

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000835**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0797**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Suspender Brackets for Lift 9E
Procedural	Procedural	Description:	

Reference Description: ZPMC performed repair on Suspender Bracket 74E at Lift 9E without having an approved CWR

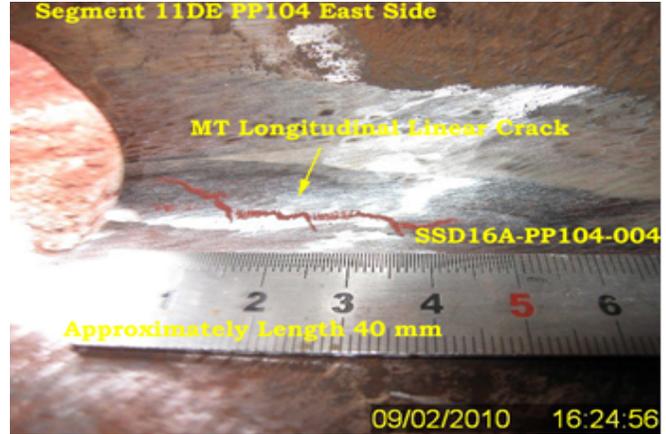
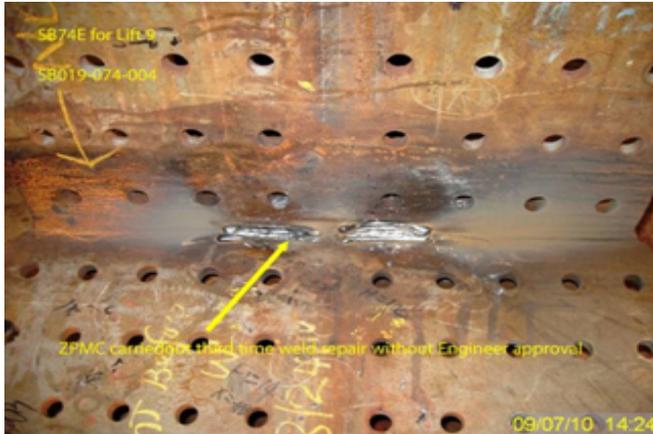
Description of Non-Conformance:

During random Quality Assurance (QA) visual review of the Suspender bracket components, this QA Inspector discovered the following issue:

- ZPMC personnel performing weld repair of one (1) transverse crack measuring approximately 10 mm without the prior approval of the Engineer, an approved Critical Weld Repair (CWR), or following the "pre-approved CWR" procedure that was agreed jointly.
- This weld is rejected for the 3rd time by Ultrasonic Testing.
- The transverse crack found in the excavation with Magnetic Particle Testing verification by ZPMC personnel after carbon arc gouging.
- The weld is identified as SB019-074-004 for OBG Lift 9E.
- Y-location of the transverse crack without CWR is at 310mm from the left end of X53B.
- Subsequent to the completion of weld repair, ZPMC sought for a CWR approval from CT for a longitudinal crack repair at a different location on the same weld joint.
- As of September 8, 2010 at 11:00, no CWR or Engineer's approval has been requested from ZPMC for this transverse crack defect.
- This member is located inside the OBG Fabrication shop Bay 19.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Special Provisions 8-3; In addition to the provisions in AWS D1.5, Section 3.7.4 and Section 12.17, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer. The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them.

WQCP Section 9.2.1.3; Prior approval shall be obtained from the Engineer for 3rd (third) time repairs in the same location.

Special Provision Section 8.3: "In addition to the provisions in AWS D1.5, Section 3.7.4 and Section 12.17, third-time repairs of welds or base metal, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer."

Who discovered the problem: Chandra Sudalaimuthu

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1430 hours, 09/07/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0730 hours, 09/08/10, Email

QC Inspector's Name: Zhang Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

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: 13-Sep-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: 05.03.06-000793

Subject: NCR No. ZPMC-0797

Reference Description: ZPMC performed repair on Suspender Bracket 74E at Lift 9E without having an approved CWR

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:** 09

Remarks:

- During random Quality Assurance (QA) visual review of the Suspender bracket components, Caltrans QA Inspector discovered the following issue:
- ZPMC personnel performing weld repair of one (1) transverse crack measuring approximately 10 mm without the prior approval of the Engineer, an approved Critical Weld Repair (CWR), or following the “pre-approved CWR” procedure that was agreed jointly.
 - This weld is rejected for the 3rd time by Ultrasonic Testing.
 - The transverse crack found in the excavation with Magnetic Particle Testing verification by ZPMC personnel after carbon arc gouging.
 - The weld is identified as SB019-074-004 for OBG Lift 9E.
 - Y-location of the transverse crack without CWR is at 310mm from the left end of X53B.
 - Subsequent to the completion of weld repair, ZPMC sought for a CWR approval from CT for a longitudinal crack repair at a different location on the same weld joint.
 - As of September 8, 2010 at 11:00, no CWR or Engineer’s approval has been requested from ZPMC for this transverse crack defect.
 - This member is located inside the OBG Fabrication shop Bay 19.

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-0797

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: 05.03.06-000793

Subject: NCR No. ZPMC-0797

Dated: 22-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000788 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the NDT documents from the electronic database which shows that the weld repair was successful in removing the defect.

ZPMC is providing the NDT documents from the electronic database which shows that the weld repair was successful in removing the defect. In the future, ZPMC has clarified the procedures for requesting "on site" approval for critical weld repairs so that this type of non conformance can be prevented. Based on these actions ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000788R00;

Caltrans' comments:

Status: REJ

Date: 26-Sep-2010

Post HSR NDT was submitted from the data base. However, a post repair NDT report is needed to verify the weld was repaired and found to be acceptable after the crack repair and the date the NCR was issued.

Submitted by: Woo, Laraine

Date: 26-Sep-2010

Attachment(s):

Magnetic Particle Examination		Report # B787-MT-27000	
Job Oakland Bay Bridge East Span		Parent Report # WDL0378147	
Structure OBG			
Sub Assembly SB74E			
Assembly		Weld Map # SB019	
Segment 9BE		Drawing # SB19	
Lift 9E		Barcode	
All Welds Associated: <input checked="" type="checkbox"/>		Voided: <input type="checkbox"/>	
NDE Detail			
Weld Type	CJP	Material Thickness (mm)	30,25,35,22,75
Code	AWS D1.5-02	Acceptance Standard	Section 6
Procedure #	ZPQC-MT-01	Percent	100%
Weld Condition	Final/After Heat Straightening		
MT Equipment			
Equipment/Model	B310S	Pole Spacing	70-150
Method Type	Continuous magnetic yoke	Mfr / Color	Circle systems-Red
Serial #	MP1193		
Method of Inspection:			
<input type="checkbox"/> Wet <input checked="" type="checkbox"/> Dry <input checked="" type="checkbox"/> Visible <input type="checkbox"/> Fluorescent			
How Media Applied:			
<input type="checkbox"/> Residual <input checked="" type="checkbox"/> AC <input type="checkbox"/> DC <input type="checkbox"/> Continuous <input checked="" type="checkbox"/> Yoke <input type="checkbox"/> Prods <input type="checkbox"/> Circular <input type="checkbox"/> True-Continuous <input type="checkbox"/> Half-Wave <input type="checkbox"/> Cable Wrap <input type="checkbox"/> Longitudinal			

NDE Record						
Weld Id	Indication	Indication Repair	Length	Distance From Y	Status	Note
SB019-074-001	0		0		Accept	
SB019-074-004	0		0		Accept	
SB019-074-005	0		0		Accept	
SB019-074-006	0		0		Accept	
SB019-074-007	0		0		Accept	
SB019-074-008	0		0		Accept	
SB019-074-009	0		0		Accept	
SB019-074-010	0		0		Accept	
SB019-074-011	0		0		Accept	
SB019-074-012	0		0		Accept	
SB019-074-013	0		0		Accept	
SB019-074-014	0		0		Accept	
SB019-074-015	0		0		Accept	
SB019-074-016	0		0		Accept	
SB019-074-017	0		0		Accept	
SB019-074-018	0		0		Accept	
SB019-074-019	0		0		Accept	
SB019-074-020	0		0		Accept	
SB019-074-025	0		0		Accept	
SB019-074-026	0		0		Accept	
SB019-074-031	0		0		Accept	
SB019-074-032	0		0		Accept	
SB019-074-037	0		0		Accept	
SB019-074-043	0		0		Accept	
SB019-074-049	0		0		Accept	
SB019-074-055	0		0		Accept	
SB019-074-061	0		0		Accept	
SB019-074-067	0		0		Accept	
SB019-074-077	0		0		Accept	

Comment:

HSR1(B)-9042

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in conformance with the requirements of AWS D1.5-02, (2002) Bridge Welding Code.

Approval

Signee	Date	Type	CWI #
Xu Hua Xiang	9/13/2010	NDE Level II	
Jianhua Lu	9/13/2010	QCM Approval	07031421

Weld Association				
SB019-074-001 WDL0378072				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-004 WDL0378075				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-005 WDL0378076				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-006 WDL0378131				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-007 WDL0378077				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-008 WDL0378078				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-009 WDL0378085				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-010 WDL0378086				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-011 WDL0378081				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-012 WDL0378089				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-013 WDL0378090				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-014 WDL0378091				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-015 WDL0378092				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No



SB019-074-016 WDL0378087				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-017 WDL0378088				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-018 WDL0378082				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-019 WDL0378079				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-020 WDL0378080				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-025 WDL0378147				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-026 WDL0378135				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-031 WDL0378149				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-032 WDL0378136				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	Fillet	SPCM/FCM No
SB019-074-037 WDL0378151				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-043 WDL0378153				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-049 WDL0378152				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No
SB019-074-055 WDL0378154				
Structure	OBG	Assembly	{none}	SubAssembly SB74E Segment 9BE
Lift	9E	Weld Type	CJP	SPCM/FCM No

SB019-074-061 WDL0378148					
Structure	OBG	Assembly	{none}	SubAssembly SB74E	Segment 9BE
Lift	9E	Weld Type	CJP		SPCM/FCM No
SB019-074-067 WDL0378150					
Structure	OBG	Assembly	{none}	SubAssembly SB74E	Segment 9BE
Lift	9E	Weld Type	CJP		SPCM/FCM No
SB019-074-077 WDL0378132					
Structure	OBG	Assembly	{none}	SubAssembly SB74E	Segment 9BE
Lift	9E	Weld Type	Fillet		SPCM/FCM No

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000793

Subject: NCR No. ZPMC-0797

Dated: 29-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000788 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: Per the Department's request the original report is being submitted. ZPMC requests closure of this NCR.
Per the Department's request the original report is being submitted. ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua
Attachment(s): ABF-NPR-000788R01;

Caltrans' comments:

Status: CLO

Date: 07-Oct-2010

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

Submitted by: Woo, Laraine
Attachment(s):

Date: 07-Oct-2010



No. B-891

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-9-23

REGARDING: NCR-000835 (ZPMC-0797)

ZPMC has written an internal NCR to address the requirement of CWR prior to start the welding repair. The CWR report number is B-CWR1889. ZPMC is providing the NDT record to show the weld in question has been removed and is acceptable now. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000835 (ZPMC-0797)

B787-UT-14963R1

Zhao Jia Meng
2010-9-23



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: 13-Sep-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0797

Job Name: SAS Superstructure
Document No: 05.03.06-000793

Reference Description: ZPMC performed repair on Suspender Bracket 74E at Lift 9E without having an approved CWR

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: 09

Remarks:

During random Quality Assurance (QA) visual review of the Suspender bracket components, Caltrans QA Inspector discovered the following issue:

- ZPMC personnel performing weld repair of one (1) transverse crack measuring approximately 10 mm without the prior approval of the Engineer, an approved Critical Weld Repair (CWR), or following the "pre-approved CWR" procedure that was agreed jointly.
- This weld is rejected for the 3rd time by Ultrasonic Testing.
- The transverse crack found in the excavation with Magnetic Particle Testing verification by ZPMC personnel after carbon arc gouging.
- The weld is identified as SB019-074-004 for OBG Lift 9E.
- Y-location of the transverse crack without CWR is at 310mm from the left end of X53B.
- Subsequent to the completion of weld repair, ZPMC sought for a CWR approval from CT for a longitudinal crack repair at a different location on the same weld joint.
- As of September 8, 2010 at 11:00, no CWR or Engineer's approval has been requested from ZPMC for this transverse crack defect.
- This member is located inside the OBG Fabrication shop Bay 19.

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-0797

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

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.25B

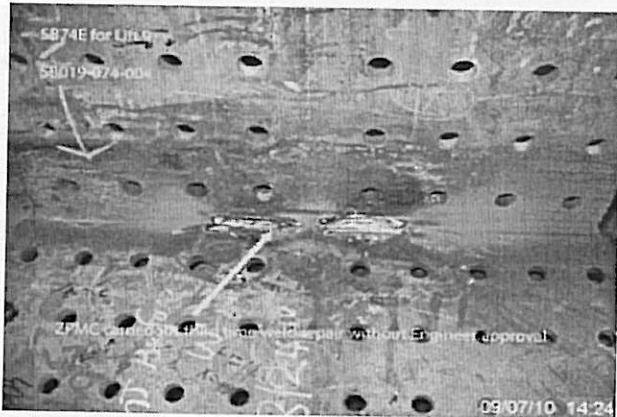
QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000835**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0797**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Suspender Brackets for Lift 9EProcedural Procedural Description:**Reference Description:** ZPMC performed repair on Suspender Bracket 74E at Lift 9E without having an approved CWR**Description of Non-Conformance:**

During random Quality Assurance (QA) visual review of the Suspender bracket components, this QA Inspector discovered the following issue:

- ZPMC personnel performing weld repair of one (1) transverse crack measuring approximately 10 mm without the prior approval of the Engineer, an approved Critical Weld Repair (CWR), or following the "pre-approved CWR" procedure that was agreed jointly.
- This weld is rejected for the 3rd time by Ultrasonic Testing.
- The transverse crack found in the excavation with Magnetic Particle Testing verification by ZPMC personnel after carbon arc gouging.
- The weld is identified as SB019-074-004 for OBG Lift 9E.
- Y-location of the transverse crack without CWR is at 310mm from the left end of X53B.
- Subsequent to the completion of weld repair, ZPMC sought for a CWR approval from CT for a longitudinal crack repair at a different location on the same weld joint.
- As of September 8, 2010 at 11:00, no CWR or Engineer's approval has been requested from ZPMC for this transverse crack defect.
- This member is located inside the OBG Fabrication shop Bay 19.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Special Provisions 8-3; In addition to the provisions in AWS D1.5, Section 3.7.4 and Section 12.17, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer. The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them.

WQCP Section 9.2.1.3; Prior approval shall be obtained from the Engineer for 3rd (third) time repairs in the same location.

Special Provision Section 8.3: "In addition to the provisions in AWS D1.5, Section 3.7.4 and Section 12.17, third-time repairs of welds or base metal, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer."

Who discovered the problem: Chandra Sudalaimuthu
Name of individual from Contractor notified: Peng Wen Jun
Time and method of notification: 1430 hours, 09/07/10, Verbal
Name of Caltrans Engineer notified: Laraine Woo
Time and method of notification: 0730 hours, 09/08/10, Email
QC Inspector's Name: Zhang Wei
Was QC Inspector aware of the problem: Yes No
Contractor's proposal to correct the problem:

N/A

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric
Reviewed By: Devey, Jim

SMR
SMR

ZPMC-0797



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-14963R1 DATE 2010.09.22 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: SUPPORT BEAM DRAWING NO.: SB74E CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

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

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

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

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709M-345T2 22/20mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
GAMMA	70°	2.5MHz	0.75in×0.625in				
Changchao	0°	2.5MHz	20mm	Reference Level 参考灵敏度			20dB

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y			
SB019-074-004	1R1	70.2				48									ACC.	100%

AFTER B-CWR1889

BLANK

EXAMINED BY 主探 <i>Xuehanbing</i> LEVEL - II SIGN / DATE 20/0.09.22	REVIEWED BY 审核 <i>Lu Jianhua</i> LEVEL - II SIGN / DATE 20/0.09.22
质量经理 / QCM <i>Lu Jianhua</i> 签字 SIGN / 日期 DATE 20/0.09.22	用户 CUSTOMER 签字 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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, P.R. China**Report No:** NCS-000809**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0797**Type of problem:**

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

Date the Non-Conformance Report was written: 07-Sep-2010**Description of Non-Conformance:**

During random Quality Assurance (QA) visual review of the Suspender bracket components, this QA Inspector discovered the following issue:

-ZPMC personnel performing weld repair of one (1) transverse crack measuring approximately 10 mm without the prior approval of the Engineer, an approved Critical Weld Repair (CWR), or following the "pre-approved CWR" procedure that was agreed jointly.

-This weld is rejected for the 3rd time by Ultrasonic Testing.

-The transverse crack found in the excavation with Magnetic Particle Testing verification by ZPMC personnel after carbon arc gouging.

-The weld is identified as SB019-074-004 for OBG Lift 9E.

-Y-location of the transverse crack without CWR is at 310mm from the left end of X53B.

-Subsequent to the completion of weld repair, ZPMC sought for a CWR approval from CT for a longitudinal crack repair at a different location on the same weld joint.

-As of September 8, 2010 at 11:00, no CWR or Engineer's approval has been requested from ZPMC for this transverse crack defect.

-This member is located inside the OBG Fabrication shop Bay 19.

Contractor's proposal to correct the problem:

Contractor will remove the weld in question, and reweld it with approved CWR. Contractor will provide the NDT report to prove the weld is acceptable. Internal NCR will be issued to address the requirement of CWR prior welding repair.

Corrective action taken:

Contractor removed and rewelded the weld. The NDT report shows the weld in question is acceptable. Internal NCR was issued to the personnel involved.

Did corrective action require Engineer's approval?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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 Wahbeh, Mazen 818-292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer