

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-000325

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2009

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

NCR #: ZPMC-0299

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 3AW
Procedural	Procedural	Description:	

Reference Description: Missed MT Indication by QC, Base Metal of Deck Panel DP009A, Segment 3AW

Description of Non-Conformance:

During random verification magnetic particle testing (MT) of temporary weld removal areas between suspender bracket SB22W and OBG Deck Panel DP009A, Caltrans Quality Assurance (QA) Inspector discovered a linear indication measuring 10mm in length located in the deck panel. One hundred percent (100%) of the temporary weld removal areas were MT tested and accepted by ZPMC Quality Control technicians.



Applicable reference:

AWS D1.5 (02) Section 3.3.8: "Removal of temporary welds shall conform to the requirements of 3.3.7.3 and 3.3.7.4."

AWS D1.5 (02) Section 3.3.7.4: "The removal of tack welds may expose unacceptably hard or cracked HAZs. Such areas on members subject to tension or reversal-of-stress shall be tested by MT (preferably by the yoke method) to assure that no cracks are present."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

AWS D1.5 (02) Section 6.26.2: "Welds that are subject to MT in addition to visual inspection shall have no cracks."

Who discovered the problem: M.Manikandan

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 10:00, 06/15/09, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 10:00, 06/19/09, Verbal

QC Inspector's Name: Wang Lu

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 Skyler Guest, (86) 1500-042-2360, who represents the Office of Structural Materials for your project.

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

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 22-Jun-2009

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: 05.03.06-000289

Subject: NCR No. ZPMC-0299

Reference Description: Missed MT Indication by QC, Base Metal of Deck Panel DP009A, Segment 3AW

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:** 03

Remarks:

During random verification magnetic particle testing (MT) of temporary weld removal areas between suspender bracket SB22W and OBG Deck Panel DP009A, Caltrans Quality Assurance (QA) Inspector discovered a linear indication measuring 10mm in length located in the deck panel. One hundred percent (100%) of the temporary weld removal areas were MT tested and accepted by ZPMC Quality Control technicians.

See attached NCR No. ZPMC-299 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues to remedy the defected work and with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0299

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000289

Subject: NCR No. ZPMC-0299

Dated: 07-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000285 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000285R00;

Caltrans' comments:

Status: REJ

Date: 21-Aug-2009

The proposed resolution is not acceptable. The attached documentation does not include the Critical Weld Repair report (CWR) or the Ultrasonic Testing (UT) report for the areas of base metal in question.

Please submit the CWR report and the acceptable UT report for the areas of base metal in question. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0299 at that time.

Submitted by: Wright, Doug

Date: 21-Aug-2009

Attachment(s):



No. B-432

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-5

REGARDING: NCR-000325 (ZPMC-0299)

With this letter of response, ZPMC requests closure for Caltrans **NCR-000325 (ZPMC-0299)**. We agree what describe in the non-conformance report, and instructed the QC guy to enhance the responsibility and reduce the working speed, and also buy some new MT machine which the type is same with the caltrans QA inspector. we have provided our MT technicians with proper lighting to decrease miss-discover occur in the future.

By the way we have performed the MT inspection to re-check the areas after weld repair, right now submit the report to support the good quality of the repair base metal.

So base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report **NCR-000325 (ZPMC-0299)**.

Please reference attached documentation for acceptance and closure the **NCR-000325 (ZPMC-0299)**.

ATTACHMENT:

NCR-000325 (ZPMC-0299)

ZPMC internal NCR

The final MT reports

Zhao Shuangbao

2009.8.5



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B
项目名称: 美国加州海湾大桥

NCR Number:
NCR 编号: NCR-B-205
(NCR-000325)

Item: Missed MT indication by QC
名称描述: MT 漏检

Item Number:
件号: N/A

Drawing:
图号: 3AW

Location: OBG Trial Assembly Yard
位置: OBG 总拼外场

Date:
日期: 2009-07-01

Description of Nonconformance:

不符合项状态描述:

During random verification magnetic particle testing of temporary weld removal areas between suspender bracket SB22W and OBG deck panel DP009A, Caltrans Quality Assurance inspector discovered a linear indication measuring 10mm in length located in the deck panel. One hundred percent 100% of the temporary weld removal areas were MT tested and accepted by ZPMC Quality control technicians.

加州检验员在对 SB22W 与顶板点焊位置去除后的位置做 MT 时发现线性缺陷, 缺陷长度为 10mm。此位置 100% MT 检测已被 ZPMCQC 接受。

Work By:

施工方:

Prepared by:

准备:

Reviewed by QCE:

质量工程师批准:

Drawing Error

图纸错误

Material Defect

材料缺陷

Fabrication Error

制作错误

Other

09.7.1
其他原因

Disposition: Use as is

处理措施: 回用

Repair

返修

Reject

拒收

Recommendation:

建议: 打磨, MT 确认去除.

Grind and perform MT to make sure that the defect is removed.

Prepared by:

准备

Approved by QCA:

质量经理批准

Reason for Nonconformance:

不符合原因:

点焊去除点线性缺陷未检测出
A linear indication wasn't discovered at the temporary weld removal areas.

预防措施:

加强质量现场控制及现场检验

Enhance supervision and inspection on the site.

Approved by/批准:

Technical Justification for Use-As-Is/Repair:

回用或返修的技术依据:

Attachment

Non-attachment

附件

无附件

Reviewed /批准:

Verification:

Acceptable

Unacceptable

确认:

可接受

不可接受

Verified by QCI/质检确认:

Reviewed by QCA/质检主任审核:

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: 22-Jun-2009

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: 05.03.06-000289

Subject: NCR No. ZPMC-0299

Reference Description: Missed MT Indication by QC, Base Metal of Deck Panel DP009A, Segment 3AW

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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- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG

Lift: 03

Remarks:

During random verification magnetic particle testing (MT) of temporary weld removal areas between suspender bracket SB22W and OBG Deck Panel DP009A, Caltrans Quality Assurance (QA) Inspector discovered a linear indication measuring 10mm in length located in the deck panel. One hundred percent (100%) of the temporary weld removal areas were MT tested and accepted by ZPMC Quality Control technicians.

See attached NCR No. ZPMC-299 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues to remedy the defected work and with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0299

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao
File: 05.03.06

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Bay Area Branch
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 (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, P.R. China

Report No: NCR-000325

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2009

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

NCR #: ZPMC-0299

Type of problem:

Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:

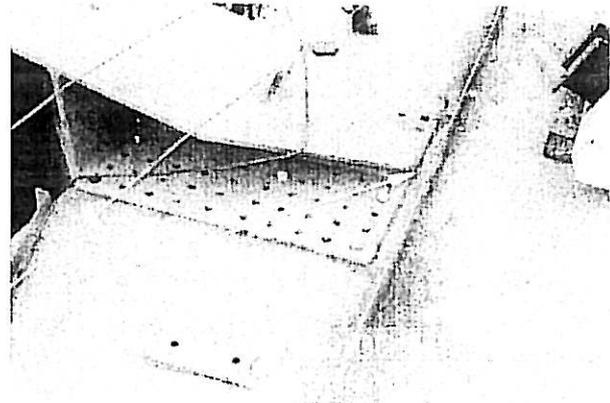
Bridge No: 34-0006

Component: OBG Segment 3AW

Reference Description: Missed MT Indication by QC, Base Metal of Deck Panel DP009A, Segment 3AW

Description of Non-Conformance:

During random verification magnetic particle testing (MT) of temporary weld removal areas between suspender bracket SB22W and OBG Deck Panel DP009A, Caltrans Quality Assurance (QA) Inspector discovered a linear indication measuring 10mm in length located in the deck panel. One hundred percent (100%) of the temporary weld removal areas were MT tested and accepted by ZPMC Quality Control technicians.



Applicable reference:

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AWS D1.5 (02) Section 3.3.7.4: "The removal of tack welds may expose unacceptably hard or cracked HAZs. Such areas on members subject to tension or reversal-of-stress shall be tested by MT (preferably by the yoke method) to assure that no cracks are present."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

AWS D1.5 (02) Section 6.26.2: "Welds that are subject to MT in addition to visual inspection shall have no cracks."

Who discovered the problem: M.Manikandan

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 10:00, 06/15/09, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 10:00, 06/19/09, Verbal

QC Inspector's Name: Wang Lu

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 Skyler Guest, (86) 1500-042-2360, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

SMR

Reviewed By: Wahbeh, Mazen

SMR

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000289

Subject: NCR No. ZPMC-0299

Dated: 18-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000285 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has now attached documents required for closure of this NCR as discussed with ABF and CT China.
ZPMC has now attached documents required for closure of this NCR as discussed with ABF and CT China.

Submitted by:

Attachment(s): ABF-NPR-000285R01;

Caltrans' comments:

Status: CLO

Date: 24-Sep-2009

Contractor has submitted all required documentation

Submitted by: Chao, Ching

Date: 24-Sep-2009

Attachment(s):



No. B-473

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-9-14

REGARDING: NCR-000325/333 (ZPMC-0299/307)

With this letter of response, ZPMC requests closure for Caltrans NCR-000325/333 (ZPMC-0299/307). Per the comments of the NPR we are providing the weld repair report that the repair has been performed and the final condition has been accepted too.

so base on the above explanation, ZPMC applies to close the caltrans's report NCR-000325/333 (ZPMC-0299/307).

Please reference attached document for acceptance and closure the NCR-000325/333 (ZPMC-0299/307).

ATTACHMENT:

NCR-000325/333 (ZPMC-0299/307)

The weld repair reports

The acceptable MT reports

Zhao Shuangbo

2009.9.14



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	SEG020B/SEG018C	报告编号 Report No.	B-WR7354
合同号 Contract No.:	04-0120F4	部件名称 Items Name	4E PLATE PANEL SPLICE	NDT报告编号 Report No.of NDT	B787-MT-13624
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

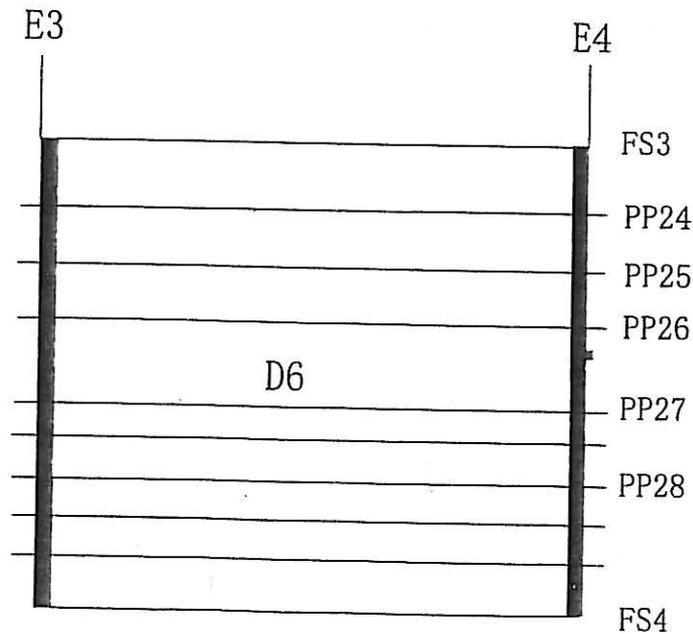
One line indication was found by use of MT on weld SEG020B-008. L=20 Y=0

One line indication was found by use of MT on weld SEG018C-026. L=30 Y=0

Sun Gongchang
 检验员 (Inspector): Sun Gongchang 日期(Date): 09.07.06

焊缝返修位置示意图:

Draft of welding discontinuity:



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): *Lizhi gang* 日期(Date): *09.07.12*

处理意见

Disposition :

1. 按照焊接返修工艺规程 (WPS) 打磨缺陷区域;
 2. 按照返修WPS准备焊接破口;
 3. 返修前对进行返修的区域作100%MT检查, 确保缺陷全部去除;
 4. 根据批准的焊接返修工艺规程 (WPS) 进行预热及焊接;
 5. 将焊接区域打磨至与周围母材平齐;
 6. 对修补区域进行VT与MT检测;
-
1. Remove all the defects according to the approved repair WPS by means of grinding.
 2. Prepare a groove based on the repair WPS.
 3. Verify with MT and VT no defects remain in the repair area prior to welding;
 4. Preheat and weld according to the relevant WPS.
 5. Grind the weld flush with adjacent base metal after welding.
 6. Perform VT and MT inspection to the repaired area.

工艺: *Hexiaolin*
Technical engineer *09.07.12*

审核:
Approved by

(Signature)

日期
Date *9.12*



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	SEG020B/SEG018C	报告编号 Report No.	B-WR7354
合同号 Contract No.:	04-0120F4	部件名称 Items Name	4E PLATE PANEL SPLICE	NDT报告编号 Report No.of NDT	B787-MT-13624
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

1. 加强焊接监控和道间清理。

1. Improve monitoring of welding and interpass cleaning.

车间负责人(Foreman): *Li Zhigang* 日期(Date): *09. 7. 12*

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-2 G(2F)-Repair WPS-345-FCAW-2 G(2F)-Repair-1 WPS-345-SMAW-2 G(2F)-FCM-Repair WPS-345-FCAW-2 G(2F)-FCM-Repair	工艺员 technologist	<i>Hexian Lin</i> <i>09.09.12</i>
返修(碳刨)前预热温度 Preheat temperature before gouging	<i>NA</i>	返修的缺陷 Description of discontinuity	<i>line indication</i>
焊前处理检查 Inspection before welding	<i>acc</i>	焊前预热温度 Preheat temperature before welding	<i>118°C</i>
最大碳刨深度 Max. depth of gouging	<i>NA</i>	碳刨总长 Total length of gouging	<i>NA</i>
焊工 welder <i>048659</i>	焊接类型 welding type <i>SMAW</i>	焊接位置 position <i>2F</i>	
焊接电流 Current <i>162</i>	焊接电压 Voltage <i>23</i>	焊接速度 Speed <i>112</i>	

返修后检查

Inspection After repairing:

外观检查 VT result <i>acc</i>	检验员 Inspector <i>Gu rong jian</i>	日期 Date <i>09. 7. 12</i>
NDT复检 NDT result <i>acc</i>	探伤员 NDT person <i>W. J. Chen</i>	日期 Date <i>09. 07. 12</i>

见证:

Witness/Review:

备注:

Remark:



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-13624 DATE日期 2009.07.06 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: SEG020B/018C CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4
 OBG 4E 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, 2009

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
 CASTING 铸件 20/14 mm
 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			
SEG020B-008	1	line indication	20		REJ.	Y=0
SEG018C-026	1	line indication	30		REJ.	Y=0
BLANK						

EXAMINED BY 主探: Sun gong chang *Sun Gongchang* REVIEWED BY 审核: Su wei *Su wei*
 LEVEL-II SIGN 签名 / DATE 日期: 9-27-06 LEVEL-II SIGN 签名 / DATE 日期: 9-26-09
 质量经理 / QCM: *(signature)* 用户 CUSTOMER: _____
 签字 SIGN / 日期 DATE: 7.6 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-13624R1-1 DATE日期 2009.07.12 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: SEG020B/018C CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
 OBG 4E 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, 2009

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
 CASTING 铸件 20/14 mm
 FORGING 锻造

WELDING PROCESS 焊接方法: SMAW 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			
SEG020B-008	1R1			ACC.		100%MT
SEG018C-026	1R1			ACC.		100%MT

AFTER B-WR7354

BLANK

EXAMINED BY 主探: Li zhen hua Li zhen hua 9.07.12
 LEVEL-II SIGN 签名 / DATE 日期
 质量经理 / QCM: Li zhen hua 7.12

REVIEWED BY 审核: Xu Hai 9.07.12
 LEVEL-II SIGN 签名 / DATE 日期
 用户 CUSTOMER: _____
 签字 SIGN / 日期 DATE: _____



焊缝返修报告

Welding Repair Report

版本 Rev. No.

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	DP9	报告编号 Report No.	B-WR7353
合同号 Contract No.:	04-0120F4	部件名称 Items Name	DECK PLATE	NDT报告编号 Report No.of NDT	B787-MT-11870
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

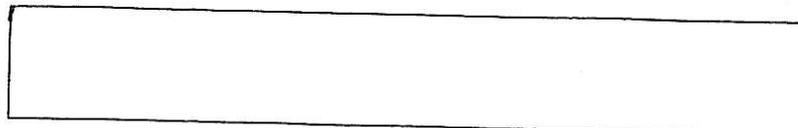
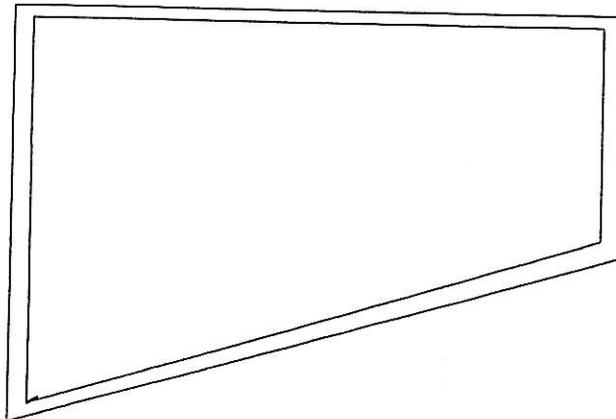
Description of welding discontinuity:

We found one line indication in material after removed tack welding PL1A. L=10 Y=0

检验员 (Inspector): Sun gong chang 日期(Date): 09.06.20

焊缝返修位置示意图:

Draft of welding discontinuity:



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 Haifei* 日期(Date): *07.08.22*

处理意见

Disposition:

1. 按照焊接返修工艺规程 (WPS) 打磨缺陷区域;
 2. 按照返修WPS准备焊接破口;
 3. 返修前对进行返修的区域作100%MT检查, 确保缺陷全部去除;
 4. 根据批准的焊接返修工艺规程 (WPS) 进行预热及焊接;
 5. 将焊接区域打磨至与周围母材平齐;
 6. 对修补区域进行VT与MT检测;
1. Remove all the defects according to the approved repair WPS by means of grinding.
 2. Prepare a groove based on the repair WPS.
 3. Verify with MT and VT no defects remain in the repair area prior to welding;
 4. Preheat and weld according to the relevant WPS.
 5. Grind the weld flush with adjacent base metal after welding.
 6. Perform VT and MT inspection to the repaired area.

工艺: *Hexiao Lin*
Technical engineer

07.08.22

审核:
Approved by

Wujianhua 日期
Date

7.12



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	DP9	报告编号 Report No.	B-WR7353
合同号 Contract No.:	04-0120F4	部件名称 Items Name	DECK PLATE	NDT报告编号 Report No.of NDT	B787-MT-11870
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): *Lidaifei* 日期(Date): *09.06.22*

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>flexiactin</i> <i>09.09.12</i>
返修(碳刨)前预热温度 Preheat temperature before gouging	<i>NA</i>	返修的缺陷 Description of discontinuity	<i>Line indication</i>
焊前处理检查 Inspection before welding	<i>acc</i>	焊前预热温度 Preheat temperature before welding	<i>136°C</i>
最大碳刨深度 Max. depth of gouging	<i>NA</i>	碳刨总长 Total length of gouging	<i>NA</i>
焊工 welder <i>04861</i>	焊接类型 welding type <i>SMAW</i>	焊接位置 position	<i>1G</i>
焊接电流 Current <i>158</i>	焊接电压 Voltage <i>22</i>	焊接速度 Speed	<i>108</i>
返修后检查 Inspection After repairing:			
外观检查 VT result <i>acc</i>	检验员 Inspector <i>Guorong Jiao</i> <i>07/2007/</i>	日期 Date	<i>09.06.22</i>
NDT复检 NDT result <i>acc</i>	探伤员 NDT person: <i>Changfangjie</i>	日期 Date	<i>09.06.22</i>
见证: Witness/Review:			
备注: Remark:			

#R787-QCP-900

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, P.R. China**Report No:** NCS-000368**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0299**Type of problem:**

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

Date the Non-Conformance Report was written: 15-Jun-2009**Description of Non-Conformance:**

During random verification magnetic particle testing (MT) of temporary weld removal areas between suspender bracket SB22W and OBG Deck Panel DP009A, Caltrans Quality Assurance (QA) Inspector discovered a linear indication measuring 10mm in length located in the deck panel. One hundred percent (100%) of the temporary weld removal areas were MT tested and accepted by ZPMC Quality Control technicians.

Contractor's proposal to correct the problem:

Repair area in question and perform the required NDT.

Corrective action taken:

Contractor submitted Welding Repair Report (WRR 7353) along with the required MT report confirming that the repair is in conformance with the Contract requirements.

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 Jim Simonis: 1347 246 3441, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer