

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-000424**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Sep-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0398**Type of problem:**

| | | | |
|---------------------|-------------------|---|--|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: Segment 10AE SEG060A-011 |
| Procedural | Procedural | Description: Missed UT Indication on Bottom to Side Plate Weld | |

Reference Description: Missed UT indications by QC on SEG060A-011**Description of Non-Conformance:**

During random verification Ultrasonic Testing (UT) of the Bottom to Side Plate weld identified as SEG060A-011 in OBG segment 10AE. Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one linear rejectable indication that measured 20mm in length.

This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

**Applicable reference:**

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5-2002 Table 6.3.

AWS D1.5-2002 section 6.261.1; The welds shall have no cracks.

Who discovered the problem: Chandra Kumar Sudalaimuthu

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Man Kit Li

Time and method of notification: 1730 hours, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1900 hours, Verbal

QC Inspector's Name: Tao Lei

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|-------------|-----|
| Inspected By: | Tsang, Eric | SMR |
|----------------------|-------------|-----|

| | | |
|---------------------|---------------|-----|
| Reviewed By: | Wahbeh, Mazen | SMR |
|---------------------|---------------|-----|



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 28-Sep-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: 05.03.06-000389

Subject: NCR No. ZPMC-0398

Reference Description: Missed UT indications by QC on SEG060A-011

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:** 10

Remarks:

During random verification Ultrasonic Testing (UT) of the Bottom to Side Plate weld identified as SEG060A-011 in OBG segment 10AE. Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one linear rejectable indication that measured 20mm in length.

This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

Please see the attached NCR No. ZPMC-398 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 with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0398

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000389

Subject: NCR No. ZPMC-0398

Dated: 16-Oct-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000390 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABFJV QCM has implemented training with ZPMC to improve the quality of inspections. ABFJV will provide documentation showing attendance by ZPMC QC inspectors and the subject of training.

ABFJV QCM has implemented training with ZPMC to improve the quality of inspections. ABFJV will provide documentation showing attendance by ZPMC QC inspectors and the subject of training. Topics to be covered during the instruction are: inspection of equipment prior to use, proper conditions for inspection, proper technique for MT, and UT. In addition, ABFJV has committed to perform overchecks in both the Tower and OBG. This will serve two purposes, first to monitor if the training is effective at reducing the number of missed indications and second to ensure missed indications are prevented.

Documentation of repairs and subsequent NDT specific to this report will be transmitted through Daily Welding Reports and will be available in the documentation data base. Based on this course of action, ZPMC is requesting that this proposed resolution be approved with action pending. Once training records are available to be transmitted, ZPMC will request closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000390R00

Caltrans' comments:

Status: REJ

Date: 19-Oct-2009

The proposed resolution for training the QC inspectors is acceptable. However, documentation of repairs and subsequent NDT specific to this NCR should be submitted, along with the training records, for the Department's review prior to closure of the NCR.

Submitted by: Chao, Ching

Date: 19-Oct-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000389

Subject: NCR No. ZPMC-0398

Dated: 14-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000390 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: Attached is document of the repair ZPMC has performed as well as the NDT after repair. Based on this ZPMC requests closure of this NCR.

ZPMC QA has issued an internal NCR for the missed indication. In addition, the ABFJV QCM has conducted refresher training with ZPMC UT inspectors and has previously submitted the training agenda and sign in sheet to the Department for verification to show the steps ABFJV is taking to address the missed indications. In addition, ABFJV has implemented NDT verification of welds to ensure that welds are acceptable prior to being inspected by the Engineer. Attached is document of the repair ZPMC has performed as well as the NDT after repair. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000390R01;

Caltrans' comments:

Status: CLO

Date: 27-Dec-2009

The documentation received closes this NCR.

Submitted by: Howe, Bill

Date: 27-Dec-2009

Attachment(s):



No. B-528

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-12-11

REGARDING: NCR-000424 (ZPMC-0398)

With this letter of response, ZPMC requests closure for CALTRANS NCR-000424 (ZPMC-0398) what mentioned that QA observed missed UT indication by ZPMC QC Technicians.. ZPMC acknowledged this problem and has issued internal NCR. ZPMC has confirmed the UT indication and issued WRR to repair. After that NDT was performed to warrant weld's quality. To enhance our UT inspection, training was performed to all the UT inspectors by ABF's QCM. So ZPMC provides internal NCR, WWR, NDT documentations and UT Training Record, hoping CALTRANS could take a review and consider close the NCR.

ATTACHMENT:

NCR-B-269

NCR-000424 (ZPMC-0398)

B-WR8139

B787-UT-9106

B787-UT-9106R1

Log
12/11/09



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-269 (ZPMC-0398)

Item: Missed UT Indication
名称描述: UT 漏检

Item Number:
件号:

Drawing: 10AE
图号:

Location: BAY 14
位置: 14 车间

Date:
日期: 2009-10-1

Description of Nonconformance:

不符合项状态描述:

During random verification Ultrasonic Testing (UT) of the Bottom to Side Plate weld identified as SEG060A-011 in OBG segment 10AE. Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one linear rejectable indication that measured 20mm in length. This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

在随机 UT 检验 10AE 底板到斜底板的对接焊缝 SEG060A-011 时, 加州检验员发现一条长约 20MM 的线性缺陷。这条焊缝之前已经被 ZPMC UT 检验员检测并接受。

Work By: [Signature]
施工方:

Prepared by: zhongwei
准备: 09.10.1

Reviewed by QCE: [Signature]
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 10-1 其他原因

Disposition: Use as is 回用 Repair 返修 Reject 拒收

Recommendation:

建议: 确认缺陷位置大小, 出具报告
Confirm defect size and issue repair report.

Prepared by: [Signature] Approved by QCA: _____
准备 质量经理批准

Reason for Nonconformance:

不符合原因: 因DB误差而导致不合格缺陷产生
DB error caused rejected defect.

Prevention of Re-occurrence:

预防措施: Enhance operation to avoid equipment error.
加强规范操作, 避免人为仪器方面差异

Approved by/批准: [Signature]

Technical Justification for Use-As-Is/Repair: Attachment 附件 Non-attachment 无附件

Reviewed /批准: _____

Verification: Acceptable 可接受 Unacceptable 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: 28-Sep-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: 05.03.06-000389

Subject: NCR No. ZPMC-0398

Reference Description: Missed UT indications by QC on SEG060A-011

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Lift: 10

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Transmitted by: Ching Chao

Attachments: ZPMC-0398

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

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
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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-000424

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 02-Sep-2009

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

NCR #: ZPMC-0398

Type of problem:

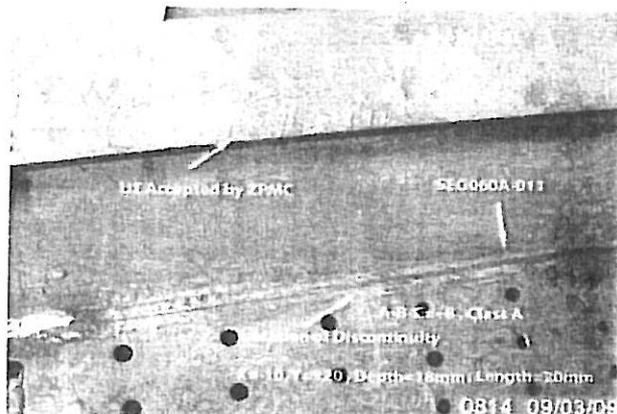
Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Segment 10AE SEG060A-011Procedural Procedural Description: Missed UT Indication on Bottom to Side Plate Weld

Reference Description: Missed UT indications by QC on SEG060A-011

Description of Non-Conformance:

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AWS D1.5-2002 Table 6.3.

AWS D1.5-2002 section 6.261.1; The welds shall have no cracks.

Who discovered the problem: Chandra Kumar Sudalaimuthu

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Man Kit Li

Time and method of notification: 1730 hours, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1900 hours, Verbal

QC Inspector's Name: Tao Lei

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

| | | | | | |
|----------------------|-----------------|--------------------|--------------------------------------|------------------------------|--------------|
| 项目名称 Project Name | 美国海湾大桥 SFOBB | 部件图号 Drawing No | SEG060A | 报告编号 Report No. | B-WR8139 |
| 合同号 Contract No. | 04-0120F4 | 部件名称 Items Name | 10AE BOTTOM AND SIDE PLATE SPLICE | NDT报告编号 Report No. of NDT | B787-UT-9106 |
| 项目编号 Project No.: | ZP06-787 | | | | |

焊缝缺陷描述:

Description of welding discontinuity:

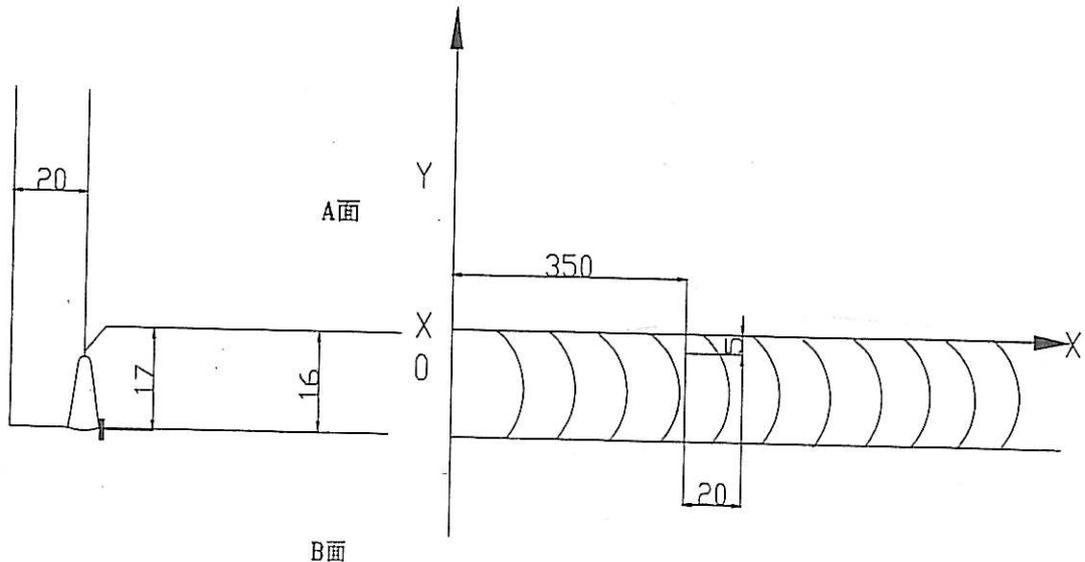
Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

(UT探伤发现的缺陷总长度小于最大允许长度。) SEG060A-011

检验员 (Inspector) : Huang Jin 日期 (Date) : 09.10.11*Huang Jin*

焊缝返修位置示意图:

Draft of welding discontinuity:



WELD NUMBER: SEG060A-011

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 gong*

日期(Date): 07.10.16.

处理意见

Disposition :

1. 从缺陷距离端面较近一侧 ($D \leq 0.65T$, D为缺陷深度, T为板厚) 采用碳刨或打磨的方法去除焊缝缺陷;
2. 参照返修焊接工艺规程 (WPS) 准备正确的接头型式, 预热和焊接;
3. 焊前对修补区域进行VT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 ($D \leq 0.65T$, "D" is depth of defects, "T" is thickness of metal) to remove all defects;
2. Follow repair WPS for joint preparation, preheat, and weld deposit;
3. Verify with VT 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: *Ji Dong kai*
Technical engineer

07.10.16.

审核:
Approved by

日期
Date



焊缝返修报告

Welding Repair Report

版本 Rev. No. 0

| | | | |
|-----------------------|--|------------------------------|----------------------------|
| 项目名称 美国海湾大桥 | 部件图号 SFOBB | 报告编号 SEG060A | 合同号 04-0120F4 |
| Project Name SFOBB | Drawing No SEG060A | Report No. B-WR8139 | Contract No.: 04-0120F4 |
| 项目编号 ZP06-787 | 部件名称 10AE BOTTOM AND SIDE PLATE SPLICE | NDT报告编号 Report No. of NDT | Project No.: ZP06-787 |
| 纠正措施: | 10AE BOTTOM AND SIDE PLATE SPLICE | | |
| 纠正措施: | Report No. of NDT | | |
| 纠正措施: | B787-UT-9106 | | |

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): 09.10.16

| | | | | | | | | | |
|--|--|--|--|---------------------------------|--------------|----------------------|-----------------|----------------------------|--------------------------------------|
| 参照的WPS编号 G(1F)-FCM-Repair WPS-345-SMAW-1 | 返修的缺陷 Description of discontinuity | 返修 (碳刨) 前预热温度 Preheat temperature before gouging | 焊前处理检查 Inspection before welding | 最大碳刨深度 Max. depth of gouging | 焊工 Welder | 焊接类型 Welding type | 焊接电压 Voltage | 焊接速度 Speed | 返修后检查 Inspection After repairing: |
| WPS-345-SMAW-1 | 70°C | 70°C | Acc | 4mm | 200113 | SMAW | 25.4 | 102 | 外观检查 VT result Acc |
| G(1F)-FCM-Repair WPS-345-FCAW-1 | 返修的缺陷 Description of discontinuity | 焊前预热温度 Preheat temperature before welding | 焊前处理检查 Inspection before welding | 碳刨总长 Total length of gouging | 40mm | 4G | 102 | NDT复验 NDT result Acc | 备注: Witness/Review: |
| G(1F)-FCM-Repair WPS-345-SMAW-4 | 返修的缺陷 Description of discontinuity | 焊前预热温度 Preheat temperature before welding | 焊前处理检查 Inspection before welding | 碳刨总长 Total length of gouging | 40mm | 4G | 102 | NDT复验 NDT result Acc | 见证: Date |
| G(4F)-FCM-Repair WPS-345-SMAW-4 | 返修的缺陷 Description of discontinuity | 焊前预热温度 Preheat temperature before welding | 焊前处理检查 Inspection before welding | 碳刨总长 Total length of gouging | 40mm | 4G | 102 | NDT复验 NDT result Acc | 探伤员 Date |
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| | | | | | | | | | | |
|--|--|---|--|--|---------------------------------|--------------|----------------------|-----------------|----------------------------|--------------------------------------|
| 车间负责人(Foreman): <i>Li Zhigang</i> 日期(Date): 09.10.16 | 参照的WPS编号 G(1F)-FCM-Repair WPS-345-SMAW-1 | 返修的缺陷 Description of discontinuity | 返修 (碳刨) 前预热温度 Preheat temperature before gouging | 焊前处理检查 Inspection before welding | 最大碳刨深度 Max. depth of gouging | 焊工 Welder | 焊接类型 Welding type | 焊接电压 Voltage | 焊接速度 Speed | 返修后检查 Inspection After repairing: |
| WPS-345-SMAW-1 | 70°C | 70°C | Acc | 4mm | 40mm | 200113 | SMAW | 25.4 | 102 | 外观检查 VT result Acc |
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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-9106R1 DATE 2009.12.10 PAGE 1 OF 1 Revision No: 0

| | | | |
|---|--|--|---|
| PROJECT NO.: 工程编号 ZP06-787 | | CONTRACTOR: CALTRANS | |
| ITEMS NAME: 10AE BOTTOM AND SIDE PLATE SPLICE 部件名称 | DRAWING NO.: SEG060A 图号 | CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号 | |
| REFERENCING CODE 参考规范 AWS D1.5-2002 | ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3) | PROCEDURE NO. 程序编号 ZPQC-UT-01 | |
| WELDING PROCESS 焊接方法 SMAW | JOINT TYPE 焊缝类型 CORNER-JOINT | CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2009 | |
| EQUIPMENT 设备 UT SCOPE | MANUFACTURER 制造商 PANAMETRICS | MODEL NO. 样式编号 EPOCH-4B | SERIAL NO. 序列编号 071565311, 061488510, 061495811, 070152011, |
| CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE II | COUPLANT 耦合剂 C.M.C | MATERIAL/THICKNESS 材料厚度 A709M-345F2-X 16/20mm | |

TRANSDUCER 探头

| MANUFACTURER 制造商 | ANGLE 角度 | FREQUENCY 频率 | SIZE 尺寸 | MANUFACTURER 制造商 | ANGLE 角度 | FREQUENCY 频率 | SIZE 尺寸 |
|---------------------|-------------|-----------------|------------|-----------------------|-------------|-----------------|------------|
| 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 | | | |
| SEG060A-011 | 1R1 | 70 | | | | 33 | | | | | | | | | ACC. | 100% |
| AFTER B-WR8139 | | | | | | | | | | | | | | | | |
| BLANK | | | | | | | | | | | | | | | | |
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| EXAMINED BY 主探 <i>Huang Jin</i> 09.12.10 LEVEL - II SIGN / DATE | REVIEWED BY 审核 <i>X. Williams</i> 09.12.10 LEVEL - II SIGN / DATE |
| 质量经理 / QCM 签字 SIGN / 日期 DATE | 用户 CUSTOMER 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
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000434**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0398**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: 02-Sep-2009**Description of Non-Conformance:**

During random verification Ultrasonic Testing (UT) of the Bottom to Side Plate weld identified as SEG060A-011 in OBG segment 10AE. Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one linear rejectable indication that measured 20mm in length.

This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

Contractor's proposal to correct the problem:

Repair indication, perform the required NDT, and provide training for the NDT Technician.

Corrective action taken:

Contractor submitted WRR along with NDT reports verifying the repairs are in conformance with Contract specifications. NDT Technician also received additional training.

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, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**