSA6-2-1				ACC.		10%MT
ESD1-FFSA6-2-2				ACC.		10%MT
ESD1-FFSA6-2-3				ACC.		10%MT
ESD1-FFSA6-2-4				ACC.		10%MT
ESD1-FFSA6-2-5				ACC.		10%MT
ESD1-FFSA6-2-6				ACC.		10%MT
ESD1-FFSA6-2-7				ACC.		10%MT
ESD1-FFSA6-2-8				ACC.		10%MT
ESD1-FFSA6-2-9				ACC.		10%MT
ESD1-FFSA6-2-10				ACC.		10%MT
ESD1-FFSA6-2-25				ACC.		10%MT
ESD1-FFSA6-2-26				ACC.		10%MT
ESD1-FFSA6-2-27				ACC.		10%MT
ESD1-FFSA6-2-28				ACC.		10%MT

AFTER HSR1(T)-11634

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EXAMINED BY 主探: Di Kunlun REVIEWED BY 审核: Wang Wei
 LEVEL - II SIGN 签名 / DATE日期: 2011.01.05 LEVEL-II SIGN / DATE日期: 2011.01.05
 质量经理 / QCM: [Signature] 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



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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-000875**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0855**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: 16-Nov-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of plug welds located on OBG bike path BK004A-053, this QA Inspector discovered the following issues:

- One (1) MT linear indication found on the plug weld of bottom cover plate (BKPL4A) measuring approximately 10mm in length.
- Y location of the indication is measured to be 650mm from bottom cover diaphragm plate (BKPL6A) as shown in picture.
- The weld is identified as: BK004A2-053-014.
- The hole is identified as fifth hole from bottom cover diaphragm plate BKPL6A.
- The thickness of the bottom cover plate is measured to be 6mm.
- This weld is a plug weld joining the bottom cover plate (BKPL4A) to the stringer plate flange (BKX7F).
- This member is located in Bay 11.

The Notice of Witness Inspection Number (NWIT) is 07379. This indication is located within the area that has been previously tested and accepted by ABF Quality Control (QC) personnel. ABF's QC personnel performed 100% MT inspection of this weld.

Contractor's proposal to correct the problem:

Contractor will repair the weld indications, and provide the NDT report to prove the weld is acceptable. Contractor will identify the inspector, and issue an internal NCR to him. Disciplinary action will be taken, if the inspector missed the indications continuously.

Corrective action taken:

Contractor repaired the indications and performed NDT subsequently. NDT results show that the weld is acceptable. Contractor identified the inspector, and issued an internal NCR to him. Contractor is monitoring his performance.

