

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-000934

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 09-Dec-2010

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

NCR #: ZPMC-0895

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Steel Barriers
Procedural	Procedural	Description:	

Reference Description: ZPMC removed welds and re-welded without Engineer's approval and QC presence over 30 minutes (Steel Barriers E5-SB13-066 and E5-SB13-072)

Description of Non-Conformance:

During Quality Assurance (QA) random in-process observations of the fabrication of OBG Steel Barriers E5-SB13-066 and E5-SB13-072, Caltrans QA Inspectors observed the following issues:

- ZPMC workers have removed multiple CJP and fillet weld joints to correct misalignment of Steel Barriers E5-SB13-066 and E5-SB13-072.
- The Contractor did not notify the Engineer of the intent to remove welds E5-SB13-066-048, 049, 050, 079, 080, 081, 084, and 085; E5-SB13-072-048, and 049 as identified in the pictures.
- Subsequently, ZPMC workers performed welding at several above mentioned locations, such as E5-SB13-066-050 as seen in the picture below.
- No ZPMC QC or CWI was present during the removal of the welds.
- No ZPMC QC or CWI was present during weld repairs.
- ZPMC workers performed welding of steel barriers inside Bay 28 on December 9, 2010 between 0200 hours and 0245 hours.
- Doors accessing Bay 28 were locked during the welding repairs.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

American Weld Society (AWS) D1.5 2002 section. 3.7.5 The Engineer shall be notified before improperly fitted and welded members are cut apart.

American Weld Society (AWS) D1.5 2002 section. 6.6.1 The Contractor shall allow access to the project fabrication facility by QA personnel. The Contractor shall cooperate with QA personnel and provide ready access to QA inspection records.

Caltrans Special Provision Section 8-3.01: QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes.

Who discovered the problem: Dennis Combs, Kelly Leavitt, Paul Dawson

Name of individual from Contractor notified: Bao Qian

Time and method of notification: 03:00, 12/09/2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 19:00, 12/09/2010, Email

QC Inspector's Name: Not available at the time

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

Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

SMR



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:	10-Dec-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-0895	Document No:	05.03.06-000891

Reference Description: ZPMC removed welds and re-welded without Engineer's approval and QC presence over 30 minutes (Steel Barriers E5-SB13-066 and

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: Barrier Rail **Lift:**

Remarks:

- During Quality Assurance (QA) random in-process observations of the fabrication of OBG Steel Barriers E5-SB13-066 and E5-SB13-072, Caltrans QA Inspectors observed the following issues:
- ZPMC workers have removed multiple CJP and fillet weld joints to correct misalignment of Steel Barriers E5-SB13-066 and E5-SB13-072.
 - The Contractor did not notify the Engineer of the intent to remove welds E5-SB13-066-048, 049, 050, 079, 080, 081, 084, and 085; E5-SB13-072-048, and 049 as identified in the pictures.
 - Subsequently, ZPMC workers performed welding at several above mentioned locations, such as E5-SB13-066-050.
 - No ZPMC QC or CWI was present during the removal of the welds.
 - No ZPMC QC or CWI was present during weld repairs.
 - ZPMC workers performed welding of steel barriers inside Bay 28 on December 9, 2010 between 0200 hours and 0245 hours.
 - Doors accessing Bay 28 were locked during the welding repairs.

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 issued is expected within 7 days.

Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0895

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: 05.03.06-000891

Subject: NCR No. ZPMC-0895

Dated: 22-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000885 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

ZPMC-0895
Please see ZPMC's response.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000885R00;

Caltrans' comments:

Status: CLO

Date: 23-Dec-2010

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

Submitted by: Woo, Laraine

Attachment(s):

Date: 23-Dec-2010



No. B-947

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-12-22

REGARDING: NCR-000934(ZPMC-0895)

ZPMC acknowledged these issues and has released an internal NCR to address. ZPMC QA personnel have talked with the field CWI/QC leaders to emphasize the requirement of QC's coverage during welding and to notify the engineer when remove completed welds. ZPMC is providing the weld repair report and NDT records to show the acceptability of these weld. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000934(ZPMC-0895)

B-WR16809

B787-MT-35179

B787-MT-35180

B787-UT-19271

A handwritten signature in black ink, appearing to be 'J. W.' or similar, written in a cursive style.

12/22/2010



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: 10-Dec-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0895

Document No: 05.03.06-000891

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Material Location: Barrier Rail

Lift:

Remarks:

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Attachments: ZPMC-0895

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

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DIVISION OF ENGINEERING SERVICES

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Date: 09-Dec-2010

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

NCR #: ZPMC-0895

Type of problem:Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:

Bridge No: 34-0006

Component: OBG Steel Barriers

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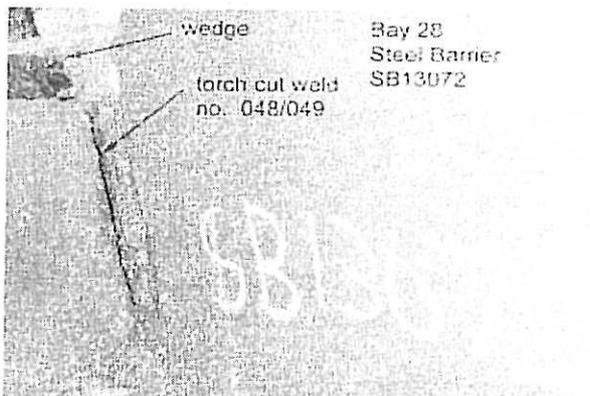
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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QC Inspector's Name: Not available at the time

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: Devey, Jim

SMR



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	E5-SB13-072 E5-SB13-066	报告编号 Report No.	B-WR16809
合同号 Contract No.:	04-0120F4	部件名称 Items Name	钢护栏 Steel barrier	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述： (钢护栏折弯板与隔板角接处平整度超标)

Description of welding discontinuity:

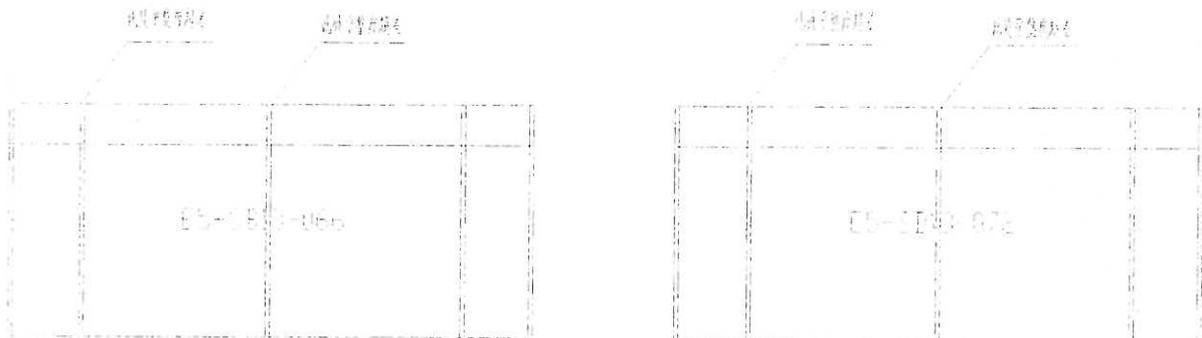
测量发现钢护栏E5-SB13-072, E5-SB13-066折弯板与隔板处发生较大扭曲, 折弯板顶部与隔板角接焊缝处焊后平整度超标, 具体数据见附页。

After inspection for Steel barrier E5-SB13-072, E5-SB13-066, the flatness of welds between bent plate and segregate plate assembly is over the requirement, please see the detail as following:

检验员 (Inspector): 柳百强 日期(Date): Dec. 07. 2010

焊缝返修位置示意图:

Draft of welding discontinuity:



产生原因:

Caused:

焊接变形及制作误差。

Welding distortion and fabrication error.

车间负责人(Foreman): 张志强 日期(Date): 2010.12.7

处理意见

Disposition :

1. 采用碳刨或火焰切割的方法割除平整度超差位置斜底板与角单元的焊缝长度L(注: L切割长度可根据现场实际平整度超差情况进行确定), 碳刨前应根据相应的WPS进行预热;
2. 调节斜底板与角单元以保证平面度满足公差要求, 调整时可借用校火, 外力(如工艺卡码等);
3. 对母材刨除区域进行VT检测确认无缺陷存在;
4. 根据批准的返修WPS焊接斜底板与角单元焊缝, 并随时检测斜底板与角单元平整度;
5. 将修补焊缝打磨与周边焊缝或母材平齐;
6. 根据图纸要求进行检测。

注: 若平整度超差区域无需开刀时, 可通过校火方法进行纠正。

1. Remove the welds where the straightness is out of tolerance between side plate and corner assembly by the way of gouging or Oxygen with length of L (The L length is confirm by actual condition), Pre heat according to the WPS prior to gouging.
2. Adjust side plate and corner assembly and ensure the straightness to meet the tolerance. When adjusting , can utilize the fire, the outer force (as C shape fixture and so on)
3. Perform 100%VT inspection to the metal cutting area to ensure no defects exist;;
4. Fit up and weld the weld between side plate and corner assembly according to the relevant WPS with check the flatness sometime;
5. Grind the weld flush to the adjacent weld or base metal.
6. Check the weld according to the shop drawings.

Notice; if the area where the straightness is out of tolerance needn't remove the welds, can proofread by the fire .

工艺:
Technical engineer

Xu Dongkang
2010.12.7

审核:
Approved by

Lu Jianhua

日期 2010.12.07
Date



焊缝返修报告

Welding Repair Report

版本 Rev. No.

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	E5-SB13-072 E5-SB13-066	报告编号 Report No.	B-WR16809
合同号 Contract No.:	04-0120F4	部件名称 Items Name	钢护栏 Steel barrier	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

车间负责人(Foreman):

日期(Date):

参照的WPS编号 Repair WPS No.	<input type="checkbox"/> WPS-345-SMAW-1G(1F)- Repair <input type="checkbox"/> WPS-345-FCAW-1G(1F)- Repair-1 <input type="checkbox"/> WPS-345-SMAW-2G(2F)-Repair <input checked="" type="checkbox"/> WPS-345-FCAW-2G(2F)-Repair-1 <input type="checkbox"/> WPS-345-SMAW-3G(3F)- Repair <input type="checkbox"/> WPS-345-SMAW-4G(4F)- Repair <input type="checkbox"/> WPS-345-SMAW-1G(1F)-FCM-Repair <input type="checkbox"/> WPS-345-SMAW-2G(2F)-FCM-Repair <input type="checkbox"/> WPS-345-SMAW-3G(3F)-FCM-Repair <input type="checkbox"/> WPS-345-SMAW-4G(4F)-FCM-Repair	CWI: Yang Bai Qiang WPS-345-FCAW-2G(2F) - ESAB - REPAIR 工艺员 technologist	Xu Dong has 2010.12.7
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返修(碳刨)前预热温度 Preheat temperature before gouging	70	返修的缺陷 Description of discontinuity	NA
焊前处理检查 Inspection before welding	Acc	焊前预热温度 Preheat temperature before welding	130
最大碳刨深度 Max. depth of gouging	10mm	碳刨总长 Total length of gouging	200mm

焊工 welder	焊接类型 welding type	焊接位置 position
059378	FCAW	2F
焊接电流 Current	焊接电压 Voltage	焊接速度 Speed
300	25.4	306

返修后检查 Inspection After repairing:		
外观检查 VT result	检验员 Inspector	日期 Date
Acc	Yang Bai Qiang	DEC. 18. 2010
NDT复检 NDT result	探伤员 NDT person	日期 Date
Acc	Jin Jian	2010.12.20

见证:
Witness/Review:备注:
Remark:



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-35180		DATE日期 2010.12.21	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: E5-SB13-066 STEEL BORRIER		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 KOREA	MODEL NO. 样式编号 MP-A2L	SERIAL NO. 连续编号 MP1644	
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 12/12mm	
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			
E5-SB13-066-048				ACC.		100%MT
E5-SB13-066-049				ACC.		100%MT
E5-SB13-066-050				ACC.		100%MT
E5-SB13-066-079				ACC.		100%MT
E5-SB13-066-080				ACC.		100%MT
E5-SB13-066-081				ACC.		100%MT
E5-SB13-066-084				ACC.		100%MT
E5-SB13-066-085				ACC.		100%MT
BLANK						

EXAMINED BY主操 Sun Gongchang <u>Sun Gongchang</u>	REVIEWED BY 审核 <u>Sun Gongchang</u>
LEVEL - II SIGN 签名 / DATE日期 2010-12-21	LEVEL-II SIGN / DATE日期 2010.12.21
质量经理 / QCM <u>Zu Tianhua</u>	用户CUSTOMER
签字 SIGN / 日期 DATE 2010.12.21	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-19271 DATE 2010.12.22 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: STEEL BARRIER DRAWING NO.: E5-SB13-066 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

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

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH 4B 071566411

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2-X 12/12mm

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		
E5-SB13-066-050		70				40								ACC.	100%
E5-SB13-066-0081		70				40								ACC.	100%
BLANK															

EXAMINED BY 主探: Liu Jian REVIEWED BY 审核: Yu Hong gang
 LEVEL - II SIGN / DATE: duo. 12.22 LEVEL - II SIGN / DATE: duo. 12.22

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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Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0895**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 09-Dec-2010**Description of Non-Conformance:**

During Quality Assurance (QA) random in-process observations of the fabrication of OBG Steel Barriers E5-SB13-066 and E5-SB13-072, Caltrans QA Inspectors observed the following issues:

-ZPMC workers have removed multiple CJP and fillet weld joints to correct misalignment of Steel Barriers E5-SB13-066 and E5-SB13-072.

-The Contractor did not notify the Engineer of the intent to remove welds E5-SB13-066-048, 049, 050, 079, 080, 081, 084, and 085; E5-SB13-072-048, and 049 as identified in the pictures.

-Subsequently, ZPMC workers performed welding at several above mentioned locations, such as E5-SB13-066-050 as seen in the picture below.

-No ZPMC QC or CWI was present during the removal of the welds.

-No ZPMC QC or CWI was present during weld repairs.

-ZPMC workers performed welding of steel barriers inside Bay 28 on December 9, 2010 between 0200 hours and 0245 hours.

-Doors accessing Bay 28 were locked during the welding repairs.

Contractor's proposal to correct the problem:

Contractor will perform NDT to prove the weld is acceptable. Contractor will discuss the CWI leader in the field regarding the requirement of QC coverage during welding, and ensure the Engineer will be notified when there is weld removal.

Corrective action taken:

Contractor provided the NDT report to prove the welds are acceptable. Contractor also discussed with the CWI leader regarding the requirement of QC coverage during welding, and instructed the Engineer must be notified when there is weld removal.

Did corrective action require Engineer's approval?

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Yes No

If so, name of Engineer providing approval:

Date:

Is Engineer's approval attached? Yes No

Comments:

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

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer