

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



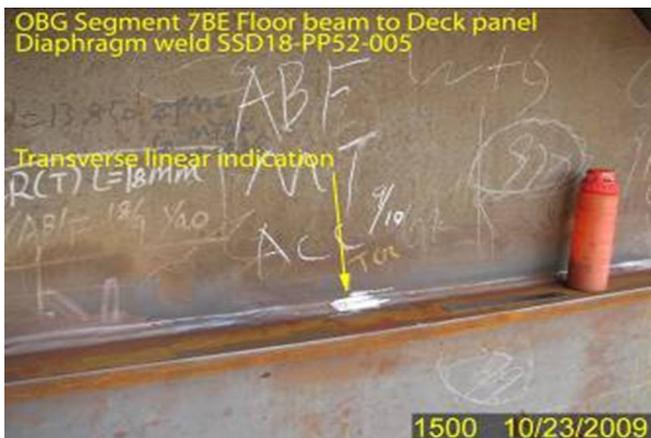
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000489**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Oct-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0462**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 7BE Floorbeam
Procedural	Procedural	Description: Missed MT indication by QC	

Reference Description: Missed MT indication by QC on Segment 7BE floorbeam flange**Description of Non-Conformance:**

During a random Magnetic Particle (MT) verification of Floor Beam to Deck Panel Diaphragm at OBG Segment 7BE, Caltrans Quality Assurance (QA) Inspector observed one (1) Transverse Crack measuring 10 mm in length on weld SSD18-PP52-005. This weld was previously tested and accepted by ZPMC and ABF Magnetic Particle Testing (MT) technicians.

**Applicable reference:**

AWS D1.5 (02) - 6.26.1; "The weld shall have no cracks."

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: Larry Viars**Name of individual from Contractor notified:** Li Man Kit**Time and method of notification:** 1500 hours, Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1600 hours, verbal

QC Inspector's Name: Zhang Dai

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: Carreon,Albert

Lead Reviewer/Task Leader

Reviewed By: Wahbeh,Mazen

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 02-Dec-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: 05.03.06-000452

Subject: NCR No. ZPMC-0462

Reference Description: Missed MT indication by QC on Segment 7BE floorbeam flange

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 a random Magnetic Particle (MT) verification of Floor Beam to Deck Panel Diaphragm at OBG Segment 7BE, Caltrans Quality Assurance (QA) Inspector observed one (1) Transverse Crack measuring 10 mm in length on weld SSD18-PP52-005. This weld was previously tested and accepted by ZPMC and ABF Magnetic Particle Testing (MT) technicians.

Action Required and/or Action Taken:

Submit a repair plan to the engineer for approval. Missing MT indications is a chronic issue. Train the MT inspectors in proper MT techniques and provide a certificate of competency.

Transmitted by: Bill Howe

Attachments: ZPMC-0462

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Dated: 18-Dec-2009

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000448 Rev: 00

Ref: 05.03.06-000452

Subject: NCR No. ZPMC-0462

Contractor's Proposed Resolution:

Reference Resolution: After repair, ZPMC or ABFJV will provide NDT documentation to show that the weld is acceptable. ZPMC requests that this response be approved with action pending.

After repair, ZPMC or ABFJV will provide NDT documentation to show that the weld is acceptable. Currently documentation is not available but based on this course of action, ZPMC requests that this response be approved with action pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000448R00

Caltrans' comments:

Status: AAP

Date: 30-Dec-2009

Request accepted.

Submitted by: Howe, Bill

Date: 30-Dec-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000452

Subject: NCR No. ZPMC-0462

Dated: 19-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000448 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT documentation that the missed indication was repaired using CWR, B-CWR873, and is acceptable. ABF QCM has conducted refresher MT training with the ZPMC inspectors.

ZPMC is providing NDT documentation that the missed indication was repaired using CWR, B-CWR873, and is acceptable. To reduce incidents of missed indication the ABF QCM has conducted refresher MT training with the ZPMC inspectors on December 23, 2009. In addition, ZPMC will begin performing 100% verification of tested areas beginning January 18, 2010 as a means of preventing future missed indications. ABFJV has purchased powder dispensers for all the ZPMC MT technicians as a means to help control the amount of powder applied during MT testing. Based on the above actions ZPMC requests this NCR be placed closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000448R01;

Caltrans' comments:

Status: CLO

Date: 26-Jan-2010

The prevention measures taken by the QCM and the documentation submitted by the contractor have been reviewed by the Engineer, and are found to be acceptable.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010



No. B-587

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-1-18

REGARDING: NCR-00489 (ZPMC-0462)

With this letter of response, ZPMC requests closure of CT NCR-00489 (ZPMC-0462), what mentioned that CT Inspector observed missed MT indication.

- ZPMC acknowledged this problem and has issued internal NCR. See attached NCR-B-317.
- CWR was issued by ZPMC for the repair to the missed MT indication. See attached B-CWR873.
- NDT was performed after repair according to the approved CWR to warrant the weld's quality. See attached B787-MT-15079 R1.

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

ATTACHMENT:

NCR-00489 (ZPMC-0462)

NCR-B-317(ZPMC-0462)

B-CWR873

B787-MT-15079 R1

A handwritten signature in black ink, appearing to be "Jm" followed by a flourish.

1/18/10



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 02-Dec-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: 05.03.06-000452

Subject: NCR No. ZPMC-0462

Reference Description: Missed MT indication by QC on Segment 7BE floorbeam flange

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 a random Magnetic Particle (MT) verification of Floor Beam to Deck Panel Diaphragm at OBG Segment 7BE, Caltrans Quality Assurance (QA) Inspector observed one (1) Transverse Crack measuring 10 mm in length on weld SSD18-PP52-005. This weld was previously tested and accepted by ZPMC and ABF Magnetic Particle Testing (MT) technicians.

Action Required and/or Action Taken:

Submit a repair plan to the engineer for approval. Missing MT indications is a chronic issue. Train the MT inspectors in proper MT techniques and provide a certificate of competency.

Transmitted by: Bill Howe

Attachments: ZPMC-0462

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

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-000489

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Oct-2009

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

NCR #: ZPMC-0462

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

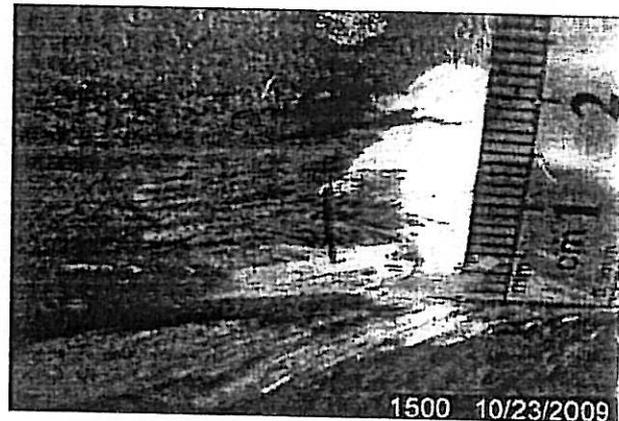
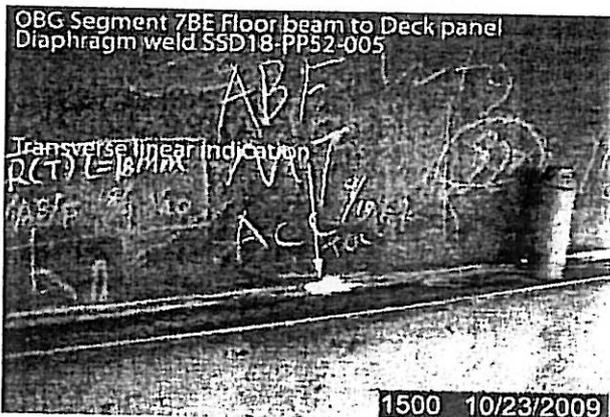
Joint fit-up Coating Other Component: OBG Segment 7BE Floorbeam

Procedural Procedural Description: Missed MT indication by QC

Reference Description: Missed MT indication by QC on Segment 7BE floorbeam flange

Description of Non-Conformance:

During a random Magnetic Particle (MT) verification of Floor Beam to Deck Panel Diaphragm at OBG Segment 7BE, Caltrans Quality Assurance (QA) Inspector observed one (1) Transverse Crack measuring 10 mm in length on weld SSD18-PP52-005. This weld was previously tested and accepted by ZPMC and ABF Magnetic Particle Testing (MT) technicians.



Applicable reference:

AWS D1.5 (02) - 6.26.1; "The weld shall have no cracks."

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: Larry Viars

Name of individual from Contractor notified: Li Man Kit

Time and method of notification: 1500 hours, Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1600 hours, verbal

QC Inspector's Name: Zhang Dai

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: Carreon, Albert

Lead Reviewer/Task Leader

Reviewed By: Wahbeh, Mazen

SMR



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-317(ZPMC-0462)	
Item: Miss MT indication by QC 名称描述: MT 漏检		Item Number: 件号: 7BE	Drawing: 图号: N/A
Location: Assembly yard 位置: 外场		Date: 日期: 2009-12-18	

Description of Nonconformance:
不符合项状态描述:

During a random Magnetic Particle verification of Floor beam to Deck Panel Diaphragm at OBG Segment 7BE, Caltrans Quality Assurance Inspector observed one Transverse Crack measuring 10 mm in length on weld SSD18-PP52-005. This weld was previously tested and accepted by ZPMC and ABE Magnetic Particle Testing technicians.

加州检验员在 7BE 发现一处纵向裂纹, 焊缝编号为 SSD18-PP52-005。且这条焊缝此前已被 ABE 和 ZPMC 接受。

Work By: [Signature] Prepared by: [Signature] Reviewed by QCE: [Signature]
 施工方: 2010.01.17 准备: 12.21 质量工程师批准: 12.21

Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
 处理措施: 回用 返修 拒收

Recommendation:
建议:

[Signature]
Confirm and repair.

Prepared by: [Signature] Approved by QCA: _____
 准备: 2010.01.17 质量经理批准

Reason for Nonconformance:
不符合原因:

[Signature]
Discover linear defect.

Prevention of Re-occurrence:
预防措施:

[Signature]
Inspect carefully and re-inspection and welding controlling

Approved by/批准: [Signature]
2010.01.17

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
回用或返修的技术依据: 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: _____

#R787-QCP-1300



关键焊缝返修报告
Critical Welding Repair Report (CWR)

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SSD18A	报告编号 Report No.:	B-CWR873
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	7BE FB WEB TO TOP FLANGE	NDT 报告编号 NDT Report No.:	B787-MT-1507
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对SSD18A-PP052-004检测时,发现1处横向裂纹。1、L1=15mm Y1=8950mm.

Welder ID No. (焊工编号): 055564 Position:(位置): 2F

One transverse crack was found by use of MT on SSD18A-PP052-004

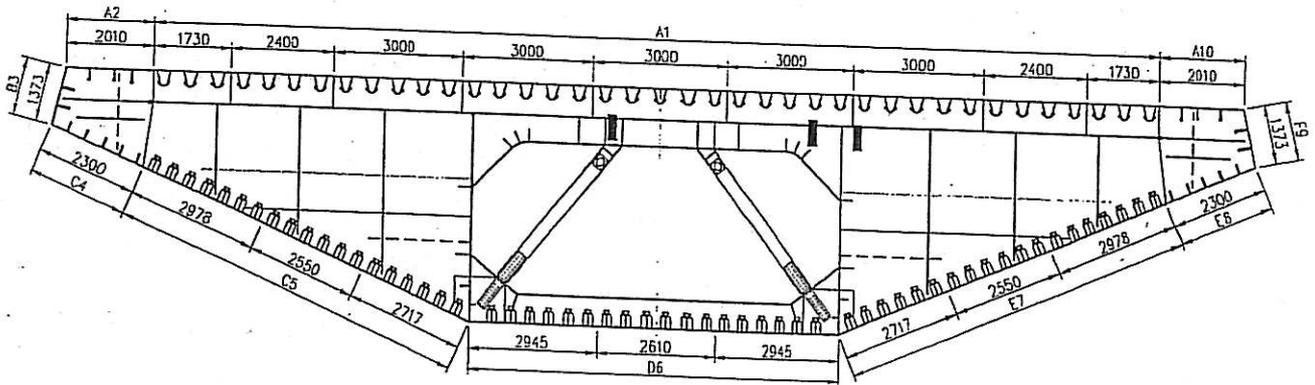
Zhao Cheng Gong

检验员 (Inspector): Zhao cheng gong

日期 (Date): 2009-10-2

焊缝返修位置示意图:

Draft of Welding Discontinuity:



<input type="checkbox"/>	APPROVED
<input checked="" type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION	
SVE <i>See Rm</i> 11/5/09	

产生原因:

Cause:

1. 火焰加热时, 水汽没有完全的去掉或者这个区域预热不够;
1. Moisture wasn't completely removed during drying the area wasn't preheated sufficiently.

车间负责人 (Foreman):

Li Zhigang

<input type="checkbox"/>	APPROVED
<input checked="" type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02	
of the Standard Specifications	
State of California	
DATE OF TRANSFORMATION	
of Engineering Society	
of the State of California	
STE [Signature] RW 11/5/09	
Structural Representative Date	

处理意见

Disposition :

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
3. MT检测之前去除热影响区域上在各个方向上不小于25mm范围内的油漆;
4. 将杂物以及MT和UT检测遗留的残留物清理干净。然后采用打磨的方法去除裂纹, 对于单个裂纹返修, 打磨返修范围为沿缺陷焊缝每一端加50mm, 对于多个裂纹的返修, 打磨返修范围为多个裂纹最外端的返修加长50mm;
5. 如果打磨时母材损伤, 则在返修前将损伤区域打磨干净; 如果打磨时或打磨后根部间隙大于5mm, 则在继续返修前另需递交文件给工程师予以审核批准, 并按照被批准的方法将角焊缝改成CJP焊缝;
6. 焊接前按照焊新的接返修工艺准备焊缝接头形式;
7. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在, 同时靠近裂纹的母材也要做MT, 保证没有裂纹延伸到母材。如果在母材上发现裂纹, 则另外需CWR, 且只有当这份另出的CWR批准后才能继续返修;
8. 将杂物以及MT检测遗留的残留物清理干净。按照新的焊缝返修工艺中表1进行预热和焊接;
9. 焊接后根据新的返修工艺中表1要求进行后热;
10. 将焊缝逐渐冷却到周围环境温度。
11. 后热后将修补区域打磨与母材或相邻焊缝平齐;
12. 在焊缝冷却至环境温度等48小时以后进行NDT检查。
13. 返修后根据图纸进行MT检测, 并按照合同10-1.59 “钢结构” 中的 “检测和试验” 要求进行附加MT检测。
1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements.
2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
3. Remove paint ≥ 25 mm in all direction of HAZ prior to MT.
4. Clean the excavation area of all loose debris including MT powder and UT gel. Remove cracks by grinding, repair area shall extend a minimum of 50mm beyond each end of single crack repairs, and 50mm beyond the outermost cracks for multiple crack repairs.
5. If base metal is damaged by grinding, the damaged area shall be ground clean prior to performing weld repair. If gap > 5 mm is found during or after grinding, comply with the notification on changing fillet weld to CJP which is submitted for Engineer's review and approval form.
6. Prepare excavation in accordance with the New Repair Procedure prior to welding.
7. Before this repair, Verify with VT and MT repair areas are defects free, and also MT shall be performed on the base metal laying abroad cracks to ensure that no cracks were propagated to the base metal. Separate CWR approval is needed if cracks are found in the base metal, and only after this new CWR's approval can continue the repair.
8. Clean excavation area of all loose debris including MT powder after excavation. Preheat and weld according to the Table 1 of the New Repair Procedure.
9. Perform post weld heating according to the Table 1 of the New Repair Procedure.
10. Allow the weld to cool to ambient temperature gradually. (SLOWLY COOL DOWN)
11. Grind the repaired area flush with base metal or the adjacent weld after post weld heating.
12. Wait 48 hours after the repair area has cooled to ambient temperature before performing NDT.
13. Perform MT inspection to all repair area according to Contract Drawings along with all additional NDT required by the applicable notes Special Provision Section 10-1.59 'Steel Structure', subsection 'inspection testing'.

工艺:

Technical Engineer: He Xiaolin

审核:

Approved By: [Signature]

日期:

Date: 9.10.29



关键焊缝返修报告

版本
Rev. No.:

Critical Welding Repair Report (CWR)

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	SSD18	报告编号 Report No.:	B-CWR873
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	9CE FB WEB TO TOP FLANGE P P78W/PP79W/PP79E	NDT 报告编号 NDT Report No.:	B787-MT-15079
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

1. 返修前, QC确认有效的预热, 以将水汽全部去除。

1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.

车间负责人 (Foreman):

Li zhiqiang

日期 (Date):

09.10.29

参照的WPS编号 Repair WPS No.:	WPS-345-SMAW-2G(2F)-Repair	工艺员 Technologist:	He Xinlin 09.10.29
返修(碳刨)前预热温度 Preheat Temperature Before Gouging:	NA	返修的缺陷 Description of Discontinuity:	CR
焊前处理检查 Inspection Before Welding:	Au	焊前预热温度 Preheat Temperature Before Welding:	165°C
最大碳刨深度 Max. Depth of Gouge:	NA	碳刨总长 Total Length of Gouge:	NA
焊工 Welder:	043661	焊接类型 Welding Type:	Sub
焊接电流 Current:	155	焊接电压 Voltage:	22
		焊接位置 Position:	2G
		焊接速度 Speed:	104

返修后检查
Inspection After Repair:

外观检查 VT Result:	Au	检验员 Inspector:	Li Tanhua 07120701	日期 Date:	09.11.08
NDT复检 NDT Result:	Acc	探伤员 NDT Person:	Huang Jinq	日期 Date:	09.11.25

见证:
Witness/Review:备注:
Remark:

#R787-QCP-900

<input type="checkbox"/> APPROVED
<input checked="" type="checkbox"/> APPROVED AS NOTED
<input type="checkbox"/> RETURNED FOR CORRECTION Pursuant to Section 5-1.02 of the Standard Specifications State of California DEPARTMENT OF TRANSPORTATION
SEE 5. 2. 7 11/5/09

Tool Box Training Agenda

Subject: MT Techniques

Reason for Training: Several CT NCR's of indications missed during ZPMC NDT inspection.

1. Safety

- a. Safety Glasses
- b. Gloves (if required)
- c. Knee Pads
- d. Electrical shock

2. Tools

- a. Lighting
- b. MT Powder. Red for ambient, Yellow for High Temperature.
- c. Powder Bulb
- d. Powder Blower
- e. MT Yoke Adequate working condition
- f. Pie Gage

3. Inspection Techniques

- a. Lighting
- b. Position of body (distance of eyes to the weld surface)
- c. Application of Powder removal of Powder
- d. Continuous method
- e. Two directions
- f. Both sides of weld
- g. Clean and dry surface



教育培训纪录

培训编号: MT-22-Dec-09

培训内容:	MT Techniques
培训对象:	项目质检
授课人员:	Steve Lawton
培训类型:	内部培训
培训时间:	22-Dec-09 5:00 PM
计划培训地点:	ZPMC QC office

人员签到:

姓名	部门	姓名	部门
孙力杰 Sunlei	钢桥	狄坤龙 Di Kunlun	钢桥
孙广强 Sun Guangqiang	钢桥	蔡新鑫 Cai Xinxin	钢桥
徐海 Xu Hai	钢桥	傅春强 Fu Chongqiang	钢桥
卞源源 Bian Yuanyuan	钢桥	顾云武 Gu Yunwu	钢桥
许兵 Xu Bing	钢桥	金建廷 Jin Jianting	钢桥 MT
李振华 Li Zhenhua	钢桥	常方杰 Chang Fangjie	钢桥
李坤阳 Li Xunyang	QA	袁俊 Yuan Jun	钢桥
王威 Wang Wei	钢桥	刘章敏 Liu Zhangmin	
孙林 Sun Lin	钢桥 MT	徐华祥 Xu Huaxiang	钢桥
丁阿成 Ding A Cheng	钢桥 MT	周东超 Zhou Dongchao	钢桥
贺佳佳 He Jiajia	钢桥	赵成功 Zhao Chenggong	钢桥
黄瑞 Huang Rui	钢桥	孙广强 Sun Guangqiang	钢桥
李黎明 Li Liming	钢桥	徐辉 Xu Hui	钢桥
李昌涛 Li Changtao		刘宏斌 Liu Hongbin	

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000452

Subject: NCR No. ZPMC-0462

Dated: 20-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000448 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: There is no requirement for in process dimensional flatness at this stage of fabrication. ZPMC strongly requests that this NCR be closed and this item be tracked on the punchlist.

The in process flatness dimension documented in this NCR has the potential to be a non conformance if it is not corrected. As stated in ABFJV's earlier response, at the time this NCR was written work was in process and ZPMC had not accepted the dimensions at the time the NCR was written. There is no requirement for in process dimensional flatness at this stage of fabrication and the references applied should be applied after work by the fabricator is complete. If the Department wants to maintain visibility of this issue, it should be added to the punchlist for later follow up after ZPMC has completed the work and can be verified. ZPMC strongly requests that this NCR be closed and this item be tracked on the punchlist.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000448R02

Caltrans' comments:

Status: CLO

Date: 26-Jan-2010

The contractor's response in this NPR no. 448R2 is not applicable to the NCT issued. A previously submitted NPR no. 448R1 has been accepted by the Engineer; therefore, it is not necessary to send another NPR for the same NCT.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010

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-000488**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0462**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: 23-Oct-2009**Description of Non-Conformance:**

During a random Magnetic Particle (MT) verification of Floor Beam to Deck Panel Diaphragm at OBG Segment 7BE, Caltrans Quality Assurance (QA) Inspector observed one (1) Transverse Crack measuring 10 mm in length on weld SSD18-PP52-005. This weld was previously tested and accepted by ZPMC and ABF Magnetic Particle Testing (MT) technicians.

Contractor's proposal to correct the problem:

Repair indication and perform required NDT.

Corrective action taken:

The indication was repaired and NDT documentation was submitted to verify the weld is in conformance with contract requirements. The Contractor has provided training to MT Technicians regarding proper technique and purchased new equipment. NDT coverage has also been increased in this area.

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