

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, PRC**Report No:** NCR-000218**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Nov-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0194**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006 L/R
Joint fit-up	Coating	Other	Component: DP-326-002 and DP-461-001
Procedural	Procedural	Description:	OBG deck panels

Reference Description: QC-MT technicians accepted non-conforming linear indications along weld toes.**Description of Non-Conformance:**

The contractors Quality Control (QC) Magnetic particle Testing (MT) technicians have accepted nonconforming linear indications along the weld toes on the following welds DP-326-002 weld 065, DP-461-001 welds 040, 037 and 019. These welds join the floor beam diaphragm to the deck panel closed ribs. See attached photo.

**Applicable reference:**

Special Provisions Section 8-3.01 Welding General, "Groove weld surface profiles that interfere with the performance of the NDT procedure or produce questionable test results shall be ground smooth and blended with the adjacent material. Fillet weld surface profiles that interfere with the performance of the NDT procedure or produce questionable test results shall be ground to blend the toes smoothly with adjacent base metal.

Questionable test results are defined as test results containing relevant or non-relevant indications or results from a situation where a defect may have been masked by the weld profile."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

AWS D1.5 2002 sections 6.26.2, "Welds that are subject to RT and MT in addition to visual inspection shall have no cracks and shall be unacceptable if the RT or MT shows any types of discontinuities described in 6.26.2.1..." 6.26.2.1 and figure 6.8

Who discovered the problem: Caltrans QA Steve Hall

Name of individual from Contractor notified: Mr. Man-Kit Li

Time and method of notification: 11/11/08 / 19:30 / Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: Verbal 19-Nov-08

QC Inspector's Name: Mr. Testino 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 Peter Dautermann, +(86) 1.500.219.9593, who represents the Office of Structural Materials for your project.

Inspected By:	Dautermann,Peter	SMR
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Reviewed By:	Dautermann,Peter	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: 04-Dec-2008

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000187

Subject: NCR No. ZPMC-0194

Reference Description: QC-MT technicians accepted non-conforming linear indications along weld toes.

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:**

Remarks:

The contractors Quality Control (QC) Magnetic particle Testing (MT) technicians have accepted nonconforming linear indications along the weld toes on the following welds DP-326-002 weld 065, DP-461-001 welds 040, 037 and 019. These welds join the floor beam diaphragm to the deck panel closed ribs.

Action Required and/or Action Taken:

Please propose a resolution for MT technicians accepting nonconforming linear indications and provide documentations for repairing linear indications.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0194

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom

File: 05.03.06

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000187

Subject: NCR No. ZPMC-0194

Dated: 18-Dec-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000190 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will submit training documentation as objective evidence to close this NCR

ZPMC NDT department has been notified of the missed indication. ABF has requested an MT training session be conducted as a preventative action measure. ZPMC will submit training documentation as objective evidence to close this NCR

Submitted by:

Attachment(s): ABF-NPR-000190R00

Caltrans' comments:

Status: AAP

Date: 22-Dec-2008

The response is acceptable, but the Non-Conformance is not closed.

Please provide the above mentioned training documentation. Also, please provide documentation of the weld repairs that were performed and that the repairs were acceptable.

The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0194 at that time.

Submitted by: Wright, Doug

Date: 23-Dec-2008

Attachment(s):

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000187

Subject: NCR No. ZPMC-0194

Dated: 23-Feb-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000190 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is requesting closure of ZPMC NCR- 0194

ZPMC has conducted training of MT personnel and attached all documentation of objective and evidence for closure of this NCR. See attachment.

Submitted by:

Attachment(s): ABF-NPR-000190R01;

Caltrans' comments:

Status: AAP

Date: 19-Mar-2009

The response is acceptable, but the Non-Conformance is not closed. This NCR included missed MT indications on 4 welds: DP-326-002-065, DP-461-001-019, DP-461-001-037, and DP-461-001-040.

The attached documentation does not include acceptable MT reports for welds DP-461-001-019 and DP-461-001-037. Please provide MT reports for these welds. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0194 at that time.

Submitted by: Wright, Doug

Date: 19-Mar-2009

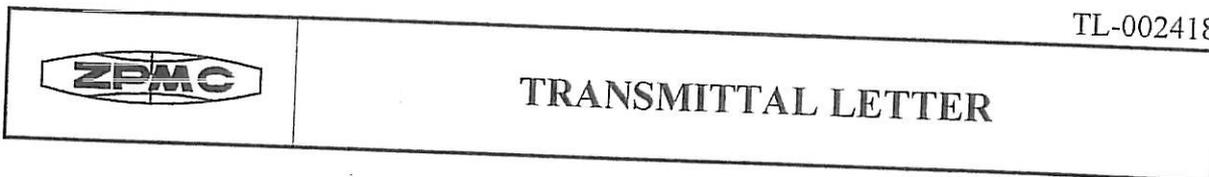
Attachment(s):

NCR FOR PMW

ZPMC-0194

(NDR-000190)

ZPMC HAS CONDUCTED TRAINING OF
MT PERSONNEL AND ATTACHED ALL
DOCUMENTATION OF OBJECTIVE EVIDENCE
FOR CLOSURE OF THIS NCR



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 02/18/2009

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: CALTRANS NCR FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-332 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000218 (ZPMC-0194)
- (3) COPY OF THE MT TRAINING DOCUMENTATION
- (4) COPY OF THE ACCEPTABLE VT AND MT INSPECTION REPORTS

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

Rosemary
PLAN HOLDER

14:52
RECEIVED 18 FEB 2009
DATE

AD ASSOCIATED GROUP
COMPANY

PHONE NO.

PLAN NUMBER: N/A
#R787-QCP-102



No. B-332

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-2-18

REGARDING: NCR-000218(ZPMC-0194)

With this letter of response, ZPMC requests closure for Caltrans NCR-000218(ZPMC-0194). We have trained our NDT operator with the dry magnetic particles. And provided the meeting content and sign list for objective evidence.

Our QC had re-inspected the location which describe in the non-conformance report. After grinding for the weld toe we verified the linear indications had been completely removed. The process was witnessed by the caltrans QA inspector Mr. Steve Hall, and gained the acceptable from him. Actually it's not defects but we also repair them only for the corporation with the corresponding QA guy on site. And then we perform the MT to confirm the good condition, the attached MT reports can support that the weld quality had reached the requirement of the standard.

So ZPMC considers NCR-000218(ZPMC-0194) can be closed, and provide the attached documents to these weld crack repair.

Please check the attached documentation for acceptance and close the NCR-000218(ZPMC-0194).

ATTACHMENT:

NCR-000218(ZPMC-0194)

The MT training documentation

The acceptable VT and MT inspection reports

Zhou Shuanghao

2008.2.18.

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
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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, PRC

Report No: NCR-000218

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 11-Nov-2008

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

NCR #: ZPMC-0194

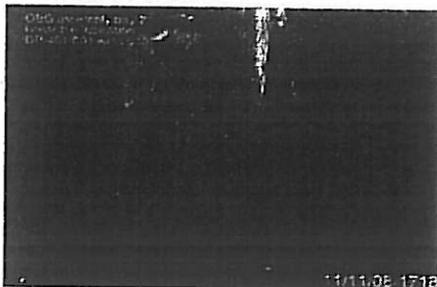
Type of problem:

Welding Concrete Other
 Welding Curing Procedural **Bridge No:** 34-0006,L/R
 Joint fit-up Coating Other **Component:** DP-326-002 and DP-461-001
 Procedural Procedural **Description:** OBG deck panels

Reference Description: QC-MT technicians accepted non-conforming linear indications along weld toes.

Description of Non-Conformance:

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Special Provisions Section 8-3.01 Welding General, "Groove weld surface profiles that interfere with the performance of the NDT procedure or produce questionable test results shall be ground smooth and blended with the adjacent material. Fillet weld surface profiles that interfere with the performance of the NDT procedure or produce questionable test results shall be ground to blend the toes smoothly with adjacent base metal.

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1/3
 20110139



Visual Weld Inspection Report
 焊缝目视检查报告

周数 54#
 日期 2008.11.10

OBG Plate Samed Splice

Caltrans Contract No. 04-0120F4
 加州合同编号
 Project No.: San Francisco Oakland Bay Bridge
 项目名称 美国海湾大桥
 Project No.: ZP06-787
 项目编号:

Quality Control Representative:
 质检代表: Fu Yunlong
 CWI:
 检验员: Luon Zhao Gang 20081110

Quality Assurance Manager ~Approval
 质量控制经理: Hu Gang

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊缝	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒绝	Repair 返修	Accept or Reject after repair 接受或拒绝
DP488-001-013	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-018	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-022	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-027	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-031	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-041	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-046	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-049	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-054	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-057	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-009	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-015	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-020	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-024	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-029	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-033	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-038	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-042	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-047	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-052	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

" / " is no defects. " X " is defects. " NA " is not applicable.

BVT 10/3/9
2/3



Visual Weld Inspection Report
焊缝目视检查报告

周数 54#
日期 2008.11.10

OBG Plate Spanel Splice

Girder/梁:
Tower/塔:
Quality Control Representative:
质检代表:
CWI:
检验员:
Quality Assurance Manager ~Approval
质量控制经理:

In Yunlong
Lumen Zhao Gang 07/08/06
Hui Gang

04-0120F4
San Francisco Oakland Bay Bridge
美国海湾大桥
ZP06-787

Caltrans Contract No.
加州合同编号
Project No.:
项目名称
Project No.:
项目编号

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 接受或拒收后
DP326-002-057	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-060	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-065	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-068	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-073	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-076	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-011	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-017	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-022	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-026	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-031	051356	3G	surpcored72H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-035	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-040	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-044	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-049	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-058	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-063	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-068	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-071	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-076	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

" / " is no defects. " X " is defects. "NA" is not applicable.

B-VT1038
1/7



Visual Weld Inspection Report
焊缝目视检查报告

周数 54#
日期 2008.11.10

OBG Plate Spanel Splice

Girder/梁: Fu Yulong
Tower/塔: Wen Zhao Gang 07110761

Quality Control Representative:
质检代表: CWI:
检验员: 1-Hu Gang

04-0120F4
San Francisco Oakland Bay Bridge
美国海湾大桥

Caltrans Contract No.
加州合同编号
Project No.:
项目编号: ZP06-787

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair NA
DP488-001-014	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-015	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-016	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-017	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-019	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-020	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-023	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-024	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-025	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-026	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-028	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-029	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-032	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-033	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-034	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-035	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-042	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-043	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-044	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-045	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP488-001-047	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

" / " is no defects. " X " is defects. " NA " is not applicable.

BVT 0158
2/7



Visual Weld Inspection Report
焊缝目视检查报告

周数 54#
日期 2008.11.10

OBG Plate Sanel Splice

Girder/梁:
Tower/塔:
Quality Control Representative:
质检代表:

CWI:
检验员:

04-0120F4
San Francisco Oakland Bay Bridge
美国海湾大桥

Caltrans Contract No.
加州合同编号:
Project No.:
项目编号:

Welder I.D.#
焊工识别号:
Weld No.
焊缝编号:

Accept or Reject
接受或拒收

Crack
裂纹

Spatters
飞溅

Arc strike
电弧擦伤

Crater
弧坑

Over lap
焊瘤

Porosity
气孔

Undercut
咬边

Welding consumables
焊接材料

Location
位置

Accept or Reject after repair
返修

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 返修
DF488-001-048	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-050	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-051	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-052	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-053	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-055	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-056	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-058	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-059	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-060	058551	2G	surpcored72H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF488-001-061	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-012	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-013	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-010	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-011	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-016	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-017	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-018	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-019	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-021	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DF326-002-022	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

Quality Assurance Manager Approval
质量控制经理:

Project No.:
项目编号:

Weld No.
焊缝编号:

"✓" is no defects. "X" is defects. "NA" is not applicable.

BV10138
3/7



Visual Weld Inspection Report
焊缝目视检查报告

周数 54#
日期 2008.11.10

OBG Plate Spanel Spice

Caltrans Contract No. 04-0120F4
加州合同编号
Project No.: San Francisco Oakland Bay Bridge
项目名称 美国海湾大桥
Project No.: ZP06-787
项目编号

Girder/梁:
Tower/塔:
Quality Control Representative:
质检代表:
CWI:
检验员:
Quality Assurance Manager ~Approval
质量控制经理:

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair
DP326-002-025	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-026	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-027	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-028	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-030	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-031	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-034	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-035	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-036	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-037	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-039	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-040	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-043	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-044	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-045	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-046	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-050	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-051	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-048	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-049	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-053	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

In Yuhong
Wan Zhao Gong 57no761

Hu Gang

"✓" is no defects. "X" is defects. "NA" is not applicable.

Z-VT 0138
4/7



Visual Weld Inspection Report
焊缝目视检查报告

周数 54#
日期 2008.11.10

OBG Plate Sanel Splice

Girder/梁:
Tower/塔:
Quality Control Representative:
质检代表:
CWI:
检验员:

In Yundong
Luan Zhao Gong 07100761

Quality Assurance Manager ~Approval
质量控制经理:

Hu Gongy

Galbraiths Contract No.
加州合同编号
Project No.:
项目名称
Project No.:
项目编号:

04-0120F4
San Francisco Oakland Bay Bridge
美国海湾大桥
ZP06-787

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair NA
DP326-002-054	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-055	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-056	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-058	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-059	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-061	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-062	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-063	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-064	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-066	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-067	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-069	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-070	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-071	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-072	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-074	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-075	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-077	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-078	058551	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-079	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP326-002-080	058551	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

" / " is no defects. " X " is defects. " NA " is not applicable.

BVT10138
5/6



Visual Weld Inspection Report
焊缝目视检查报告

周数 54#
日期 2008.11.10

OBG Plate,SaneI,Splice

Quality Control Representative:
质检代表:
CWI:
检验员:
Huan Zhao Gang 07no761
Hu Guang

Girder/梁:
Tower/塔:
Quality Assurance Manager ~Approval
质量控制经理:

Caltrans Contract No. 04-0120F-4
加州合同编号
Project No.: San Francisco Oakland Bay Bridge
项目名称 美国海湾大桥
Project No.: ZP06-787
项目编号:

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spalters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair NA
DP461-001-014	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-015	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-012	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-013	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-018	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-019	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-020	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-021	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-023	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-024	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-027	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-028	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-029	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-030	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-032	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-033	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-036	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-037	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-038	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-039	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-041	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

" / " is no defects. " X " is defects. "NA" is not applicable.

2/17/08
6/7



Visual Weld Inspection Report
焊缝目视检查报告

Caltrans Contract No. 04-0120F4
加州合同编号
Project No.: San Francisco Oakland Bay Bridge
项目名称 美国海湾大桥
PROJECT No.: ZP06-787
项目编号:

Girder/梁: OBG Plate Spanel Splice
Tower/塔:
Quality Control Representative: 质检代表: *Tu Yulong*
CWI: 检验员: *Luon Zhao Gang 07/10/06*
Quality Assurance Manager -- Approval 质量控制经理: *Hui Gang*

周数 54#
日期 2008.11.10

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair
DP461-001-042	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-045	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-046	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-047	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-048	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-050	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-051	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-061	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-062	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-059	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-060	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-064	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-065	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-066	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-067	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-069	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-070	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-072	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-073	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-074	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-075	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

" / " is no defects. " X " is defects. "NA" is not applicable.

BVT10138
7/7



Visual Weld Inspection Report
焊缝目视检查报告

周数 54#
日期 2008.11.10

OBG Plate SaneISplice

Caltrans Contract No. 04-0120F4
 加州合同编号
 Project No.: San Francisco Oakland Bay Bridge
 项目名称 美国海湾大桥
 Project No.: ZP06-787
 项目编号

Girder/梁: In the lens
 Tower/塔: Wan Zhao Gang 27110761
 Quality Control Representative: Hu Gang
 质检代表: 质检控制经理:

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 接受或拒收
DP461-001-077	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-078	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-080	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-081	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-082	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-083	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-085	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-086	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-088	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-089	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-090	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-091	051356	2G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-093	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP461-001-094	051356	3G	surpcored71H	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

After root weld
 After CWR or WRR No. :
 After cover pass
 After HSR No. :
 Others

#R787-QCP-603

" / " is no defects. " X " is defects. "NA" is not applicable.



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638 DATE日期 2008.11.11 PAGE OF 页码 1/10 Revision No: 0

PROJECT NO. 工程编号: ZP06-787	CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE	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
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2008
MAGNETIZING METHOD 磁化方法 Continuous magnetic yoke 磁轭式连续法	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
PARTICLE TYPE 磁粉类型 Dry magnet powder 干磁粉	CURRENT 电流 AC	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 12/14mm	
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			
DP488-001-014				ACC.		100%MT
DP488-001-015						*
DP488-001-016				ACC.		100%MT
DP488-001-017						*
DP488-001-019				ACC.		100%MT
DP488-001-020						*
DP488-001-023				ACC.		100%MT
DP488-001-024						*
DP488-001-025				ACC.		100%MT
DP488-001-026						*
DP488-001-028				ACC.		100%MT
DP488-001-029						*
DP488-001-032						*
DP488-001-033						*
DP488-001-034						*

EXAMINED BY 主操 <i>Wang</i>	REVIEWED BY 审核 <i>Cai Xinxin</i>
LEVEL - II SIGN 签名 / DATE 日期 08.11.11	LEVEL II SIGN / DATE 日期 08.11.11
质量经理 / QCM	用户 CUSTOMER



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4632 DATE日期 2008.11.11 PAGE OF页码 2/10 Revision No: 0

PROJECT NO. 工程编号:	ZP06-787	CONTRACTOR: 用户:	CALTRANS
DRAWING NO. 图号:	DP488+DP326+DP461 OBG PLATE PANEL SPLICE	CALTRANS CONTRACT NO.: 加州工程编号	04-0120F4
REFERENCING CODE 参考规范编码	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号	CALIBRATION DUE DATE 仪器校正有效期
AWS D1.5-2002	AWS D1.5-2002	ZPQC-MT-01	Dec. 28 ST , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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 12/14mm
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			
DP488-001-035						*
DP488-001-042						*
DP488-001-043						*
DP488-001-044						*
DP488-001-045						*
DP488-001-047						*
DP488-001-048						*
DP488-001-050						*
DP488-001-051						*
DP488-001-052						*
DP488-001-053						*
DP488-001-055						*
DP488-001-056						*
DP488-001-058						*
DP488-001-059						*

EXAMINED BY 主探 <i>Wang Wei</i>	REVIEWED BY 审核 <i>Cai Xinxin</i>
LEVEL-II SIGN 签名 / DATE日期 <i>08.11.11</i>	LEVEL-II SIGN / DATE日期 <i>08.11.11</i>
质量经理 / QCM	用户CUSTOMER



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638 DATE日期 2008.11.11 PAGE OF页码 3/10 Revision No: 0

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

DRAWING NO. 图号: DP488+DP326+DP461 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
 OBG PLATE PANEL SPLICE

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. 28ST, 2008

EQUIPMENT 设备: MT YOKE MANUFACTURER 制造商: PARKER MODEL NO. 样式编号: B310S SERIAL NO. 连续编号: 5395 5617 5620

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: WELDING 焊接件 Material & thickness 母材, 厚度: A709M-345T2-X 12/14mm
 CASTING 铸件 FORGING 锻造

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			
DP488-001-060						*
DP488-001-061						*
DP326-002-012				ACC.		100%MT
DP326-002-013						*
DP326-002-010				ACC.		100%MT
DP326-002-011						*
DP326-002-016				ACC.		100%MT
DP326-002-017						*
DP326-002-018				ACC.		100%MT
DP326-002-019						*
DP326-002-021				ACC.		100%MT
DP326-002-022						*
DP326-002-025				ACC.		100%MT
DP326-002-026						*
DP326-002-027				ACC.		100%MT

EXAMINED BY 主探: Wang Wei

REVIEWED BY 审核: Cai Xinxin

LEVEL: II SIGN 签名 / DATE日期: 08.11.11

LEVEL: II SIGN 签名 / DATE日期: 08.11.11

质量经理 / QCM

用户 CUSTOMER

公司: ZPMC

公司: ZPMC



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638 DATE日期 2008.11.11 PAGE OF页码 4/10 Revision No: 0

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

DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE 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. 28ST, 2008

EQUIPMENT 设备 MT YOKE MANUFACTURER 制造商 PARKER MODEL NO. 样式编号 B310S SERIAL NO. 连续编号 5395 5617 5620

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 WELDING 焊接件 CASTING 铸件 FORGING 锻造 Material & thickness 母材,厚度 A709M-345T2-X 12/14mm

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			
DP326-002-028						*
DP326-002-030				ACC.		100%MT
DP326-002-031						*
DP326-002-034				ACC.		100%MT
DP326-002-035						*
DP326-002-036				ACC.		100%MT
DP326-002-037						*
DP326-002-039				ACC.		100%MT
DP326-002-040						*
DP326-002-043				ACC.		100%MT
DP326-002-044						*
DP326-002-045				ACC.		100%MT
DP326-002-046						*
DP326-002-050						*
DP326-002-051						*

EXAMINED BY 主操
Wang Wei

REVIEWED BY 审核
Cai Xinxin

LEVEL-II SIGN 签名 / DATE日期 08.11.11

LEVEL-II SIGN / DATE日期 08.11.11

质量经理 / QCM

客户代表

质量经理 / QCM

客户代表



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638

DATE日期 2008.11.11

PAGE OF页码 5/10

Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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 12/14mm
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			
DP326-002-048						*
DP326-002-049						*
DP326-002-053						*
DP326-002-054						*
DP326-002-055						*
DP326-002-056						*
DP326-002-058						*
DP326-002-059						*
DP326-002-061						*
DP326-002-062						*
DP326-002-063						*
DP326-002-064						*
DP326-002-066						*
DP326-002-067						*
DP326-002-069						*

EXAMINED BY主操

Wang Wei

LEVEL-II SIGN 签名 / DATE日期 08.11.11

质量经理 / QCM

REVIEWED BY 审核

Cai Xinxin

LEVEL-II SIGN / DATE日期 08.11.11

客户代表 / CUSTOMER



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638 DATE日期 2008.11.11 PAGE OF页码 8/10 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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 12/14mm
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			
DP326-002-070						*
DP326-002-071						*
DP326-002-072						*
DP326-002-074						*
DP326-002-075						*
DP326-002-077						*
DP326-002-078						*
DP326-002-079						*
DP326-002-080						*
DP461-001-014						*
DP461-001-015						*
DP461-001-012						*
DP461-001-013						*
DP461-001-018				ACC.		100%MT
DP461-001-019						*

EXAMINED BY 主操
Wang Wei
 LEVEL - II SIGN 签名 / DATE日期 08.11.11
 质量经理 / QCM
[Signature]

REVIEWED BY 审核
Cal Xinxin
 LEVEL-II SIGN / DATE日期 08-11-11
 客户 / CUSTOMER
 日期 / DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638 DATE日期 2008.11.11 PAGE OF页码 7/10 Revision No: 0

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

DRAWING NO. DP488+DP326+DP461 CALTRANS CONTRACT NO.: 04-0120F4
 图号: OBG PLATE PANEL SPLICE 加州工程编号

REFERENCING CODE ACCEPTANCE STANDARD PROCEDURE NO. CALIBRATION DUE DATE
 参考规范编码 接受标准 程序编号 仪器校正有效期
 AWS D1.5-2002 AWS D1.5-2002 ZPQC-MT-01 Dec. 28ST, 2008

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 连续编号
 MT YOKE PARKER B310S 5395 5617 5620

MAGNETIZING METHOD Continuous magnetic yoke CURRENT AC
 磁化方法 磁轭式连续法 电流

PARTICLE TYPE Dry magnet powder YOKE SPACING 70~150mm
 磁粉类型 干磁粉 磁轭间距

MATERIAL TO BE √ WELDING 焊接件 Material & thickness A709M-345T2-X
 EXAMINED □ CASTING 铸件 母材, 厚度 12/14mm
 检测材料 □ FORGING 锻造

WELDING PROCESS FCAW TYPE OF JOINT T-JOINT
 焊接方法 焊缝类型

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			
DP461-001-020				ACC.		100%MT
DP461-001-021						*
DP461-001-023				ACC.		100%MT
DP461-001-024						*
DP461-001-027				ACC.		100%MT
DP461-001-028						*
DP461-001-029				ACC.		100%MT
DP461-001-030						*
DP461-001-032				ACC.		100%MT
DP461-001-033						*
DP461-001-036				ACC.		100%MT
DP461-001-037						*
DP461-001-038				ACC.		100%MT
DP461-001-039						*
DP461-001-041				ACC.		100%MT

EXAMINED BY 主操
 Wang Hai

REVIEWED BY 审核
 Cai Xinxin

LEVEL-II SIGN 签名 / DATE日期 08.11.11

LEVEL-II SIGN / DATE日期 08.11.11

质量经理 / QM
 [Signature]

用户CUSTOMER
 [Signature]



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638		DATE日期 2008.11.11	PAGE OF页码 8/10	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008	
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620	
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 12/14mm	
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			
DP461-001-042						*
DP461-001-045				ACC.		100%MT
DP461-001-046						*
DP461-001-047				ACC.		100%MT
DP461-001-048						*
DP461-001-050				ACC.		100%MT
DP461-001-051						*
DP461-001-061						*
DP461-001-062						*
DP461-001-059						*
DP461-001-060						*
DP461-001-064						*
DP461-001-065						*
DP461-001-066						*
DP461-001-067						*

EXAMINED BY 主探 <i>Wang Tusi</i>	REVIEWED BY 审核 <i>Cai Xinxin</i>
LEVEL - II / SIGN 签名 / DATE日期 08.11.11	LEVEL II / SIGN / DATE日期 08.11.11
质量经理 / QC M	用户 CUSTOMER



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638 DATE日期 2008.11.11 PAGE OF页码 9/10 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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 12/14mm
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			
DP461-001-069						*
DP461-001-070						*
DP461-001-072						*
DP461-001-073						*
DP461-001-074						*
DP461-001-075						*
DP461-001-077						*
DP461-001-078						*
DP461-001-080						*
DP461-001-081						*
DP461-001-082						*
DP461-001-083						*
DP461-001-085						*
DP461-001-086						*
DP461-001-088						*

EXAMINED BY 主操 <u>Wang Yong</u> LEVEL - II SIGN 签名 / DATE日期 08.11.11	REVIEWED BY 审核 <u>Cai Yanjin</u> LEVEL - II SIGN / DATE日期 08.11.11
质量经理 / QCM	用户 CUSTOMER
日期 DATE	日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638 DATE日期 2008.11.11 PAGE OF页码 10/10 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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 12/14mm
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			
DP461-001-089						*
DP461-001-090						*
DP461-001-091						*
DP461-001-093						*
DP461-001-094						*

* DP488-001-014, DP488-001-016, DP488-001-019, DP488-001-023, DP488-001-025, DP488-001-028, DP326-002-012, DP326-002-010, DP326-002-016, DP326-002-018, DP326-002-021, DP326-002-025, DP326-002-027, DP326-002-030, DP326-002-034, DP326-002-036, DP326-002-039, DP326-002-043, DP326-002-045, DP461-001-018, DP461-001-020, DP461-001-023, DP461-001-027, DP461-001-029, DP461-001-032, DP461-001-036, DP461-001-038, DP461-001-041, DP461-001-045, DP461-001-047, DP461-001-050 were MT inspection and ACC, which is the result of required 10% MT.
* DP488-001-014, DP488-001-016, DP488-001-019, DP488-001-023, DP488-001-025, DP488-001-028, DP326-002-012, DP326-002-010, DP326-002-016, DP326-002-018, DP326-002-021, DP326-002-025, DP326-002-027, DP326-002-030, DP326-002-034, DP326-002-036, DP326-002-039, DP326-002-043, DP326-002-045, DP461-001-018, DP461-001-020, DP461-001-023, DP461-001-027, DP461-001-029, DP461-001-032, DP461-001-036, DP461-001-038, DP461-001-041, DP461-001-045, DP461-001-047, DP461-001-050 焊缝经MT抽检合格, 且累积检测长度已经达到了此批要求的10%检测长度。

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EXAMINED BY 主操 <i>Wang Mapi</i>	REVIEWED BY 审核 <i>Cai Xinxin</i>
LEVEL-II SIGN 签名 / DATE 日期 <i>08-11-11</i>	LEVEL-II SIGN / DATE 日期 <i>08-11-11</i>
质量经理 / QCM <i>He Guang</i>	客户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4639		DATE日期 2008.11.11	PAGE OF页码 1/3	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008	
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620	
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 12/14mm	
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			
DP488-001-013				ACC.		100%MT
DP488-001-018				ACC.		100%MT
DP488-001-022				ACC.		100%MT
DP488-001-027				ACC.		100%MT
DP488-001-031				ACC.		100%MT
DP488-001-041				ACC.		100%MT
DP488-001-046				ACC.		100%MT
DP488-001-049				ACC.		100%MT
DP488-001-054				ACC.		100%MT
DP488-001-057				ACC.		100%MT
DP326-002-009				ACC.		100%MT
DP326-002-015				ACC.		100%MT
DP326-002-020				ACC.		100%MT
DP326-002-024				ACC.		100%MT
DP326-002-029				ACC.		100%MT

EXAMINED BY 主探
Wang Wang
 LEVEL - II - SIGN 签名 / DATE日期 08.11.11
 质量经理 / QC/M
[Signature]
 签字 SIGN / 日期 DATE

REVIEWED BY 审核
Cai Yinxin
 LEVEL-II SIGN / DATE日期 08.11.11
 用户 CUSTOMER
 签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4639 DATE日期 2008.11.11 PAGE OF页码 2/3 Revision No: 0

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

DRAWING NO. 图号: DP488+DP326+DP461 CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4
OBG PLATE PANEL SPLICE

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. 28ST, 2008

EQUIPMENT 设备: MT YOKE MANUFACTURER 制造商: PARKER MODEL NO. 样式编号: B310S SERIAL NO. 连续编号: 5395 5617 5620

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: WELDING 焊接件 Material & thickness 母材,厚度: A709M-345T2-X
 CASTING 铸件 12/14mm
 FORGING 锻造

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			
DP326-002-033				ACC.		100%MT
DP326-002-038				ACC.		100%MT
DP326-002-042				ACC.		100%MT
DP326-002-047				ACC.		100%MT
DP326-002-052				ACC.		100%MT
DP326-002-057				ACC.		100%MT
DP326-002-060				ACC.		100%MT
DP326-002-065				ACC.		100%MT
DP326-002-068				ACC.		100%MT
DP326-002-073				ACC.		100%MT
DP326-002-076				ACC.		100%MT
DP461-001-011				ACC.		100%MT
DP461-001-017				ACC.		100%MT
DP461-001-022				ACC.		100%MT
DP461-001-026				ACC.		100%MT

EXAMINED BY主探: Wang Wei
LEVEL-II SIGN 签名 / DATE日期: 08.11.11

REVIEWED BY审核: Cai Xinlin
LEVEL-II SIGN 签名 / DATE日期: 08.11.11

质量经理 / CQM:
签字 SIGN 日期 DATE:

用户 CUSTOMER:
签字 SIGN 日期 DATE:



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4639 DATE日期 2008.11.11 PAGE OF页码 3/3 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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 12/14mm
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			
DP461-001-031				ACC.		100%MT
DP461-001-035				ACC.		100%MT
DP461-001-040				ACC.		100%MT
DP461-001-044				ACC.		100%MT
DP461-001-049				ACC.		100%MT
DP461-001-058				ACC.		100%MT
DP461-001-063				ACC.		100%MT
DP461-001-068				ACC.		100%MT
DP461-001-071				ACC.		100%MT
DP461-001-076				ACC.		100%MT
DP461-001-079				ACC.		100%MT
DP461-001-084				ACC.		100%MT
DP461-001-087				ACC.		100%MT
DP461-001-092				ACC.		100%MT

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EXAMINED BY 主操 <i>Wang Mei</i>	REVIEWED BY 审核 <i>Cai Xinxin</i>
LEVEL - II SIGN 签名 / DATE日期 <i>08.11.11</i>	LEVEL-II SIGN / DATE日期 <i>08.11.11</i>
质量经理 / QC M	用户 / CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000187

Subject: NCR No. ZPMC-0194

Dated: 06-Apr-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000190 **Rev:** 02

Contractor's Proposed Resolution:

Reference Resolution: Attached are the remaining documents requested by CT for closure of this NCR.

Attached are the remaining documents requested by CT for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000190R02;

Caltrans' comments:

Status: CLO

Date: 12-Apr-2009

The proposed resolution is acceptable. The inspection documents requested in Rev 1 of NPR-0190 have been provided. The Department concurs that Non-Conformance ZPMC-0194 is closed.

Submitted by: Wright, Doug

Date: 12-Apr-2009

Attachment(s):



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-4638-1 DATE日期 2008.11.11 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: DP488+DP326+DP461 OBG PLATE PANEL SPLICE		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 , 2008
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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 12/14mm
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			
DP461-001-037				ACC.		100%MT
DP461-001-019				ACC.		100%MT
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EXAMINED BY主探 <i>Wang Wei</i> 2008.11.11	REVIEWED BY 审核 <i>Cai Xinlin</i> 2008.11.11
LEVEL - II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
	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



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.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000415**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0194**Type of problem:**

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

Date the Non-Conformance Report was written: 11-Nov-2008**Description of Non-Conformance:**

The contractors Quality Control (QC) Magnetic particle Testing (MT) technicians have accepted nonconforming linear indications along the weld toes on the following welds DP-326-002 weld 065, DP-461-001 welds 040, 037 and 019. These welds join the floor beam diaphragm to the deck panel closed ribs. See attached photo.

Contractor's proposal to correct the problem:

Repair and Perform NDT verification.

Corrective action taken:

Contractor has repaired the weld with acceptable NDT documentation.

Did corrective action require Engineer's approval? 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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer