

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, PRC

Report No: NCR-000222

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Dec-2008

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

NCR #: ZPMC-0198

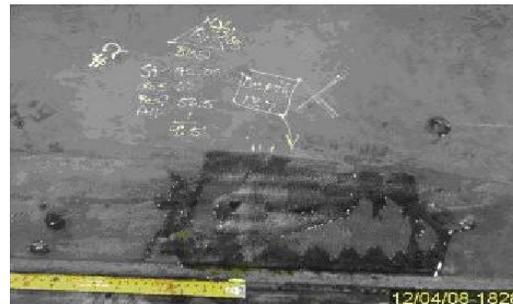
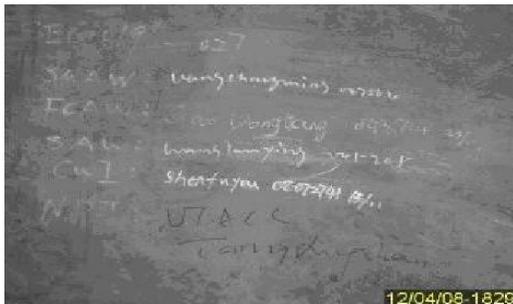
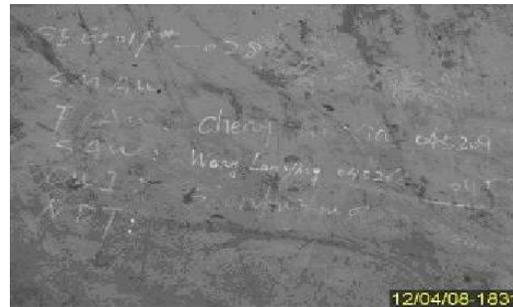
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006 L/R
Joint fit-up	Coating	Other	Component: welds SEG-019-027 and 028 deck panel CJP splice joint
Procedural	Procedural	Description: OBG deck panels	

Reference Description: Nonconforming class A indications on welds SEG-019-027 and SEG-019-028

Description of Non-Conformance:

The contractors Quality Control (QC) Ultrasonic Testing (UT) technicians have accepted nonconforming class A indications on welds SEG-019-027 and SEG-019-028. See attached photos.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Contract Special Provisions section 8-3.01, "The QC Inspector or CAWI shall inspect and approve each joint preparation, assembly practice, welding technique, joint fit-up, and the performance of each welder, welding operator, and tack welder to make certain that the applicable requirements of this code and the approved WPS are met. The QC Inspector shall examine the work to make certain that it meets the requirements of Sections 3 and 6.26."

AWS D1.5 2002 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 2002 Table 6.3, "Class A (large flaws) Any indication in this category shall be rejected (regardless of length)."

Who discovered the problem: Caltrans QA Steve Hall

Name of individual from Contractor notified: Mr. Steve Lawton

Time and method of notification: 12/04/08 / 20:30 / Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 12/8/08

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
Reviewed By:	Dautermann,Peter	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: 09-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: 05.03.06-000190

Subject: NCR No. ZPMC-0198

Reference Description: Nonconforming class A indications on welds SEG-019-027 and SEG-019-028

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) Ultrasonic Testing (UT) technicians have accepted nonconforming class A indications on welds SEG-019-027 and SEG-019-028.

Action Required and/or Action Taken:

Please propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0198

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: 05.03.06-000190

Subject: NCR No. ZPMC-0198

Dated: 18-Dec-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000192 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will submit training documentation as objective evidence to close this NCR. The UT operator was notified and shown the indication noted by CT.

ZPMC NDT department has been notified of the missed indication. ABF has requested a UT training session be conducted as a preventative action measure. ZPMC will submit training documentation as objective evidence to close this NCR. The UT operator was notified and shown the indication noted by CT.

Submitted by:

Attachment(s): ABF-NPR-000192R00; ABF-NPR-000191R00

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-0198 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: 05.03.06-000190

Subject: NCR No. ZPMC-0198

Dated: 11-Mar-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000192 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC requests closure of the NCR ZPMC-0198 based on the Training and Inspection records attached.
ZPMC requests closure of the NCR ZPMC-0198 based on the Training and Inspection records attached.

Submitted by:

Attachment(s): ABF-NPR-000192R01;

Caltrans' comments:

Status: CLO

Date: 17-Mar-2009

The proposed resolution is acceptable. Training regarding Ultrasonic Testing (UT) application was performed, and the welds in question have been accepted by UT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0198 is closed.

Submitted by: Wright, Doug

Date: 17-Mar-2009

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 03/09/2009

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-334 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000222 (ZPMC-0198)
- (3) COPY OF WELD REPAIR REPORTS
- (4) COPY OF VT AND UT REPORTS FOR THE TWO WELD
- (5) COPY OF THE TRAINING RECORD OF ZPMC UT OPERATORS
- (6) COPY OF ZPMC INTERNAL NCR

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

Rosemary

PLAN HOLDER

13:51
RECEIVED 09 MAR 2009

DATE



COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. B-334

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-3-9

REGARDING: NCR-000222(ZPMC-0198)

With this letter of response, ZPMC requests closure for Caltrans NCR-000222(ZPMC-0198). We agree what described in the non-conformance report, and have made an internal NCR for the operator's mistake. Besides we have instructed our NDT QC that how to decrease to miss the rejected indications. Therefore we apply to close the NCR-000222(ZPMC-0198).

Additional we provide the corresponding reports to prove the final good quality after repaired the indication which were found by the caltrans QA guy.

So ZPMC considers NCR-000222(ZPMC-0198) can be closed, and provide the attached documents to that two weld.

Please check the attached documentation for acceptance and close the NCR-000222(ZPMC-0198).

ATTACHMENT:

NCR-000222(ZPMC-0198)

The weld repair reports

The VT and UT reports for the two weld

The training record of ZPMC UT operators

ZPMC internal NCR

zhuoshuangbao

2009.3.9

DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
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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-000222

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Dec-2008

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

NCR #: ZPMC-0198

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description: OBG deck panels

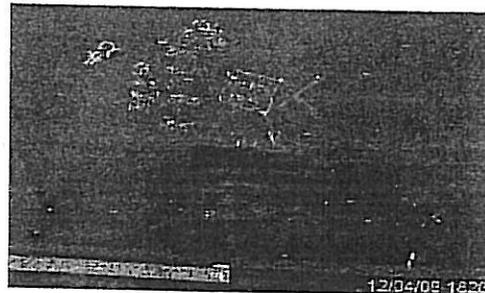
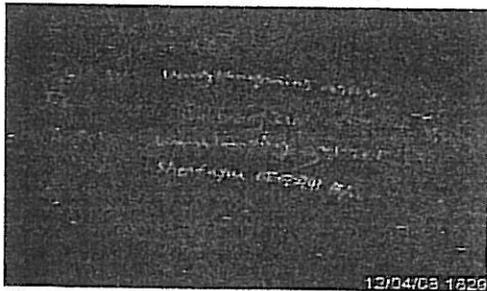
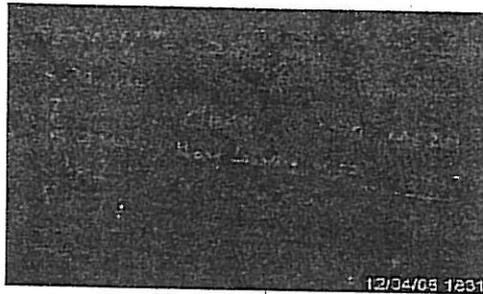
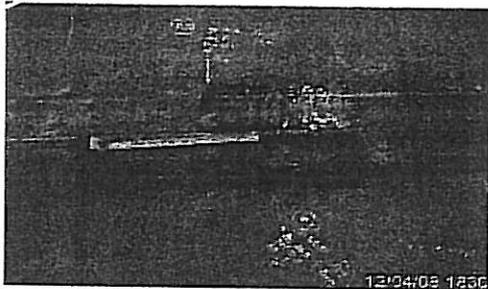
Bridge No: 34-0006 L/R

Component: welds SEG-019-027 and 028 deck panel CJP splice joint

Reference Description: Nonconforming class A indications on welds SEG-019-027 and SEG-019-028

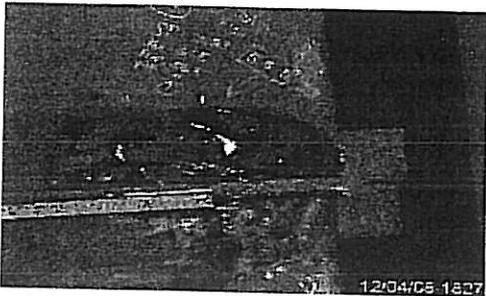
Description of Non-Conformance:

The contractors Quality Control (QC) Ultrasonic Testing (UT) technicians have accepted nonconforming class A indications on welds SEG-019-027 and SEG-019-028. See attached photos.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Contract Special Provisions section 8-3.01, "The QC Inspector or CAWI shall inspect and approve each joint preparation, assembly practice, welding technique, joint fit-up, and the performance of each welder, welding operator, and tack welder to make certain that the applicable requirements of this code and the approved WPS are met. The QC Inspector shall examine the work to make certain that it meets the requirements of Sections 3 and 6.26."

AWS D1.5 2002 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 2002 Table 6.3, "Class A (large flaws) Any indication in this category shall be rejected (regardless of length)."

Who discovered the problem: Caltrans QA Steve Hall

Name of individual from Contractor notified: Mr. Steve Lawton

Time and method of notification: 12/04/08 / 20:30 / Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 12/8/08

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

Reviewed By: Dautermann, Peter

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	SEG19	报告编号 Report No.	B-WR1581
合同号 Contract No.:	04-0120F4	部件名称 Items Name	OBG PLATE PANEL SPLICE	NDT报告编号 Report No.of NDT	B787-UT-3569
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

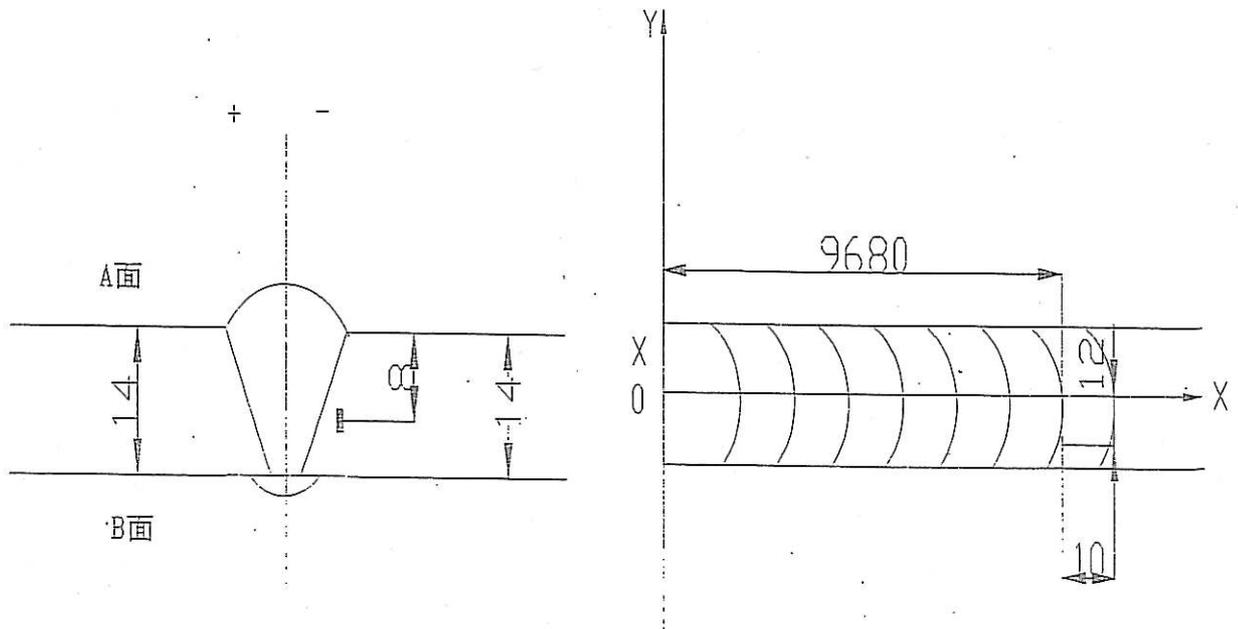
(UT探伤发现的缺陷总长度小于最大允许长度。)SEG019*-028

Tang Xinduan

检验员 (Inspector): Tang Xinduan 日期(Date): 08.12.07

焊缝返修位置示意图:

Draft of welding discontinuity:



WELD NUMBER: SEG019*-028

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): *Zhang Yanli* 日期(Date): 2008.12.09

处理意见

Disposition:

1. 从B面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. 焊前对修补区域进行VT与MT检测保证缺陷完全被清除;
 4. 将修补区域打磨到与母材或邻近焊缝平齐;
 5. 根据批准的车间图纸检查焊缝.
-
1. Gouge or grind from face B to remove all defects;
 2. Follow repair WPS for joint preparation, preheat, and weld deposit;
 3. Verify with VT and MT no defects remain in the weld joint prior to welding;
 4. Grind the repaired area flush with base metal or the adjacent weld;
 5. Check the welds according to the working drawings.

工艺:
Technical engineer *Nia Tiefeng*

审核:
Approved by *[Signature]*

日期
Date 08.12.09



焊缝返修报告

Welding Repair Report

版本 Rev. 1

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	SEG19	报告编号 Report No.	B-WR1581
合同号 Contract No.:	04-0120F4	部件名称 Items Name	OBG PLATE PANEL SPLICE	NDT报告编号 Report No. of NDT	B787-UT-356
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) *Zhang Yan* 日期(Date): 2008.12.09

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair WPS-345-FCAW-1 G(1F)-Repair-1	工艺员 technologist	<i>Niu Tiefeng</i> 08.12.09
返修(碳刨)前预热温度 Preheat temperature before gouging	70°C	返修的缺陷 Description of discontinuity	ZF
焊前处理检查 Inspection before welding	Acc	焊前预热温度 Preheat temperature before welding	103°C
最大碳刨深度 Max. depth of gouging	9mm	碳刨总长 Total length of gouging	40mm
焊工 welder	051348	焊接类型 welding type	SMAW
焊接电流 Current	160A	焊接电压 Voltage	24.3V
		焊接位置 position	1G
		焊接速度 Speed	110 mm/min

返修后检查
Inspection After repairing:

外观检查 VT result	<i>Acc</i>	检验员 Inspector	<i>Li Yanchuan</i>	日期 Date	09.02.26
NDT复检 NDT result	<i>Acc</i>	探伤员 NDT person	<i>Tang Jingsha</i>	日期 Date	09.02.26

见证:
Witness/Review:备注:
Remark:

#B787-10F-000



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-3559 DATE 2008.12.07 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: OBG PLATE PANEL DRAWING NO.: SEG19 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 SPLICE 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
 SAW BUTT Dec. 28ST, 2008

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510,
 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2-X 14mm

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
Changchao	70°	2.5 MHz	18x18 mm				
Changchao	0°	2.5 MHz	20 mm	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		
SEG019*-028	1	70	A	1	35	33	0	+2	10	21	8	-12	9680	REF.	100%

BLANK

EXAMINED BY 主探: Lany King Chan 8.12.07 DATE
 LEVEL-II SIGN DATE

REVIEWED BY 审核: Xuehan 8.12.07 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



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	SEG19	报告编号 Report No.	B-WR1580
合同号 Contract No.:	04-0120F4	部件名称 Items Name	OBG PLATE PANEL SPLICE	NDT报告编号 Report No.of NDT	B787-UT-3568
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

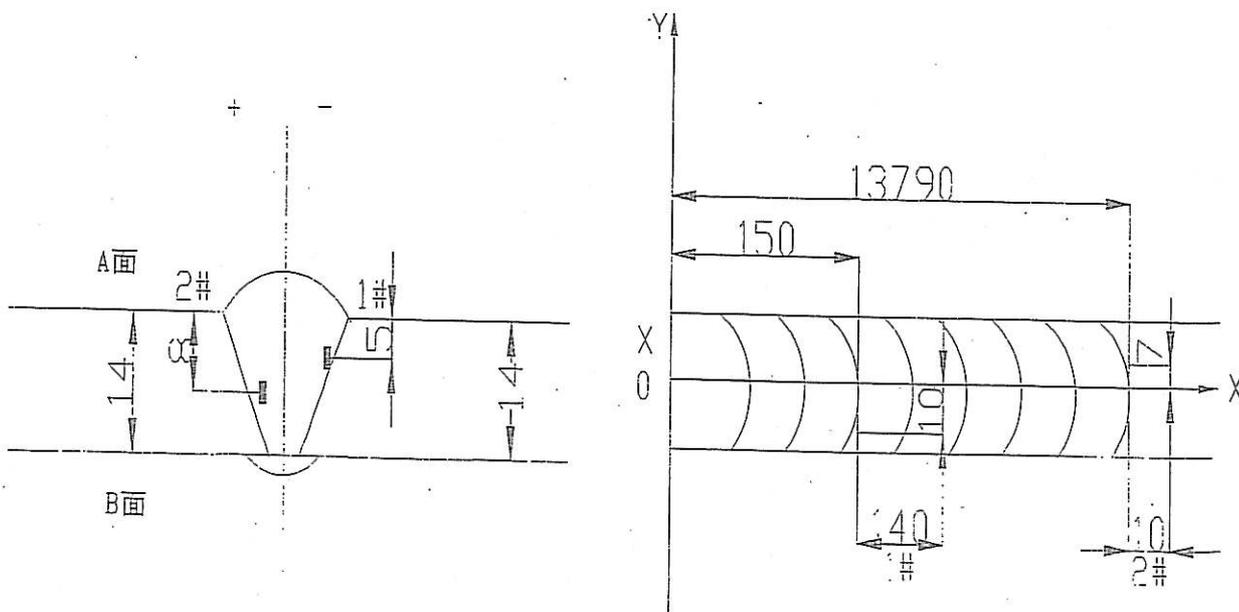
Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

(UT探伤发现的缺陷总长度小于最大允许长度。)SEG019*-027

检验员 (Inspector): Tang Xingshan 日期(Date): 08.12.07

焊缝返修位置示意图:

Draft of welding discontinuity:



WELD NUMBER: SEG019*-027

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):

Shang Yanhui

日期(Date): 2008.12.07

处理意见

Disposition:

1. 从缺陷距离端面较近一侧 ($D \leq 1/2T$, 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. 焊前对修补区域进行VT/MT检测保证缺陷完全被清除;
4. 将修补区域打磨到与母材或邻近焊缝平齐;
5. 根据批准的车间图纸检查焊缝.

1. Gouge or grind from nearer side from metal edge ($D \leq 1/2T$, "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. Verify with VT/MT no defects remain in the weld joint prior to welding;
4. Grind the repaired area flush with base metal or the adjacent weld;
5. Check the welds according to the working drawings.

工艺:
Technical engineer

W. T. T. T.

审核:
Approved by

T. T. T.

日期
Date

08.12.07



焊缝返修报告

Welding Repair Report

版本 Rev. 1

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	SEG19	报告编号 Report No.	B-WR1580
合同号 Contract No.:	04-0120F4	部件名称 Items Name	OBG PLATE PANEL SPLICE	NDT报告编号 Report No. of NDT	B787-UT-356
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): Zhang Yanchi 日期(Date): 2008.12.09

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair WPS-345-FCAW-1 G(1F)-Repair-1	工艺员 technologist	Niu Tiefeng 08.12.09
返修(碳刨)前预热温度 Preheat temperature before gouging	190°C	返修的缺陷 Description of discontinuity	2.F
焊前处理检查 Inspection before welding	Ac	焊前预热温度 Preheat temperature before welding	117°C
最大碳刨深度 Max. depth of gouging	9mm	碳刨总长 Total length of gouging	200mm
焊工 welder	051348	焊接类型 welding type	SMAW
焊接电流 Current	160-A	焊接电压 Voltage	24.7V
		焊接位置 position	1G
		焊接速度 Speed	112mm/min

返修后检查

Inspection After repairing:

外观检查 VT result	Ac	检验员 Inspector	Li Yanhua	日期 Date	09.02.26
NDT复检 NDT result	Ac	探伤员 NDT person	Tang Jingchen	日期 Date	09.02.26
见证: Witness/Review:					
备注: Remark:					



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-3568

DATE 2008.12.07

PAGE 1 OF 1

Revision No: 0

PROJECT NO.: 工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: OBG PLATE PANEL

DRAWING NO.: SEG19

CALTRANS CONTRACT NO.: 04-0120F4

部件名称 SPLICE

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

SAW

BUTT

Dec. 28ST, 2008

EQUIPMENT 设备

MANUFACTURER 制造商

MODEL NO. 样式编号

SERIAL NO. 序列编号

UT SCOPE

PANAMETRICS

EPOCH-4B

071565311, 061488510,

061495811, 070152011,

CALIBRATION BLOCK 试块

COUPLANT 耦合剂

MATERIAL/THICKNESS 材料厚度

AWS IIW BLOCK TYPE II

C.M.C

A709M-345T2-X 14mm

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
Changchao	70 °	2.5 MHz	18x18 mm				
Changchao	0 °	2.5 MHz	20 mm	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		
SEG019*-027	1	70	A	2	31	33	3	-5	140	62	5	-10	150	REJ.	100%
	2	70	A	2	43	33	2	+8	10	52	8	+7	13790	REJ.	100%

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EXAMINED BY 主探

Caney Dinghuan 08.12.07

LEVEL - II SIGN / DATE

REVIEWED BY 审核:

Xue Ma Wang 08.12.07

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-JT-3569R1 DATE 2009.02.26 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: OBG PLATE PANEL DRAWING NO.: CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 SPLICE, 图号 SEG19 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
 SMAW BUTT Dec. 28ST, 2009

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510, 061495811, 070152011,

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 14mm

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
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	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
SEG019*-028	1R1	70				32									ACC.	100%
AFTER B-WR1581																
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EXAMINED BY 主探 <i>Tony...</i> 09.02.26 LEVEL - II SIGN / DATE	REVIEWED BY 审核 <i>Zhu...</i> LEVEL - II SIGN / DATE
质量经理 / QCM _____	用户 CUSTOMER _____
日期 DATE _____	日期 DATE _____



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-3568R1 DATE 2009.02.26 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: OBG PLATE PANEL DRAWING NO.: SEG19
 部件名称 SPLICE 图号
 CALTRANS CONTRACT NO.: 04-0120F4
 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
 SMAW BUTT Dec. 28ST, 2009

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510,
 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2-X 14mm

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
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	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			
SEG019*-027	1R1	70				32									ACC.	100%

AFTER B-WR1580

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EXAMINED BY 主探: *[Signature]* REVIEWED BY 审核: *[Signature]*
 LEVEL - II SIGN / DATE: 9.2.26 LEVEL - II SIGN / DATE: 9.2.26

质量经理 / QCM: _____ 客户 CUSTOMER: _____
 签字 SIGN / 日期 DATE: _____ 签字 SIGN / 日期 DATE: _____

level and the reference level with correction for attenuation
as indicated in the following expressions:

Instruments with gain in dB :

$$a - b - c = d$$

Instruments with attenuation in dB :

$$b - a - c = d$$

6.19.7 The length of flaws shall be determined in conformance
with the procedure in 6.23.2.

Application For Leave

AMERICAN BRIDGE / FLUOR CHINA

Name: Rosemary Chen	Position: TDC	Employee Number: CNEN0415
Dept./ Project: SFOBB Project		Location: Shanghai
Applying for (Please tick √)		
<input type="checkbox"/> Annual Leave	<input type="checkbox"/> Sick Leave	
<input type="checkbox"/> Statutory Leave	<input type="checkbox"/> Unpaid Leave	
<input type="checkbox"/> Home Visit (for assignment)	<input type="checkbox"/> Compensation for OT	
<input type="checkbox"/> R & R	<input type="checkbox"/> Home Leave (for Expat.)	
Reason	Duration (from .. to ..)	Total number of working hours
<ul style="list-style-type: none"> • Duties to be covered by Mr./ Ms. _____ • Contact during the leave (if necessary) : _____ 		

Applicant : _____

Date: _____

Approved by : _____

Date: _____

Remarks:

- Prior application is required
- Medical certification is required for sick leave (beyond one day)
- This form should be attached to your timesheet

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-000213**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Mar-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0198**Type of problem:**

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

Date the Non-Conformance Report was written: 04-Dec-2008**Description of Non-Conformance:**

The contractors Quality Control (QC) Ultrasonic Testing (UT) technicians have accepted nonconforming class A indications on welds SEG-019-027 and SEG-019-028. See attached photos.

Contractor's proposal to correct the problem:

The Contractor will provide acceptable UT inspection results and training records to correct the problem.

Corrective action taken:

Per NPR192R01, the Contractor has provided acceptable UT inspection result along with training records. The welds in question have been accepted by UT. The Department concurs that an acceptable corrective action has been taken.

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 Eric Tsang, +(86) 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer