

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-000988

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 12-Mar-2011

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

NCR #: ZPMC-0946

Type of problem:

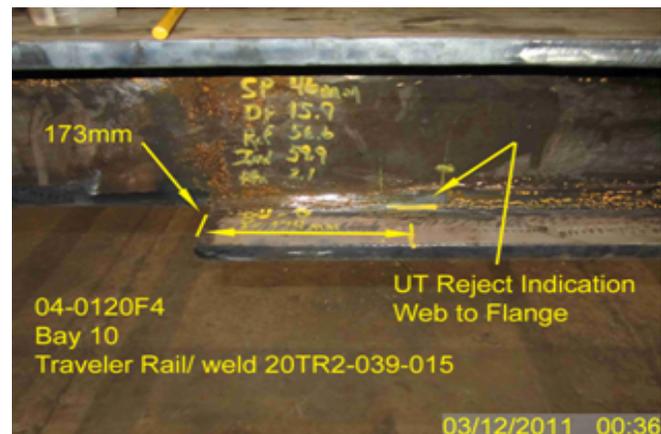
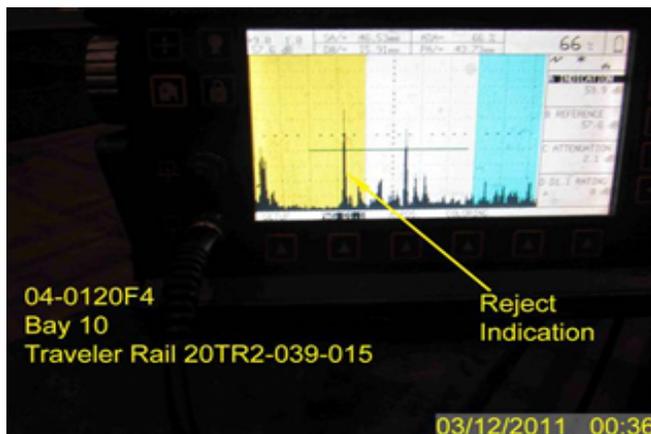
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Traveler Rail 20TR2-039
Procedural	Procedural	Description: QA found an UT indication	

Reference Description: QA found an UT indication after ZPMC had tested and accepted the weld at Traveler Rail 20TR2-039

Description of Non-Conformance:

During the Quality Assurance (QA) Ultrasonic Testing (UT) verification of weld located on traveler rail 20TR2-039-015, this QA Inspector discovered the following issue:

- One (1) Class "A" indication measuring approximately 25mm in length.
- The Indication rating is +0dB.
- The thickness of the plate is 20mm and depth of the indication approximately 15.9mm.
- The indication is located on the weld joint identified as 20TR2-039-015.
- The "Y" location for this indication is approximately 173mm from weld termination point.
- The weld is a Complete Joint Penetration (CJP) T-Joint joining web to flange
- The indication is clearly marked by QA on/near the weld.
- Traveler Rail is located inside bay 10.
- The Notice of Witness Inspection Number (NWIT) is 08518. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5-2002, Section 6, Table 6.3. Specifies a class A indication as having a dB rating of +10 and lower for weld thicknesses 8mm through 20mm.

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."

Who discovered the problem: Mike Hasler

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 07:00_3/12/11_Email

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 19:00_3/12/11_Email

QC Inspector's Name: Zhu Feng

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-0946

Job Name: SAS Superstructure
Document No: 05.03.06-000945

Reference Description: QA found an UT indication after ZPMC had tested and accepted the weld at Traveler Rail 20TR2-039

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:** N/A

Remarks:

- During the Quality Assurance (QA) Ultrasonic Testing (UT) verification of weld located on traveler rail 20TR2-039-015, this QA Inspector discovered the following issue:
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 - The Indication rating is +0dB.
 - The thickness of the plate is 20mm and depth of the indication approximately 15.9mm.
 - The indication is located on the weld joint identified as 20TR2-039-015.
 - The "Y" location for this indication is approximately 173mm from weld termination point.
 - The weld is a Complete Joint Penetration (CJP) T-Joint joining web to flange
 - The indication is clearly marked by QA on/near the weld.
 - Traveler Rail is located inside bay 10.
 - The Notice of Witness Inspection Number (NWIT) is 08518. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of this weld.

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-0946

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: 05.03.06-000945

Subject: NCR No. ZPMC-0946

Dated: 01-Apr-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000944 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-000944R00;

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-0946 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 03-Apr-2011



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-988

(02) NCR-000988(ZPMC-0946)

NCR-000989(ZPMC-0947)

B-WR20550 R0

B787-UT-20834

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-988

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-04-01

REGARDING: NCR-000988(ZPMC-0946) & NCR-000989(ZPMC-0947)

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

ATTACHMENT:

NCR-000988(ZPMC-0946)

NCR-000989(ZPMC-0947)

B-WR20550 R0

B787-UT-20834

Zhang Wei.

4/1/11



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
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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
Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Document No: 05.03.06-000945

Subject: NCR No. ZPMC-0946

Reference Description: QA found an UT indication after ZPMC had tested and accepted the weld at Traveler Rail 20TR2-039

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

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- Non-Conformance Resolved.

Material Location: OBG

Lift: N/A

Remarks:

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(Continued Page 2 of 2)

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cc: Peter Siegenthaler, Stanley Ku, Brian Boal, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

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 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Report No: NCR-000988

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 12-Mar-2011

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

NCR #: ZPMC-0946

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

Joint fit-up Coating Other Component: Traveler Rail 20TR2-039

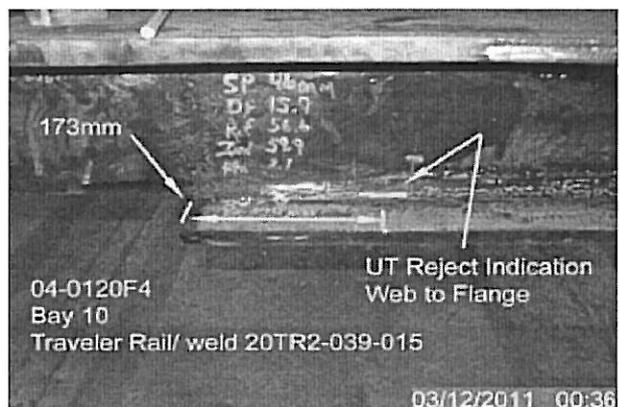
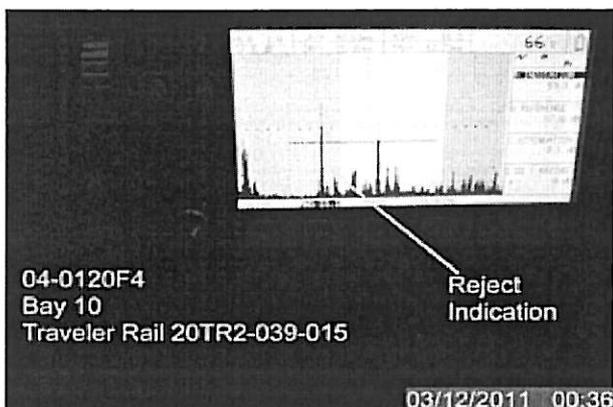
Procedural Procedural Description: QA found an UT indication

Reference Description: QA found an UT indication after ZPMC had tested and accepted the weld at Traveler Rail 20TR2-039

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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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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Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 07:00_3/12/11_Email

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 19:00_3/12/11_Email

QC Inspector's Name: Zhu Feng

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

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	20TR2-030,039	报告编号 Report No.	B-WR20550
合同号 Contract No.	04-0120F4	部件名称 Items Name	OBG traveler rail	NDT报告编号 Report No.of NDT	B787-UT-20834
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.

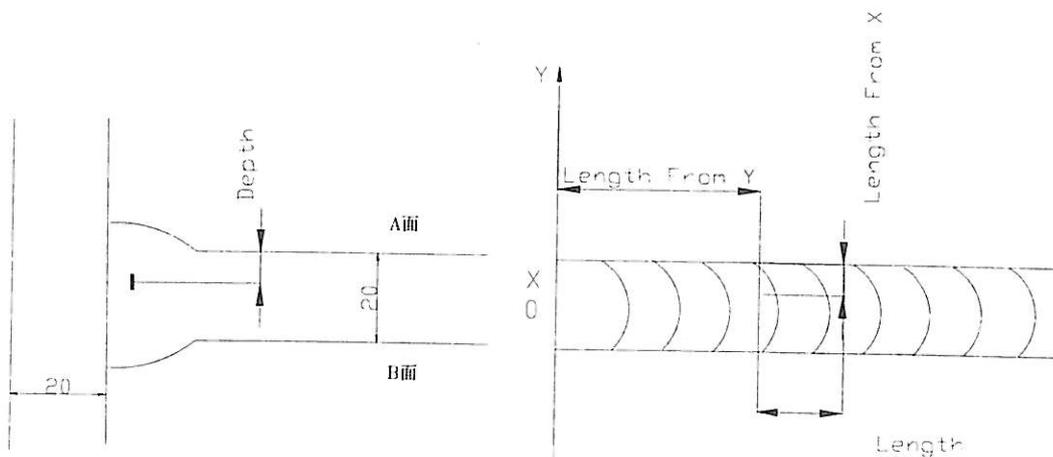
焊缝编号为： 20TR2-030-015,20TR2-039-015

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 Chigang* 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 Tie Feng*
Technical engineer

审核: *Wu Jianhua*
Approved by

日期 *2011.03.10*
Date



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	20TR2-030,039	报告编号 Report No.	B-WR20550
合同号 Contract No.:	04-0120F4	部件名称 Items Name	OBG traveler rail	NDT报告编号 Report No. of NDT	B787-UT-20834
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) Linhuo 日期(Date): 2011.03.30

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 checked="" 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	<u>Mr. Jeffrey</u>
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返修(碳刨)前预热温度 Preheat temperature before gouging	<u>NA</u>	返修的缺陷 Description of discontinuity	<u>slag.</u>
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焊前处理检查 Inspection before welding	<u>VT</u>	焊前预热温度 Preheat temperature before welding	<u>110°C</u>
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最大碳刨深度 Max. depth of gouging	<u>10</u>	碳刨总长 Total length of gouging	<u>230 mm</u>
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焊工 welder <u>052930, 044511, 057258</u>	焊接类型 welding type <u>SMAW</u>	焊接位置 position <u>2G</u>
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焊接电流 Current <u>220A</u>	焊接电压 Voltage <u>28.0V</u>	焊接速度 Speed <u>136 mm/min</u>
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**返修后检查
Inspection After repairing:**

外观检查 VT result <u>VT</u>	检验员 Inspector <u>Xuleifeng</u>	日期 Date <u>2011.3.30</u>
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NDT复检 NDT result <u>WTA</u>	探伤员 NDT person <u>Xuleifeng</u>	日期 Date <u>2011.3.31</u>
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见证:

Witness/Review:

备注:

Remark:



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-20834 DATE 2011.03.31 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: OBG traveler rail DRAWING NO.: 20TR2-030,039 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 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-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 IIW BLOCK TYPE II COUPLANT 耦合剂 C.M.C MATERIAL/THICKNESS 材料厚度 A709M-345T2-X 20mm

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		
20TR2-030-015	1R1	70				38								ACC.	100%
20TR2-039-015	1R1	70				38								ACC.	100%

AFTER B-WR20550

BLANK

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EXAMINED BY 主探 Xu Ronggang REVIEWED BY 审核 Dai Gensheng
 LEVEL - II SIGN DATE 2011.03.31 LEVEL - II SIGN DATE 2011.03.31

质量经理 / QCM 用户 CUSTOMER
 签字 SIGN / 日期 DATE 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-000959**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Apr-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0946**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: 12-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 missing indications, disciplinary action will be taken.

Corrective action taken:

Contractor repaired the weld. NDT report was provided which shows the weld is acceptable. ZPMC issued internal NCR and the inspector performance is being monitored.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?**

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
