

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, China

Report No: NCR-000776

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Jun-2010

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

NCR #: ZPMC-0738

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Floorbeam FB3138A on Lift 13BE
Procedural	Procedural	Description:	

Reference Description: Weld Joint Not Detailed on Approved Shop Drawings

Description of Non-Conformance:

During Quality Assurance (QA) random in-process observations of the fabrication of OBG floor beam subassemblies this Caltrans (CT) QA observed the following issues:

-ZPMC has created a weld joint that is not detailed on the approved shop drawings, without the Engineers approval.

-ZPMC has added approximately 300mm to the end of stiffener plate identified as X3630B.

-The floor beam subassembly is identified as FB3138A.

-FB3138A is located in OBG subassembly bay 3.



Applicable reference:

AWS D1.5-2002 Section 3.1.4; "The location of welds shall not be changed without approval".

AWS D1.5-2002 Section 3.1.5; "Welds shall be prohibited on the work except as follows:

- (2) All welds detailed on approved shop drawings

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer

AWS D1.5-2002 Section 3.7.4; Prior approval of the Engineer shall be obtained for repairs to base metal or for revised design to compensate for deficiencies.

AWS D1.5-2002 Section 6.5.1; "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval".

Special Provisions 8-3; Inspection and approval of all joint preparations, assembly practices, joint fit-ups, welding techniques, and the performance of each welder, welding operator, and tack welder shall be documented by the QC Inspector on a daily basis for each day the welding is performed. For each inspection, the QC Inspector shall confirm and document compliance with the requirements of the AWS code criteria and the requirements of these Special Provisions on all weld joints before welding, during welding and after the completion of welding.

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Mike Williams

Time and method of notification: 09:30, 6/27/10, Email

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 14:30, 6/28/10, Email

QC Inspector's Name: Zhang Wei

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:	Devey,Jim	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-Jun-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: 05.03.06-000734

Subject: NCR No. ZPMC-0738

Reference Description: Weld Joint Not Detailed on Approved Shop Drawings

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:** 13

Remarks:

During Quality Assurance (QA) random in-process observations of the fabrication of OBG floor beam subassemblies this Caltrans (CT) QA observed the following issues:

- ZPMC has created a weld joint that is not detailed on the approved shop drawings, without the Engineers approval.
- ZPMC has added approximately 300mm to the end of stiffener plate identified as X3630B.
- The floor beam subassembly is identified as FB3138A.
- FB3138A is located in OBG subassembly bay 3.

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: Sean Eagen Transportation Engineer

Attachments: ZPMC-0738

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000734

Subject: NCR No. ZPMC-0738

Dated: 03-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000764 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the NDT required by the RFI of the additional weld joint to show the weld joint is acceptable.

ZPMC is providing the RFI which shows the justification for adding the weld joint. In this case the shop drawings were detailed incorrectly and the stiffener was shorter than required. ZPMC is providing the NDT required by the RFI of the additional weld joint to show the weld joint is acceptable. Although the ZPMC's technology department took the initiative to create a solution for the short stiffener, ZPMC QA has been instructed that before allowing a weld joint to be added the Engineer must be given an opportunity to review the resolution to ensure it is acceptable. The ZPMC QA and Technology engineers understand this and will notify the ABFJV when these cases occur so they can be addressed in an RFI can be issued and answered quickly. ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000764R00;

Caltrans' comments:

Status: CLO

Date: 14-Sep-2010

The proposed resolution is acceptable. This NCR is considered closed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 14-Sep-2010



No. B-866

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-09-03

REGARDING: NCR-000776(ZPMC-0738)

Per approved RFI response, ZPMC is providing the revised weld map and the NDT record to show the acceptance of these added welds. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000776(ZPMC-0738)

RFI-ZPMC-000836 RESPONSE

WELD MAP: FB3138

B787-UT-14230

B787-UT-14230 R1

B787-MT-25673

A handwritten signature in black ink, appearing to be 'J. W.' or similar, written in a cursive style.

9/3/10



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: 28-Jun-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: 05.03.06-000734

Subject: NCR No. ZPMC-0738

Reference Description: Weld Joint Not Detailed on Approved Shop Drawings

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: 13

Remarks:

During Quality Assurance (QA) random in-process observations of the fabrication of OBG floor beam subassemblies this Caltrans (CT) QA observed the following issues:

- ZPMC has created a weld joint that is not detailed on the approved shop drawings, without the Engineers approval.
- ZPMC has added approximately 300mm to the end of stiffener plate identified as X3630B.
- The floor beam subassembly is identified as FB3138A.
- FB3138A is located in OBG subassembly bay 3.

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: Sean Eagen Transportation Engineer

Attachments: ZPMC-0738

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

Report No: NCR-000776

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Jun-2010

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

NCR #: ZPMC-0738

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

Joint fit-up Coating Other Component: Floorbeam FB3138A on Lift 13BE

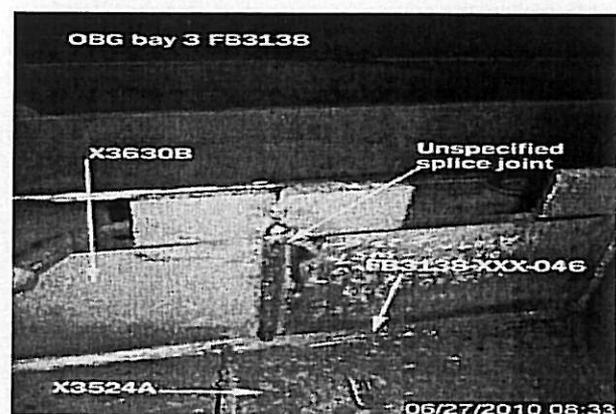
Procedural Procedural Description:

Reference Description: Weld Joint Not Detailed on Approved Shop Drawings

Description of Non-Conformance:

During Quality Assurance (QA) random in-process observations of the fabrication of OBG floor beam subassemblies this Caltrans (CT) QA observed the following issues:

- ZPMC has created a weld joint that is not detailed on the approved shop drawings, without the Engineers approval.
- ZPMC has added approximately 300mm to the end of stiffener plate identified as X3630B.
- The floor beam subassembly is identified as FB3138A.
- FB3138A is located in OBG subassembly bay 3.



Applicable reference:

AWS D1.5-2002 Section 3.1.4; "The location of welds shall not be changed without approval".

AWS D1.5-2002 Section 3.1.5; "Welds shall be prohibited on the work except as follows:

- (2) All welds detailed on approved shop drawings

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer

AWS D1.5-2002 Section 3.7.4; Prior approval of the Engineer shall be obtained for repairs to base metal or for revised design to compensate for deficiencies.

AWS D1.5-2002 Section 6.5.1; "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval".

Special Provisions 8-3; Inspection and approval of all joint preparations, assembly practices, joint fit-ups, welding techniques, and the performance of each welder, welding operator, and tack welder shall be documented by the QC Inspector on a daily basis for each day the welding is performed. For each inspection, the QC Inspector shall confirm and document compliance with the requirements of the AWS code criteria and the requirements of these Special Provisions on all weld joints before welding, during welding and after the completion of welding.

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Mike Williams

Time and method of notification: 09:30, 6/27/10, Email

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 14:30, 6/28/10, Email

QC Inspector's Name: Zhang Wei

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:	Devey,Jim	SMR
Reviewed By:	Wahbeh,Mazen	SMR

REQUEST FOR INFORMATION (RFI) – ABF&SUB.

RFI No.: RFI-ZPMC-000836R00 Submitted by: Zhao Xing Page(s): 1
 RFI Date: 12-Jul-2010 Contact Name: Sun Weidong Phone No. +86-21-51907431

Subject: Add Weld joint for OBG floorbeam stiffener X3630B

References:

Response required by: 19-Jul-2010 (date) Response affects critical path activity? X YES NO

Description:

Please find attached shop drawings X3630 & FB3138, it is confirmed that the dimension for stiffener X3630B is incorrect, it is short for 30mm if connect to the flange plate.

To facilitate fabrication ZPMC propose to cut the X3630B with 270mm and then add weld joint for the X3630B and a new stiffener with 300mm length.

Please confirm if it is acceptable.

This RFI is being submitted for:

- Material Procurement
 Contractor Convenience
 Clarification of the Contract Documents
 Engineering Review Request (ERR) for missing design information/coordination.

The Cost and Time Impact from this RFI is:

- No cost or time impacts in the performance of our Work.
 Cost and/or time impacts in the performance of our Work will result.
 We are unable to determine at this point whether there will be cost and/or time impacts.

Response:

Date: 7/14/2010	Respondent: Roman Granados	Phone No.:
-----------------	----------------------------	------------

The proposal is acceptable with the following requirements (see attached photo with comments):

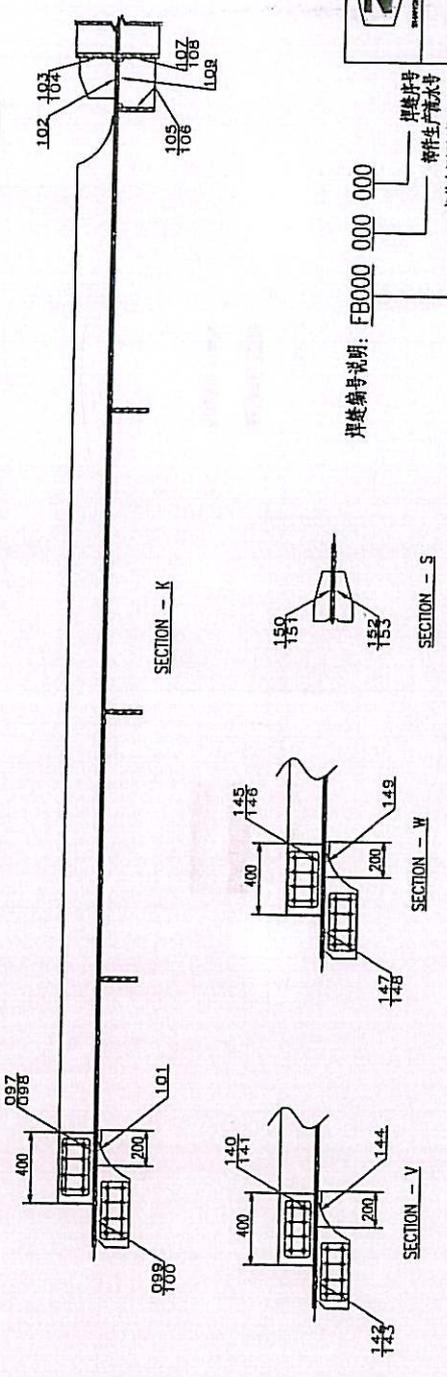
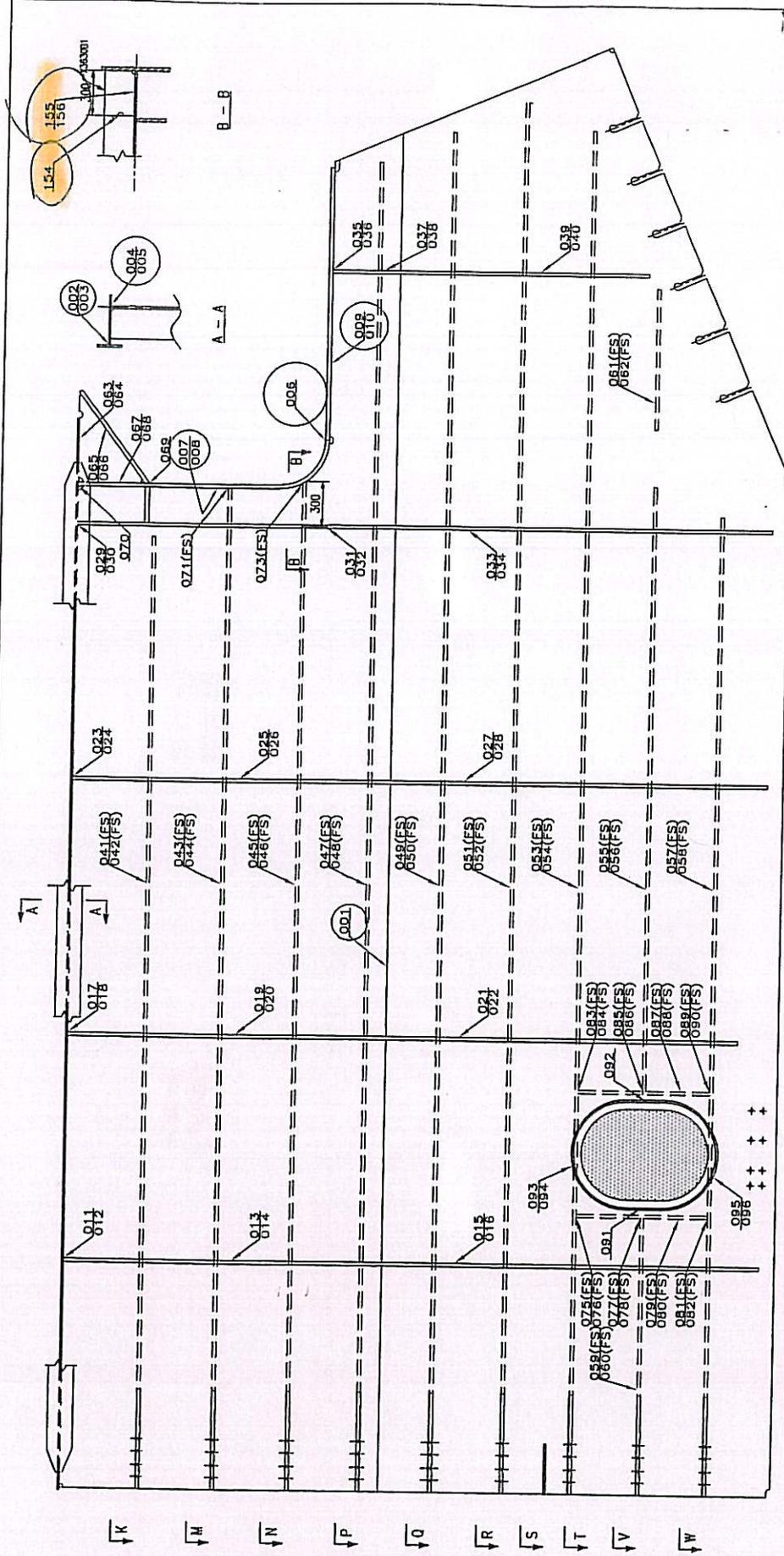
- perform 100% UT on the X3630B CJP Splice weld to the added 300mm PL;
- perform 100% MT on both fillet welds connecting the added 300mm plate to the floorbeam + 75mm past the fillet weld intersection with the CJP;
- add a 25mm cope hole by backgouging where the CJP weld intersects with the fillet welds;
- and, revise and re-submit the weld map to include the new weld and its ID.



RFI Status: (sign and date)

Closed:

Revision Pending:



注意: 如有遗漏或重复的标注焊缝, 请QC人员通知工艺
进行补标或删减

焊接编号说明: FB000 000 000
 焊条生产流水号
 焊条序号
 构件生产流水号

ZPMC
 ZHONGYUAN PORT INFRASTRUCTURE CO., LTD.
 WELDING MAP
 DRAWN: []
 CHECKED: []
 SHEET NO.: FB3138
 PAGES: 1/1



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25673 DATE日期 2010.08.06 PAGE OF页码 1/4 Revision No: 0

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

DRAWING NO. FB3138 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 13th lifting floor beam 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
---	--	-------------------------------------	---

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 14/16/25/22/30/12mm
---------------------------------	---	-------------------------------	--------------------------------------

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			
FB3138-001-002				ACC.		25%MT
FB3138-001-003				ACC.		25%MT
FB3138-001-004				ACC.		25%MT
FB3138-001-005				ACC.		25%MT
FB3138-001-007				ACC.		25%MT
FB3138-001-008				ACC.		25%MT
FB3138-001-009				ACC.		25%MT
FB3138-001-010				ACC.		25%MT
FB3138-001-063						*
FB3138-001-064						*
FB3138-001-065				ACC.		25%MT
FB3138-001-066				ACC.		25%MT
FB3138-001-105						*
FB3138-001-106						*

EXAMINED BY主探
 Xu Huaxiang Xu Huaxiang 2010.8.06
 LEVEL - II SIGN 签名 / DATE日期

REVIEWED BY 审核
 Sun Guangchang Sun Guangchang 2010.8.06
 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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25673 DATE日期 2010.08.06 PAGE OF页码 2/4 Revision No: 0

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

DRAWING NO. FB3138 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 13th lifting floor beam 加州工程编号

REFERENCING CODE 参考规范编码	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号	CALIBRATION DUE DATE 仪器校正有效期
AWS D1.5-2002	AWS D1.5-2002	ZPQC-MT-01	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 14/16/25/22/30/12mm
---------------------------------	---	-------------------------------	--

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			
FB3138-001-107						*
FB3138-001-108						*
FB3138-001-150				ACC.		100%MT
FB3138-001-151				ACC.		100%MT
FB3138-001-152				ACC.		100%MT
FB3138-001-153				ACC.		100%MT
FB3138-001-155				ACC.		100%MT
FB3138-001-156				ACC.		100%MT
FB3138-001-085				ACC.		100%MT
FB3138-001-086				ACC.		100%MT
FB3138-001-087				ACC.		25%MT
FB3138-001-088				ACC.		25%MT
FB3138-001-089				ACC.		100%MT
FB3138-001-090				ACC.		100%MT

EXAMINED BY主探 Xu Huaxiang <i>Xu Huaxiang</i> 2010.8.06 LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM	REVIEWED BY 审核 Sun Gangchang <i>Sun Gangchang</i> 2010.8.06 LEVEL-II SIGN / DATE日期 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-25673 DATE日期 2010.08.06 PAGE OF页码 3/4 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: FB3138 13th lifting floor beam		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 14/16/25/22/30/12mm
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			
FB3138-001-093				ACC.		25%MT
FB3138-001-094				ACC.		25%MT
FB3138-001-095				ACC.		25%MT
FB3138-001-096				ACC.		25%MT
FB3138-001-103						*
FB3138-001-104						*
FB3138-001-067						*
FB3138-001-068						*
FB3138-001-075				ACC.		100%MT
FB3138-001-076				ACC.		100%MT
FB3138-001-077				ACC.		100%MT
FB3138-001-078				ACC.		100%MT
FB3138-001-079				ACC.		25%MT
FB3138-001-080				ACC.		25%MT

EXAMINED BY主探 Xu Huaxiang <i>Xu Huaxiang</i> 2010.8.06	REVIEWED BY审核 <i>Sun Guang cheng</i> 2010.8.06
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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25673 DATE日期 2010.08.06 PAGE OF页码 4/4 Revision No: 0

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

DRAWING NO. FB3138 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 13th lifting floor beam 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
---	--	-------------------------------------	---

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 14/16/25/22/30/12mm
---------------------------------	---	--------------------------------	--

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			
FB3138-001-081				ACC.		100%MT
FB3138-001-082				ACC.		100%MT
FB3138-001-083				ACC.		100%MT
FB3138-001-084				ACC.		100%MT

* FB3138-001-002, FB3138-001-003, FB3138-001-004, FB3138-001-005, FB3138-001-007, FB3138-001-008, FB3138-001-009, FB3138-001-010, FB3138-001-065, FB3138-001-066, FB3138-001-150, FB3138-001-151, FB3138-001-152, FB3138-001-153, FB3138-001-155, FB3138-001-156, FB3138-001-085, FB3138-001-086, FB3138-001-087, FB3138-001-088, FB3138-001-089, FB3138-001-090, FB3138-001-093, FB3138-001-094, FB3138-001-095, FB3138-001-096, FB3138-001-075, FB3138-001-076, FB3138-001-077, FB3138-001-078, FB3138-001-079, FB3138-001-080, FB3138-001-081, FB3138-001-082, FB3138-001-083, FB3138-001-084 were MT inspection and ACC, which is the result of required 25% MT.

* FB3138-001-002, FB3138-001-003, FB3138-001-004, FB3138-001-005, FB3138-001-007, FB3138-001-008, FB3138-001-009, FB3138-001-010, FB3138-001-065, FB3138-001-066, FB3138-001-150, FB3138-001-151, FB3138-001-152, FB3138-001-153, FB3138-001-155, FB3138-001-156, FB3138-001-085, FB3138-001-086, FB3138-001-087, FB3138-001-088, FB3138-001-089, FB3138-001-090, FB3138-001-093, FB3138-001-094, FB3138-001-095, FB3138-001-096, FB3138-001-075, FB3138-001-076, FB3138-001-077, FB3138-001-078, FB3138-001-079, FB3138-001-080, FB3138-001-081, FB3138-001-082, FB3138-001-083, FB3138-001-084 were MT inspection and ACC, which is the result of required 25% MT.

EXAMINED BY 主探 Xu Huaxiang <i>Xu Huaxiang</i> 2010.8.06 LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Sun Gang cheng</i> 2010.8.06 LEVEL-II SIGN DATE 日期 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, China**Report No:** NCS-000767**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0738**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: 27-Jun-2010**Description of Non-Conformance:**

During Quality Assurance (QA) random in-process observations of the fabrication of OBG floor beam subassemblies this Caltrans (CT) QA observed the following issues:

-ZPMC has created a weld joint that is not detailed on the approved shop drawings, without the Engineers approval.

-ZPMC has added approximately 300mm to the end of stiffener plate identified as X3630B.

-The floor beam subassembly is identified as FB3138A.

-FB3138A is located in OBG subassembly bay 3.

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

This issue was addressed and found to be acceptable by TC-RFI 96.

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