

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-000949**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0908**Type of problem:**

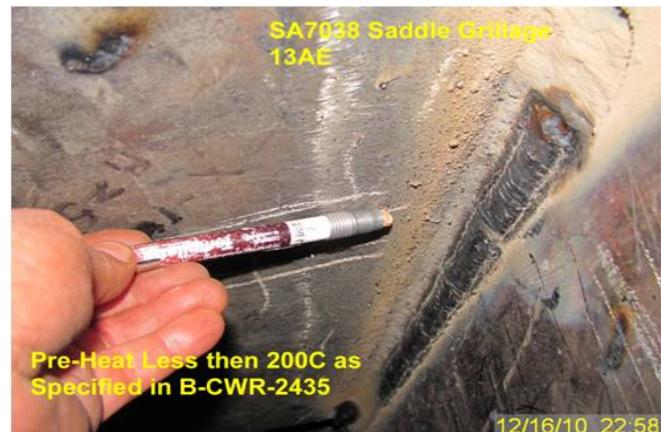
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 13AE, SA7038A, Saddle Grillage
Procedural	Procedural	Description:	

Reference Description: Lack of Preheat Observed on Critical Weld Repair being performed on Saddle Grillage for Lift 13EA

Description of Non-Conformance:

During the Quality Assurance in-process observation of the fabrication of the East Grillage sub-assembly SA7038A, this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC did not appear to properly preheat prior to performing a critical weld repair.
- The applicable critical weld repair report (B-CWR-2435) specifies a minimum preheat value of 200 C for material thickness greater than 40mm.
- This QA observed that a 200 C temp stick did not melt within 75mm of the Complete Joint Penetration (CJP) joint being repaired.
- The weld joint is identified as SA7038-051.
- The weld is a CJP joint, joining members identified as X3801A To X3788A (SPCM and TTP).
- Material thickness is 75 mm.
- Welding process is Shielded Metal Arc Welding (SMAW)
- The member is located in fabrication Bay 13.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

Special Provisions Section 8 3.WELDING- "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."

Approved CWR- B-CWR-2435

Who discovered the problem: Robert A. DeArmond

Name of individual from Contractor notified: Bao Quian

Time and method of notification: 2300, 12-16-2010, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 1130, 12-17-2010, Email

QC Inspector's Name: Geng Wei

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
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Reviewed By:	Wahbeh,Mazen	SMR
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DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 16-Dec-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: 05.03.06-000904

Subject: NCR No. ZPMC-0908

Reference Description: Lack of Preheat Observed on Critical Weld Repair being performed on Saddle Grillage for Lift 13EA

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 in-process observation of the fabrication of the East Grillage sub-assembly SA7038A, this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC did not appear to properly preheat prior to performing a critical weld repair.
- The applicable critical weld repair report (B-CWR-2435) specifies a minimum preheat value of 200 C for material thickness greater than 40mm.
- This QA observed that a 200 C temp stick did not melt within 75mm of the Complete Joint Penetration (CJP) joint being repaired.
- The weld joint is identified as SA7038-051.
- The weld is a CJP joint, joining members identified as X3801A To X3788A (SPCM and TTP).
- Material thickness is 75 mm.
- Welding process is Shielded Metal Arc Welding (SMAW)
- The member is located in fabrication Bay 13.

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: Ching Chao

Attachments: ZPMC-0908

cc: Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Laraine Woo, 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: 05.03.06-000904

Subject: NCR No. ZPMC-0908

Dated: 12-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000907 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

"Please see ZPMC's comments"

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000907R00;

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-0908 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 12-Jan-2011



No. B-959

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-1-11

REGARDING: NCR-000949(ZPMC-0908)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC QA personnel have talked with the CWI in responsibility to instruct the requirement to follow the repair procedure during welding. ZPMC is providing the NDT record to show the acceptability of this weld. Based on this, please consider closure of this NCR.

ATTACHMENT:

NCR-000949(ZPMC-0908)

B787-UT-18227

B787-UT-18227 R1

B787-UT-18227 R2

B787-UT-18227 R3

for [unclear]
1/11/2011



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 16-Dec-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: 05.03.06-000904

Subject: NCR No. ZPMC-0908

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- 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 in-process observation of the fabrication of the East Grillage sub-assembly SA7038A, this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC did not appear to properly preheat prior to performing a critical weld repair.
- The applicable critical weld repair report (B-CWR-2435) specifies a minimum preheat value of 200 C for material thickness greater than 40mm.
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Transmitted by: Ching Chao

Attachments: ZPMC-0908

cc: Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Laraine Woo, Bill Casey

File: 05.03.06

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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, China

Report No: NCR-000949

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Dec-2010

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

NCR #: ZPMC-0908

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

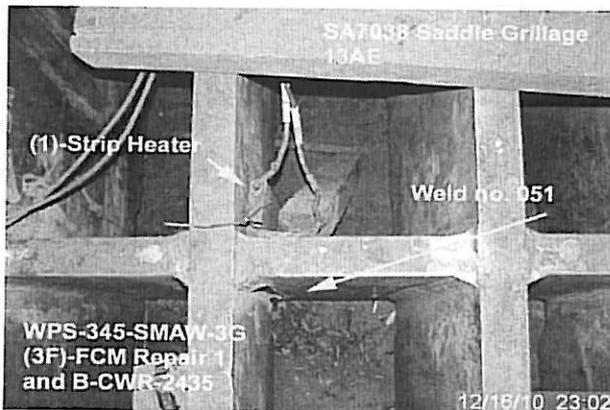
Component: Lift 13AE, SA7038A, Saddle Grillage

Reference Description: Lack of Preheat Observed on Critical Weld Repair being performed on Saddle Grillage for Lift 13EA

Description of Non-Conformance:

During the Quality Assurance in-process observation of the fabrication of the East Grillage sub-assembly SA7038A, this Quality Assurance Inspector (QA) discovered the following issue:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

Special Provisions Section 8 3.WELDING- "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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Time and method of notification: 2300, 12-16-2010, Verbal

Name of Caltrans Engineer notified: Stanley Ku

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QC Inspector's Name: Geng Wei

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
Reviewed By:	Wahbeh,Mazen	SMR



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18227 DATE 2010.11.15 PAGE 1 OF 5 Revision No: 0

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

ITEMS NAME: 13AE BED DRAWING NO.: SA7038 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 GE USM35 10526a

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709M-345T2-X 100/75mm

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	changchao	0°	2.5MHz	20mm
AMERICA	45°	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	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SA7038-029	1	70.6	A	1	52	42	10	0	30	144	51	0	470	REJ.	100%
		45.1				40								ACC.	100%
SA7038-030		70.6				42								ACC.	100%
	1	45.1	A	1	51	40	11	0	30	168	32	0	230	REJ.	100%
SA7038-031	1	70.6	b	1	50	42	8	0	20	121	43	0	780	REJ.	100%
		45.1				40								ACC.	100%
SA7038-032	1	70	A	1	51	44	8	-1	30	125	43	0	0	REJ.	100%
	2	70	B	1	47	42	7	-2	20	116	41	0	0	REJ.	100%

EXAMINED BY 主探: Bru Quanfu 2010.11.15 REVIEWED BY 审核: Li Liming 2010.11.15
 LEVEL - II SIGN / DATE LEVEL - II SIGN / DATE

质量经理 / QCM 用户CUSTOMER
 签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18227 DATE 2010.11.15 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	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
	3	70	B	1	48	42	7	-1	30	112	40	-10	200	REJ.	100%
	4	70	B	1	55	42	13	0	20	184	66	-30	510	REJ.	100%
		45				40								ACC.	100%
SA7038-035	1	70.6	B	1	48	42	6	0	20	97	35	0	120	REJ.	100%
	2	70.6	B	1	52	42	10	0	30	153	56	-3	270	REJ.	100%
	3	45.1	A	1	50	40	4	+6	30	78	55	-10	440	REJ.	100%
	4	70.6	A	1	53	42	11	0	20	167	60	-5	840	REJ.	100%
	5	70.6	A	1	52	42	10	0	50	155	55	-5	1050	REJ.	100%
		0	C			20								ACC.	100%
SA7038-036	1	45.1	A	1	45	40	4	+1	30	73	51	0	130	REJ.	100%
	2	45.1	A	1	55	48	3	+4	20	64	45	-2	650	REJ.	100%
	3	70.6	B	1	48	42	6	0	70	108	38	0	20	REJ.	100%
	4	70.6	B	1	50	42	7	+1	120	118	42	-5	220	REJ.	100%
	5	45.1	B	1	49	40	5	+4	30	81	55	-2	440	REJ.	100%
SA7038-037	1	70.6	B	1	52	42	10	0	30	145	52	-10	210	REJ.	100%
	2	45.1	B	1	47	40	3	+4	20	77	54	-2	570	REJ.	100%
	3	70.6	B	1	50	42	8	0	30	130	46	-5	930	REJ.	100%
	4	45.1	A	1	57	40	13	+4	20	187	19	-10	610	REJ.	100%
SA7038-038	1	70	B	1	47	42	5	0	10	89	31	-5	730	REJ.	100%
		45				40								ACC.	100%
		0	C			20								ACC.	100%
SA7038-043		70				42								ACC.	100%

EXAMINED BY 主探 LEVEL - II SIGN / DATE 2010.11.15	REVIEWED BY 审核 LEVEL - II SIGN / DATE 2010.11.15
质量经理 / QCM 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

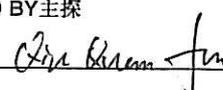


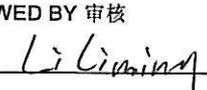
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					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
	1	45	B	1	50	40	6	+4	20	96	66	-10	80	REJ.	100%
	2	45	B	1	52	40	8	+4	20	120	65	0	330	REJ.	100%
SA7038-044	1	70	A	1	48	42	6	0	30	96	35	0	410	REJ.	100%
		45				40								ACC.	100%
SA7038-045	1	70	A	1	50	42	8	0	30	129	47	0	440	REJ.	100%
	2	45	B	1	50	40	4	+6	30	75	53	-5	10	REJ.	100%
	3	70	B	1	49	42	6	+1	20	93	34	-15	940	REJ.	100%
SA7038-046	1	45	A	1	47	40	3	+4	20	62	43	-5	430	REJ.	100%
	2	45	A	1	47	40	4	+3	20	74	52	-15	580	REJ.	100%
	3	70	A	1	47	42	5	0	20	86	31	-10	940	REJ.	100%
SA7038-049	1	70	B	1	51	42	9	0	30	137	48	-5	580	REJ.	100%
		45				40								ACC.	100%
		0	C			20								ACC.	100%
SA7038-050	1	70	B	1	48	42	6	0	30	96	33	-5	440	REJ.	100%
		45				40								ACC.	100%
SA7038-051	1	70	A	1	48	42	6	0	20	109	40	0	0	REJ.	100%
		45				40								ACC.	100%
SA7038-052		70				42								ACC.	100%
	1	45	A	1	56	40	11	+5	20	168	32	-10	330	REJ.	100%
	2	45	B	1	49	40	3	+6	20	58	40	-25	340	REJ.	100%
		0	C			20								ACC.	100%
SA7038-057	1	70	B	1	47	42	5	0	20	83	30	-10	290	REJ.	100%

EXAMINED BY 主探

 LEVEL - II SIGN / DATE 2010.11.15

REVIEWED BY 审核

 LEVEL - II SIGN / DATE 2010.11.15

质量经理 / QCM

 签字 SIGN / 日期 DATE

用户 CUSTOMER

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	2	70	A	1	48	42	6	0	20	99	36	-8	60	REJ.	100%
	3	70	A	1	48	42	6	0	20	98	36	-10	200	REJ.	100%
	4	70	A	1	48	42	6	0	30	99	36	-8	260	REJ.	100%
	5	70	A	1	47	42	5	0	20	83	30	-2	800	REJ.	100%
		45				40								ACC.	100%
SA7038-058		70.6				42								ACC.	100%
	1	45.1	B	1	52	42	4	+6	30	80	56	-5	330	REJ.	100%
	2	45.1	A	1	44	40	3	+1	40	58	41	-10	380	REJ.	100%
SA7038-059	1	45.1	B	1	55	40	12	+3	50	170	31	0	570	REJ.	100%
	2	70.6	A	1	49	42	7	0	30	110	40	-7	360	REJ.	100%
	3	70.6	A	1	47	42	5	0	35	84	31	0	640	REJ.	100%
SA7038-060	1	45.1	A	1	50	40	4	+6	30	75	52	-10	540	REJ.	100%
	2	45.1	B	1	51	40	5	+6	30	85	65	-20	220	REJ.	100%
SA7038-063	1	70	A	1	52	42	10	0	30	145	53	0	450	REJ.	100%
		0	C			20								ACC.	100%
SA7038-064	1	70.6	B	1	48	42	6	0	200	106	39	0	10	REJ.	100%
	2	45.1	A	1	48	40	5	+3	30	57	40	-17	0	REJ.	100%
SA7038-065	1	45.1	B	1	45	40	1	+4	30	41	29	-10	0	REJ.	100%
	2	45.1	B	1	47	40	2	+5	100	47	38	-15	60	REJ.	100%
	3	70.6	A	1	48	42	8	-2	230	125	46	-10	0	REJ.	100%
	4	70.6	A	1	47	42	5	0	50	90	33	-5	630	REJ.	100%
SA7038-066	1	70.6	B	1	45	38	6	+1	35	94	33	-20	380	REJ.	100%

EXAMINED BY 主探

 LEVEL - II SIGN / DATE 2010.11.15

REVIEWED BY 审核

 LEVEL - II SIGN / DATE 2010.11.15

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-18227 DATE 2010.11.15 PAGE 5 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		
	2	45.1	B	1	48	40	2	+6	40	55	40	-10	680	REJ.	100%
	3	70.6	A	1	49	42	6	+1	30	100	36	-5	140	REJ.	100%
	4	70.6	A	1	49	42	6	+1	35	100	36	-5	310	REJ.	100%
	5	70.6	A	1	49	42	6	+1	30	100	36	-5	650	REJ.	100%
		0	C			20								ACC.	100%

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EXAMINED BY 主探

 LEVEL - II SIGN / DATE 2010.11.15

REVIEWED BY 审核

 LEVEL - II SIGN / DATE 2010.11.15

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-18227R1 DATE 2010.11.25 PAGE 1 OF 5 Revision No: 0

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

ITEMS NAME: 部件名称 13AE BED	DRAWING NO.: 图号 SA7038	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
------------------------------	---------------------------	--

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
--	--	----------------------------------

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

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 GE	MODEL NO. 样式编号 USM35	SERIAL NO. 序列编号 10526a
--------------------------	------------------------	-------------------------	---------------------------

CALIBRATION BLOCK 试块 AWS IIV BLOCK TYPE II	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345T2-X 100/75mm
---	-----------------------	--

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	changchao	0°	2.5MHz	20mm
AMERICA	45°	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 a	Reference Level b	Attenuation Factor c	Indication Rating d	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y			
SA7038-029	1R1	70				42									ACC.	100%
	2R1	45	B	1	42	36	4	+2	40	74	52	0	260		REJ.	100%
	3R1	45	B	2	52	36	13	+3	20	178	24	-10	310		REJ.	100%
SA7038-030		70				42									ACC.	100%
	1R1	45	A	1	56	46	5	+5	35	80	57	-30	0		REJ.	100%
	2R1	45	B	1	48	42	2	+4	20	54	38	-10	470		REJ.	100%
SA7038-031	1R1	70				42									ACC.	100%
		45				40									ACC.	100%

EXAMINED BY 主探 <i>Hui Renfan</i> 2010.11.25 LEVEL - II SIGN / DATE	REVIEWED BY 审核 <i>Li Liming</i> 2010.11.25 LEVEL - II SIGN / DATE
--	---

质量经理 / QCM _____ 签字 SIGN / 日期 DATE	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-18227R1 DATE 2010.11.25 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	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SA7038-032	1R1	45	A	1	48	36	6	+6	20	104	71	-30	510	REJ.	100%
	2R1	45	A	1	48	36	7	+5	20	114	70	0	580	REJ.	100%
	3R1	70	A	1	47	40	8	-1	20	120	38	0	1030	REJ.	100%
	4R1	70	B	1	47	40	7	0	20	116	37	0	0	REJ.	100%
	5R1	70	B	1	50	40	11	-1	30	160	50	0	510	ACC.	100%
SA7038-035	1R1	70				40								ACC.	100%
	2R1	70				40								ACC.	100%
	3R1	45	B	1	45	36	5	+4	20	82	58	-10	53	REJ.	100%
	4R1	70				40								ACC.	100%
	5R1	70				40								ACC.	100%
		0	C			20								ACC.	100%
SA7038-036	1R1	45				40								ACC.	100%
	2R1	45				48								ACC.	100%
	3R1	70				42								ACC.	100%
	4R1	70				42								ACC.	100%
	5R1	45				40								ACC.	100%
SA7038-037	1R1	45	A	2	53	36	11	+6	30	159	40	-5	140	REJ.	100%
	2R1	45	A	2	52	36	12	+4	35	182	22	-5	610	REJ.	100%
	3R1	45	A	2	46	36	10	0	40	159	28	-10	700	REJ.	100%
	4R1	45	B	1	45	36	4	+5	20	77	54	-2	570	REJ.	100%
	5R1	70				40								ACC.	100%
SA7038-038	1R1	70				42								ACC.	100%

EXAMINED BY 主探

 LEVEL - II SIGN / DATE

REVIEWED BY 审核

 LEVEL - II SIGN / DATE

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-18227

DATE 2010.11.15

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		
	2R1	45	B	1	45	36	8	+1	20	66	46	-5	390	REJ.	100%
		0	C			20								ACC.	100%
SA7038-043		70				42								ACC.	100%
	1R1	45				40								ACC.	100%
	2R1	45				40								ACC.	100%
		0	C			20								ACC.	100%
SA7038-044	1R1	70	A	1	46	40	6	0	30	96	35	0	410	REJ.	100%
	2R1	45	B	2	48	36	7	+5	20	116	68	-28	60	REJ.	100%
SA7038-045	1R1	45	A	1	46	36	6	+4	40	102	72	-30	470	REJ.	100%
	2R1	45	A	1	44	36	5	+3	20	85	60	-20	670	REJ.	100%
	3R1	45	A	1	47	36	7	+4	30	117	38	-30	790	REJ.	100%
		70				40								ACC.	100%
SA7038-046	1R1	45	A	1	42	36	6	0	30	103	71	-30	420	REJ.	100%
	2R1	45	A	1	46	36	6	+4	20	105	73	-30	480	REJ.	100%
	3R1	45	A	1	42	36	3	+3	20	65	45	-10	850	REJ.	100%
	4R1	45	B	2	44	36	6	+2	20	83	60	0	880	REJ.	100%
		70				40								ACC.	100%
SA7038-049	1R1	70				42								ACC.	100%
	2R1	45	A	1	45	36	5	+4	20	76	53	-10	970	REJ.	100%
SA7038-050	1R1	70				42								ACC.	100%
		45				40								ACC.	100%
		0	C			20								ACC.	100%

 EXAMINED BY主探
Qiu Ruijun 2010.11.25
 LEVEL - II SIGN / DATE

 REVIEWED BY审核
Li Liming 2010.11.25
 LEVEL - II SIGN / DATE

 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-18227R1 DATE 2010.11.25 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		
SA7038-051	1R1	70	A	1	48	40	7	+1	35	107	35	-25	420	REJ.	100%
	2R1	45	A	1	38	36	2	0	40	70	49	0	310	REJ.	100%
SA7038-052	1R1	45	B	1	43	36	5	+2	20	87	60	-10	250	REJ.	100%
	2R1	70	B	1	44	40	5	-1	30	86	38	-18	300	REJ.	100%
	3R1	45	B	1	45	36	6	+3	35	102	72	-30	710	REJ.	100%
		0	C			20								ACC.	100%
SA7038-057	1R1	70	A	1	44	40	6	-2	40	81	26	-10	200	REJ.	100%
	2R1	70	A	1	48	40	9	-1	25	130	41	-10	440	REJ.	100%
	3R1	45	B	1	41	36	2	+3	40	51	35	-20	430	REJ.	100%
	4R1	45	B	1	44	36	6	+2	40	95	65	-15	520	REJ.	100%
	5R1	70				42								ACC.	100%
		45				40								ACC.	100%
SA7038-058		70				42								ACC.	100%
	1R1	45	A	1	44	36	2	+6	25	52	42	-20	380	REJ.	100%
	2R1	45	B	2	49	36	12	+1	30	170	30	-15	360	REJ.	100%
SA7038-059	1R1	45	B	2	50	36	8	+6	25	120	25	-10	330	REJ.	100%
	2R1	70	A	1	51	40	11	0	30	165	35	-30	740	REJ.	100%
	3R1	70				40								ACC.	100%
SA7038-060	1R1	45				36								ACC.	100%
	2R1	45				36								ACC.	100%
		70				40								ACC.	100%
SA7038-063	1R1	70	A	1	56	40	11	+5	36	168	36	-10	0	REJ.	100%

EXAMINED BY主探
Qin Quan fan 2010.11.25

LEVEL - II SIGN / DATE

质量经理 / QCM

签字 SIGN / 日期 DATE

REVIEWED BY 审核
L. Liming 2010.11.25

LEVEL - II SIGN / DATE

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签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18227R1 DATE 2010.11.25 PAGE 5 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			
		45				36									ACC.	100%
SA7038-064	1R1	70				42									ACC.	100%
	2R1	45	A	1	46	36	5	+5	40	86	61	-10	580	REJ.	100%	
SA7038-065	1R1	45				40								ACC.	100%	
	2R1	45				40								ACC.	100%	
	3R1	70				42								ACC.	100%	
	4R1	70				42								ACC.	100%	
SA7038-066	1R1	70	A	1	49	40	8	+1	30	131	42	-5	620	REJ.	100%	
	2R1	45	A	1	46	36	4	+6	20	71	52	-15	370	REJ.	100%	
	3R1	45	B	1	45	36	4	+5	20	76	53	-10	580	REJ.	100%	
	4R1	70				40								ACC.	100%	
	5R1	70				40								ACC.	100%	
		0	C			20								ACC.	100%	

AFTER 17101, 17112~17119, 17121~17123, 17149~17151, 17278~17286

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EXAMINED BY 主探 LEVEL - II SIGN / DATE 2010.11.25	REVIEWED BY 审核 LEVEL - II SIGN / DATE 2010.11.25
质量经理 / QCM _____ 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE

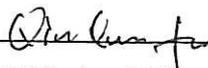


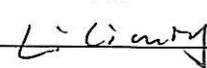
REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18227R2 DATE 2010.12.10 PAGE 2 OF 4 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			
	2R2	45				36									ACC.	100%
		70				40									ACC.	100%
	3R2	70				40									ACC.	100%
		45				36									ACC.	100%
	4R2	70				40									ACC.	100%
		45				36									ACC.	100%
	5R2	70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-035	1R2	70	A	1	51	40	10	+1	40	145	50	0	850	REJ.	100%	
		45				36									ACC.	100%
	2R2	70				40									ACC.	100%
		45				36									ACC.	100%
	3R2	45				36									ACC.	100%
		70				40									ACC.	100%
	4R2	70				40									ACC.	100%
		45				36									ACC.	100%
	5R2	70				40									ACC.	100%
		45				36									ACC.	100%
		0	C			20									ACC.	100%
SA7038-037		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-038		70				40									ACC.	100%

EXAMINED BY主探

 LEVEL - II SIGN / DATE 2010.12.10

REVIEWED BY审核

 LEVEL - II SIGN / DATE 2010.12.10

质量经理 / QCM

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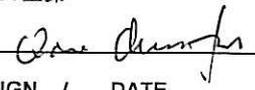


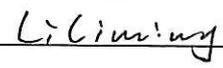
REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18227R2 DATE 2010.12.10 PAGE 3 OF 4 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			
		45				36									ACC.	100%
SA7038-044		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-045		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-046		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-049		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-051	1R2	45	A	1	42	36	3	+3	50	62	44	-10	380	REJ.	100%	
		70				40									ACC.	100%
	2R2	45	A	1	46	36	3	+7	60	62	44	-20	640	REJ.	100%	
		70				40									ACC.	100%
SA7038-052		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-057		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-058		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-059		70				40									ACC.	100%
		45				36									ACC.	100%
SA7038-063		70				40									ACC.	100%

EXAMINED BY主探

 LEVEL - II SIGN / DATE 2010.12.10

REVIEWED BY审核

 LEVEL - II SIGN / DATE 2010.12.10

质量经理 / QCM

 签字 SIGN / 日期 DATE

用户CUSTOMER

 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

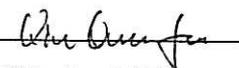
UT探伤报告

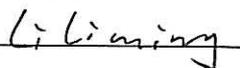
REPORT NO. 报告编号 B787-UT-18227R2 DATE 2010.12.10 PAGE 4 OF 4 Revision No: 0

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		
		45				36								ACC.	100%
SA7038-064		70				40								ACC.	100%
		45				36								ACC.	100%
SA7038-066	1R2	70				40								ACC.	100%
		45				36								ACC.	100%
	2R2	45	B	1	47	36	5	+6	50	85	60	-10	140	REJ.	100%
		70				40								ACC.	100%
	3R2	45	B	1	43	36	3	+4	30	60	86	-10	390	REJ.	100%
		70				40								ACC.	100%
		0	C			20								ACC.	100%

AFTER B-WR17818, 17824~17829, 17831~17841

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EXAMINED BY主探
 2010.12.10
 LEVEL - II SIGN / DATE

REVIEWED BY 审核
 2010.12.10
 LEVEL - II SIGN / DATE

质量经理 / QCM

 签字 SIGN / 日期 DATE

用户CUSTOMER

 签字 SIGN / 日期 DATE

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

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
