

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-000813
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 26-Jul-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0775

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 13 Various Edge /Side Plates
Procedural	Procedural	Description:	

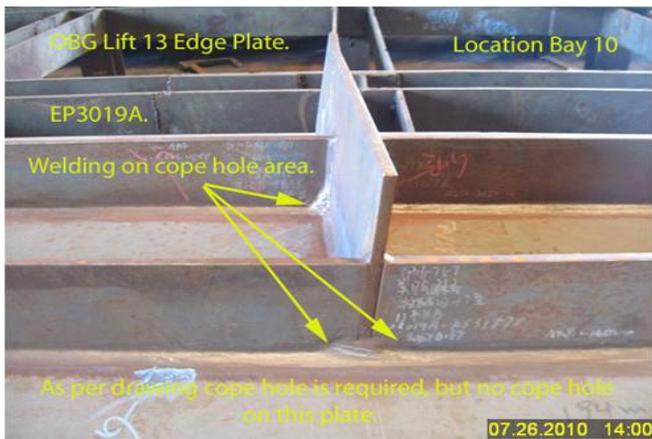
Reference Description: Cope Access Holes welded over on Lift 13 Sub Assembly Components

Description of Non-Conformance:

Quality Assurance in-process observations of the fabrication of Edge Plates and Side Plates in Tower Bay 10 discovered the following issue:

- ZPMC personnel have welded over cope hole and snipe areas on various Lift 13 Edge and Side Plates.
- Edge Plates identified are as follows: EP3018C, EP3025A and EP3026A.
- Side Plates identified are as follows: SP3081, SP3115A, SP3113A, SP3109A, SP3078A and SP3110A.
- According to the approved shop drawings, cope hole and/or snipes are required in the areas where the panel stiffeners intersect the panel diaphragms.
- All above mentioned panels are located in Tower Bay#10.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Drawing No- Sheet No- EP3018C, EP3025A, EP3026A, SP3081, SP3115A, SP3113A, SP3109A, SP3078A and SP3110A.

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

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".

Who discovered the problem: Shailesh Gaikwad / Robin Sharma

Name of individual from Contractor notified: Shen Jian

Time and method of notification: 14:00 hours_07/26/2010_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:30 hours_7/27/10_Email

QC Inspector's Name: Sun Tian Liang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

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
 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: 27-Jul-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: 05.03.06-000769

Subject: NCR No. ZPMC-0775

Reference Description: Cope Access Holes welded over on Lift 13 Sub Assembly Components

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:

- Quality Assurance in-process observations of the fabrication of edge plates and side plates in Bay No. 10 discovered the following issue:
- ZPMC personnel have welded over cope hole and snipe areas on various Lift 13 edge and side plates.
 - Edge Plates identified are as follows: EP3018C, EP3025A and EP3026A.
 - Side Plates identified are as follows: SP3081, SP3115A, SP3113A, SP3109A, SP3078A and SP3110A.
 - According to the approved shop drawings, cope hole and/or snipes are required in the areas where the panel stiffeners intersect the panel diaphragms.
 - All above mentioned panels are located in Bay No. 10.

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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0775

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: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000769

Subject: NCR No. ZPMC-0775

Dated: 21-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000787 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT of the welded over areas to show they are free of defect.

Per the RFI approved in China, snipes and copes welded on these sub assemblies are accepted "as is". ZPMC is providing NDT of the welded over areas to show they are free of defect. ZPMC production is aware that welded copes and snipes are not allowed unless with approval from the Engineer. To prevent future occurrences the ABFJV QCM has met with all lead inspectors on the projects for all areas and it is clear that welded snipes and copes are not acceptable conditions. Based on this, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000787R00;

Caltrans' comments:

Status: AAP

Date: 26-Sep-2010

TC-RFI 126 accepts the weld wraps on EP3018c, EP3025A, EP3026A, and SP3081, but the remaining members noted in the NCR need to be addressed or the unspecified welds shall be removed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 26-Sep-2010



No. B-885

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-9-18

REGARDING: NCR-000811(ZPMC-0773) NCR-000813(ZPMC-0775)

During the welding, the snipes on stiffeners were welded. As talked with ABF QCM, he agreed to leave these access holes as they were. And an RFI will be sent to department. Based on this and the attached NDT records, ZPMC is requesting closure of these NCRs.

ATTACHMENT:

- NCR-000811(ZPMC-0773)
- B787-MT-25163
- B787-MT-25640
- NCR-000813(ZPMC-0775)
- B787-MT-25395
- B787-MT-25767
- B787-MT-25189
- B787-MT-25161
- B787-MT-26146
- B787-MT-26147
- B787-MT-26148
- B787-MT-26149
- B787-MT-26149 RI
- B787-MT-26150
- B787-MT-26154
- B787-MT-26156
- B787-MT-26158
- B787-MT-25396

[Handwritten signature]
9/18/10



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

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 27-Jul-2010

Dear: Mr. Charles Kanapicki
 Attention: Mr. Thomas Nilsson Project/Fabrication Manager
 Subject: NCR No. ZPMC-0773

Contract No: 04-0120F4
 04-SF-80-13.2 / 13.9
 Job Name: SAS Superstructure
 Document No: 05.03.06-000768

Reference Description: Welded cope holes on EP3019A, and SP3083A

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 the Caltrans Quality Assurance in-process observations of the fabrication of edge plate ,EP3019A, and side plate, SP3083A, this Quality Assurance Inspector (QA) discovered the following issue:
- ZPMC personnel welded on cope hole area of edge plate and side plate, non seismic performance critical material (NON SPCM).
- The affected Edge plate identified as EP3019A (PL3213C) and stiffeners (RS3157B, RS3757D, RS3167A, RS3167B)
- The affected side plate identified as SP3083A (PL3264A) and stiffeners (RS3192A, RS3192D, RS3192C, RS3192N,)
- The welding has been done at all cope hole area in both plates, but as per the Shop Drawings, no welding shall be done on cope hole area.
- The Material thickness is 12 mm.
- This edge plate and side plate are located in Bay No. 10.

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: Lorraine Woo Transportation Engineer

Attachments: ZPMC-0773

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

02.02:15.04
 05.03.06-000768.NCT

Received
 NCT-000768 27 Jul 10 Page 1 of 1

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, China

Prime Contractor: American Bridge/Fluor Enterprises, a JV

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

Report No: NCR-000811

Date: 23-Jul-2010

NCR #: ZPMC-0773

Type of problem:

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

Bridge No: 34-0006

Component: Lift 13, EP3019A, SP3083A

Reference Description: Welded cope holes on EP3019A, and SP3083A

Description of Non-Conformance:

During the Caltrans Quality Assurance in-process observations of the fabrication of Edge Plate EP3019A, and SP3083A, this Quality Assurance Inspector (QA) discovered the following issue:

-ZPMC personnel done welding on Cope Hole area of Edge plate and Side plate, non Seismic Performance Critical Material (NON SPCM).

-The effected Edge plate identified as EP3019A (PL3213C) and stiffeners (RS3157B, RS3757D, RS3167A, RS3167B,)

- The effected Side plate identified as SP3083A (PL3264A) and stiffeners (RS3192A, RS3192D, RS3192C, RS3192N,)

-The welding has been done at all Cope Hole area in both plates, but as per drawing no welding on cope hole area,

-The Material thickness is 12 mm.

-This Edge Plate and Side plate are located in Sub assembly Bay#10.

For further information, please see the attached pictures below.



QUALITY ASSURANCE – NON-CONFORMANCE REPORT
(Continued Page 2 of 2)



Applicable reference:

Drawing No- Sheet No- EP3019 and SP3083

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

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".

Who discovered the problem: Shailesh Gaikwad.

Name of individual from Contractor notified: Sen Jian

Time and method of notification: 15:00 hours, 07-23-2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 8:30_7-24-10_Email

QC Inspector's Name: Sun Tian Liang

Was QC Inspector aware of the problem:

Yes No

Contractor's proposal to correct the problem:

NA

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

Reviewed By: Wahbeh, Mazen

SMR

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

zpmc-0773

REPORT NO. 报告编号 B787-MT-25163

DATE日期 2010.07.22

PAGE OF页码 1/3

Revisioing No.: 0

PROJECT NO.

ZP06-787

CONTRACTOR:

CALTRANS

DRAWING NO.

EP3019-001

用户:

CALTRANS CONTRACT NO.:

图号:

13th lifting edge plate

加州工程编号

04-0120F4

REFERENCING CODE

ACCEPTANCE STANDARD

PROCEDURE NO.

CALIBRATION DUE DATE

参考规范编码

接受标准

程序编号

仪器校正有效期

AWS D1.5-2002

AWS D1.5-2002

ZPQC-MT-01

Dec. 28th, 2010

EQUIPMENT 设备

MANUFACTURER 制造商

MODEL NO. 样式编号

SERIAL NO. 连续编号

MT YOKE

PARKER

B310S

5395 5617 5620

MAGNETIZING METHOD

Continuous magnetic yoke

CURRENT

AC

磁化方法

磁轭式连续法

电流

PARTICLE TYPE

Dry magnet powder

YOKE SPACING

70~150mm

磁粉类型

干磁粉

磁轭间距

MATERIAL TO BE

WELDING 焊接件

Material & thickness

A709M-345T2-X

EXAMINED

CASTING 铸件

母材,厚度

12/16/25/14mm

检测材料

FORGING 锻造

WELDING PROCESS

FCAW

TYPE OF JOINT

T-JOINT

焊接方法

焊缝类型

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			
EP3019-001-019				ACC.		100%MT
EP3019-001-020				ACC.		100%MT
EP3019-001-029				ACC.		100%MT
EP3019-001-030				ACC.		100%MT
EP3019-001-023				ACC.		100%MT
EP3019-001-024				ACC.		100%MT
EP3019-001-033				ACC.		100%MT
EP3019-001-034				ACC.		100%MT
EP3019-001-027				ACC.		100%MT
EP3019-001-028				ACC.		100%MT
EP3019-001-037				ACC.		100%MT
EP3019-001-038				ACC.		100%MT
EP3019-001-005				ACC.		100%MT
EP3019-001-006				ACC.		100%MT
				ACC.		100%MT

EXAMINED BY主探

Cai Xinxin *Cai Xinxin* 10.07.22

REVIEWED BY 审核

Lu Bing 10.07.22

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

(FORM# ZPQC-MT01)



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25163

DATE日期 2010.07.22

PAGE OF页码 2/3

Revision No.: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: EP3019-001 13th lifting edge plate		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 12/16/25/14mm
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			
EP3019-001-007				ACC.		100%MT
EP3019-001-008				ACC.		100%MT
EP3019-001-009				ACC.		100%MT
EP3019-001-010				ACC.		100%MT
EP3019-001-001				ACC.		100%MT
EP3019-001-002				ACC.		100%MT
EP3019-001-003				ACC.		100%MT
EP3019-001-004				ACC.		100%MT
EP3019-001-021				ACC.		100%MT
EP3019-001-022				ACC.		100%MT
EP3019-001-031				ACC.		100%MT
EP3019-001-032				ACC.		100%MT
EP3019-001-025				ACC.		100%MT
EP3019-001-026				ACC.		100%MT

EXAMINED BY主探
Cai Xinxin (Signature) 10.07.22
LEVEL - II SIGN 签名 / DATE日期
质量经理 / QCM
签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

REVIEWED BY审核
Luo Bing (Signature) 10.07.22
LEVEL-II SIGN / DATE日期
用户CUSTOMER
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-25163

DATE 日期 2010.07.22

PAGE OF 页码 3/3

Revision No.: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: EP3019-001 13th lifting edge plate		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 th , 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 12/16/25/14mm
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			
EP3019-001-035				ACC.		100%MT
EP3019-001-036				ACC.		100%MT
EP3019-001-039				ACC.		100%MT
AFTER HSR1(B)-8785						
BLANK						

EXAMINED BY 主操 Cal Xinxin <i>Cal Xinxin</i> 10.07.22	REVIEWED BY 审核 <i>Lu Bing</i> 10.07.22
LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	LEVEL - II SIGN 签名 / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



ZPMC-0773.

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25640 DATE日期 2010.08.03 PAGE OF页码 1/10 Revision No: 0

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

DRAWING NO. SP3083-001 CALTRANS CONTRACT NO.:
 图号: 13th lifting edge plate 加州工程编号 04-0120F4

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 th , 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 25/16/12mm

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			
SP3083-001-001				ACC.		100%MT
SP3083-001-002				ACC.		100%MT
SP3083-001-003				ACC.		100%MT
SP3083-001-004				ACC.		100%MT
SP3083-001-005				ACC.		100%MT
SP3083-001-006				ACC.		100%MT
SP3083-001-007				ACC.		100%MT
SP3083-001-008				ACC.		100%MT
SP3083-001-009				ACC.		100%MT
SP3083-001-010				ACC.		100%MT
SP3083-001-011				ACC.		100%MT
SP3083-001-012				ACC.		100%MT
SP3083-001-013				ACC.		100%MT
SP3083-001-014				ACC.		100%MT

EXAMINED BY 主操
 Cal Xinxin *Cal Xinxin* 8.3
 LEVEL - II SIGN 签名 / DATE 日期
 质量经理 / QCM

REVIEWED BY 审核
Lu Bing 8.3
 LEVEL-II SIGN / DATE 日期
 用户 CUSTOMER

签字 SIGN / 日期 DATE
 (FORM# ZPQC-MT01)

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-25640		DATE 日期 2010.08.03	PAGE OF 页码 3/10	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3083-001 13th lifting edge plate		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 th , 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 25/16/12mm	
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			
SP3083-001-029				ACC.		100%MT
SP3083-001-030				ACC.		100%MT
SP3083-001-031				ACC.		100%MT
SP3083-001-032				ACC.		100%MT
SP3083-001-033				ACC.		100%MT
SP3083-001-034				ACC.		100%MT
SP3083-001-035				ACC.		100%MT
SP3083-001-036				ACC.		100%MT
SP3083-001-037				ACC.		100%MT
SP3083-001-038				ACC.		100%MT
SP3083-001-039				ACC.		100%MT
SP3083-001-040				ACC.		100%MT
SP3083-001-041				ACC.		100%MT
SP3083-001-042				ACC.		100%MT

EXAMINED BY 主操 Cai Xinxin (Cai Xinxin S.)	REVIEWED BY 审核 Xue Baoy (Xue Baoy S.)
LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	LEVEL-II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)	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-25640 DATE日期 2010.08.03 PAGE OF页码 4/10 Revision No: 0

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

DRAWING NO. SP3083-001 CALTRANS CONTRACT NO.:
 图号: 13th lifting edge plate 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 25/16/12mm
---------------------------------	---	--------------------------------	---------------------------------

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			
SP3083-001-043				ACC.		100%MT
SP3083-001-044				ACC.		100%MT
SP3083-001-045				ACC.		100%MT
SP3083-001-046				ACC.		100%MT
SP3083-001-047				ACC.		100%MT
SP3083-001-048				ACC.		100%MT
SP3083-001-049				ACC.		100%MT
SP3083-001-050				ACC.		100%MT
SP3083-001-051				ACC.		100%MT
SP3083-001-052				ACC.		100%MT
SP3083-001-053				ACC.		100%MT
SP3083-001-054				ACC.		100%MT
SP3083-001-055				ACC.		100%MT
SP3083-001-056				ACC.		100%MT

EXAMINED BY 主探
Cai Xinxin *Cai Xinxin 8.3*

REVIEWED BY 审核
Lu Bing 8.3

LEVEL - II SIGN 签名 / DATE 日期
质量经理 / QCM

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-25640 DATE日期 2010.08.03 PAGE OF页码 5/10 Revision No: 0

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

DRAWING NO. SP3083-001 CALTRANS CONTRACT NO.:
 图号: 13th lifting edge plate 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 th , 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 25/16/12mm
--	---

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			
SP3083-001-057				ACC.		100%MT
SP3083-001-058				ACC.		100%MT
SP3083-001-059				ACC.		100%MT
SP3083-001-060				ACC.		100%MT
SP3083-001-061				ACC.		100%MT
SP3083-001-062				ACC.		100%MT
SP3083-001-063				ACC.		100%MT
SP3083-001-064				ACC.		100%MT
SP3083-001-065				ACC.		100%MT
SP3083-001-066				ACC.		100%MT
SP3083-001-067				ACC.		100%MT
SP3083-001-068				ACC.		100%MT
SP3083-001-069				ACC.		100%MT
SP3083-001-070				ACC.		100%MT

EXAMINED BY 主探
 Cai Xinxin *(Signature)*
 LEVEL - II SIGN 签名 / DATE日期
 质量经理 / QCM

REVIEWED BY 审核
(Signature)
 LEVEL-II SIGN / DATE日期
 用户CUSTOMER

签字 SIGN / 日期 DATE
 (FORM# ZPQC-MT01)

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-25640		DATE 日期 2010.08.03		PAGE OF 页码 6/10		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SP3083-001 13th lifting edge plate				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 th , 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 25/16/12mm	
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			
SP3083-001-071				ACC.		100%MT
SP3083-001-072				ACC.		100%MT
SP3083-001-073				ACC.		100%MT
SP3083-001-074				ACC.		100%MT
SP3083-001-075				ACC.		100%MT
SP3083-001-076				ACC.		100%MT
SP3083-001-077				ACC.		100%MT
SP3083-001-078				ACC.		100%MT
SP3083-001-079				ACC.		100%MT
SP3083-001-080				ACC.		100%MT
SP3083-001-081				ACC.		100%MT
SP3083-001-082				ACC.		100%MT
SP3083-001-083				ACC.		100%MT
SP3083-001-084				ACC.		100%MT

EXAMINED BY 主探 Cai Xinxin <i>Cai Xinxin</i> 8.03	REVIEWED BY 审核 <i>La Boy</i> 8.03
LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	LEVEL - II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)	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-25640

DATE日期 2010.08.03

PAGE OF页码 7/10

Revision-No: 0

PROJECT NO.

工程编号: ZP06-787

CONTRACTOR:

用户: CALTRANS

DRAWING NO.

SP3083-001

CALTRANS CONTRACT NO.:

加州工程编号 04-0120F4

图号:

13th lifting edge plate

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. 28ST, 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

25/16/12mm

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

INDICATION

指示

TYPE

类型

LENGTH IN mm

长度

ACCEPT

接受

REJECT

拒收

REMARKS

备注

SP3083-001-085

SP3083-001-086

SP3083-001-087

SP3083-001-088

SP3083-001-089

SP3083-001-090

SP3083-001-091

SP3083-001-092

SP3083-001-093

SP3083-001-094

SP3083-001-095

SP3083-001-096

SP3083-001-097

SP3083-001-098

ACC.

100%MT

EXAMINED BY主探

Cal Xinxin

LEVEL - II SIGN 签名 / DATE日期

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核

LEVEL-II SIGN / DATE日期

用户CUSTOMER

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-25640

DATE 日期 2010.08.03

PAGE OF 页码 8/10

Revision No: 0

PROJECT NO.

工程编号: ZP06-787

CONTRACTOR:

用户: CALTRANS

DRAWING NO.

SP3083-001

CALTRANS CONTRACT NO.:

加州工程编号 04-0120F4

图号:

13th lifting edge plate

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. 28ST, 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

25/16/12mm

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

INDICATION

指示

TYPE

类型

LENGTH IN mm

长度

ACCEPT

接受

REJECT

拒收

REMARKS

备注

SP3083-001-099

SP3083-001-100

SP3083-001-101

SP3083-001-102

SP3083-001-103

SP3083-001-104

SP3083-001-105

SP3083-001-106

SP3083-001-107

SP3083-001-108

SP3083-001-109

SP3083-001-110

SP3083-001-111

SP3083-001-112

ACC.

100%MT

EXAMINED BY 主探

Cai Xinxin

LEVEL - II SIGN 签名 / DATE 日期

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

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-25640		DATE 日期 2010.08.03		PAGE OF 页码 9/10	Revision No: 0
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3083-001 13th lifting edge plate			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 th , 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 25/16/12mm		
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			
SP3083-001-113				ACC.		100%MT
SP3083-001-114				ACC.		100%MT
SP3083-001-115				ACC.		100%MT
SP3083-001-116				ACC.		100%MT
SP3083-001-117				ACC.		100%MT
SP3083-001-118				ACC.		100%MT
SP3083-001-119				ACC.		100%MT
SP3083-001-120				ACC.		100%MT
SP3083-001-121				ACC.		100%MT
SP3083-001-122				ACC.		100%MT
SP3083-001-123				ACC.		100%MT
SP3083-001-124				ACC.		100%MT
SP3083-001-125				ACC.		100%MT
SP3083-001-126				ACC.		100%MT

EXAMINED BY 主探 Cai Xinxin	REVIEWED BY 审核 Lu Boyi
LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	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-25640 DATE日期 2010.08.03 PAGE OF页码 10/10 Revision No: 0

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

DRAWING NO. 图号: SP3083-001 CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
13th lifting edge plate

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 th , 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 25/16/12mm
---	--

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			
SP3083-001-127				ACC.		100%MT
SP3083-001-128				ACC.		100%MT
SP3083-001-129				ACC.		100%MT
SP3083-001-130				ACC.		100%MT
SP3083-001-131				ACC.		100%MT
SP3083-001-132				ACC.		100%MT
SP3083-001-133				ACC.		100%MT
SP3083-001-134				ACC.		100%MT
SP3083-001-135				ACC.		100%MT
SP3083-001-136				ACC.		100%MT
SP3083-001-137				ACC.		100%MT

AFTER HSR1(B)-8858

BLANK

EXAMINED BY 主探
Cai Xinxin *Cai Xinxin 8.3*
LEVEL-II SIGN 签名 / DATE 日期
质量经理 / QCM

REVIEWED BY 审核
Lu Boyu 8.3
LEVEL-II SIGN / DATE 日期
用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



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: 27-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

Subject: NCR No. ZPMC-0775

Document No: 05.03.06-000769

Reference Description: Cope Access Holes welded over on Lift 13 Sub Assembly Components

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:

Quality Assurance in-process observations of the fabrication of edge plates and side plates in Bay No. 10 discovered the following issue:

-ZPMC personnel have welded over cope hole and snipe areas on various Lift 13 edge and side plates.

-Edge Plates identified are as follows: EP3018C, EP3025A and ~~EP3025A~~.

-Side Plates identified are as follows: SP3081, ~~SP3115A, SP3113A, SP3109A, SP3078A and SP3110A~~.

-According to the approved shop drawings, cope hole and/or snipes are required in the areas where the panel stiffeners intersect the panel diaphragms.

-All above mentioned panels are located in Bay No. 10.

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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0775

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

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-000813

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 26-Jul-2010

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

NCR #: ZPMC-0775

Type of problem:

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

Bridge No: 34-0006

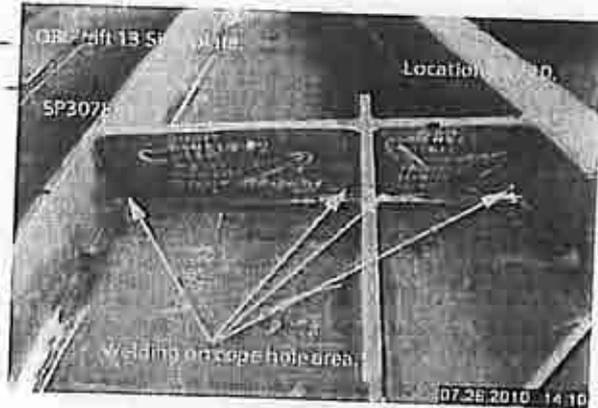
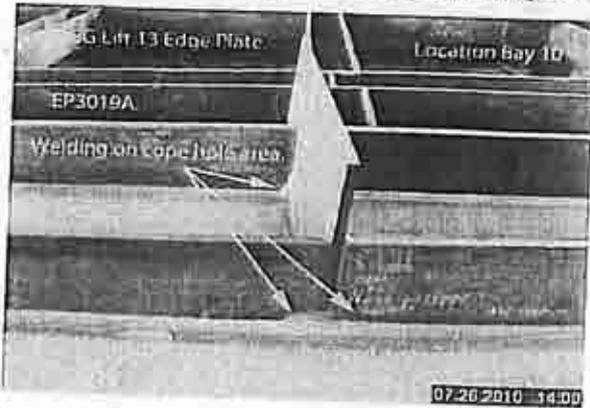
Component: Lift 13 Various Edge /Side Plates

Reference Description: Cope Access Holes welded over on Lift 13 Sub Assembly Components

Description of Non-Conformance:

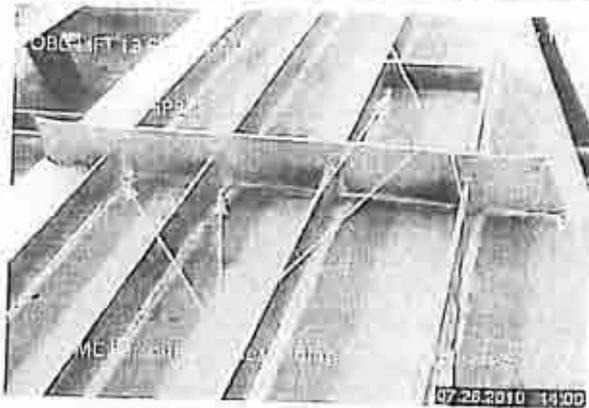
Quality Assurance in-process observations of the fabrication of Edge Plates and Side Plates in Tower Bay 10 discovered the following issue:

- ZPMC personnel have welded over cope hole and snipe areas on various Lift 13 Edge and Side Plates.
 - Edge Plates identified are as follows: EP3018C, EP3025A and EP3026A.
 - Side Plates identified are as follows: SP3081, SP3115A, SP3113A, SP3109A, SP3078A and SP3110A.
 - According to the approved shop drawings, cope hole and/or snipes are required in the areas where the panel stiffeners intersect the panel diaphragms.
 - All above mentioned panels are located in Tower Bay#10.
- For further information, please see the attached pictures below.



QUALITY ASSURANCE – NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Drawing No- Sheet No- EP3018C, EP3025A, EP3026A, SP3081, SP3115A, SP3113A, SP3109A, SP3078A and SP3110A.

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

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".

Who discovered the problem: Shailesh Gaikwad / Robin Sharma

Name of individual from Contractor notified: Shen Jian

Time and method of notification: 14:00 hours_07/26/2010_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:30 hours_7/27/10_Email

QC Inspector's Name: Sun Tian Liang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

PMC-0725

REPORT NO. 报告编号 B787-MT-25395 DATE日期 2010.07.26 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: EP3018-001 13th lifting edge plate		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 th , 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 12/16/25mm
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			
EP3018-001-003				ACC.		100%MT
EP3018-001-004				ACC.		100%MT
EP3018-001-009				ACC.		100%MT
EP3018-001-010				ACC.		100%MT
EP3018-001-013				ACC.		100%MT
EP3018-001-014				ACC.		100%MT
EP3018-001-015				ACC.		100%MT
EP3018-001-016				ACC.		100%MT
EP3018-001-021				ACC.		100%MT
EP3018-001-022				ACC.		100%MT
EP3018-001-025				ACC.		100%MT
EP3018-001-026				ACC.		100%MT
EP3018-001-027				ACC.		100%MT
EP3018-001-028				ACC.		100%MT

EXAMINED BY 主操 Cal Xinxin <i>Cal Xinxin</i> 10.07.26	REVIEWED BY 审核 <i>Lu Bing</i> 07.26
LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM	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-25395

DATE 日期 2010.07.26

PAGE OF 页码 2/2

Revision No: 0

PROJECT NO.

工程编号:

ZP06-787

CONTRACTOR:

用户:

CALTRANS

DRAWING NO.

图号:

EP3018-001

13th lifting edge plate

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. 28ST, 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

12/16/25mm

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			
EP3018-001-029				ACC.		100%MT
EP3018-001-030				ACC.		100%MT
EP3018-001-031				ACC.		100%MT
EP3018-001-032				ACC.		100%MT
AFTER HSR1(B)-8788						
BLANK						

EXAMINED BY 主操

Cai Xinxin

Cai Xinxin 2010.07.26

REVIEWED BY 审核

Xue Bing

2010.07.26

LEVEL - II SIGN 签名 / DATE 日期

质量经理 / QCM

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

zpmc-0775

REPORT NO. 报告编号 B787-MT-25767		DATE 日期 2010.08.05		PAGE OF 页码 1/3		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: EP3016-001 13th lifting edge plate				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 th , 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 22/18mm	
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			
EP3016-001-001				ACC.		100%MT
EP3016-001-002				ACC.		100%MT
EP3016-001-003				ACC.		100%MT
EP3016-001-004				ACC.		100%MT
EP3016-001-005				ACC.		100%MT
EP3016-001-006				ACC.		100%MT
EP3016-001-007				ACC.		100%MT
EP3016-001-008				ACC.		100%MT
EP3016-001-009				ACC.		100%MT
EP3016-001-010				ACC.		100%MT
EP3016-001-011				ACC.		100%MT
EP3016-001-012				ACC.		100%MT
EP3016-001-013				ACC.		100%MT
EP3016-001-014				ACC.		100%MT

EXAMINED BY 主探 Xu Bing <i>Xu Bing</i> 10.8.05		REVIEWED BY 审核 <i>Xu Bing</i> 10.8.05	
LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM		LEVEL-II SIGN / DATE 日期 用户 CUSTOMER	
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)		签字 SIGN / 日期 DATE	



ZPMC-0173

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-25161 DATE日期 2010.07.22 PAGE OF 页码 1/1 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3078C-001 13th lifting edge plate		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 12/16/25mm
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			
SP3078C-001-001				ACC.		100%MT
SP3078C-001-002				ACC.		100%MT
SP3078C-001-004				ACC.		100%MT
SP3078C-001-005				ACC.		100%MT
SP3078C-001-006				ACC.		100%MT
SP3078C-001-007				ACC.		100%MT
SP3078C-001-008				ACC.		100%MT
SP3078C-001-009				ACC.		100%MT
SP3078C-001-010				ACC.		100%MT
SP3078C-001-011				ACC.		100%MT
SP3078C-001-003				ACC.		100%MT

AFTER HSR1(B)-8850

BLANK

EXAMINED BY 主操 Cai Xinlin <i>Cai Xinlin</i> 07.22	REVIEWED BY 审核 <i>Lu Bing</i> 07.22
LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	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-26146		DATE 日期 2010.08.15	PAGE OF 页码 2/2	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3113-001 OBG-13 LIFTING		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 12/16mm	
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			
SP3113-001-015				ACC.		100%MT
SP3113-001-016				ACC.		100%MT
SP3113-001-017				ACC.		100%MT
SP3113-001-018				ACC.		100%MT
AFTER HSR1(B)-8861						
BLANK						

EXAMINED BY 主探 Xu Bing LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Xu Bing</i> 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-26147

DATE日期 2010.08.15

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:

SP3113-001-

OBG-13 LIFTING

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. 28ST, 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

12/16mm

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			
SP3113-001-019				ACC.		100%MT
SP3113-001-020				ACC.		100%MT
SP3113-001-021				ACC.		100%MT
SP3113-001-022				ACC.		100%MT
SP3113-001-023				ACC.		100%MT
SP3113-001-024				ACC.		100%MT
SP3113-001-025				ACC.		100%MT
SP3113-001-026				ACC.		100%MT
SP3113-001-027				ACC.		100%MT
SP3113-001-028				ACC.		100%MT
SP3113-001-029				ACC.		100%MT
SP3113-001-030				ACC.		100%MT
SP3113-001-031				ACC.		100%MT
SP3113-001-032				ACC.		100%MT

EXAMINED BY 主探

Xu BING

LEVEL - II SIGN 签名 / DATE 日期

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核

Calvin M. of 15

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

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-26147 DATE日期 2010.08.15 PAGE OF页码 2/2 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3113-001- OBG-13 LIFTING		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 12/16mm
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			
SP3113-001-033				ACC.		100%MT
SP3113-001-034				ACC.		100%MT
SP3113-001-035				ACC.		100%MT
SP3113-001-036				ACC.		100%MT
AFTER HSR1(B)-8861						
BLANK						

EXAMINED BY 主操 Xu Bing LEVEL - II SIGN 签名 质量经理 / QCM	<i>Xu Bing</i> 8.15 DATE 日期	REVIEWED BY 审核 <i>Calvin</i> 8.15 LEVEL-II SIGN / DATE 日期	用户 CUSTOMER
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)		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-26148		DATE 日期 2010.08.15	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: SP3113-001 OBG-13 LIFTING		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 12/16mm	
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			
SP3113-001-037				ACC.		100%MT
SP3113-001-038				ACC.		100%MT
SP3113-001-110				ACC.		100%MT
SP3113-001-111				ACC.		100%MT
SP3113-001-113				ACC.		100%MT
SP3113-001-114				ACC.		100%MT
SP3113-001-116				ACC.		100%MT
SP3113-001-117				ACC.		100%MT
SP3113-001-055				ACC.		100%MT
SP3113-001-056				ACC.		100%MT
SP3113-001-057				ACC.		100%MT
SP3113-001-058				ACC.		100%MT
SP3113-001-059				ACC.		100%MT
SP3113-001-060				ACC.		100%MT

EXAMINED BY 主探 Xu Bing LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 Cai Landa 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-26148		DATE 日期 2010.08.15		PAGE OF 页码 2/2		Revision No: 0-	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SP3113-001 OBG-13 LIFTING				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 th , 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 12/16mm	
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			
SP3113-001-061				ACC.		100%MT
SP3113-001-062				ACC.		100%MT
SP3113-001-067				ACC.		100%MT
SP3113-001-068				ACC.		100%MT
AFTER HSR1(B)-8861						
BLANK						

EXAMINED BY 主操 Xu Bing <i>Xu Bing 8.15</i> LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM		REVIEWED BY 审核 <i>Wei London 8.15</i> 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-26149

DATE 日期 2010.08.15

PAGE OF 页码 1/2

Revision No: 0-

PROJECT NO.

工程编号: ZP06-787

CONTRACTOR:

用户: CALTRANS

DRAWING NO.

SP3113

CALTRANS CONTRACT NO.:

加州工程编号 04-0120F4

图号:

THE 13 LIFTING SIDE PLATE

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. 28ST, 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

12/16/25mm

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			
SP3113-001-096				ACC.		100%MT
SP3113-001-097				ACC.		100%MT
SP3113-001-108				ACC.		100%MT
SP3113-001-109				ACC.		100%MT
SP3113-001-074				ACC.		100%MT
SP3113-001-075				ACC.		100%MT
SP3113-001-039				ACC.		100%MT
SP3113-001-040				ACC.		100%MT
SP3113-001-041				ACC.		100%MT
SP3113-001-042				ACC.		100%MT
SP3113-001-043				ACC.		100%MT
SP3113-001-044				ACC.		100%MT
SP3113-001-045				ACC.		100%MT
SP3113-001-046				ACC.		100%MT

EXAMINED BY 主探

Xu Bing *Xu Bing* 8.15

LEVEL - II SIGN 签名 / DATE 日期

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核

Lei Xun 8.15

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

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-26149		DATE 日期 2010.08.15		PAGE OF 页码 2/2		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SP3113 THE 13 LIFTING SIDE PLATE				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 th , 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 12/16/25mm	
WELDING PROCESS 焊接方法				TYPE OF JOINT 焊缝类型			
FCAW				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			
SP3113-001-047				ACC.		100%MT
SP3113-001-048				ACC.		100%MT
SP3113-001-049				ACC.		100%MT
SP3113-001-050	1	LONGITUDINAL CRACK	60		REJ.	Y=40
AFTER HSR1(B)-8861						
BLANK						

EXAMINED BY 主探 Xu Bing <i>Xu Bing</i> 8.15		REVIEWED BY 审核 <i>(Signature)</i> 8.15	
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-26149R1 DATE日期 2010.08.27 PAGE OF 页码 1/1 Revision No: 0-

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3113 THE 13 LIFTING SIDE PLATE		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 12/16/25mm
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			
SP3113-001-50	1R1			ACC.		100%MT

AFTER B-CWR1800REV0

BLANK

EXAMINED BY 主探 Xu Bing <i>Xu Bing</i> 8.27	REVIEWED BY 审核 <i>Lei Lu</i> 8.27
LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM	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-26150		DATE 日期 2010.08.15	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: SP3113-001 OBG-13 LIFTING		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 th , 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 25/16mm	
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			
SP3113-001-051				ACC.		100%MT
SP3113-001-052				ACC.		100%MT
SP3113-001-053				ACC.		100%MT
SP3113-001-054				ACC.		100%MT
SP3113-001-063				ACC.		100%MT
SP3113-001-064				ACC.		100%MT
SP3113-001-065				ACC.		100%MT
SP3113-001-066				ACC.		100%MT
SP3113-001-092				ACC.		100%MT
SP3113-001-093				ACC.		100%MT
SP3113-001-094				ACC.		100%MT
SP3113-001-095				ACC.		100%MT
SP3113-001-101				ACC.		100%MT
SP3113-001-102				ACC.		100%MT

EXAMINED BY 主操 Xu Bing LEVEL - II SIGN 签名 质量经理 / QCM	REVIEWED BY 审核 <i>Carson Don</i> LEVEL-II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)	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-26150 DATE日期 2010.08.15 PAGE OF 页码 2/2 Revision No. 0-

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

DRAWING NO. SP3113-001 CALTRANS CONTRACT NO.:
图号: OBG-13 LIFTING 加州工程编号 04-0120F4

REFERENCING CODE ACCEPTANCE STANDARD PROCEDURE NO. CALIBRATION DUE DATE
参考规范编码 接受标准 程序编号 仪器校正有效期
AWS D1.5-2002 AWS D1.5-2002 ZPQC-MT-01 Dec. 28th, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 连续编号
MT YOKE PARKER B310S 5395 5617 5620

MAGNETIZING METHOD Continuous magnetic yoke CURRENT
磁化方法 磁轭式连续法 电流 AC

PARTICLE TYPE Dry magnet powder YOKE SPACING
磁粉类型 干磁粉 磁轭间距 70~150mm

MATERIAL TO BE EXAMINED WELDING 焊接件 Material & thickness A709M-345T2-X
检测材料 CASTING 铸件 母材, 厚度 25/16mm
 FORGING 锻造

WELDING PROCESS FCAW TYPE OF JOINT T-JOINT
焊接方法 焊缝类型

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			
SP3113-001-103				ACC.		100%MT
SP3113-001-104				ACC.		100%MT
SP3113-001-070				ACC.		100%MT
SP3113-001-071				ACC.		100%MT

AFTER HSR1(B)-8861

BLANK

EXAMINED BY 主探
Xu Bing *Xu Bing 8.15*
LEVEL-II SIGN 签名 / DATE 日期
质量经理 / QCM
签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

REVIEWED BY 审核
Caider Xu 8.15
LEVEL-II SIGN / DATE 日期
用户 CUSTOMER
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-26154

DATE 日期 2010.08.26

PAGE OF 页码 1/5

Revision No. 0

PROJECT NO.

工程编号: ZP06-787

CONTRACTOR:

用户: CALTRANS

DRAWING NO.

SP3110-001

CALTRANS CONTRACT NO.:

图号:

13 LIFTING

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

12/16/25mm

WELDING PROCESS

焊接方法

FCAW

TYPE OF JOINT

焊缝类型

T-JOINT

DISCONTINUITY 不连续性

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			
SP3110-001-001				ACC		100%MT
SP3110-001-002				ACC		100%MT
SP3110-001-003				ACC		100%MT
SP3110-001-004				ACC		100%MT
SP3110-001-005				ACC		100%MT
SP3110-001-006				ACC		100%MT
SP3110-001-007				ACC		100%MT
SP3110-001-008				ACC		100%MT
SP3110-001-009				ACC		100%MT
SP3110-001-010				ACC		100%MT
SP3110-001-011				ACC		100%MT
SP3110-001-012				ACC		100%MT
SP3110-001-013				ACC		100%MT
SP3110-001-014				ACC		100%MT

EXAMINED BY 主探

CaiXinxin

LEVEL-II SIGN 签名 / DATE 日期

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核

Lu Boyi

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

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-26154 DATE 日期 2010.08.26 PAGE OF 页码 2/5 Revision No. 0-

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3110-001 13 LIFTING		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 12/16/25mm
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			
SP3110-001-015				ACC		100%MT
SP3110-001-016				ACC		100%MT
SP3110-001-017				ACC		100%MT
SP3110-001-018				ACC		100%MT
SP3110-001-019				ACC		100%MT
SP3110-001-020				ACC		100%MT
SP3110-001-021				ACC		100%MT
SP3110-001-022				ACC		100%MT
SP3110-001-023				ACC		100%MT
SP3110-001-024				ACC		100%MT
SP3110-001-025				ACC		100%MT
SP3110-001-026				ACC		100%MT
SP3110-001-027				ACC		100%MT
SP3110-001-028				ACC		100%MT

EXAMINED BY 主操
CaiXinxin *CaiXinxin* 08.26
LEVEL - II SIGN 签名 / DATE 日期
质量经理 / QCM
签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

REVIEWED BY 审核
Lu Boyi 08.26
LEVEL-II SIGN / DATE 日期
用户 CUSTOMER
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-26154 DATE日期 2010.08.26 PAGE OF 页码 3/5 Revision No: 0-

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

DRAWING NO. SP3110-001 CALTRANS CONTRACT NO.:
图号: 13 LIFTING 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 th , 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 12/16/25mm
---------------------------------	---	--------------------------------	---------------------------------

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			
SP3110-001-029				ACC		100%MT
SP3110-001-030				ACC		100%MT
SP3110-001-031				ACC		100%MT
SP3110-001-032				ACC		100%MT
SP3110-001-033				ACC		100%MT
SP3110-001-034				ACC		100%MT
SP3110-001-035				ACC		100%MT
SP3110-001-036				ACC		100%MT
SP3110-001-037				ACC		100%MT
SP3110-001-038				ACC		100%MT
SP3110-001-039				ACC		100%MT
SP3110-001-040				ACC		100%MT
SP3110-001-041				ACC		100%MT
SP3110-001-042				ACC		100%MT

EXAMINED BY 主探 CaiXinxin <i>CaiXinxin</i> 8.26 LEVEL-II SIGN 签名 / DATE日期 质量经理 / QCM	REVIEWED BY 审核 <i>Lu Bing</i> 8.16 LEVEL-II SIGN / DATE日期 用户 CUSTOMER
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)	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-26154

DATE 日期 2010.08.26

PAGE OF 页码 4/5

Revision No: 0-

PROJECT NO.

工程编号:

ZP06-787

CONTRACTOR:

用户:

CALTRANS

DRAWING NO.

图号:

SP3110-001

13 LIFTING

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

12/16/25mm

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			
SP3110-001-047				ACC		100%MT
SP3110-001-048				ACC		100%MT
SP3110-001-053				ACC		100%MT
SP3110-001-054				ACC		100%MT
SP3110-001-059				ACC		100%MT
SP3110-001-060				ACC		100%MT
SP3110-001-043				ACC		100%MT
SP3110-001-044				ACC		100%MT
SP3110-001-045				ACC		100%MT
SP3110-001-046				ACC		100%MT
SP3110-001-049				ACC		100%MT
SP3110-001-050				ACC		100%MT
SP3110-001-051				ACC		100%MT
SP3110-001-052				ACC		100%MT

EXAMINED BY 主操

CaiXinxin

LEVEL - II SIGN 签名 / DATE 日期

质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核

LEVEL-II SIGN / DATE 日期

用户 CUSTOMER

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-26154		DATE 日期 2010.08.26	PAGE OF 页码 5/5	Revision No. 0.
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3110-001 13 LIFTING		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 th , 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 12/16/25mm	
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			
SP3110-001-056				ACC		100%MT
SP3110-001-057				ACC		100%MT
SP3110-001-058				ACC		100%MT
SP3110-001-060				ACC		100%MT
SP3110-001-061				ACC		100%MT
SP3110-001-062				ACC		100%MT
SP3110-001-063				ACC		100%MT
SP3110-001-064				ACC		100%MT

AFTER HSR1(B)-8860

BLANK

EXAMINED BY 主操 CaiXinxin <i>CaiXinxin</i> 8.26 LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Lu Bing</i> 8.26 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-26156		DATE 日期 2010.08.26		PAGE OF 页码 1/7		Revision No: 0-	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SP3109-001 13 LIFTING				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 th , 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 12/16/25/14mm	
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			
SP3109-001-001				ACC		100%MT
SP3109-001-002				ACC		100%MT
SP3109-001-003				ACC		100%MT
SP3109-001-004				ACC		100%MT
SP3109-001-005				ACC		100%MT
SP3109-001-006				ACC		100%MT
SP3109-001-007				ACC		100%MT
SP3109-001-008				ACC		100%MT
SP3109-001-009				ACC		100%MT
SP3109-001-010				ACC		100%MT
SP3109-001-011				ACC		100%MT
SP3109-001-012				ACC		100%MT
SP3109-001-013				ACC		100%MT
SP3109-001-014				ACC		100%MT

EXAMINED BY 主探 CalXinxin <i>CalXinxin 18.26</i>		REVIEWED BY 审核 <i>Lu Bing 18.26</i>	
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-26156		DATE 日期 2010.08.26	PAGE OF 页码 2/7	Revision No. 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3109-001 13 LIFTING		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 th , 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 12/16/25/14mm	
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			
SP3109-001-070				ACC		100%MT
SP3109-001-071				ACC		100%MT
SP3109-001-072				ACC		100%MT
SP3109-001-073				ACC		100%MT
SP3109-001-074				ACC		100%MT
SP3109-001-075				ACC		100%MT
SP3109-001-076				ACC		100%MT
SP3109-001-077				ACC		100%MT
SP3109-001-078				ACC		100%MT
SP3109-001-079				ACC		100%MT
SP3109-001-080				ACC		100%MT
SP3109-001-081				ACC		100%MT
SP3109-001-082				ACC		100%MT
SP3109-001-083				ACC		100%MT

EXAMINED BY 主探 CaiXinxin <i>Cai Xinxin</i> of 16 LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Xu Bing</i> of 26 LEVEL - II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)	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-26156		DATE 日期 2010.08.26	PAGE OF 页码 3/7	Revision No. 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3109-001 13 LIFTING		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 12/16/25/14mm	
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			
SP3109-001-084				ACC		100%MT
SP3109-001-085				ACC		100%MT
SP3109-001-086				ACC		100%MT
SP3109-001-087				ACC		100%MT
SP3109-001-088				ACC		100%MT
SP3109-001-089				ACC		100%MT
SP3109-001-090				ACC		100%MT
SP3109-001-091				ACC		100%MT
SP3109-001-092				ACC		100%MT
SP3109-001-093				ACC		100%MT
SP3109-001-094				ACC		100%MT
SP3109-001-095				ACC		100%MT
SP3109-001-096				ACC		100%MT
SP3109-001-097				ACC		100%MT

EXAMINED BY 主操 CaiXinxin LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>[Signature]</i> LEVEL-II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)	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-26156 DATE日期 2010.08.26 PAGE OF 页码 4/7 Revision No: 0.

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

DRAWING NO. SP3109-001 CALTRANS CONTRACT NO.:
图号: 13 LIFTING 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 th , 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 12/16/25/14mm
---------------------------------	---	--------------------------------	--------------------------------

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			
SP3109-001-098				ACC		100%MT
SP3109-001-099				ACC		100%MT
SP3109-001-100				ACC		100%MT
SP3109-001-101				ACC		100%MT
SP3109-001-102				ACC		100%MT
SP3109-001-103				ACC		100%MT
SP3109-001-104				ACC		100%MT
SP3109-001-105				ACC		100%MT
SP3109-001-106				ACC		100%MT
SP3109-001-107				ACC		100%MT
SP3109-001-108				ACC		100%MT
SP3109-001-109				ACC		100%MT
SP3109-001-110				ACC		100%MT
SP3109-001-111				ACC		100%MT

EXAMINED BY 主探
CaiXinxin *CaiXinxin* 8.26
LEVEL - II SIGN 签名 / DATE日期
质量经理 / QCM
签字 SIGN / 日期 DATE

REVIEWED BY 审核
Lu Boyu 8.26
LEVEL-II SIGN / DATE日期
用户CUSTOMER
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-26156		DATE 日期 2010.08.26	PAGE OF 页码 5/7	Revision No: 0.
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3109-001 13 LIFTING		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 th , 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 12/16/25/14mm	
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			
SP3109-001-112				ACC		100%MT
SP3109-001-113				ACC		100%MT
SP3109-001-114				ACC		100%MT
SP3109-001-115				ACC		100%MT
SP3109-001-030				ACC		100%MT
SP3109-001-031				ACC		100%MT
SP3109-001-034				ACC		100%MT
SP3109-001-035				ACC		100%MT
SP3109-001-044				ACC		100%MT
SP3109-001-045				ACC		100%MT
SP3109-001-046				ACC		100%MT
SP3109-001-047				ACC		100%MT
SP3109-001-048				ACC		100%MT
SP3109-001-049				ACC		100%MT

EXAMINED BY 主操 CaiXinxin LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Lu Boyu</i> LEVEL-II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

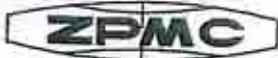


REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 B787-MT-26156		DATE 日期 2010.08.26		PAGE OF 页码 6/7		Revision No: 0-	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SP3109-001 13 LIFTING				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 th , 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 12/16/25/14mm	
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			
SP3109-001-050				ACC		100%MT
SP3109-001-051				ACC		100%MT
SP3109-001-052				ACC		100%MT
SP3109-001-053				ACC		100%MT
SP3109-001-054				ACC		100%MT
SP3109-001-055				ACC		100%MT
SP3109-001-056				ACC		100%MT
SP3109-001-057				ACC		100%MT
SP3109-001-058				ACC		100%MT
SP3109-001-059				ACC		100%MT
SP3109-001-060				ACC		100%MT
SP3109-001-061				ACC		100%MT
SP3109-001-062				ACC		100%MT
SP3109-001-063				ACC		100%MT

EXAMINED BY 主探 CalXinxin <i>CalXinxin</i> 8.26		REVIEWED BY 审核 <i>Xu Boyu</i> 8.26	
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-26156		DATE 日期 2010.08.26	PAGE OF 页码 7/7	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SP3109-001 13 LIFTING		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 th , 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 12/16/25/14mm	
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			
SP3109-001-064				ACC		100%MT
SP3109-001-065				ACC		100%MT
SP3109-001-066				ACC		100%MT
SP3109-001-067				ACC		100%MT
SP3109-001-068				ACC		100%MT
SP3109-001-069				ACC		100%MT
SP3109-001-019				ACC		100%MT
SP3109-001-043				ACC		100%MT

AFTER HSR1(B)-8859

BLANK

EXAMINED BY 主操 CaiXinxin LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Xu Boyu</i> 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-26158		DATE 日期 2010.08.26		PAGE OF 页码 1/4		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: SP3115-001 13 LIFTING				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 25/16/12mm	
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			
SP3115-001-023				ACC		100%MT
SP3115-001-024				ACC		100%MT
SP3115-001-026				ACC		100%MT
SP3115-001-029				ACC		100%MT
SP3115-001-030				ACC		100%MT
SP3115-001-031				ACC		100%MT
SP3115-001-035				ACC		100%MT
SP3115-001-036				ACC		100%MT
SP3115-001-037				ACC		100%MT
SP3115-001-038				ACC		100%MT
SP3115-001-001				ACC		100%MT
SP3115-001-018				ACC		100%MT
SP3115-001-025				ACC		100%MT
SP3115-001-032				ACC		100%MT
SP3115-001-039				ACC		100%MT

EXAMINED BY 主探
CaiXinxin *CaiXinxin* 8.26
LEVEL-II SIGN 签名 / DATE 日期
质量经理 / QCM
签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

REVIEWED BY 审核
Xu Hong 8.26
LEVEL-II SIGN / DATE 日期
用户 CUSTOMER
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-26158

DATE 日期 2010.08.26

PAGE OF 页码 2/4

Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3115-001 13 LIFTING		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 th , 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 25/16/12mm
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			
SP3115-001-040				ACC		100%MT
SP3115-001-041				ACC		100%MT
SP3115-001-042				ACC		100%MT
SP3115-001-043				ACC		100%MT
SP3115-001-044				ACC		100%MT
SP3115-001-045				ACC		100%MT
SP3115-001-046				ACC		100%MT
SP3115-001-047				ACC		100%MT
SP3115-001-048				ACC		100%MT
SP3115-001-049				ACC		100%MT
SP3115-001-050				ACC		100%MT
SP3115-001-051				ACC		100%MT
SP3115-001-052				ACC		100%MT
SP3115-001-053				ACC		100%MT

EXAMINED BY 主操
CaiXinxin *CaiXinxin* 8.26
LEVEL - II SIGN 签名 / DATE 日期
质量经理 / QCM
签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

REVIEWED BY 审核
John Boyd 8.26
LEVEL-II SIGN / DATE 日期
用户 CUSTOMER
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-26158		DATE 日期 2010.08.26		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: SP3115-001 13 LIFTING				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 th , 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 25/16/12mm	
WELDING PROCESS 焊接方法				TYPE OF JOINT 焊缝类型			
FCAW				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			
SP3115-001-054				ACC		100%MT
SP3115-001-055				ACC		100%MT
SP3115-001-056				ACC		100%MT
SP3115-001-057				ACC		100%MT
SP3115-001-058				ACC		100%MT
SP3115-001-059				ACC		100%MT
SP3115-001-060				ACC		100%MT
SP3115-001-061				ACC		100%MT
SP3115-001-062				ACC		100%MT
SP3115-001-063				ACC		100%MT
SP3115-001-064				ACC		100%MT
SP3115-001-065				ACC		100%MT
SP3115-001-002				ACC		100%MT
SP3115-001-003				ACC		100%MT

EXAMINED BY 主操
CaiXinxin *Cai Xinxin* of 26
LEVEL - II SIGN 签名 / DATE 日期
质量经理 / QCM
签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

REVIEWED BY 审核
Lu Bing of 26
LEVEL-II SIGN / DATE 日期
用户 CUSTOMER
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-26158 DATE 日期 2010.08.26 PAGE OF 页码 4/4 Revision No: 0.

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: SP3115-001 13 LIFTING		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 th , 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 25/16/12mm
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			
SP3115-001-019				ACC		100%MT
SP3115-001-020				ACC		100%MT
SP3115-001-026				ACC		100%MT
SP3115-001-027				ACC		100%MT
SP3115-001-033				ACC		100%MT
SP3115-001-034				ACC		100%MT
SP3115-001-004				ACC		100%MT
SP3115-001-005				ACC		100%MT
SP3115-001-006				ACC		100%MT
SP3115-001-007				ACC		100%MT
SP3115-001-021				ACC		100%MT
SP3115-001-022				ACC		100%MT

AFTER HSR1(B)-8862

BLANK

EXAMINED BY 主探 CaiXinxin LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Lu Bing</i> 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

zpmc-0775

REPORT NO. 报告编号 B787-MT-25396		DATE 日期 2010.07.26	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: EP3025-001 13th lifting edge plate		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 th , 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 12/16/25mm	
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			
EP3025-001-001				ACC.		100%MT
EP3025-001-002				ACC.		100%MT
EP3025-001-007				ACC.		100%MT
EP3025-001-008				ACC.		100%MT
EP3025-001-009				ACC.		100%MT
EP3025-001-010				ACC.		100%MT
EP3025-001-011				ACC.		100%MT
EP3025-001-012				ACC.		100%MT
EP3025-001-017				ACC.		100%MT
EP3025-001-018				ACC.		100%MT
EP3025-001-019				ACC.		100%MT
EP3025-001-020				ACC.		100%MT
EP3025-001-029				ACC.		100%MT
EP3025-001-030				ACC.		100%MT

EXAMINED BY 主操
Cai Xinxin *Cai Xinxin* 10.07.26
LEVEL - II SIGN 签名 / DATE 日期
质量经理 / QCM

REVIEWED BY 审核
Lu Hong 10.07.26
LEVEL-II SIGN / DATE 日期
用户 CUSTOMER

签字 SIGN / 日期 DATE
(FORM# ZPQC-MT01)

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-25396		DATE 日期 2010.07.26	PAGE OF 页码 2/2	Revision No: .0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: EP3025-001 13th lifting edge plate		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 12/16/25mm	
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			
EP3025-001-027				ACC.		100%MT
EP3025-001-028				ACC.		100%MT
EP3025-001-025				ACC.		100%MT
EP3025-001-026				ACC.		100%MT

AFTER HSRT(B)-8829

BLANK

EXAMINED BY 主探 Cai Xinlin <i>Cai Xinlin</i> 10.07.26	REVIEWED BY 审核 <i>Lu Bin</i> 10.07.26
LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	LEVEL-II SIGN 1 / DATE 日期
签字 SIGN / 日期 DATE (FORM# ZPQC-MT01)	用户 CUSTOMER
	签字 SIGN / 日期 DATE

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000769

Subject: NCR No. ZPMC-0775

Dated: 29-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000787 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: See attached email approval to leave the welded snipes in EP3018C, EP3026A, SP3081 as is. Based on this, ZPMC requests closure of this NCR.

See attached email approval to leave the welded snipes in EP3018C, EP3026A, SP3081 as is. Based on this, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000787R01;

Caltrans' comments:

Status: CLO

Date: 12-Oct-2010

Per the latest discussion in TC-RF1126R0 as well as both the provided documentation in ZPMC-0773 and ZPMC-0775, this NCR is considered closed.

Submitted by: Woo, Laraine

Date: 12-Oct-2010

Attachment(s):

From: Chris Havel [mailto:chris_havel@dot.ca.gov]
Sent: Tuesday, August 24, 2010 4:54 PM
To: Sean Wichman; Gene Rosamilia; Thomas Nilsson; Gang Jiao
Cc: stanley_ku@dot.ca.gov; jsimonis@sasbridge.com; jdevey@sasbridge.com
Subject: Fw: Snipes filled by welds

Reference sheets EP3019A, SP3082A, EP3026A, SP3110B, SP3078B, SP3081A, EP3026B, EP3025A, EP3018C, EP3017B, EP3024A, EP3018C where snipes have been closed by overwelding. At these locations, snipes can be left "as-is" on a fit-for-purpose basis. On sheets EP3016 and EP3023 no snipes are indicated. Let me know if you have any questions. Chris

"I don't know, don't really care
Let there be songs to fill the air"
Robert Hunter

Chris Havel, PE
Contract 04-0120F4 - SAS
China Cell 158-2142-4572
----- Forwarded by Chris Havel/D04/Caltrans/CAGov on 08/24/2010 04:49 PM

(See attached file: List of welded snipe locations.pdf)

--

This message has been scanned for viruses and dangerous content by [MailScanner](#), and is believed to be clean.

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-000771**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0775**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: 26-Jul-2010**Description of Non-Conformance:**

Quality Assurance in-process observations of the fabrication of Edge Plates and Side Plates in Tower Bay 10 discovered the following issue:

- ZPMC personnel have welded over cope hole and snipe areas on various Lift 13 Edge and Side Plates.
- Edge Plates identified are as follows: EP3018C, EP3025A and EP3026A.
- Side Plates identified are as follows: SP3081, SP3115A, SP3113A, SP3109A, SP3078A and SP3110A.
- According to the approved shop drawings, cope hole and/or snipes are required in the areas where the panel stiffeners intersect the panel diaphragms.
- All above mentioned panels are located in Tower Bay#10.

Contractor's proposal to correct the problem:

Per the latest discussion in TC-RFI126R0 and email discussion, the issue can be closed.

"Reference sheets EP3019A, SP3082A, EP3026A, SP3110B, SP3078B, SP3081A, EP3026B, EP3025A, EP3018C, EP3017B, EP3024A, EP3018C where snipes have been closed by overwelding. At these locations, snipes can be left "as-is" on a fit-for-purpose basis."

Corrective action taken:

None. The snipes can be left "as-is" on a fit-for-purpose basis.

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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer