

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

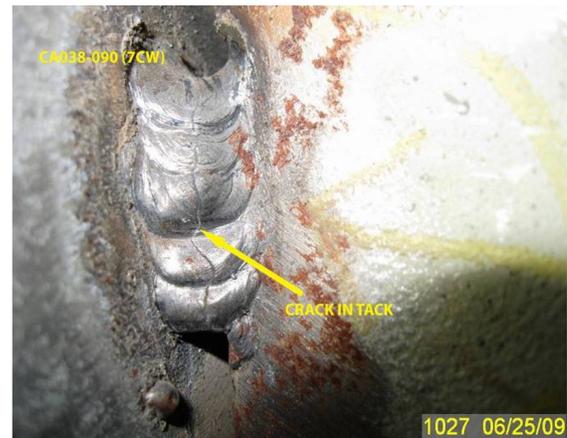
Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000342**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0316**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG Segments 7CW & 7DW**Procedural****Procedural****Description:****Reference Description:** QC missed VT linear indications on tack welds**Description of Non-Conformance:**

During in process visual inspection of the fabrication of segment assemblies for OBG segment 7CW and 7DW, Caltrans Quality Assurance (QA) Inspector discovered that the corner assemblies (CA) stiffener connected to the deck plate stiffener was fit-up and tack welded at CA041-028 (7DW) and CA038-090 (7CW). Linear indications were present in the center of said tacks. These tack welds were previously accepted by ZPMC QC personnel.

**Applicable reference:**

AWS D1.5 (2002) – Sec. 6.26.1.1 “The weld shall have no cracks.”

AWS D1.5 (2002) – Sec. 3.3.7.1 “Tack welds shall be subject to the same quality requirements as the final welds...”

Who discovered the problem: Chandrakumar S.**Name of individual from Contractor notified:** Liu Jin Ping**Time and method of notification:** 1030 hours, Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 1130 hours, Verbal

QC Inspector's Name: Xu Tao

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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

Inspected By:	Simonis,Jim	QA Inspector
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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: 07-Jul-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: 05.03.06-000306

Subject: NCR No. ZPMC-0316

Reference Description: QC missed VT linear indications on tack welds

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:** 07

Remarks:

During in process visual inspection of the fabrication of segment assemblies for OBG segment 7CW and 7DW, Caltrans Quality Assurance (QA) Inspector discovered that the corner assemblies (CA) stiffener connected to the deck plate stiffener was fit-up and tack welded at CA041-028 (7DW) and CA038-090 (7CW). Linear indications were present in the center of said tacks. These tack welds were previously accepted by ZPMC QC personnel.

Please see attached NCR ZPMC-316 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

Transmitted by: Ching Chao

Attachments: ZPMC-0316

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: 05.03.06-000306

Subject: NCR No. ZPMC-0316

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000318 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The cracked tack welds were ground out prior to production welding. ZPMC will submit inspection reports at a later date to close this NCR.

ZPMC acknowledges cracked welds are unacceptable, however, even though ZPMC inspected and accepted these tack welds, it is not uncommon tack welds to crack later as there is minimal weld strength involved. The cracked tack welds were ground out prior to production welding. ZPMC will submit inspection reports at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000318R00

Caltrans' comments:

Status: AAP

Date: 28-Aug-2009

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

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-0316 at that time.

Submitted by: Wright, Doug

Date: 28-Aug-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000306

Subject: NCR No. ZPMC-0316

Dated: 11-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000318 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: As stated in the ZPMC response letter, ZPMC had not performed the inspection of these tacks as there was no acceptance indication marked on the part. These tacks were removed prior to welding.

As stated in the ZPMC response letter, ZPMC had not performed the inspection of these tacks as there was no acceptance indication marked on the part. These tacks were removed prior to welding. ZPMC requests closure of this NCR.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000318R01;

Caltrans' comments:

Status: REJ

Date: 11-Jan-2010

Until verification is received that these tacks were removed prior to production welding, this NPR is rejected.

Submitted by: Howe, Bill

Attachment(s):

Date: 11-Jan-2010



No. B-547

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-1-5

REGARDING: NCR-000342(ZPMC-0316)

With this letter of response, ZPMC requests withdraw of CALTRANS NCR-000342(ZPMC-0316) what mentioned that QA observed tack welds' crack.

This QA inspector discovered several tack welds' crack before ZPMC performing welding. And this QA Inspector thought ZPMC has accepted these tack welds. It should be clarified that this QA inspector performed VT to these tacks prior to ZPMC's QC inspection. No "VT ACC" has been marked by ZPMC QC at the adjacent area for these welds. Further more these unacceptable tacks have been removed prior to production welding according to fabrication procedure.

So ZPMC thought no NON-CONFORMANCE was occurred here. Please could take a review and consider **withdraw** this NCR.

ATTACHMENT:

NCR-000342(ZPMC-0316)

Long W
1/5/10



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: 07-Jul-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: 05.03.06-000306

Subject: NCR No. ZPMC-0316

Reference Description: QC missed VT linear indications on tack welds

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: 07

Remarks:

During in process visual inspection of the fabrication of segment assemblies for OBG segment 7CW and 7DW, Caltrans Quality Assurance (QA) Inspector discovered that the corner assemblies (CA) stiffener connected to the deck plate stiffener was fit-up and tack welded at CA041-028 (7DW) and CA038-090 (7CW). Linear indications were present in the center of said tacks. These tack welds were previously accepted by ZPMC QC personnel.

Please see attached NCR ZPMC-316 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

Transmitted by: Ching Chao

Attachments: ZPMC-0316

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

File: 05.03.06

02.02;15.04

05.03.06-000306.NCT

Received
NCT 000306 08 Jul 09

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-000342

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 25-Jun-2009

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

NCR #: ZPMC-0316

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

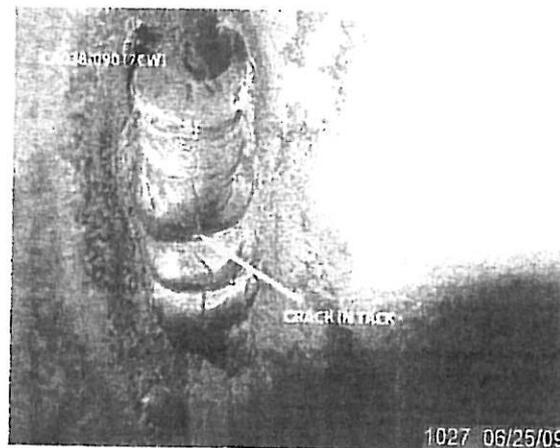
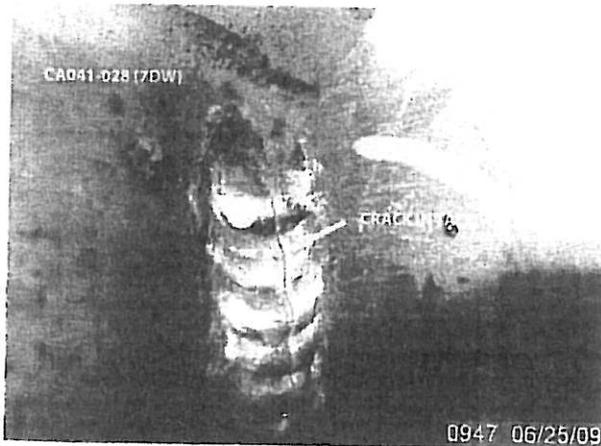
Bridge No: 34-0006

Component: OBG Segments 7CW & 7DW

Reference Description: QC missed VT linear indications on tack welds

Description of Non-Conformance:

During in process visual inspection of the fabrication of segment assemblies for OBG segment 7CW and 7DW, Caltrans Quality Assurance (QA) Inspector discovered that the corner assemblies (CA) stiffener connected to the deck plate stiffener was fit-up and tack welded at CA041-028 (7DW) and CA038-090 (7CW). Linear indications were present in the center of said tacks. These tack welds were previously accepted by ZPMC QC personnel.



Applicable reference:

AWS D1.5 (2002) – Sec. 6.26.1.1 “The weld shall have no cracks.”

AWS D1.5 (2002) – Sec. 3.3.7.1 “Tack welds shall be subject to the same quality requirements as the final welds...”

Who discovered the problem: Chandrakumar S.

Name of individual from Contractor notified: Liu Jin Ping

Time and method of notification: 1030 hours, Verbal

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000306

Subject: NCR No. ZPMC-0316

Dated: 27-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000318 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT documentation of the weld to show that welds are acceptable. The tack welds documented in the NCR were removed prior to welding. ZPMC requests closure of this NCR.

ZPMC is providing NDT documentation of the weld to show that welds are acceptable. The tack welds documented in the NCR were removed prior to welding. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000318R02;

Caltrans' comments:

Status: CLO

Date: 02-Feb-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Date: 02-Feb-2010

Attachment(s):



No. B-590

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-1-22

REGARDING: NCR-00342 (ZPMC-0316)

With this letter of response, ZPMC requests closure of CT NCR-00342 (ZPMC-0316), what mentioned that CT Inspector observed VT linear indications on tack welds.

- This CT inspector performed Visual Inspection prior to ZPMC's, so it's shouldn't been identified as missed VT linear indications by ZPMC.
- These tack welds were removed prior to welding.
- FVT for Segments have been performed and accepted by three parties.
- MT was performed to warrant the welds' quality. See attached B787-MT-16712 & B787-MT-16921.

Based on the responses and documentations, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-0000342 (ZPMC-0316)

B787-MT-16712

B787-MT-16921

1/22/10 [Signature]

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch

690 Walnut Ave. St. 150

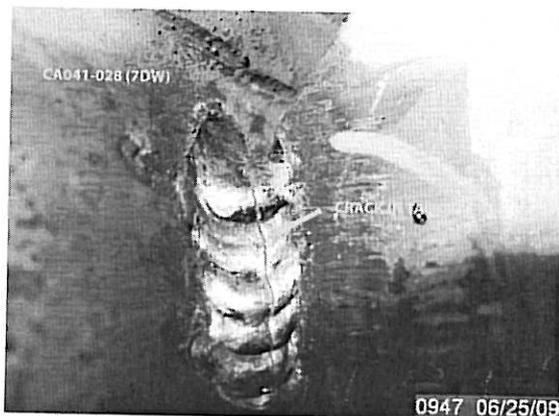
Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000342**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0316**Type of problem:**Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description: **Bridge No:** 34-0006**Component:** OBG Segments 7CW & 7DW**Reference Description:** QC missed VT linear indications on tack welds**Description of Non-Conformance:**

During in process visual inspection of the fabrication of segment assemblies for OBG segment 7CW and 7DW, Caltrans Quality Assurance (QA) Inspector discovered that the corner assemblies (CA) stiffener connected to the deck plate stiffener was fit-up and tack welded at CA041-028 (7DW) and CA038-090 (7CW). Linear indications were present in the center of said tacks. These tack welds were previously accepted by ZPMC QC personnel.

**Applicable reference:**

AWS D1.5 (2002) – Sec. 6.26.1.1 “The weld shall have no cracks.”

AWS D1.5 (2002) – Sec. 3.3.7.1 “Tack welds shall be subject to the same quality requirements as the final welds...”

Who discovered the problem: Chandrakumar S.**Name of individual from Contractor notified:** Liu Jin Ping**Time and method of notification:** 1030 hours, Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 1130 hours, Verbal

QC Inspector's Name: Xu Tao

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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

Inspected By: Simonis, Jim

QA Inspector

Reviewed By: Wahbeh, Mazen

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-16712		DATE日期 2010.01.03	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: CA038 OBG 7CW CORNER ASSEMBLY		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 , 2010			
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 12/16/30/35mm			
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	CORNER-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			
CA038-007				ACC.		100%MT
CA038-008				ACC.		100%MT
CA038-009				ACC.		100%MT
CA038-010				ACC.		100%MT
CA038-011				ACC.		100%MT
CA038-012				ACC.		100%MT
CA038-013				ACC.		100%MT
CA038-014				ACC.		100%MT
CA038-015				ACC.		100%MT
CA038-016				ACC.		100%MT
CA038-017				ACC.		100%MT
CA038-018				ACC.		100%MT
CA038-025				ACC.		100%MT
CA038-026				ACC.		100%MT
CA038-027				ACC.		100%MT
CA038-028				ACC.		100%MT
EXAMINED BY 主探 Sun Gongchang <i>Sun Gongchang</i>		REVIEWED BY 审核 <i>Su Wei</i>				
LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM		LEVEL-II SIGN / DATE日期				
SIGN / DATE		SIGN / DATE				



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-16712 DATE日期 2010.01.03 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: CA038 CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4
 OBG 7CW CORNER ASSEMBLY

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, 2010

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 12/16/30/35mm
 FORGING 锻造

WELDING PROCESS 焊接方法: SMAW TYPE OF JOINT 焊缝类型: CORNER-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			
CA038-029				ACC.		100%MT
CA038-030				ACC.		100%MT
CA038-037				ACC.		100%MT
CA038-038				ACC.		100%MT
CA038-039				ACC.		100%MT
CA038-040				ACC.		100%MT
CA038-041				ACC.		100%MT
CA038-042				ACC.		100%MT
CA038-049				ACC.		100%MT
CA038-050				ACC.		100%MT
CA038-051				ACC.		100%MT
CA038-052				ACC.		100%MT
CA038-053				ACC.		100%MT
CA038-054				ACC.		100%MT
CA038-061				ACC.		100%MT
CA038-062				ACC.		100%MT

EXAMINED BY 主探: Sun Gongchang REVIEWED BY 审核: Su Wei
 LEVEL - II SIGN 签名 / DATE日期: 12.1.3 LEVEL-II SIGN / DATE日期: 12.1.3
 质量经理 / QCM 用户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-16712 DATE日期 2010.01.03 PAGE OF页码 3/3 Revision No: 0

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

DRAWING NO. CA038 CALTRANS CONTRACT NO.: 04-0120F4
 图号: OBG 7CW CORNER ASSEMBLY 加州工程编号

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 , 2010
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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
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MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
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PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
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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 12/16/30/35mm
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WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	CORNER-JOINT
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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			
CA038-063				ACC.		100%MT
CA038-064				ACC.		100%MT
CA038-065				ACC.		100%MT
CA038-066				ACC.		100%MT
CA038-073				ACC.		100%MT
CA038-074				ACC.		100%MT
CA038-075				ACC.		100%MT
CA038-076				ACC.		100%MT
CA038-077				ACC.		100%MT
CA038-078				ACC.		100%MT
CA038-085				ACC.		100%MT
CA038-086				ACC.		100%MT
CA038-087				ACC.		100%MT
CA038-088				ACC.		100%MT
CA038-089				ACC.		100%MT
CA038-090				ACC.		100%MT

EXAMINED BY 主探
 Sun Gongchang Sun Gongchang 10.1.3
 LEVEL - II SIGN 签名 / DATE日期

REVIEWED BY 审核
 Su Wei Su Wei 10.1.3
 LEVEL-II SIGN / DATE日期

质量经理 / QCM
 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-16921 DATE日期 2010.01.16 PAGE OF页码 1/3 Revision No: 0

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

DRAWING NO. CA041 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 7DW CORNER ASSEMBLY 加州工程编号

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 , 2010
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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
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MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
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PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
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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 12/18/16/30mm
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WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	CORNER-JOINT
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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			
CA041-008				ACC.		100%MT
CA041-009				ACC.		100%MT
CA041-012				ACC.		100%MT
CA041-013				ACC.		100%MT
CA041-016				ACC.		100%MT
CA041-017				ACC.		100%MT
CA041-025				ACC.		100%MT
CA041-026				ACC.		100%MT
CA041-027				ACC.		100%MT
CA041-028				ACC.		100%MT
CA041-029				ACC.		100%MT
CA041-030				ACC.		100%MT
CA041-037				ACC.		100%MT
CA041-038				ACC.		100%MT
CA041-039				ACC.		100%MT
CA041-040				ACC.		100%MT

EXAMINED BY 主探 Sun Gongchang LEVEL - II SIGN 签名 / DATE日期 10.1.16 质量经理 / QCM	REVIEWED BY 审核 Su Wei LEVEL-II SIGN / DATE日期 10.1.16 用户 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-16921 DATE日期 2010.01.16 PAGE OF页码 2/3 Revision No: 0

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

DRAWING NO. CA041 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 7DW CORNER ASSEMBLY 加州工程编号

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 , 2010
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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
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MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
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PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
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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 12/18/16/30mm
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WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	CORNER-JOINT
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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			
CA041-041				ACC.		100%MT
CA041-042				ACC.		100%MT
CA041-049				ACC.		100%MT
CA041-050				ACC.		100%MT
CA041-051				ACC.		100%MT
CA041-052				ACC.		100%MT
CA041-053				ACC.		100%MT
CA041-054				ACC.		100%MT
CA041-061				ACC.		100%MT
CA041-062				ACC.		100%MT
CA041-063				ACC.		100%MT
CA041-064				ACC.		100%MT
CA041-065				ACC.		100%MT
CA041-066				ACC.		100%MT
CA041-073				ACC.		100%MT
CA041-074				ACC.		100%MT

EXAMINED BY主探 Sun Gongchang <i>Sun Gongchang</i> LEVEL - II SIGN 签名 / DATE日期 10.1.16 质量经理 / QCM	REVIEWED BY 审核 <i>Su Wei</i> LEVEL-II SIGN / DATE日期 10.1.16 用户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-16921 DATE日期 2010.01.16 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: CA041 7DW CORNER ASSEMBLY		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 , 2010
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 12/18/16/30mm
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	CORNER-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			
CA041-075				ACC.		100%MT
CA041-076				ACC.		100%MT
CA041-077				ACC.		100%MT
CA041-078				ACC.		100%MT
CA041-085				ACC.		100%MT
CA041-086				ACC.		100%MT
CA041-087				ACC.		100%MT
CA041-088				ACC.		100%MT
CA041-089				ACC.		100%MT
CA041-090				ACC.		100%MT
CA041-007				ACC.		100%MT
CA041-010				ACC.		100%MT
CA041-011				ACC.		100%MT
CA041-014				ACC.		100%MT
CA041-015				ACC.		100%MT
CA041-018				ACC.		100%MT

EXAMINED BY 主探 Sun Gongchang <i>Sun Gongchang</i>	REVIEWED BY 审核 <i>Sun Wei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>10.1.16</i>	LEVEL-II SIGN / DATE日期 <i>10.1.16</i>
质量经理 / QCM	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, P.R. China**Report No:** NCS-000498**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0316**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: 25-Jun-2009**Description of Non-Conformance:**

During in process visual inspection of the fabrication of segment assemblies for OBG segment 7CW and 7DW, Caltrans Quality Assurance (QA) Inspector discovered that the corner assemblies (CA) stiffener connected to the deck plate stiffener was fit-up and tack welded at CA041-028 (7DW) and CA038-090 (7CW). Linear indications were present in the center of said tacks. These tack welds were previously accepted by ZPMC QC personnel.

Contractor's proposal to correct the problem:

Remove cracked tack welds prior to final welding and perform required NDT.

Corrective action taken:

Crack tack welds were removed prior to final welding and the Contractor submitted NDT documentation verifying the welds are in conformance with 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 152. 1675.3703, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer