

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, China**Report No:** NCR-000901**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0863**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 13AE Segment Welds
Procedural	Procedural	Description:	

Reference Description: New Weld Procedure Not Followed (Rager/McQuaid)**Description of Non-Conformance:**

During Caltrans QA in process observations of the fabrication of Orthotropic Box Girder (OBG) 13AE welds SEG3007J-047, SEG3007G-020 and SEG007L-045, QA discovered ZPMC welding personnel did not appear to be following the NEW WELD PROCEDURE (Rager/McQuaid)

The following requirements were not followed:

5. Postweld Thermal Treatment (5A, 5C, 5D)

NOTE: The above issue is relative to section 5 of the NEW WELD PROCEDURE (Rager/McQuaid) and the corresponding paragraph letters.

Issue number 1:

The weld was identified as SEG3007J-047

The welding process used was FCAW

The area was preheated using electric strip heaters

The weld is a complete joint penetration weld that joins FB3111A to bottom plate SA3012A

FB3111A and SA3012A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

Issue number 2

The weld was identified as SEG3007G-020

The welding process used was FCAW

The area was preheated using electric strip heaters

The weld is a complete joint penetration weld that joins FB3127A to longitudinal diaphragm LD3026A,

FB3127A and LD3026A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)

Issue number 3

The weld was identified as SEG3007L-045

The welding process used was FCAW

The area was preheated using electric strip heaters

The weld is a complete joint penetration weld that joins FB3124A to bottom plate SA3012A

FB3124A and SA3012A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

See attached photographs for additional detail.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)



Applicable reference:

NEW WELD PROCEDURE (Rager / McQuaid)

5) Postweld Thermal Treatment.

A. After welding is completed but before the temperature falls below that of the preheat temperature, post heat shall be applied to maintain the temperature in the area of the weld at 165 C - 225°C.

B. Post weld heating shall be maintained for a minimum of 1.5 hours for material base metal thickness of 25mm or less.

C. For material thickness over 25mm, post heating times will be increased by 1/2 hour for each increment of 12 mm or fraction thereof.

D. After the post weld heating time has been reached the repair shall be cooled by removing the heating source and leaving the blankets in place.

Who discovered the problem: Paul Dawson

Name of individual from Contractor notified: Bao Qian

Time and method of notification: 22:30hrs, Verbal, 11-23-2010

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 18:00hrs, Verbal, 11-24-2010

QC Inspector's Name: Zhong Guo Hui

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: Devey,Jim SMR

Reviewed By: Wahbeh,Mazen SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To:	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	Date:	25-Nov-2010
Dear:	Mr. Charles Kanapicki	Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Attention:	Mr. Thomas Nilsson Project/Fabrication Manager	Job Name:	SAS Superstructure
Subject:	NCR No. ZPMC-0863	Document No:	05.03.06-000858
Reference Description:	New Weld Procedure Not Followed (Rager/McQuaid)		

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

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG **Lift:** 13

Remarks:

During Caltrans QA in process observations of the fabrication of Orthotropic Box Girder (OBG)13AE welds SEG3007J-047, SEG3007G-020 and SEG007L-045, QA discovered ZPMC welding personnel did not appear to be following the NEW WELD PROCEDURE (Rager/McQuaid)

The following requirements were not followed:

- 5. Postweld Thermal Treatment (5A, 5C, 5D)

NOTE: The above issue is relative to section 5 of the NEW WELD PROCEDURE (Rager/McQuaid) and the corresponding paragraph letters.

Issue number 1:

The weld was identified as SEG3007J-047
The welding process used was FCAW
The area was preheated using electric strip heaters
The weld is a complete joint penetration weld that joins FB3111A to bottom plate SA3012A
FB3111A and SA3012A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

Issue number 2

The weld was identified as SEG3007G-020
The welding process used was FCAW
The area was preheated using electric strip heaters
The weld is a complete joint penetration weld that joins FB3127A to longitudinal diaphragm LD3026A,
FB3127A and LD3026A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

NCT

(Continued Page 2 of 2)

Issue number 3

The weld was identified as SEG3007L-045

The welding process used was FCAW

The area was preheated using electric strip heaters

The weld is a complete joint penetration weld that joins FB3124A to bottom plate SA3012A

FB3124A and SA3012A are designated on the approved shop drawings as Seismic Performance Critical

Members. This OBG segment 13AE weld is located in Bay 14

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-0863

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000858

Subject: NCR No. ZPMC-0863

Dated: 01-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000856 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: As this NCR was written without a contractual basis it should be withdrawn.

The "NEW WELD PROCEDURE (Rager/McQuaid)" quoted as the basis for this NCR is not a contract document only a recommendation from the QA/QC Committee. If the Department wants to incorporate the QA/QC committee's recommendations as a contract requirement a contract change order should be issued. As this NCR was written without a contractual basis it should be withdrawn.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000856R00

Caltrans' comments:

Status: REJ

Date: 03-Dec-2010

CT acknowledges contractor's response. However, successful NDT will close this NCR.

Submitted by: Chao, Ching

Date: 03-Dec-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000858

Subject: NCR No. ZPMC-0863

Dated: 08-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000856 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: We understand your response and we will not submit the normal NCR closure package with NDT reports for this and expect that CT will close these as the green tags for these components are issued.

We understand your response and we will not submit the normal NCR closure package with NDT reports for this and expect that CT will close these as the green tags for these components are issued.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000856R01

Caltrans' comments:

Status: REJ

Date: 09-Dec-2010

Normal NCR closure package with NDT reports shall be submitted with the NPR to close out the NCR.

Submitted by: Woo, Laraine

Date: 09-Dec-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000858

Subject: NCR No. ZPMC-0863

Dated: 22-Feb-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000856 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-000856R02;

Caltrans' comments:

Status: CLO

Date: 23-Feb-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0863 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 23-Feb-2011

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

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Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, China**Report No:** NCR-000901**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0863**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)

Issue number 3

The weld was identified as SEG3007L-045

The welding process used was FCAW

The area was preheated using electric strip heaters

The weld is a complete joint penetration weld that joins FB3124A to bottom plate SA3012A

FB3124A and SA3012A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

See attached photographs for additional detail.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)



Applicable reference:

NEW WELD PROCEDURE (Rager / McQuaid)

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Comments:

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Inspected By: Devey,Jim SMR

Reviewed By: Wahbeh,Mazen SMR



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18379R1-2 DATE 2011.01.25 PAGE 1 OF 3 Revision No: 0

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

ITEMS NAME: 部件名称	13AE PLATE PANEL SPLICE	DRAWING NO.: 图号	SEG3007	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
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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
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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. 28 ST , 2011
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EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 GE	MODEL NO. 样式编号 USM35	SERIAL NO. 序列编号 10526a
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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 100/35/25mm
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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
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 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
SEG3007G-048	1R1	69.6				39									ACC.	100%
	2R1	69.6				39									ACC.	100%
	3R1	69.6				39									ACC.	100%
	4R1	69.6				39									ACC.	100%
	5R1	69.6				39									ACC.	100%
	6R1	69.6				39									ACC.	100%
	7R1	69.6				39									ACC.	100%
SEG3007J-047	1R1	69.6				39									ACC.	100%

EXAMINED BY 主探 <i>Zhang Qianli</i>	REVIEWED BY 审核 <i>Xu Yong gang</i>
LEVEL - II SIGN / DATE 2011.1.25	LEVEL - II SIGN / DATE 2011.11.25

质量经理 / QCM <i>[Signature]</i>	用户 CUSTOMER
签字 SIGN / 日期 DATE 2011.1.25	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18379R1-2 DATE 2011.01.25 PAGE 2 OF 3 Revision No: 0

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		
	2R1	69.6				39								ACC.	100%
	3R1	69.6				39								ACC.	100%
	4R1	69.6				39								ACC.	100%
SEG3007G-049	1R1	69.6				39								ACC.	100%
	2R1	69.6				39								ACC.	100%
	3R1	69.6				39								ACC.	100%
	4R1	69.6				39								ACC.	100%
	5R1	69.6				39								ACC.	100%
	6R1	69.6				39								ACC.	100%
	7R1	69.6				39								ACC.	100%
	8R1	69.6				39								ACC.	100%
SEG3007L-045	1R1	69.6				39								ACC.	100%
SEG3007L-046	1R1	69.6				39								ACC.	100%
	2R1	69.6				39								ACC.	100%
	3R1	69.6				39								ACC.	100%
	4R1	69.6				39								ACC.	100%
	5R1	69.6				39								ACC.	100%
	6R1	69.6				39								ACC.	100%
	7R1	69.6				39								ACC.	100%
	8R1	69.6				39								ACC.	100%
	9R1	69.6				39								ACC.	100%
	10R1	69.6				39								ACC.	100%
	11R1	69.6				39								ACC.	100%

<p>EXAMINED BY 主探 <u>Zhang Quan li</u></p> <p>LEVEL - II SIGN / DATE 2011.01.25</p>	<p>REVIEWED BY 审核 <u>Xu rong gang</u></p> <p>LEVEL - II SIGN / DATE 2011.01.25</p>
<p>质量经理 / QCM <u>[Signature]</u></p> <p>签字 SIGN / 日期 DATE 2011.01.25</p>	<p>用户CUSTOMER _____</p> <p>签字 SIGN / 日期 DATE _____</p>



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18379R1-2 DATE 2011.01.25 PAGE 3 OF 3 Revision No: 0

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		
	12R1	69.6				39								ACC.	100%
	13R1	69.6				39								ACC.	100%
	14R1	69.6				39								ACC.	100%
	15R1	69.6				39								ACC.	100%

AFTER B-WR18552~18554 18556 18557

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EXAMINED BY 主探 <u>Zhang Quan li</u> LEVEL - II SIGN / DATE 2011.01.25	REVIEWED BY 审核 <u>Xu rong gang</u> LEVEL - II SIGN / DATE 2011.01.25
质量经理 / QCM <u>[Signature]</u> 签字 SIGN / 日期 DATE 2011.01.25	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-18355R1 DATE 2010.12.27 PAGE 1 OF 3 Revision No: 0

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

ITEMS NAME: 13AE DRAWING NO.: SEG3007 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号 ZP06-787

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 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 AMERICA EPOCH 4B 071565511

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 18/20/25/35mm

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
AMERICA	70°	2.25MHz	0.75×0.625in				
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		
SEG3007L-014	1R1	70				38								ACC.	100%
	2R1	70				38								ACC.	100%
	3R1	70				38								ACC.	100%
	4R1	70				38								ACC.	100%
	5R1	70				38								ACC.	100%
	6R1	70				38								ACC.	100%
SEG3007L-016	1R1	70				38								ACC.	100%

EXAMINED BY 主探 Zhang Quan Li REVIEWED BY 审核 Xu Yong Gang
 LEVEL - II SIGN / DATE 2010.12.27 LEVEL - II SIGN / DATE 2010.12.27

质量经理 / QCM Lu Jianhua 用户CUSTOMER _____
 签字 SIGN / 日期 DATE 2010.12.27 签字 SIGN / 日期 DATE _____



REPORT OF ULTRASONIC EXAMINATION

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	2R1	70					38								ACC.	100%
	3R1	70					38								ACC.	100%
	4R1	70					38								ACC.	100%
SEG3007J-034	1R1	70					38								ACC.	100%
	2R1	70					38								ACC.	100%
	3R1	70					38								ACC.	100%
	4R1	70					38								ACC.	100%
	5R1	70					38								ACC.	100%
SEG3007J-036	1R1	70					38								ACC.	100%
	2R1	70					38								ACC.	100%
	3R1	70					38								ACC.	100%
	4R1	70					38								ACC.	100%
	5R1	70					38								ACC.	100%
SEG3007G-018	1R1	70					38								ACC.	100%
	2R1	70					38								ACC.	100%
	3R1	70					38								ACC.	100%
SEG3007G-020	1R1	70					38								ACC.	100%
	2R1	70					38								ACC.	100%
	3R1	70					38								ACC.	100%
SEG3007C-175	1R1	70					38								ACC.	100%

EXAMINED BY 主探
Zhang Quanli
 LEVEL - II SIGN / DATE 2010.12.27

REVIEWED BY 审核
Xu rong yang
 LEVEL - II SIGN / DATE 2010.12.27

质量经理 / QCM
Wujianhua
 签字 SIGN / 日期 DATE 2010.12.27

用户 CUSTOMER
 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, China**Report No:** NCS-000923**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Feb-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0863**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: 23-Nov-2010**Description of Non-Conformance:**

During Caltrans QA in process observations of the fabrication of Orthotropic Box Girder (OBG) 13AE welds SEG3007J-047, SEG3007G-020 and SEG007L-045, QA discovered ZPMC welding personnel did not appear to be following the NEW WELD PROCEDURE (Rager/McQuaid)

The following requirements were not followed:

5. Postweld Thermal Treatment (5A, 5C, 5D)

NOTE: The above issue is relative to section 5 of the NEW WELD PROCEDURE (Rager/McQuaid) and the corresponding paragraph letters.

Issue number 1:

The weld was identified as SEG3007J-047

The welding process used was FCAW

The area was preheated using electric strip heaters

The weld is a complete joint penetration weld that joins FB3111A to bottom plate SA3012A

FB3111A and SA3012A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

Issue number 2

The weld was identified as SEG3007G-020

The welding process used was FCAW

The area was preheated using electric strip heaters

The weld is a complete joint penetration weld that joins FB3127A to longitudinal diaphragm LD3026A,

FB3127A and LD3026A are designated on the approved shop drawings as Seismic Performance Critical Members. This OBG segment 13AE weld is located in Bay 14

