

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-000684**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0651**Type of problem:**

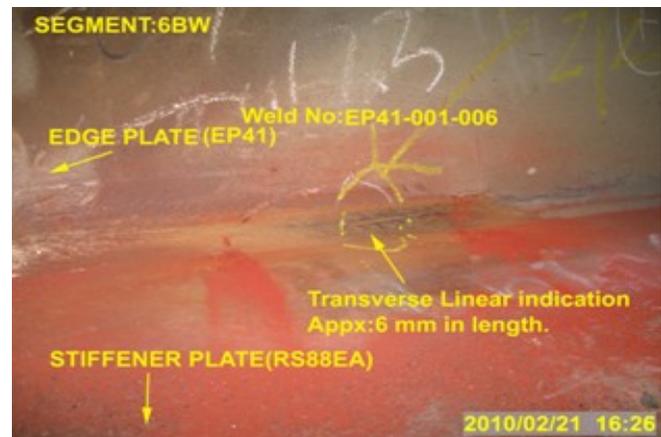
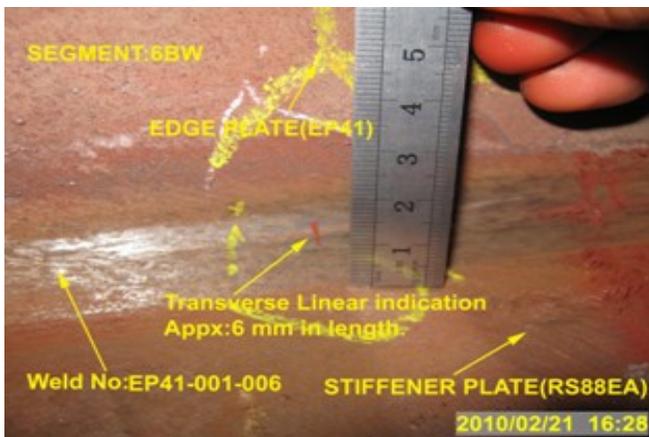
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 6BW Edge Panel Stiffener
Procedural	Procedural	Description: Missed MT transverse indication by QC	

Reference Description: Missed MT Transverse Indication by QC on Segment 6BW Edge Panel Stiffener**Description of Non-Conformance:**

During Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Segment 6BW, this QA Inspector discovered the following issue:

- One (1) Transverse Linear indication measuring approximately 6 mm in length.
- The weld is identified as: EP41-001-006.
- The weld is a fillet weld joining stiffener plate RS88EA to edge plate EP41.
- The Y location is approximately 200mm from segment splice weld identified as OBW6-001.
- Segment 6BW is located in the OBG trial assembly yard.

The Notice of Witness Inspection Number (NWIT) is 005218. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC QC personnel are required to perform 100% MT inspection of these welds.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002, Figure 6.8: – specifies for fillet weld sizes between 6mm and 13mm the maximum discontinuity length is approximately 2mm to 4mm.

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.”

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Zouhu

Time and method of notification: 16:20_2-21-10_Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 10:00_2-22-10_Verbal

QC Inspector's Name: Wang Li Yang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Provide CWR and perform weld repair and subsequent NDT to ensure that the weld is acceptable to the contract requirement.

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

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: 23-Feb-2010

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: 05.03.06-000641

Subject: NCR No. ZPMC-0651

Reference Description: Missed MT Transverse Indication by QC on Segment 6BW Edge Panel Stiffener

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 Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Segment 6BW, this QA Inspector discovered the following issue:
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Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0651

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: 05.03.06-000641

Subject: NCR No. ZPMC-0651

Dated: 16-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000620 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indication in accordance with B-CWR1240, attached is the MT report showing that the weld is now acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC has repaired the indication in accordance with B-CWR1240, attached is the MT report showing that the weld is now acceptable. To prevent future occurrences ZPMC and ABF have conducted training with the inspectors to improve their technique and prevent future occurrences. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000620R00;

Caltrans' comments:

Status: CLO
Date: 18-Mar-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Attachment(s):

Date: 18-Mar-2010



No. B-679

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-15

REGARDING: NCR-000684(ZPMC-0651)

Attached NDT record shows this indication has been repaired, retested and is now acceptable. Please refer to B-CWR1240 of the repair report. This issue has been removed from punchlist after the verification by CT's representative. Based on this, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-000684(ZPMC-0651)

B787-MT-19659 R1

A handwritten signature in black ink, appearing to read "Jay Carr", is written over the typed name.

3/15/10



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: 23-Feb-2010

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

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Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000684

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 21-Feb-2010

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

NCR #: ZPMC-0651

Type of problem:

- Welding Concrete Other
 Welding Curing Procedural
 Joint fit-up Coating Other
 Procedural Procedural Description: Missed MT transverse indication by QC

Bridge No: 34-0006

Component: Segment 6BW Edge Panel Stiffener

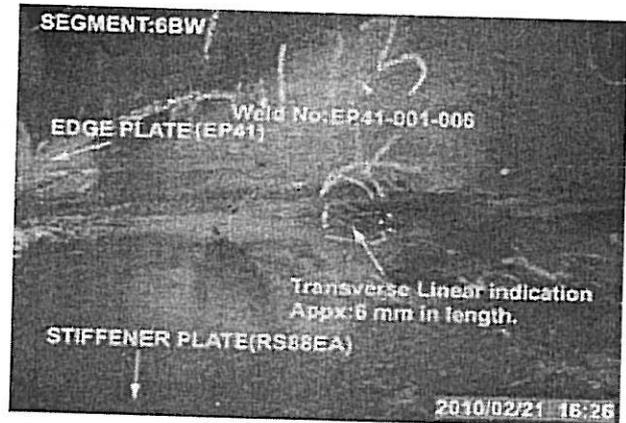
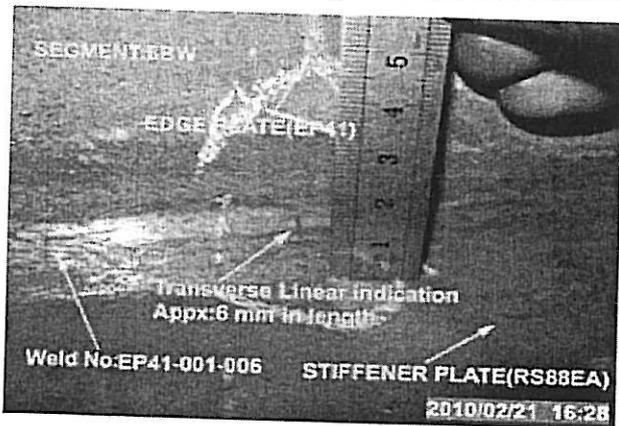
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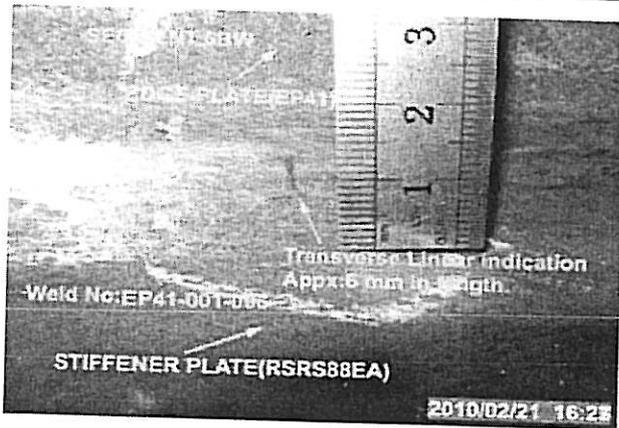
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Time and method of notification: 16:20_2-21-10_Verbal

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Time and method of notification: 10:00_2-22-10_Verbal

QC Inspector's Name: Wang Li Yang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Provide CWR and perform weld repair and subsequent NDT to ensure that the weld is acceptable to the contract requirement.

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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-19659R1 DATE日期 2010.03.09 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. EP041 CALTRANS CONTRACT NO.:
 图号: CORNER ASSEMBLY I-RIB 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
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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-345 28mm
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WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-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			
EP041-001-006	1R1			ACC.		100%MT

AFTER B-CWR1240

BLANK

EXAMINED BY 主探 Ding Acheng <i>Ding Acheng</i>	REVIEWED BY 审核 <i>Sueh</i>
LEVEL - II SIGN 签名 <i>Ding Acheng</i> DATE 日期 2010.3.9	LEVEL-II SIGN / DATE 日期 <i>Sueh</i> 2010.3.9
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

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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-000562**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0651**Type of problem:**

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

Date the Non-Conformance Report was written: 21-Feb-2010**Description of Non-Conformance:**

During Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Segment 6BW, this QA Inspector discovered the following issue:

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Contractor's proposal to correct the problem:

Repair said indications and perform NDT required to verify weld quality

Corrective action taken:

Contractor submitted NDT reports verifying the welds were repaired in conformance with approved CWRs and are now in conformance with Contract specifications. An internal NCR was also issued by the Contractor in regards to this issue.

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.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer