

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China**Report No:** NCR-000987**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Mar-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0945**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 12 Bikepath Cantilever Beam
Procedural	Procedural	Description: QA found an UT indication	

Reference Description: QA found an UT indication after ZPMC had tested and accepted the weld in the Bikepath Cantilever Beam at PP113 (Lift 12)

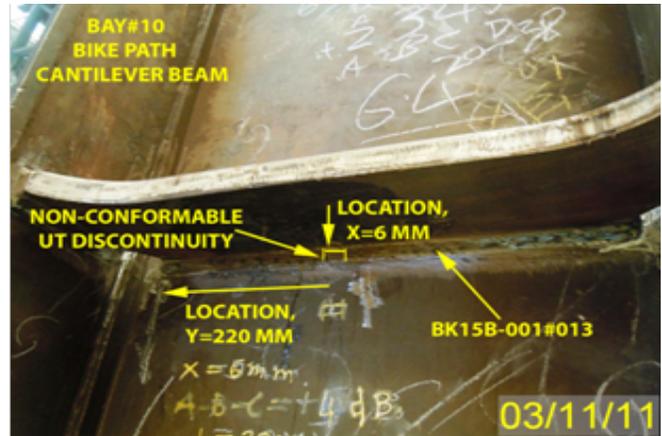
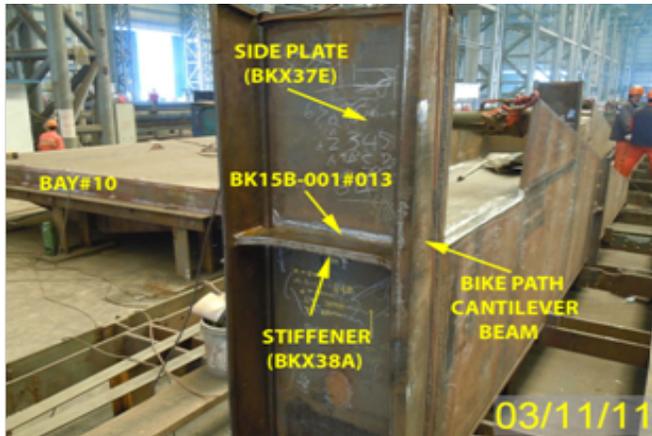
Description of Non-Conformance:

During the Ultrasonic Testing (UT) of bike path cantilever beam, this Quality Assurance Inspector discovered the following issue:

- One (1) Class "A" non conforming longitudinal indication in a weld.
- UT discontinuity rating was +4 db; Class "A" non-conformable indication.
- Depth of the discontinuity from face "B" is approximately 25 mm.
- Length of the discontinuity is approximately 25 mm in length.
- Y location is approximately 220 mm from left side of the joint.
- Weld is a double groove, complete joint penetration (CJP) T- joint, joining the side plate (BKX37E) to the stiffener (BKX38A).
- The weld is identified as BK15B-001-013.
- Scanning was performed from face "A" and "B" to cover the full volumetric scan of the weld.
- The material thickness is 32 mm.
- Component located at fabrication Bay#10.
- The Notice of Witness Inspection Number (NWIT) is 08509. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel performed 100% UT inspection of this weld.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

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

AWS D1.5 Section 6.26.3.1: "Welds that are subject to UT in addition to visual inspection shall be acceptable if they meet the following requirements:...(1) Welds subject to tensile stress under any condition of loading shall conform to the requirements of Table 6.3.

AWS D1.5-02 Table 6.2: "General Note 5: On tension welds on bridges, the top quarter of thickness shall be tested with the final leg of sound progressing from Face B towards Face A, the bottom quarter of thickness shall be tested with the final leg of sound progressing from Face A towards Face B; ie., the top quarter of thickness shall be tested either from Face A in Leg II or from Face B in Leg I".

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Yang Yi Heng

Time and method of notification: 1100 hours, 03/11/11, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1500 hours, 3/11/11, Verbal

QC Inspector's Name: Sun Zi Wang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

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

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



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: 14-Mar-2011

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0945

Job Name: SAS Superstructure
Document No: 05.03.06-000944

Reference Description: QA found an UT indication after ZPMC had tested and accepted the weld in the Bikepath Cantilever Beam at PP113 (Lift 12)

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

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

Material Location: Bike Path **Lift:** 12

Remarks:

During the Ultrasonic Testing (UT) of bike path cantilever beam, this Quality Assurance Inspector discovered the following issue:

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Action Required and/or Action Taken:

Propose a resolution for this non-conformance and provide documentation that the deficiency has been brought into compliance with the contract requirements. Propose a resolution that addresses the apparent failure of Quality Control to identify the indication. Additionally, provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

Transmitted by: Sean Eagen Transportation Engineer

NCT

(Continued Page 2 of 2)

Attachments: ZPMC-0945

cc: 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: 05.03.06-000944

Subject: NCR No. ZPMC-0945

Dated: 01-Apr-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000943 Rev: 00

Contractor's Proposed Resolution:

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

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

ABFJV has noted which inspector was responsible for this missed indication and is monitoring his performance, if he continues to miss indications disciplinary action will be undertaken. Based on these actions, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000943R00;

Caltrans' comments:

Status: CLO

Date: 03-Apr-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0945 is closed.

Submitted by: Eagen, Sean

Date: 03-Apr-2011

Attachment(s):



TRANSMITTAL LETTER

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

DATE:2011-04-01

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: OBG NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

(01) LR: No. B-987

(02) NCR-000987(ZPMC-0945)

B-WR20551 R0

B787-UT-20833 R1

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

Rosemary

DATE: 16:10

RECEIVED 01 APR 2011

COMPANY:



PHONE NO.

PLAN NUMBER:N/A

#R787-QCP-102



No. B-987

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-04-01

REGARDING: NCR-000987(ZPMC-0945)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC has repaired the indications noted in the NCR and is providing WR & NDT documentation after the repair to show the indication has been removed. Based on these actions, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-000987(ZPMC-0945)

B-WR20551 R0

B787-UT-20833 R1

Sheng Wei
4/1/11



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666 Feng Bin Road Room 708, Changxing Island
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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000987

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 11-Mar-2011

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

NCR #: ZPMC-0945

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Lift 12 Bikepath Cantilever Beam
 Procedural Procedural Description: QA found an UT indication

Reference Description: QA found an UT indication after ZPMC had tested and accepted the weld in the Bikepath Cantilever Beam at PP113 (Lift 12)

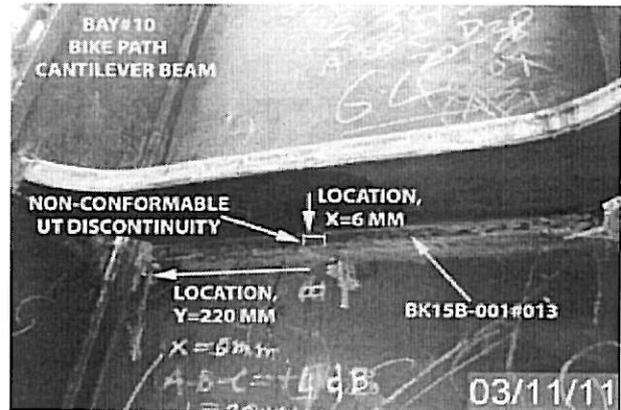
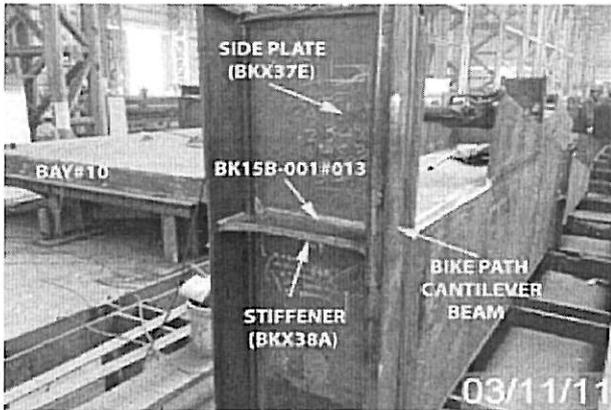
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Who discovered the problem: Naddi Sandeep Kumar
Name of individual from Contractor notified: Yang Yi Heng
Time and method of notification: 1100 hours, 03/11/11, Verbal
Name of Caltrans Engineer notified: Sean Eagen
Time and method of notification: 1500 hours, 3/11/11, Verbal
QC Inspector's Name: Sun Zi Wang
Was QC Inspector aware of the problem: Yes No
Contractor's proposal to correct the problem:

Comments:

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



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	BK15B	报告编号 Report No.	B-WR20551
合同号 Contract No.	04-0120F4	部件名称 Items Name	SUPPORT BEAM	NDT报告编号 Report No. of NDT	B787-UT-20833
项目编号 Project No.	ZP06-787				

焊缝缺陷描述：(普通UT探伤发现的缺陷长度小于最大允许长度)

(Description of welding discontinuity): Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

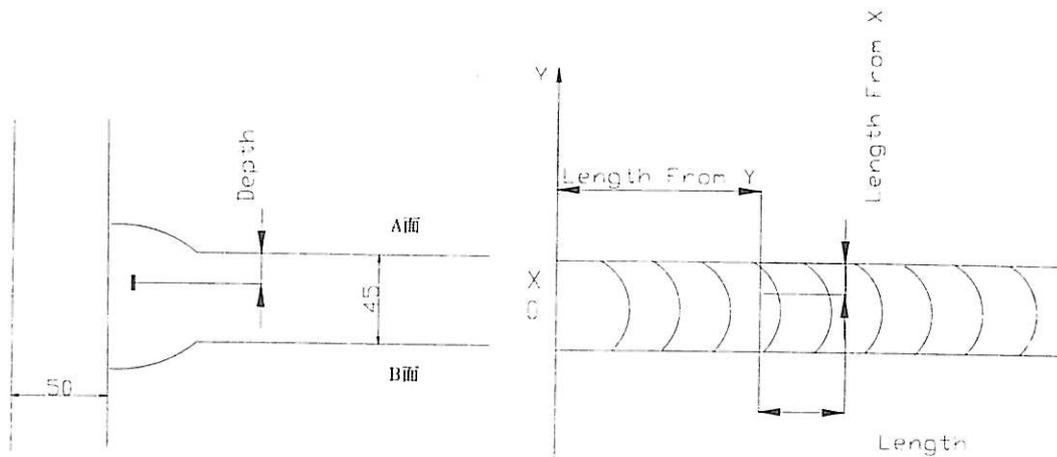
焊缝编号为： BK15B-001-013

检验员 (Inspector) : *Xu Ronggang*

(Date) : 2011.03.30

焊缝返修位置示意图：

Draft of welding discontinuity:



Please see the detail data from UT report!

产生原因:

Caused:

1. 焊道未及时处理干净。
1. Did not clear the weld pass completely in time.

车间负责人(Foreman): *Li Zhijiang* 日期(Date):

处理意见

Disposition :

1. 从缺陷距离端面较近一侧 ($D \leq 0.65T$, D为缺陷深度, T为板厚) 采用碳刨或打磨的方法去除焊缝缺陷;
2. 参照返修焊接工艺规程(WPS)准备正确的接头型式, 预热和焊接;
3. 将修补区域打磨到与母材或邻近焊缝平齐;
4. 根据批准的车间图纸检查焊缝.

1. Gouge or grind from nearer side from metal edge ($D \leq 0.65T$, "D" is depth of defects, "T" is thickness of metal) to remove all defects;
2. Follow repair WPS for joint preparation, preheat, and weld deposit;
3. Grind the repaired area flush with base metal or the adjacent weld;
4. Check the welds according to the working drawings.

工艺: *Niu Tiefeng*
Technical engineer

审核: *W. Jianhua*
Approved by

日期 *2016.03.03*
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	BK15B	报告编号 Report No.	B-WR20551
合同号 Contract No.:	04-0120F4	部件名称 Items Name	SUPPORT BEAM	NDT报告编号 Report No.of NDT	B787-UT-20833
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

1. 加强焊接监控和道间清理。

1. Improve monitoring of welding and interpass cleaning.

车间负责人(Foreman): *Li Zhi Gang* 日期(Date): 11.03.30

参照的WPS编号 Repair WPS No.	<input checked="" 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 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 <input type="checkbox"/> WPS-345-FCAW-3G(3F)-Repair	工艺员 technologist	<i>Niu Jie Feng</i>
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返修(碳刨)前预热温度 Preheat temperature before gouging	65	返修的缺陷 Description of discontinuity	夹渣
焊前处理检查 Inspection before welding	打磨光滑	焊前预热温度 Preheat temperature before welding	110
最大碳刨深度 Max. depth of gouging	26	碳刨总长 Total length of gouging	120

焊工 welder	焊接类型 welding type	焊接位置 position
040365	SMAW	1G
焊接电流 Current	焊接电压 Voltage	焊接速度 Speed
165	25.7	110

返修后检查
Inspection After repairing:

外观检查 VT result	检验员 Inspector	日期 Date
<i>V/A</i>	<i>Xu Le Feng</i>	11.3.30
NDT复检 NDT result	探伤员 NDT person	日期 Date
<i>u710</i>	<i>Lu Peng</i>	11-3-31

见证:
Witness/Review:备注:
Remark:



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-20833R1 DATE 2011.03.31 PAGE 1 OF 1 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

ITEMS NAME: SUPPORT BEAM DRAWING NO.: BK15B CONTRACTOR: CALTRANS
 部件名称 图号 加州工程编号

CALTRANS CONTRACT NO.: 04-0120F4

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-JONT CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST, 2011

EQUIPMENT 设备 MANUFACTURER 制造商 HANWEI MODEL NO. 样式编号 H610e SERIAL NO. 序列编号 61e1684

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 45/50mm

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	0.75x0.625 in				
Base metal inspected per AWS D1.5-2002 Section 6.19.5 Reference Level 参考灵敏度 20dB							

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
BK15B-001-013	1R1	70																	

AFTER B-WR20551

BLANK

EXAMINED BY 主探 Xu Ronggang
 LEVEL - II SIGN DATE 2011.03.31
 质量经理 / QCM [Signature]
 签字 SIGN / 日期 DATE

REVIEWED BY 审核 Dai Gangsheng
 LEVEL - II SIGN DATE 2011.3.31
 用户 CUSTOMER
 签字 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000958**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Apr-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0945**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: 11-Mar-2011**Description of Non-Conformance:**

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Contractor's proposal to correct the problem:

Contractor will repair the weld, and provide the NDT report to prove the weld is acceptable. Contractor will identify and monitor the inspector responsible. If the inspector continues miss indications, disciplinary action will be taken.

Corrective action taken:

Contractor repaired the weld. NDT report was provided showing the weld is acceptable. ZPMC identified the inspector and issued internal NCR. The inspector's performance is being monitored.

Did corrective action require Engineer's approval?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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