

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-000791

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Jul-2010

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

NCR #: ZPMC-0753

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 4 Strut (ND1-STSA4-6-127M-1)
Procedural	Procedural	Description:	

Reference Description: Lift 4 Strut (ND1-STSA4-6-127M-1): Missed UT Indication

Description of Non-Conformance:

During random 10% verification Ultrasonic Testing (UT) of Tower Strut, Quality Assurance Inspector (QA) discovered the following issues:

One (1) Class "A" non conforming longitudinal indication measuring approximately 15 mm in length. The weld is a complete joint penetration (CJP) corner joint, joining Web to Flange and is identified as ND1-STSA4-6-127M-1.

The discontinuity rating is +9, Class "A" and reject.

Depth of the discontinuity from face B is approximately 15 mm, and Y location was 1500mm.

The Material thickness is 16 mm.

The member is SPCM (Seismic Performance Critical Member).

The member is located in fabrication Bay 11.

The indication is in an area previously tested and accepted by ZPMC QC UT technicians.

The Notice of Witness Inspection Number (NWIT) is 006164.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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 Section 6.26.3.1; “Welds that are subject to UT in addition to visual inspection shall be acceptable if they meet the following requirements:...(1) Welds subject to tensile stress under any condition of loading shall conform to the requirements of Table 6.3...(2) Welds subject to compressive stress shall conform to the requirements of Table 6.4.”

AWS D1.5-02 Section 6; Table 6.3

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Zhao Xian He

Time and method of notification: 1100 Hrs./ 07/10/10/ Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 0800Hrs/ 7/12/10

QC Inspector's Name: Yu Dong Ping

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

Inspected By: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: 510-286-0539 Fax: 510-286-0550

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 13-Jul-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0753

Job Name: SAS Superstructure
Document No: 05.03.06-000752

Reference Description: Lift 4 Strut (ND1-STSA4-6-127M-1): Missed UT Indication/Tower/Lift 4 Strut

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: Tower **Lift:** 04

Remarks:

During random 10% verification Ultrasonic Testing (UT) of Tower Strut, Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Class "A" non conforming longitudinal indication measuring approximately 15 mm in length.
- The weld is a complete joint penetration (CJP) corner joint, joining Web to Flange and is identified as ND1-STSA4-6-127M-1.
- The discontinuity rating is +9, Class "A" and reject.
- Depth of the discontinuity from face B is approximately 15 mm, and Y location was 1500mm.
- The Material thickness is 16 mm.
- The member is SPCM (Seismic Performance Critical Member).
- The member is located in fabrication Bay 11.
- The indication is in an area previously tested and accepted by ZPMC QC UT technicians.
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AWS D1.5-02 Section 6; Table 6.3

Action Required and/or Action Taken:

Propose a resolution for this non-conformance and provide documentation that the deficiency has been brought into compliance with the contract requirements. Propose a resolution that addresses the apparent failure of Quality Control to identify the indication.

NCT

(Continued Page 2 of 2)

Additionally, provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

Transmitted by: Gina Rizzardo Transportation Engineer

Attachments: ZPMC-0753

cc: Rick Morrow, Gary Pursell, Mark Woods

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000752

Subject: NCR No. ZPMC-0753

Dated: 27-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000800 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the missed indication and is providing the WRR and NDT performed after the repair to show the weld is acceptable.

ZPMC has repaired the missed indication and is providing the WRR and NDT performed after the repair to show the weld is acceptable. To deal with the number of missed indications ABFJV tracks inspector performance to determine which inspector is responsible for missed indications, a pattern of continued missed indications will result in disciplinary action and potential removal. ZPMC has written an internal NCR to document this incident as well. Based on these actions and acceptable results after repair, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000800R00;

Caltrans' comments:

Status: CLO

Date: 28-Sep-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0753 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 28-Sep-2010



No. T-173

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-09-27

REGARDING: NCR-000791 (ZPMC-753)

ZPMC received NCR-000791 (ZPMC-753), it mentioned that CT inspectors found indication on weld ND1-STSA4-6-127M-1-10A/B.

Once CT inspector found indication on this weld, ZPMC took positive action and performed repair work under approval of CT site inspector. Finally this weld was checked by CT and green tagged.

Anyway, as a conscientious attitude and to improve welding quality, we have already inculcated the welder to perform carefully, and welding must be covered by QC.

Here attached WRR and related NDT reports show the weld is sound finally.

Basing on above information, ZPMC hope CT could take a review and close the NCR.

ATTACHMENT:

NCR-000791 (ZPMC-753)

T-WR3650

T787-UT-3247 R0

T787-UT-3247 R1

Zhao jianeng

2010.9.27



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: 510-286-0539 Fax: 510-286-0550

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 13-Jul-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure
Document No: 05.03.06-000752

Subject: NCR No. ZPMC-0753

Reference Description: Lift 4 Strut (ND1-STSA4-6-127M-1): Missed UT Indication/Tower/Lift 4 Strut

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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.
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Material Location: Tower

Lift: 04

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05.03.06-000752,NCT

NCT

(Continued Page 2 of 2)

Additionally, provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

Transmitted by: Gina Rizzardo Transportation Engineer

Attachments: ZPMC-0753

cc: Rick Morrow, Gary Pursell, Mark Woods

File: 05.03.06

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Cty: SF/ALA Rte: 80 PM: 13.2/13.9
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000791

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Jul-2010

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

NCR #: ZPMC-0753

Type of problem:

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

Bridge No: 34-0006

Component: Lift 4 Strut (ND1-STSA4-6-127M-1)

Reference Description: Lift 4 Strut (ND1-STSA4-6-127M-1): Missed UT Indication

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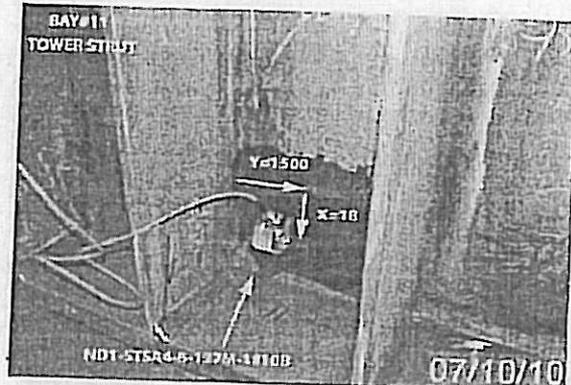
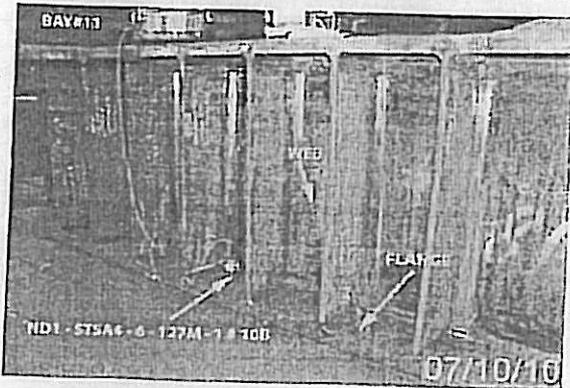
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Time and method of notification: 1100 Hrs./ 07/10/10/ Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 0800Hrs/ 7/12/10

QC Inspector's Name: Yu Dong Ping

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

Inspected By: Ng, Michael

Reviewed By: Devey, Jim

QA Inspector

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	ND1-STSA4-6	报告编号 Report No.	T-WR3650
合同号 Contract No.:	04-0120F4	部件名称 Items Name	FOURTH LIFTING STR UT	NDT报告编号 Report No.of NDT	T787-UT-3247
项目编号 Project No.:	ZP06-787				

缺陷描述:

Description of welding discontinuity:

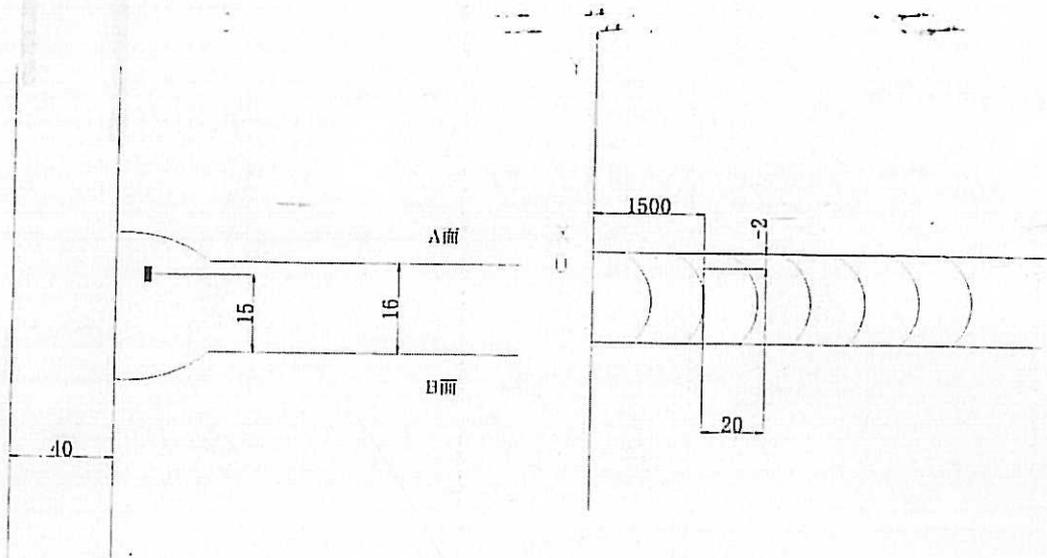
Rejected indication found by ultrasonic inspection is less than the maximum allowance aggregate length.

(UT探伤发现的缺陷总长度小于最大允许长度) ND1-STSA4-6-127M-1-10A/B

检验员 (Inspector): Dai Gang Sheng 日期 (Date): 10.07.10

焊缝返修位置示意图

Draft of welding discontinuity:



WELD NUMBER: ND1-STSA4-6-127M-1-10A/B

产生原因:

Caused:

- 1、 碳刨后,焊接接头没有有效打磨;
 - 2、 起弧和收弧没有交错布置,以将焊渣减少到最少;
 - 3、 焊道间没有有效的清理.
- 1.The weld joint was not ground sufficiently after arc-gouging.
 2. The arc starts and stops were not staggered to minimize slag entrapment.
 3. Interpass cleaning was not performed properly.

车间负责人(Foreman): *Lu Yefei* 日期(Date): 10.07.10

处理意见

Disposition :

工艺:
Technical engineer

Zhang Jindong

审核:
Approved by

Li Jun

日期
Date 2010.07.10



焊缝返修报告

Welding Repair Report

版本 Rev. No.

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	ND1-STSA4-6	报告编号 Report No.	T-WR3650
合同号 Contract No.:	04-0120F4	部件名称 Items Name	FOURTH LIFTING STR UT	NDT 报告编号 Report No. of NDT	T787-UT-3247
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

- 1、碳刨后的接头位置打磨圆滑过渡，保证每道焊缝的接头可以交错布置；
 - 2、认真仔细检查每道焊缝和加强焊道的清理；
 - 3、焊缝中所有的焊渣全部去除后，表面的缺陷全部打磨干净。
1. The joint shall be ground to a smooth transition to ensure that arc starts and stops are in a staggered Arrangement.
 2. QC shall inspect the weld passes more carefully and enforcing interpass cleaning.
 3. All weld slag shall be removed and surface defects ground during interpass cleaning.

车间负责人(Foreman): *Lu Yefei* 日期(Date): 10.07.10

参照的WPS编号 Repair WPS No.	WPS-SL325-SMAW-1g- <i>Repair</i> WPS-SL325-SMAW-2G- <i>Repair</i>	工艺员 technologist	<i>Shang Jindong</i> 10.07.10
返修(碳刨)前预热温度 Preheat temperature before gouging	70°C	返修的缺陷 Description of discontinuity	夹渣
焊前处理检查 Inspection before welding	Acc	焊前预热温度 Preheat-temperature before welding	180°C
最大碳刨深度 Max. depth of gouging	6mm	碳刨总长 Total length of gouging	120mm
焊工 welder <i>500363</i> (14.0)	焊接类型 welding type SMAW	焊接位置 position 2G	
焊接电流 Current 180A	焊接电压 Voltage 23V	焊接速度 Speed 106 mm/min	

返修后检查
Inspection After repairing:

外观检查 VT result <i>Acc</i>	检验员 Inspector <i>Yu Dong Ping</i>	日期 Date 10.07.12	
NDT复检 NDT result <i>WPA</i>	探伤员 NDT person <i>Pet Grayshaw</i>	日期 Date 10.07.13	
见证: Witness/Review:			
备注: Remark:			



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-3247R1 DATE 2010.07.13 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: FOURTH LIFTING STRUT DRAWING NO.: ND1-STSA4-6 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 SMAW T-JOINT Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709SL-GR485/GR345 A709M-345F2-X-Z 90mm

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	45°	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 探测面	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
ND1-STSA4-6-127M-1-10A/B	1R1	70				34										ACC.	100%

AFTER B-WR3650

BLANK

EXAMINED BY 主探 <i>Daifeng Gong</i> / 07.13 LEVEL - II SIGN / DATE	REVIEWED BY 审核 <i>Wukong gang</i> / 10.07.13 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



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(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-000856**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0753**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: 10-Jul-2010**Description of Non-Conformance:**

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The member is located in fabrication Bay 11.

The indication is in an area previously tested and accepted by ZPMC QC UT technicians.

The Notice of Witness Inspection Number (NWIT) is 006164.

Contractor's proposal to correct the problem:

Contractor will repair the missed indications, and provide NDT report to prove the weld is acceptable after repair. Contractor will issue an internal NCR to the inspector who missed the indications. Contractor will monitor the performance of the inspector involved, taking disciplinary action which may result in removal should this non-conformance act persists.

Corrective action taken:

Contractor repaired the indications, and provided the NDT documentation proving the weld is acceptable.

Contractor also identified the inspector who missed the indications is monitoring his performance.

Did corrective action require Engineer's approval? Yes No

If so, name of Engineer providing approval:

Date:

Is Engineer's approval attached?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Yes No

Comments:

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Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer
