

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-000846**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0808**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Bike Path and Suspender Bracket
Procedural	Procedural	Description: No QC presence during fabrication	

Reference Description: No QC presence during fabrication over 1.5 hour in Bay 19**Description of Non-Conformance:**

-On-going welding being performed on Bike Path component welds without a ZPMC Quality Control Inspector and/or Certified Welding Inspector (CWI) present for a period exceeding 1.5 hours in Bay 19. This time frame exceeds the allowable maximum time for QC Inspection coverage as required by Caltrans Special Provision Section 8-3.01.

-This Caltrans QA inspector was present from 18:30 to 20:00 hours.

-Caltrans QA called ZPMC QA at 1855 hrs trying to locate QC personnel; ZPMC stated that ABF would be monitoring this location.

-Caltrans QA called ABF personnel at 1900 hrs. ABF stated that ZPMC is to monitor this location and ZPMC was informed by ABF.

-Caltrans QA inspector still had not seen any QC at this location by 1945 hrs after 2 additional phone calls speaking with ABF and ZPMC personnel.

-Locations that ZPMC performed welding during the time period that QC/CWI was absent as identified by Caltrans QA are as follows:

Bike Path

BK004A2-013-061 (2/FW)

BK004A-005-085, 086, 087, 080, 082, 083 (1/FW)

BK004A8-001-072, 073 (2/FW)

BK004A8-003-072, 073 (2/FW)

Suspender Bracket

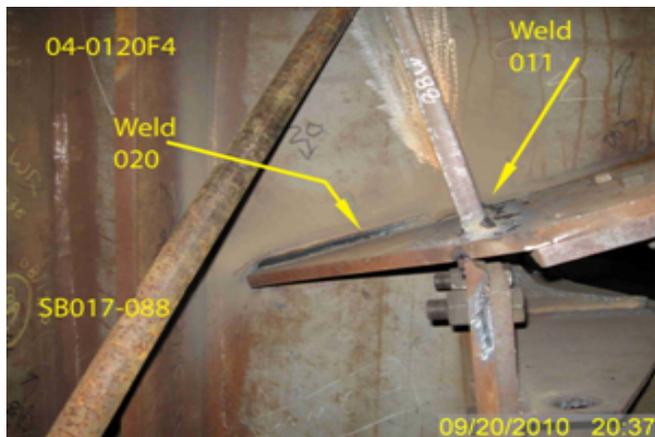
SB017-088-020, 011 (2/GW)

SB017-086-086, 020 (2/GW)

SB017-090-018, 011 (2/GW)

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Caltrans Special Provision Section 8-3.01: QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes.

Who discovered the problem: Mike Hasler

Name of individual from Contractor notified: Kelvin Cheung

Time and method of notification: 1945 hours, 9/20/10_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0700 hours, 9/22/10_Verbal

QC Inspector's Name: Zhong 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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric SMR

Reviewed By: Wahbeh, Mazen SMR



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

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 23-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: 05.03.06-000803

Subject: NCR No. ZPMC-0808

Reference Description: No QC presence during fabrication over 1.5 hour in Bay 19

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: Bike Path **Lift:**

Remarks:

On-going welding being performed on Bike Path component welds without a ZPMC Quality Control Inspector and/or Certified Welding Inspector (CWI) present for a period exceeding 1.5 hours in Bay 19. This time frame exceeds the allowable maximum time for QC Inspection coverage as required by Caltrans Special Provision Section 8-3.01.

- Caltrans QA inspector was present from 18:30 to 20:00 hours.
- Caltrans QA called ZPMC QA at 1855 hrs trying to locate QC personnel; ZPMC stated that ABF would be monitoring this location.
- Caltrans QA called ABF personnel at 1900 hrs. ABF stated that ZPMC is to monitor this location and ZPMC was informed by ABF.
- Caltrans QA inspector still had not seen any QC at this location by 1945 hrs after 2 additional phone calls speaking with ABF and ZPMC personnel.
- Locations that ZPMC performed welding during the time period that QC/CWI was absent as identified by Caltrans QA are as follows:
 Bike Path
 BK004A2-013-061 (2/FW)
 BK004A-005-085, 086, 087, 080, 082, 083 (1/FW)
 BK004A8-001-072, 073 (2/FW)
 BK004A8-003-072, 073 (2/FW)
 Suspender Bracket
 SB017-088-020, 011 (2/GW)
 SB017-086-086, 020 (2/GW)
 SB017-090-018, 011 (2/GW)

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.

NCT

(Continued Page 2 of 2)

Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0808

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: 05.03.06-000803

Subject: NCR No. ZPMC-0808

Dated: 29-Nov-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000847 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT records of the component which were welded when there was no QC supervision showing that the welds are acceptable.

ZPMC is providing NDT records of the component which were welded when there was no QC supervision showing that the welds are acceptable. Since this time ZPMC has conducted training with the inspectors to prevent future lapses in inspection coverage. Based on this, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000847R00;

Caltrans' comments:

Status: CLO

Date: 30-Nov-2010

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

Submitted by: Woo, Laraine

Date: 30-Nov-2010

Attachment(s):



No. B-939

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-11-26

REGARDING: NCR-000846(ZPMC-0808)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC QA personnel have talked with the floor CWI on the requirement of QC's coverage during welding. ZPMC is providing the NDT records to show the acceptance of the affected welds. Please be noticed ZPMC is providing the correct weld IDs in attached NDT records. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000846(ZPMC-0808)

B787-MT-31576

B787-MT-28779

B787-MT-29293

B787-MT-29294

B787-UT-16003

B787-UT-16003 R1-3

B787-UT-16002 R1-2

B787-UT-16002

B787-UT-16004

B787-UT-16004 R1-2

A handwritten signature in black ink, appearing to be "L. M." followed by a flourish.

11/26 (2010)



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 23-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: 05.03.06-000803

Subject: NCR No. ZPMC-0808

Reference Description: No QC presence during fabrication over 1.5 hour in Bay 19

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: Bike Path

Lift:

Remarks:

On-going welding being performed on Bike Path component welds without a ZPMC Quality Control Inspector and/or Certified Welding Inspector (CWI) present for a period exceeding 1.5 hours in Bay 19. This time frame exceeds the allowable maximum time for QC Inspection coverage as required by Caltrans Special Provision Section 8-3.01.

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BK004A2-013-061 (2/FW)

BK004A-005-085, 086, 087, 080, 082, 083 (1/FW)

BK004A8-001-072, 073 (2/FW)

BK004A8-003-072, 073 (2/FW)

Suspender Bracket

SB017-088-020, 011 (2/GW)

SB017-086-086, 020 (2/GW)

SB017-090-018, 011 (2/GW)

Action Required and/or Action Taken:

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NCT

(Continued Page 2 of 2)

Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0808

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

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China**Report No:** NCR-000846**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0808**Type of problem:**

Welding **Concrete** **Other**
Welding **Curing** **Procedural** **Bridge No:** 34-0006
Joint fit-up **Coating** **Other** **Component:** Bike Path and Suspender Bracket
Procedural **Procedural** **Description:** No QC presence during fabrication

Reference Description: No QC presence during fabrication over 1.5 hour in Bay 19**Description of Non-Conformance:**

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BK004A8-001-072, 073 (2/FW)

BK004A8-003-072, 073 (2/FW)

Suspender Bracket

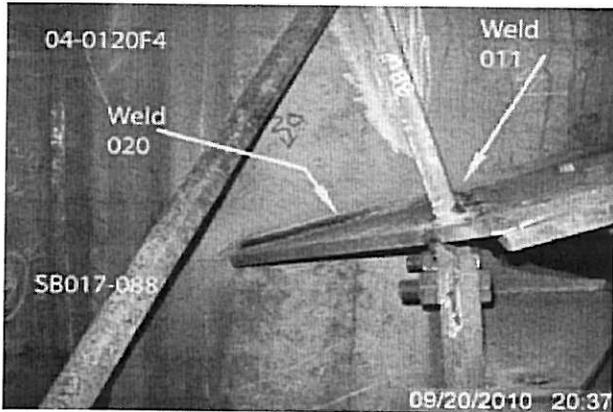
SB017-088-020, 011 (2/GW)

SB017-086-086, 020 (2/GW)

SB017-090-018, 011 (2/GW)

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Caltrans Special Provision Section 8-3.01: QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes.

Who discovered the problem: Mike Hasler

Name of individual from Contractor notified: Kelvin Cheung

Time and method of notification: 1945 hours, 9/20/10_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0700 hours, 9/22/10_Verbal

QC Inspector's Name: Zhong 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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
Reviewed By:	Wahbeh, Mazen	SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-31576		DATE日期 2010.11.24	PAGE OF页码 9/16	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: BK004-013 bike path		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 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 13977	
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 10/16mm	
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			
BK004A7-013-044				ACC.		100%MT
BK004A7-013-049				ACC.		100%MT
BK004A7-013-050				ACC.		100%MT
BK004A7-013-055				ACC.		100%MT
BK004A7-013-056				ACC.		100%MT
BK004A7-013-061				ACC.		100%MT
BK004A7-013-062				ACC.		100%MT
BK004A7-013-067				ACC.		100%MT
BK004A7-013-068				ACC.		100%MT
BK004A7-013-073				ACC.		100%MT
BK004A7-013-074				ACC.		100%MT
BK004A7-013-079				ACC.		100%MT
BK004A7-013-080				ACC.		100%MT
BK004A7-013-085				ACC.		100%MT
BK004A7-013-086				ACC.		100%MT

EXAMINED BY 主探 Ye Jieqian <u>Ye Jieqian</u> 2010.11.24	REVIEWED BY 审核 <u>Sun Gangchun</u> 2010.11.24
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-28779		DATE日期 2010.10.09		PAGE OF页码 2/6	Revision No: 0	
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: BK004A-005 bike path			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 KOREA	MODEL NO. 样式编号 MP-A2L	SERIAL NO. 连续编号 MP1193			
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 16/10mm			
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			
BK004A6-005-082				ACC.		100%MT
BK004A6-005-086				ACC.		100%MT
BK004A6-005-092				ACC.		100%MT
BK004A6-005-096				ACC.		100%MT
BK004A6-005-102				ACC.		100%MT
② BK004A6-005-063				ACC.		100%MT
③ BK004A6-005-080				ACC.		100%MT
④ BK004A6-005-090				ACC.		100%MT
⑤ BK004A6-005-100				ACC.		100%MT
⑥ BK004A6-005-070				ACC.		100%MT
⑦ BK004A6-005-078				ACC.		100%MT
BK004A6-005-088				ACC.		100%MT
BK004A6-005-098				ACC.		100%MT
BK004A6-005-072				ACC.		100%MT
BK004A6-005-073				ACC.		100%MT
EXAMINED BY主探 Xu Huaxiang <i>Xu Huaxiang</i> 2010.10.09			REVIEWED BY 审核 <i>Sun Guoyang</i> 2010.10.09			
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-29293		DATE日期 2010.10.09		PAGE OF页码 4/7		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS				
DRAWING NO. 图号: BK004A-001 bike path			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 KOREA		MODEL NO. 样式编号 MP-A2L		SERIAL NO. 连续编号 MP1193	
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 16/10mm	
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				
BK004A8-001-082				ACC.		100%MT	
BK004A8-001-086				ACC.		100%MT	
BK004A8-001-092				ACC.		100%MT	
BK004A8-001-096				ACC.		100%MT	
BK004A8-001-102				ACC.		100%MT	
BK004A8-001-063				ACC.		100%MT	
BK004A8-001-080				ACC.		100%MT	
BK004A8-001-090				ACC.		100%MT	
BK004A8-001-100				ACC.		100%MT	
BK004A8-001-070				ACC.		100%MT	
BK004A8-001-078				ACC.		100%MT	
BK004A8-001-088				ACC.		100%MT	
BK004A8-001-098				ACC.		100%MT	
BK004A8-001-072				ACC.		100%MT	
BK004A8-001-073				ACC.		100%MT	
EXAMINED BY 主探 Xu Huaxiang <i>Xu Huaxiang</i> 2010.10.09				REVIEWED BY 审核 <i>Sun Guangchun</i> 2010.10.09			
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-29294 DATE日期 2010.10.09 PAGE OF页码 4/7 Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS	
DRAWING NO. 图号: BK004A-003 bike path		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 KOREA	MODEL NO. 样式编号 MP-A2L	SERIAL NO. 连续编号 MP1193
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 16/10mm
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			
BK004A8-003-082				ACC.		100%MT
BK004A8-003-086				ACC.		100%MT
BK004A8-003-092				ACC.		100%MT
BK004A8-003-096				ACC.		100%MT
BK004A8-003-102				ACC.		100%MT
BK004A8-003-063				ACC.		100%MT
BK004A8-003-080				ACC.		100%MT
BK004A8-003-090				ACC.		100%MT
BK004A8-003-100				ACC.		100%MT
BK004A8-003-070				ACC.		100%MT
BK004A8-003-078				ACC.		100%MT
BK004A8-003-088				ACC.		100%MT
BK004A8-003-098				ACC.		100%MT
BK004A8-003-072				ACC.		100%MT
BK004A8-003-073				ACC.		100%MT

EXAMINED BY 主探 Xu Huaxiang <i>Xu Huaxiang</i> 2010.10.09 LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM	REVIEWED BY 审核 Sun Guangchun <i>Sun Guangchun</i> 2010.10.09 LEVEL-II SIGN / DATE日期 用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-16003 DATE 2010.10.05 PAGE 2 OF 2 Revision No: 0

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			
SB017-088-067		70				45									ACC.	100%
SB017-088-011	1	70	A	1	48	45	1	+2	10	43	13	0	0	REJ.	100%	
SB017-088-018	1	70	A	1	51	45	3	+3	10	58	18	-10	0	REJ.	100%	
SB017-088-001	1	70	A	1	51	45	3	+3	10	56	16	0	300	REJ.	100%	
SB017-088-004	1	70	A	1	50	45	1	+4	800	35	11	-16	0	REJ.	100%	
SB017-088-005	1	70	A	1	52	45	4	+3	10	81	27	0	200	REJ.	100%	
SB017-088-007	1	70	A	1	51	45	3	+3	10	61	20	0	260	REJ.	100%	
SB017-088-008	1	70	A	1	51	45	3	+3	100	66	21	0	0	REJ.	100%	
SB017-088-019	1	70	A	2	50	45	3	+2	200	60	20	+15	0	REJ.	100%	
SB017-088-020		70				45								ACC.	100%	

AFTER HSR(B)-9430

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EXAMINED BY 主探 <u>Xue Hairong</u> LEVEL - II SIGN / DATE 2010.10.05 质量经理 / QCM _____ 签字 SIGN / 日期 DATE	REVIEWED BY 审核 <u>Tang Xingshan</u> LEVEL - II SIGN / DATE 2010.10.05 用户 CUSTOMER _____ 签字 SIGN / 日期 DATE
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REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-16003R1-3 DATE 2010.10.20 PAGE 1 OF 2 Revision No: 0

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

ITEMS NAME: SUPPORT BEAM DRAWING NO.: SB88W CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号 ZP06-787

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

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

EQUIPMENT 设备 UT SCOPE MANUFACTURER 制造商 GE MODEL NO. 样式编号 USM33 SERIAL NO. 序列编号 0712027B

CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE II COUPLANT 耦合剂 C.M.C MATERIAL/THICKNESS 材料厚度 A709M-345T2 20/25/30/40/22mm

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
AMERICA	70°	2.25MHz	0.75×0.625in				
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			
SB017-088-031	1R1	70				41									ACC.	100%
SB017-088-037	1R1	70				41									ACC.	100%
SB017-088-043	1R1	70				41									ACC.	100%
SB017-088-061	1R1	70				41									ACC.	100%
② SB017-088-011	1R1	70				41									ACC.	100%
SB017-088-018	1R1	70				41									ACC.	100%
SB017-088-001	1R1	70				41									ACC.	100%

EXAMINED BY 主探 Xue Hairong REVIEWED BY 审核 Tang Xing shan
 LEVEL - II SIGN / DATE 2010.10.05 LEVEL - II SIGN / DATE 2010.10.05

质量经理 / QCM 用户CUSTOMER
 签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-16002R1-2 DATE 2010.10.20 PAGE 1 OF 2 Revision No: 0

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

ITEMS NAME: SUPPORT BEAM DRAWING NO.: SB86W CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号 ZP06-787

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
 FCAW 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 GE USM33 0712027B

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709M-345T2 20/25/30/40/22mm

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
AMERICA	70°	2.25MHz	0.75×0.625in				
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 a	Reference Level b	Attenuation Factor c	Indication Rating d	LOCATION OF DISCONTINUITY 不连续位置(mm)						
									Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SB017-086-025	1R1	70				41								ACC.	100%
SB017-086-037	1R1	70				41								ACC.	100%
SB017-086-049	1R1	70				41								ACC.	100%
SB017-086-061	1R1	70				41								ACC.	100%
SB017-086-067	1R1	70				41								ACC.	100%
SB017-086-019	1R1	70				41								ACC.	100%
SB017-086-007	1R1	70				41								ACC.	100%

EXAMINED BY 主探: Xiao Hairong REVIEWED BY 审核: Tang Xingshan
 LEVEL - II SIGN / DATE 2010.10.05 LEVEL - II SIGN / DATE 2010.10.05

质量经理 / QCM 用户CUSTOMER
 签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-16002 DATE 2010.10.05 PAGE 2 OF 2 Revision No: 0

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		
SB017-086-067	1	70	A	1	51	45	4	+2	200	78	24	-10	0	REJ.	100%
SB017-086-011		70				45								ACC.	100%
SB017-086-018		70				45								ACC.	100%
SB017-086-001		70				45								ACC.	100%
SB017-086-004	1	70	A	1	50	45	2	+3	150	51	16	0	100	REJ.	100%
SB017-086-005		70				45								ACC.	100%
SB017-086-007	1	70	A	2	51	45	7	+5	10	112	8	-7	0	REJ.	100%
SB017-086-008		70				45								ACC.	100%
SB017-086-019	1	70	A	1	53	45	3	+5	10	66	21	0	50	REJ.	100%
SB017-086-020		70				45								ACC.	100%

AFTER HSR(B)-9429

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EXAMINED BY 主探 <u>Xue Hairong</u> LEVEL - II SIGN / DATE 2010.10.05	REVIEWED BY 审核 <u>Tang Xingshan</u> LEVEL - II SIGN / DATE 2010.10.05
质量经理 / QCM _____ 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-16004 DATE 2010.10.05 PAGE 2 OF 2 Revision No: 0

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		
SB017-090-067	1	70	A	2	51	45	4	+2	10	78	16	-10	0	REJ.	100%
SB017-090-011	1	70	A	1	50	45	2	+3	10	44	14	0	0	REJ.	100%
SB017-090-018		70				45								ACC.	100%
SB017-090-001	1	70	A	1	52	45	5	+2	100	87	28	0	200	REJ.	100%
	2	70	A	1	52	45	4	+3	100	75	24	0	0	REJ.	100%
SB017-090-004	1	70	A	1	48	45	1	+2	800	33	10	-10	0	REJ.	100%
SB017-090-005	1	70	A	1	51	45	5	+2	10	84	27	-15	100	REJ.	100%
SB017-090-007	1	70	A	1	50	45	1	+4	10	34	13	0	25	REJ.	100%
SB017-090-008		70				45								ACC.	100%
SB017-090-019		70				45								ACC.	100%
SB017-090-020	1	70	A	1	51	45	3	+3	10	67	20	0	100	REJ.	100%
AFTER HSR(B)-9431															
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EXAMINED BY 主探 <i>Xue Hai rong</i> LEVEL - II SIGN / DATE 2010.10.05	REVIEWED BY 审核 <i>Tang Xing shan</i> LEVEL - II SIGN / DATE 2010.10.05
质量经理 / QCM _____	用户CUSTOMER _____
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China**Report No:** NCS-000838**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0808**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: 20-Sep-2010**Description of Non-Conformance:**

-On-going welding being performed on Bike Path component welds without a ZPMC Quality Control Inspector and/or Certified Welding Inspector (CWI) present for a period exceeding 1.5 hours in Bay 19. This time frame exceeds the allowable maximum time for QC Inspection coverage as required by Caltrans Special Provision Section 8-3.01.

-This Caltrans QA inspector was present from 18:30 to 20:00 hours.

-Caltrans QA called ZPMC QA at 1855 hrs trying to locate QC personnel; ZPMC stated that ABF would be monitoring this location.

-Caltrans QA called ABF personnel at 1900 hrs. ABF stated that ZPMC is to monitor this location and ZPMC was informed by ABF.

-Caltrans QA inspector still had not seen any QC at this location by 1945 hrs after 2 additional phone calls speaking with ABF and ZPMC personnel.

-Locations that ZPMC performed welding during the time period that QC/CWI was absent as identified by Caltrans QA are as follows:

Bike Path

BK004A2-013-061 (2/FW)

BK004A-005-085, 086, 087, 080, 082, 083 (1/FW)

BK004A8-001-072, 073 (2/FW)

BK004A8-003-072, 073 (2/FW)

Suspender Bracket

SB017-088-020, 011 (2/GW)

SB017-086-086, 020 (2/GW)

SB017-090-018, 011 (2/GW)

