

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.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, China**Report No:** NCR-000925**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0887**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: SA7512A, Lift 13AW
Procedural	Procedural	Description:	

Reference Description: Critical Weld Repair on Lift 13W Saddle Grillage without Prior Approval from Engineer

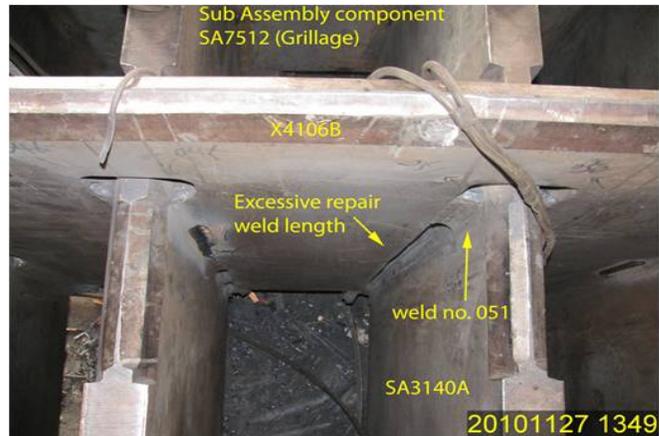
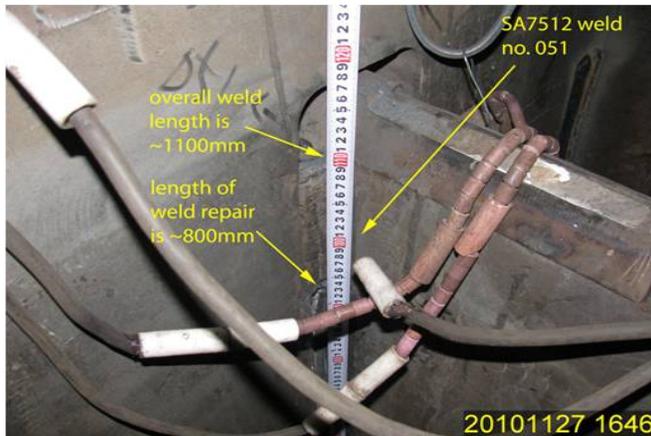
Description of Non-Conformance:

During the Quality Assurance Daily Observation of repair welding located on OBG Sub Assembly SA7512A this Quality Assurance Inspector (QA) discovered the following issues:

- ZPMC has performed Critical Weld Repairs (CWR) on Seismic Performance Critical Material (SPCM) without the Engineers approval.
 - The length of the excavation exceeded the limits of a Non Critical Weld Repair as defined in Section 12 of AWS D1.5 2002.
 - The length of excavation as measured by this QA was approximately 800mm on a 1100mm long weld.
 - The weld is identified as SA7512-051.
 - The repair documentation available for review was identified as B-WR-17780 and WPS-345-FCAW-3G (3F)-FCM-Repair.
 - The weld is a Complete Joint Penetration (CJP) joint, joining component identified as SA3141A to component identified as X4106B. Both plates are identified as SPCM on the approved shop drawings.
 - OBG Sub Assembly SA7512A is located in Bay 2.
- For further information, please see the attached pictures below.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



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 D1.5M – 2002 section 12.17.2(4) Noncritical Repair Welds – “First time excavation and repair from one side of groove welds and fillet welds which contain unacceptable porosity, slag, and fusion discontinuities, provided the excavations do not exceed the following limits: Length of weld “L” over 1.0m to 2.0m excavation is not to exceed 450mm.”

AWS D1.5M – 2002 section 12.17.3 Critical weld repairs. “Except as provided in 12.17.2, all welded repairs shall be considered critical. They include, but are not limited to the following:

(5) Corrections requiring weld removal and re-welding except as provided in 12.17.2 (4)”.

Who discovered the problem: Rene Hernandez

Name of individual from Contractor notified: Wang Wen Bin

Time and method of notification: 1630 hours, 11/27/10, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 10:30 hours, 11/29/10, Email

QC Inspector's Name: Tian Lei

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: Devey,Jim

SMR

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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: 30-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: 05.03.06-000882

Subject: NCR No. ZPMC-0887

Reference Description: Critical Weld Repair on Lift 13W Saddle Grillage without Prior Approval from Engineer

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

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

Material Location: OBG **Lift:** 13

Remarks:

- During the Quality Assurance Daily Observation of repair welding located on OBG Sub Assembly SA7512A, Caltrans Quality Assurance Inspector (QA) discovered the following issues:
- ZPMC has performed Critical Weld Repairs (CWR) on Seismic Performance Critical Material (SPCM) without the Engineers approval.
 - The length of the excavation exceeded the limits of a Non Critical Weld Repair as defined in Section 12 of AWS D1.5 2002.
 - The length of excavation as measured by this QA was approximately 800mm on a 1100mm long weld.
 - The weld is identified as SA7512-051.
 - The repair documentation available for review was identified as B-WR-17780 and WPS-345-FCAW-3G (3F)-FCM-Repair.
 - The weld is a Complete Joint Penetration (CJP) joint, joining component identified as SA3141A to component identified as X4106B. Both plates are identified as SPCM on the approved shop drawings.
 - OBG Sub Assembly SA7512A is located in Bay 2.

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-0887

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: 05.03.06-000882

Subject: NCR No. ZPMC-0887

Dated: 12-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000903 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

"Please see ZPMC's comments"

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000903R00;

Caltrans' comments:

Status: CLO

Date: 12-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0887 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 12-Jan-2011



No. B-962

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-01-12

REGARDING: NCR-000925(ZPMC-0887)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC QA personnel have talked with the site personnel to emphasize the requirement to get the engineer's prior approval of repair when the length of excavation on weld exceeded the limits of a Non critical weld repair as defined in AWS D1.5 Section 12. ZPMC is providing the NDT records to show the acceptability of this weld. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000925(ZPMC-0887)

B787-UT-17609 R2

B787-UT-17609 R5

by [signature]
1/12/2011

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.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, China

Report No: NCR-000925

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Nov-2010

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

NCR #: ZPMC-0887

Type of problem:

Welding Concrete Other Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: SA7512A, Lift 13AW

Procedural Procedural Description:

Reference Description: Critical Weld Repair on Lift 13W Saddle Grillage without Prior Approval from Engineer

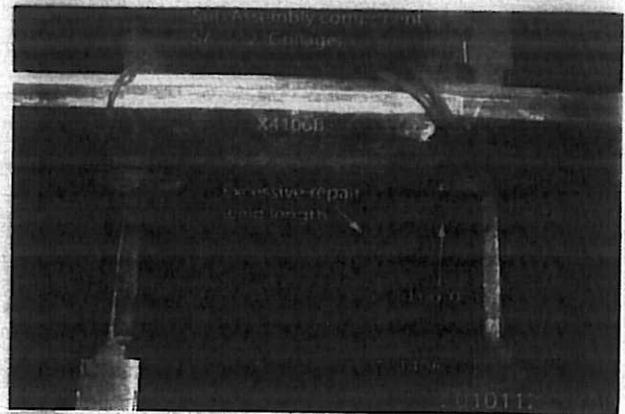
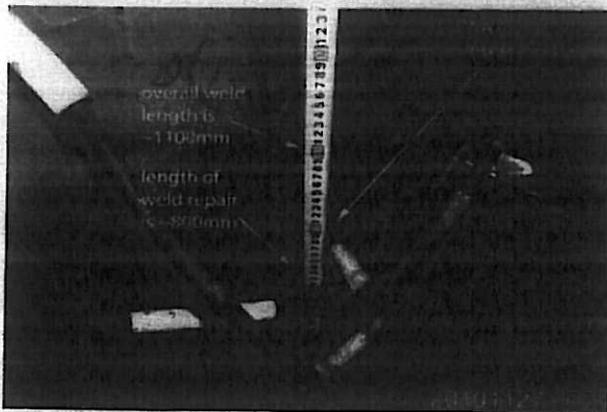
Description of Non-Conformance:

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 - The length of excavation as measured by this QA was approximately 800mm on a 1100mm long weld.
 - The weld is identified as SA7512-051.
 - The repair documentation available for review was identified as ~~17609~~ / 17609 RS Acc. B-WR-17780 and WPS-345-FCAW-3G (3F)-FCM-Repair.
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- For further information, please see the attached pictures below.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



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.”

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(5) Corrections requiring weld removal and re-welding except as provided in 12.17.2 (4)”.

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Name of individual from Contractor notified: Wang Wen Bin

Time and method of notification: 1630 hours, 11/27/10, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 10:30 hours, 11/29/10, Email

QC Inspector's Name: Tian Lei

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: Devey, Jim

SMR

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Reviewed By: Wahbeh, Mazen

SMR



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-17609R2 DATE 2010.12.08 PAGE 1 OF 5 Revision No: 0

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

ITEMS NAME: 13 LIFTING BED DRAWING NO.: SA7512 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
 SMAW T-JOINT Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE OLYMPUS EPOCH 4B 081610708

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345F2-X 75/100mm

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				
AMERICA	45°	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		
SA7512-001-045	1R2	70	A	1	52	40	11	+1	10	161	53	-25	180	REJ.	100%
	2R2	45	A	2	56	40	13	+3	10	186	18	-30	220	REJ.	100%
	3R2	70				40								ACC.	100%
	4R2	45				40								ACC.	100%
	5R2	45				40								ACC.	100%
	6R2	70				40								ACC.	100%
	7R2	45				40								ACC.	100%
	8R2	45				40								ACC.	100%

EXAMINED BY 主探 <i>Lina Jian</i> LEVEL - II SIGN / DATE 2010.12.08 质量经理 / QCM <i>[Signature]</i> 签字 SIGN / 日期 DATE	REVIEWED BY 审核 <i>Dai Genqiang</i> LEVEL - II SIGN / DATE 2010.12.08 用户 CUSTOMER 签字 SIGN / 日期 DATE
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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-17609R2 DATE 2010.12.08 PAGE 2 OF 5 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
	9R2	45				40									ACC.	100%
SA7512-001-052	1R2	70	A	1	51	40	11	0	20	163	55	-15	60	REJ.	100%	
	2R2	45	A	2	56	40	13	+3	10	186	18	-10	40	REJ.	100%	
	3R2	45	A	2	56	40	13	+3	10	180	22	-3	140	REJ.	100%	
	4R2	45	A	2	56	40	13	+3	10	183	20	-30	200	REJ.	100%	
	7R2	70				40								ACC.	100%	
SA7512-001-057	1R2	70				40								ACC.	100%	
	2R2	45				40								ACC.	100%	
	3R2	70				40								ACC.	100%	
SA7512-001-065	1R2	70				40								ACC.	100%	
	2R2	70				40								ACC.	100%	
		45				40								ACC.	100%	
SA7512-001-035	1R2	70				40								ACC.	100%	
	2R2	70				40								ACC.	100%	
	3R2	70				40								ACC.	100%	
		45				40								ACC.	100%	
SA7512-001-030	1R2	70	A	1	46	40	7	-1	10	113	39	-20	200	REJ.	100%	
	2R2	70	A	1	47	40	7	0	15	113	39	-20	260	REJ.	100%	
	3R2	70	A	1	51	40	10	+1	10	151	52	-10	460	REJ.	100%	
		45				40								ACC.	100%	

EXAMINED BY 主探
Liu Jian
LEVEL - II SIGN / DATE 2010.12.08

REVIEWED BY 审核
Dai Gengsheng
LEVEL - II SIGN / DATE 2010.12.08

质量经理 / QCM

签字 SIGN / 日期 DATE

用户 CUSTOMER

签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-17609R2 DATE 2010.12.08 PAGE 3 OF 5 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		
SA7512-001-036	1R2	70	A	1	55	40	15	0	10	217	75	-5	740	REJ.	100%
	2R2	70				40								ACC.	100%
	3R2	70				40								ACC.	100%
	4R2	70				40								ACC.	100%
	5R2	70				40								ACC.	100%
		45				40								ACC.	100%
SA7512-001-037	1R2	70	A	1	55	40	14	+1	10	197	68	-10	1050	REJ.	100%
	2R2	70				40								ACC.	100%
		45				40								ACC.	100%
SA7512-001-031	1R2	45	A	2	58	40	14	+4	10	208	2	0	220	REJ.	100%
	2R2	70	A	1	48	40	7	+1	10	116	44	-6	500	REJ.	100%
	3R2	70	A	1	54	40	14	0	10	200	69	-10	525	REJ.	100%
	4R2	70	A	1	49	40	10	-1	10	153	53	-6	550	REJ.	100%
	5R2	70	A	1	48	40	8	0	10	122	42	0	700	REJ.	100%
	6R2	70	A	1	55	40	14	+1	10	201	69	-37	800	REJ.	100%
SA7512-001-032	1R2	45	A	1	56	40	13	+3	10	187	19	-32	420	REJ.	100%
	2R2	70	A	1	51	40	12	-1	10	175	59	0	500	REJ.	100%
	3R2	70	A	1	48	40	7	+1	10	105	38	-10	730	REJ.	100%
	4R2	70				40								ACC.	100%
SA7512-001-038	1R2	70	A	1	46	40	5	+1	10	84	29	-28	420	REJ.	100%

EXAMINED BY主探
Lia Jian

REVIEWED BY审核
Dai Chengsheng

LEVEL - II SIGN / DATE 2010.12.08

LEVEL - II SIGN / DATE 2010.12.08

质量经理 / QCM

用户CUSTOMER

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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-17609R2 DATE 2010.12.08 PAGE 4 OF 5 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		
	2R2	70	A	1	45	36	6	0	10	105	38	-10	465	REJ.	100%
	3R2	45				40								ACC.	100%
	4R2	45				40								ACC.	100%
SA7512-001-049	1R2	45				40								ACC.	100%
		70				40								ACC.	100%
SA7512-001-043	1R2	70	A	1	45	36	14	0	10	207	70	-2	140	REJ.	100%
	2R2	70	A	1	45	36	5	+1	10	83	60	-10	240	REJ.	100%
		45				40								ACC.	100%
SA7512-001-044	1R2	45				40								ACC.	100%
	2R2	70				40								ACC.	100%
SA7512-001-051	1R2	45				40								ACC.	100%
	2R2	70				40								ACC.	100%
SA7512-001-059	1R2	70	A	1	45	36	12	-1	20	176	62	-10	50	REJ.	100%
	2R2	70	A	1	45	36	8	0	20	125	43	-10	700	REJ.	100%
	3R2	45	A	2	45	36	12	+5	20	175	26	-10	650	REJ.	100%
	4R2	70				40								ACC.	100%
SA7512-001-060	1R2	45	A	2	45	36	14	+1	10	200	11	-30	200	REJ.	100%
	2R2	45	A	2	45	36	14	+2	20	205	5	-40	280	REJ.	100%
	3R2	70	A	1	45	36	13	+1	10	180	65	-30	150	REJ.	100%
	4R2	70	A	1	45	36	13	0	20	180	65	0	700	REJ.	100%

EXAMINED BY 主探
Lia Jian
LEVEL - II SIGN / DATE 2010.12.08

REVIEWED BY 审核
Dai Gengsheng
LEVEL - II SIGN / DATE 2010.12.08

质量经理 / QCM

签字 SIGN / 日期 DATE

用户 CUSTOMER

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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-17609R5 DATE 2010.12.24 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 13 LIFTING GRILLAGE DRAWING NO.: SA7512 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
 SMAW T-JOINT Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE OLYMPUS EPOCH 4B 081610708

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345F2-X 75/100mm

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				
AMERICA	45°	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			
SA7512-030	1R5	70				40									ACC.	100%
SA7512-032	1R5	70				40									ACC.	100%
SA7512-060	1R5	45				35									ACC.	100%

AFTER B-CWR2349/2353/2308

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EXAMINED BY 主探 <i>Dai Geng sheng</i> LEVEL - II SIGN / DATE 2010.12.08 质量经理 / QCM <i>[Signature]</i> 签字 SIGN / 日期 DATE	REVIEWED BY 审核 <i>Kra Jian</i> LEVEL - II SIGN / DATE 2010.12.08 用户 CUSTOMER 签字 SIGN / 日期 DATE
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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-000938**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0887**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: 27-Nov-2010**Description of Non-Conformance:**

During the Quality Assurance Daily Observation of repair welding located on OBG Sub Assembly SA7512A this Quality Assurance Inspector (QA) discovered the following issues:

-ZPMC has performed Critical Weld Repairs (CWR) on Seismic Performance Critical Material (SPCM) without the Engineers approval.

-The length of the excavation exceeded the limits of a Non Critical Weld Repair as defined in Section 12 of AWS D1.5 2002.

-The length of excavation as measured by this QA was approximately 800mm on a 1100mm long weld.

-The weld is identified as SA7512-051.

-The repair documentation available for review was identified as B-WR-17780 and WPS-345-FCAW-3G (3F)-FCM-Repair.

-The weld is a Complete Joint Penetration (CJP) joint, joining component identified as SA3141A to component identified as X4106B. Both plates are identified as SPCM on the approved shop drawings.

-OBG Sub Assembly SA7512A is located in Bay 2.

For further information, please see the attached pictures below.

Contractor's proposal to correct the problem:

Contractor will provide the NDT report to prove the weld repair is acceptable. ZPMC will issue an internal NCR and will remind the site personnel the necessity to notify and seek approval from Engineer when the length of excavation on weld exceeds the limits of Non Critical weld repair as defined in AWS D1.5 , Section 12.

Corrective action taken:

Contractor provided the NDT report proving the weld repair was completed satisfactorily. Internal NCR issued to the QC personnel involved. QA from Contractor also discussed with the site personnel reinforcing that Engineer must be notified when the length of excavation on weld exceeds the limit of Non critical weld repair defined in Code.

