

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

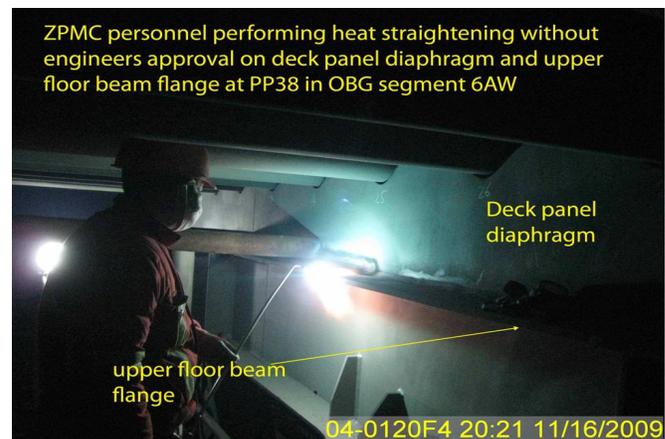
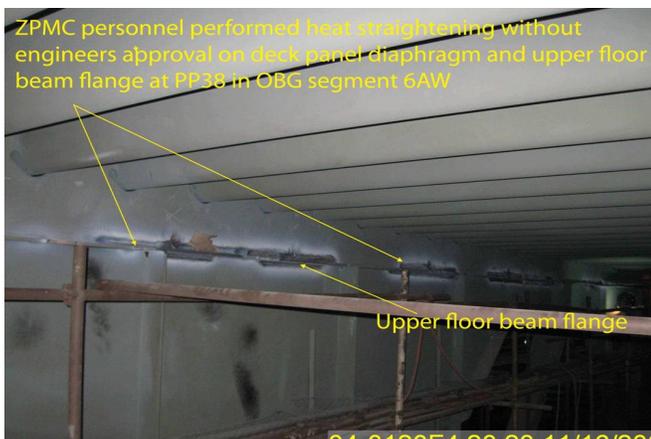


Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000509**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0482**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Segment 6AW, OBG Upper Floor Beam Flange**Procedural****Procedural****Description:****Reference Description:** Heat Straightening performed without Engineer's Approval in Segment 6AW PP38**Description of Non-Conformance:**

During random visual inspection this Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel were performing heat straightening on various locations on deck panel diaphragm and the upper floor beam flange in OBG segment 6AW at panel point 38. ZPMC QC or CWI were not present during the time of heat straightening. The non-conforming issues were noted:

1. No prior approval of the Engineer for the Heat Straightening Record. The maximum distortion noted on the flange is 20mm over the width of 170mm along the flange.
2. The heat straightening work performed was deviated from the HSR1(B)-7886 approved internally by ZPMC.

**Applicable reference:**

-Contract Special Provisions, Section 8.3: "For material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer."

-AWS D1.5/2002 Section 3.7.3; "Members distorted by welding shall be heat straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the engineer."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

”
Who discovered the problem: Shrikant Utekar

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 1300 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1400 hours, Verbal

QC Inspector's Name: Li Yan Yue

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:	11-Dec-2009
Dear:	Mr. Charles Kanapicki	Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Attention:	Mr. Thomas Nilsson Project/Fabrication Manager	Job Name:	SAS Superstructure
Subject:	NCR No. ZPMC-0482	Document No:	05.03.06-000472

Reference Description: Heat Straightening performed without Engineer's Approval in Segment 6AW PP38

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:** 06

Remarks:

During random visual inspection this Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel were performing heat straightening on various locations on deck panel diaphragm and the upper floor beam flange in OBG segment 6AW at panel point 38. ZPMC QC or CWI were not present during the time o heat straightening. The non-conforming issues were noted:

1. No prior approval of the Engineer for the Heat Straightening Record. The maximum distortion noted on the flange is 20mm over the width of 170mm along the flange.
2. The heat straightening work performed was deviated from the HSR1(B)-7886 approved internally by ZPMC.

Action Required and/or Action Taken:

Obtain prior approval from the engineer before performing the work using an approved HSR. Submit a repair procedure to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0482

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000472

Subject: NCR No. ZPMC-0482

Dated: 25-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000544 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will provide explanation of measures that they took to correct the issue. In addition, the repair report and NDT documentation will be provided to show the welds were not damaged by the repair.

ZPMC will provide explanation of measures that they took to correct the issue documented in the NCR. In addition, the repair report and NDT documentation will be provided to show the welds were not damaged by the repair. Based on this ZPMC requests that this course of action be approved with action pending. When documents become available ZPMC will request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000544R00

Caltrans' comments:

Status: AAP

Date: 26-Jan-2010

The proposed resolution provided by the contractor is accepted. The NCR will be closed once the required preventative measures are taken and repair documentation are submitted for the Engineer's review and acceptance.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000472

Subject: NCR No. ZPMC-0482

Dated: 10-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000544 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing both the internal heat straightening document used and the dimensional checks done after to verify that the distortion was corrected and requests that this NCR be closed.

ZPMC is providing both the internal heat straightening document used and the dimensional checks done after to verify that the distortion was corrected and requests that this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000544R01;

Caltrans' comments:

Status: REJ

Date: 11-Feb-2010

Submit NDT records for all affected welds during heat straightening.

Submitted by: Howe, Bill

Date: 11-Feb-2010

Attachment(s):



No. B-605

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-2-10

REGARDING: NCR-00509 (ZPMC-0482)

With this letter of response, ZPMC requests withdraw of CT NCR-00509 (ZPMC-0482), what mentioned that CT Inspector observed Heat Straightening without Engineer's approval in 6AW the Upper Flange of Floor Beam.

- The upper flange of Floor Beam is NON SPCM material. The heat straightening was performed according to HSR1(B)-7886. Refer to pictures in ZPMC-0482 the distortion was against the length of flange so the fire work was performing along with the length. The maximum distortion was measured 20mm in length of 24000mm. For this case, the heat straightening is not required to notify the Engineer.
 - ZPMC provides the HSR1 and dimension check report for Engineer review.
- Based on the responses and attached documentation, ZPMC requests withdraw of this NCR.

ATTACHMENT:

NCR-00509 (ZPMC-0482)

HSR1(B)-7886

DIEMENSION CHECK REPORT AFTER HEAT STRAIGHTENING

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

2/10/10



Nonconformance Report

不符合项报告

N

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-328(ZPMC-0482)	
Item: Heat Straightening without engineer's approval 名称描述: 校火没有经过工程师批准		Item Number: 件号: N/A	Drawing: 图号: N/A
Location: Outside yard 位置: 外场		Date: 日期: 2009-12-24	

Description of Nonconformance:

不符合项状态描述:

During random visual inspection this Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel were performing heat straightening on various locations on deck panel diaphragm and the upper floor beam flange in OBG segment 6AW at panel point 38. ZPMC QC or CWI were not present during the time on heat straightening. The non-conforming issues were noted:

1. No prior approval of the Engineer for the Heat Straightening Record. The maximum distortion noted on the flange is 20mm over the width of 170mm along the flange.
2. The heat straightening work performed was deviated from the HSR1(B)-7886 approved internally by ZPMC.

在随机目检的过程中加州检验员发现 ZPMC 施工人员在 6AW PP38 位置的顶板连接板和隔板上部进行校火。ZPMC QC 和 CWI 在校火过程中并没有到达现场。所有记录如下所述:

1. 校火记录没有经过工程师批准。170mm 的顶板连接板最大变形达到 20mm
2. 校火工作没有按照 HSR1(B)-7886 来进行。

Work By: 施工方:	Prepared by: Zhangwei 准备: 2009.12.24	Reviewed by QCE: 质量工程师批准: [Signature]
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: 处理措施:	<input type="checkbox"/> Use as is 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
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Recommendation:

建议:

Prepared by: _____ 准备	Approved by QCA: _____ 质量经理批准
--------------------------	----------------------------------

Reason for Nonconformance:

不符合原因: 由于 6AW PP38 位置的顶板连接板和隔板上部进行校火
 按现场没有工程师批准和没有按照 HSR1(B)-7886 来进行。
 Heat straighten 6AW PP38 deck plate connect plate and floor beam
 without engineer approve and didn't perform according to HSR1(B)-7886

Prevention of Re-occurrence:

预防措施:

加强现场监控和检查

Enhance supervision and inspection on-site

Approved by/批准: Gao Jun 12.26

Technical Justification for Use-As-Is/Repair:

回用或返修的技术依据:

Attachment

附件

Non-attachment

无附件

加强现场监控和管理

Enhance supervision and management on site.

Reviewed /批准: Mar Lijie 12-30/09

Verification:

确认:

Acceptable

可接受

Unacceptable

不可接受

Verified by QCI/质检确认: Li Yanhua 10.01.05

Reviewed by QCA/质检主任审核: _____

#R787-QCP-1300



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
575 BURMA ROAD
OAKLAND CA 95607

Date: 11-Dec-2009

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

Job Name: SAS Superstructure

Document No: 05.03.06-000472

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0482

Reference Description: Heat Straightening performed without Engineer's Approval in Segment 6AW PP38

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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- 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: 06

Remarks:

During random visual inspection this Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel were performing heat straightening on various locations on deck panel-diaphragm and the upper floor beam flange in OBG segment 6AW at panel point 38. ZPMC QC or CWI were not present during the time of heat straightening. The non-conforming issues were noted:

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Action Required and/or Action Taken:

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Transmitted by: Bill Howe

Attachments: ZPMC-0482

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, 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

City: 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-000509

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 16-Nov-2009

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

NCR #: ZPMC-0482

Type of problem:

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

Bridge No: 34-0006

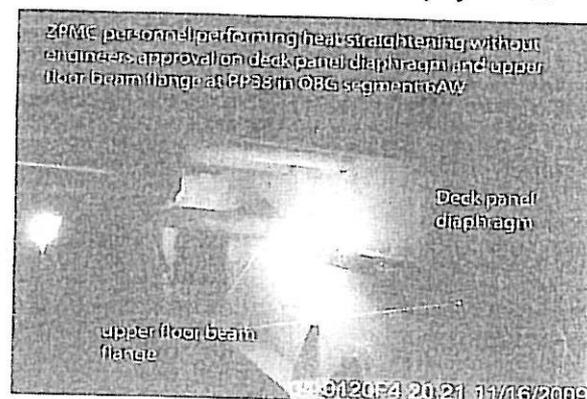
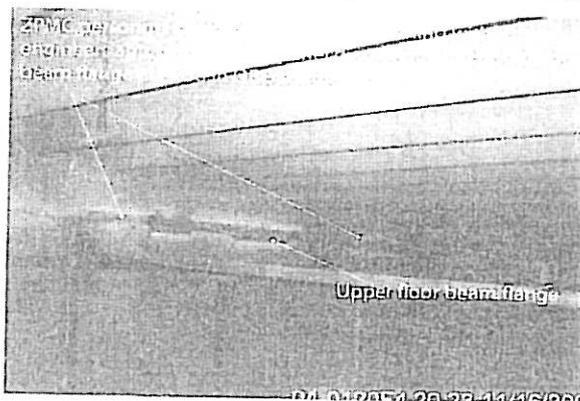
Component: Segment 6AW, OBG Upper Floor Beam Flange

Reference Description: Heat Straightening performed without Engineer's Approval in Segment 6AW PP38

Description of Non-Conformance:

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Applicable reference:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Who discovered the problem: Shrikant Utekar
Name of individual from Contractor notified: Steve Lawton
Time and method of notification: 1300 hours, Verbal
Name of Caltrans Engineer notified: Ching Chao and Bill Howe
Time and method of notification: 1400 hours, Verbal
QC Inspector's Name: Li Yan Yue
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
Reviewed By: Wahbeh, Mazen

Lead Reviewer/Task Leader
SMR



火工校正记录

Heat Straightening Record(HSR1)

报告号 Record #

HSR1(B)-7886

版本号 Revision #

0

日期 Date

2009.11.12

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:

质检代表/Quality Control Representative

部装 Sub-Assembly:

梁段 Gird:

6AW

质检经理/Quality Assurance Manager-Approval

塔段 Tower:

N/A

焊缝号 Weld No:

See Sketch

焊缝地图号 Weld Map No:

N/A

情况描述 Description of Condition

Cause 原因

Welding distortion 焊接变形

Type of Defect 缺陷类型

Welding distortion 焊接变形

Inspection Method 检查方法

Visual 目检

处置方法 Disposition

缺陷去除方法(Defect Removal Method):

natural gas 天然气

后续NDE(Post-Removal NDE):

After finishing heat straightening, the weld of the heat area shall perform NDT according to the approved shop drawing 校火后, 根据图纸要求对热影响区域进行NDT检测。

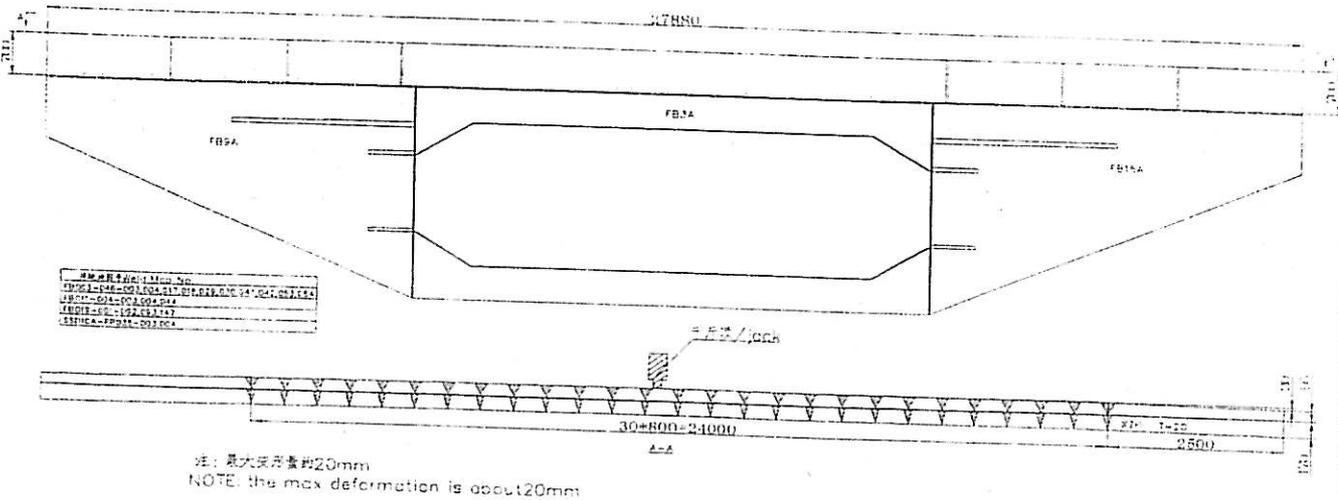
纠正措施(Corrective Action(s)):

Control current, voltage and weld speed according to relevant WPS. If necessary anti-deformation or hold down device can be added 依据相应的WPS的要求控制电流, 电压和焊接速度, 如有必要, 可使用反变形设施进行校正。

实施次数(Number of application): 1~3

最高温度(Maximum temperature): <650°C

简图 Sketch



To be signed when Closing HSR~Verify compliance and all necessary reports are ready to attach

检验员 Inspector:

Li Yanhua

签字 Signature:

李艳华

CWI #

07120701

II 级探伤 NDE Certification:

Level II

Closing Date:

质检经理 QC Manager

Li Yanhua

审核日期 Review Date:

11

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787-QCP-1101

Approved by Li Yanhua

美国钢桥钢板平整度火工校正检查记录卡

The report of steel plate heat straightening process checking

ZPMC

工程编号: The serial no. of project:	工程号: The drawing no.:	构件名称 The part name.:
材料: Material:	炉批号: The heatno of plate:	火工校正次数 The times of heat straightening:
移植是否正确: Material mark checking:	钢板编号: Plate ID:	桥段名称 Section name:

火工校正温度控制 The temperature record of heat straightening

检查时间 Checking time:	10:40	11:00							
测量温度 Measure result:	480°C	502°C							

火工前平整度测量 Flatness checking before heat straightening (mm)

测量点 Measure position:	A	B	C						
测量值 Measure result:	14	20	10						

火工后平整度测量 Flatness checking after heat straightening (mm)

测量点 Measure position:	A	B	C						
测量值 Measure result:	1	2	1						

整体平整度/筋板垂直度是否合格
Heat straightening result: A/C

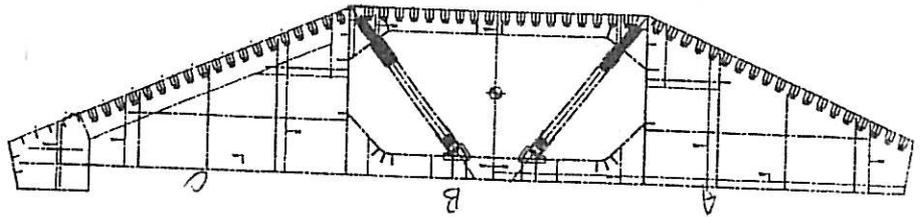
检验员
QC inspector: Zhang Qiang

日期
Date: 2009.11.15

若校正影响焊缝,请填写以下项目
Fill the following items if the straightening affects the weld

对应NDT报告编号
NDT report no.

UT	AW	NDT检验员签字 NDT inspector:	日期 Date:
VT	PLC	Xu Huijun	10.01.17
RT	N/A	Li Zhangjun	12.01.18



NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000472

Subject: NCR No. ZPMC-0482

Dated: 26-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000544 **Rev:** 02

Contractor's Proposed Resolution:

Reference Resolution: Per the Department's request, ZPMC is providing the NDT documents to show that the welds were acceptable after heat straightening. Based on this ZPMC requests closure of this NCR.

Per the Department's request, ZPMC is providing the NDT documents to show that the welds were acceptable after heat straightening. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000544R02;

Caltrans' comments:

Status: CLO

Date: 05-Apr-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0482 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 05-Apr-2010



No. B-708

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-25

REGARDING: NCR-000509 (ZPMC-0482)

As request in ABF-NPR-000544 R1, ZPMC is providing the NDR records show the soundness of welds after HS and requests the closure of NCR ZPMC-0482.

ATTACHMENT:

B787-UT-11889

B787-MT-21029

A handwritten signature in black ink, appearing to be "J. W.", is located below the attachment list.

3/25/10



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-11889 DATE 2010.01.17 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 6AW FLOOR BEAM SPLICE DRAWING NO.: SSD10 CALTRANS CONTRACT NO.: 04-0120F4
 附件名称 型号 甲方工程编号

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 FCAW JOINT TYPE 焊缝类型 T-JOINT CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST, 2010

EQUIPMENT 设备 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 IIV BLOCK TYPE II COUPLANT 耦合剂 C.M.C MATERIAL/THICKNESS 材料厚度 A709M-345T2-X 14/20mm

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 探头角度	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
SSD10-PP38-003		70				34									ACC.	100%
SSD10-PP38-004		70				34									ACC.	100%
FB011-004-044		70				34									ACC.	100%
FB019-001-147		70				34									ACC.	100%

AFTER HSR1(B)-7886

BLANK

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EXAMINED BY 主探 Xuehairong REVIEWED BY 审核 Tang Xingshan
 LEVEL - II SIGN / DATE 2010.1.17 LEVEL - II SIGN / DATE 1/17/10

质量经理 / QCM Lu Jinhua 1/17/10 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-21029 DATE日期 2010.01.18 PAGE OF页码 1/2 Revision No: 0

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

DRAWING NO. 图号: SSD10 6AW FLOOR BEAM SPLICE 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. 28th, 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 CASTING 铸件 FORGING 锻造 Material & thickness 母材, 厚度: A709M-345T2-X 14/20/12mm

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			
SSD10-PP38-003				ACC.		100%MT
SSD10-PP38-004				ACC.		100%MT
FB003-046-005				ACC.		100%MT
FB003-046-004				ACC.		100%MT
FB003-046-017				ACC.		100%MT
FB003-046-018				ACC.		100%MT
FB003-046-029				ACC.		100%MT
FB003-046-030				ACC.		100%MT
FB003-046-041				ACC.		100%MT
FB003-046-042				ACC.		100%MT
FB003-046-053				ACC.		100%MT
FB003-046-054				ACC.		100%MT
FB019-001-092				ACC.		100%MT
FB019-001-093				ACC.		100%MT

EXAMINED BY主探: Lin Zhang Min / 01.18 REVIEWED BY审核: Margaret / 01.18
 LEVEL - II SIGN 签名 / DATE日期 LEVEL-II SIGN / DATE日期
 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



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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-000615**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0482**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: 16-Nov-2009**Description of Non-Conformance:**

During random visual inspection this Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel were performing heat straightening on various locations on deck panel diaphragm and the upper floor beam flange in OBG segment 6AW at panel point 38. ZPMC QC or CWI were not present during the time of heat straightening. The non-conforming issues were noted:

1. No prior approval of the Engineer for the Heat Straightening Record. The maximum distortion noted on the flange is 20mm over the width of 170mm along the flange.
2. The heat straightening work performed was deviated from the HSR1(B)-7886 approved internally by ZPMC.

Contractor's proposal to correct the problem:

Perform NDT required to verify the quality of welds affected during heat straightening.

Corrective action taken:

Contractor has supplied NDT documentation verifying the affected floorbeam welds are in conformance with Contract specifications. Additional reinforcing and NDT of deck panel welds will be addressed in Oakland in conformance with RFI2083.

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