

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, PR China**Report No:** NCR-000867**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0829**Type of problem:**

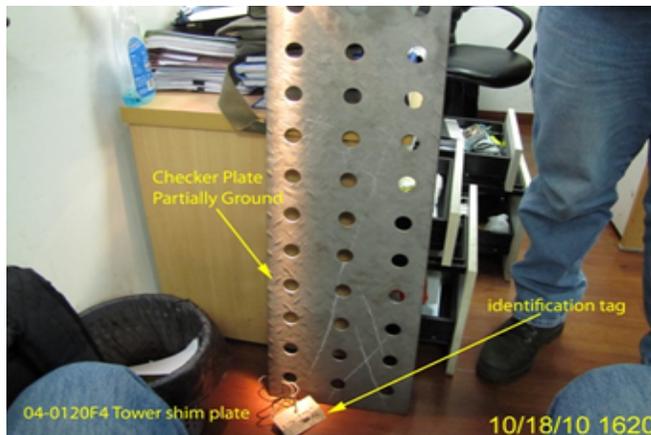
Welding	Concrete	Other
Welding	Curing	Procedural
Joint fit-up	Coating	Other
Procedural	Procedural	Description:

Bridge No: 34-0006**Component:** Tower Splice, 114M**Reference Description:** Unidentified Material**Description of Non-Conformance:**

During random visual inspection in Blast Shop #2, this Quality Assurance Inspector (QA) discovered the following issue:

- Shim plate was presented for blast inspection prior to being painted at which time inspector discovered raised areas on the faying surface.
- Shim plate was made from unidentifiable material (checkered plate) with the raised areas partially ground flush.
- Piece is marked E-D4-T-N-SA4-2
- Material is 5mm thick.
- The member was located in Blast Bay #2.
- The Notice of Inspection Number is T1236.

For further information, please see the attached pictures:



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

55-1.01 DESCRIPTION

This work shall consist of constructing steel structures in conformance with the details shown on the plans and as specified in these specifications and the special provisions.

55-2.01 DESCRIPTION

The various materials shall conform to the requirements in ASTM as listed in the table entitled "Structural Steel Materials" at the end of this Section 55-2.01.

Who discovered the problem: James Lumley

Name of individual from Contractor notified: Mr. Wei Changyou

Time and method of notification: 10/17/10, 18:30 Hrs, Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 10/19/10, 15:00 Hrs, Verbal

QC Inspector's Name: Ms. Yi Mingfei

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

Inspected By: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 666 Feng Bin Road Room 708, Changxing Island
 Shanghai 201913 PR China
 Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 20-Oct-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-0829

Job Name: SAS Superstructure
Document No: 05.03.06-000824

Reference Description: Unidentified Material

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: Tower **Lift:**

Remarks:

- During random visual inspection in Blast Shop #2, this Quality Assurance Inspector (QA) discovered the following issue:
- Shim plate was presented for blast inspection prior to being painted at which time inspector discovered raised areas on the faying surface.
 - Shim plate was made from unidentifiable material (checkered plate) with the raised areas partially ground flush.
 - Piece is marked E-D4-T-N-SA4-2
 - Material is 5mm thick.
 - The member was located in Blast Bay #2.
 - The Notice of Inspection Number is T1236.

Action Required and/or Action Taken:

Propose resolutions for the identified non-conformance items and document that the various deficiencies have been brought in compliance with contract requirements. Also propose a resolution that addresses the apparent failure of Quality Control to identify the non-conformance with the appropriate Welding Procedure Specification (WPS). Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

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

Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0829

cc: Rick Morrow, Peter Siegenthaler, Brian Boal, Mark Woods, 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: 05.03.06-000824

Subject: NCR No. ZPMC-0829

Dated: 29-Oct-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000825 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: Please see ZPMC's comments, based on their actions ZPMC requests closure of this NCR.
Please see ZPMC's comments, based on their actions ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua
Attachment(s): ABF-NPR-000825R00;

Caltrans' comments:

Status: AAP
Date: 31-Oct-2010

This proposed resolution is accepted with action pending. This NCR will be considered closed once the MTRs for the materials described in the NPR are submitted and reviewed.

Submitted by: Eagen, Sean
Attachment(s):

Date: 31-Oct-2010



No. T-176

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-10-29

REGARDING: NCR-000867 (ZPMC-829)

ZPMC received NCR-000867(ZPMC-829), it mentioned that CT inspectors found unidentified material was used for shim plate.

Once CT inspector found this issue, once got this information, subsequent investigation was taken by ZPMC immediately. The story was during splice plate trial assembly, it was urgent to put a shim plate in, but at that stage, the production shim plate was unavailable. So the work team took an unidentified material to instead. Their original idea was to replace back the production shim plate, but unfortunately, it was forgotten.

Anyway, problem is still problem, this issue had caused great concern of ZPMC department. A related meeting was taken duly, in order to prevent such issue appears again in the future, the following steps had been taken.

1. ZPMC internal NCR had been issued to make warning.
2. Re-fabricate a new piece of production shim, then match drill and make marking.
3. Perform fully check on the shims of this batch, confirm the entire plates meet with the requirement and prevent unidentifiable material mixed in the shims.
4. Doing heavy punishment on involved work team and foreman and making self-examination.
5. Strictly perform according to approved procedure and criteria during work, once issue appears, it's required to report to site QC immediately, and not permit to treat it privately.

Now, the unidentifiable material had been replaced by production shim, and the others had also been rechecked by both ABF and ZPMC.

Basing on above, we provide related reports, hope CT could take review and close this NCR.

ATTACHMENT:

NCR-000867(ZPMC-829)

ZPMC internal NCR-T-091

Meeting Memo

Zhang Jia Li
2010-10-29

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
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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, PR China

Report No: NCR-000867

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 18-Oct-2010

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

NCR #: ZPMC-0829

Type of problem:

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

Bridge No: 34-0006

Component: Tower Splice, 114M

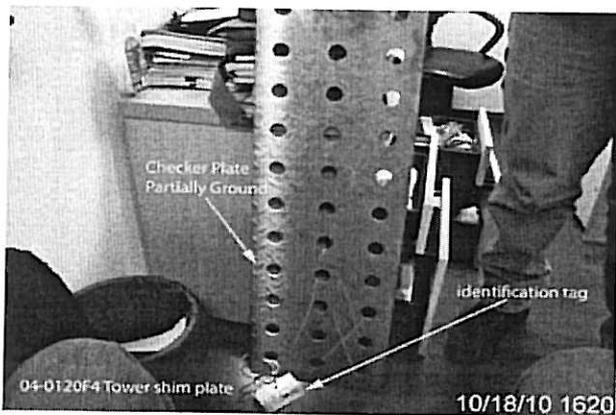
Reference Description: Unidentified Material

Description of Non-Conformance:

During random visual inspection in Blast Shop #2, this Quality Assurance Inspector (QA) discovered the following issue:

- Shim plate was presented for blast inspection prior to being painted at which time inspector discovered raised areas on the faying surface.
- Shim plate was made from unidentifiable material (checkered plate) with the raised areas partially ground flush.
- Piece is marked E-D4-T-N-SA4-2
- Material is 5mm thick.
- The member was located in Blast Bay #2.
- The Notice of Inspection Number is T1236.

For further information, please see the attached pictures:



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

55-1.01 DESCRIPTION

This work shall consist of constructing steel structures in conformance with the details shown on the plans and as specified in these specifications and the special provisions.

55-2.01 DESCRIPTION

The various materials shall conform to the requirements in ASTM as listed in the table entitled "Structural Steel Materials" at the end of this Section 55-2.01.

Who discovered the problem: James Lumley

Name of individual from Contractor notified: Mr. Wei Changyou

Time and method of notification: 10/17/10, 18:30 Hrs, Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 10/19/10, 15:00 Hrs, Verbal

QC Inspector's Name: Ms. Yi Mingfei

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

Inspected By: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B
 项目名称: 美国加州海湾大桥

NCR Number:
 NCR 编号: NCR-T-091

Item: Unidentified material for shim plate
 Item Number: E-D4-T-N-SA4-2
 名称描述: 垫板用错母材
 件号:
 东塔三吊纵向筋连接板垫板

Drawing: 图号:
 N/A

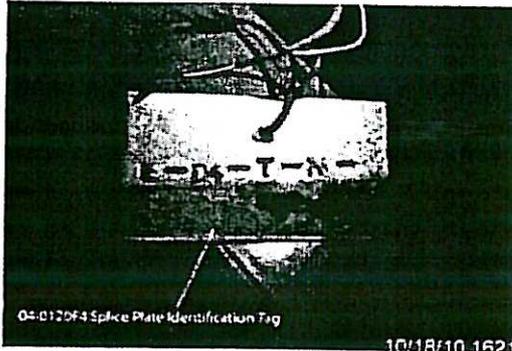
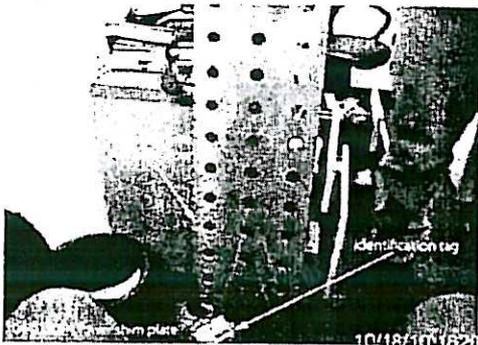
Location: Bay 11
 位置: 重型二车间

Date: 2010-10-26
 日期:

Description of Nonconformance: 不符合项状态描述:

施工队使用未经批准的不明材料来充当东塔三吊纵向筋连接板垫板。

The unauthorized material was used as the shim plate E-D4-T-N-SA4-2



Work By:

施工方: Guguopijq

Prepared by:

准备: 张俊英 2010.10.26

Reviewed by QCE:

质量工程师批准: [Signature]

Drawing Error Material Defect Fabrication Error Other

图纸错误 材料缺陷 制作错误 其他原因

Disposition:

处理措施:

Use as is Repair Reject

回用 返修 拒收

用原、制作一批的备用垫板。重新配孔、标记制作一件。 Refabricate a new one, then match drill and marking.

Recommendation:

建议:

1. 彻查整批连接板, 确认物件符合要求。

2. 对相关施工队要进行相关培训。

1. Recheck the whole batch of the shims, confirm all the plates meet the requirement.
 2. Doing training and education on work team.

Prepared by: 张俊英 2010.10.28
 准备

Approved by QCA: [Signature]
 质量经理批准

2010/10/28

Reason for Nonconformance:

不符合原因:

责任施工队未经相关部门允许私自使用不明材料

充当三、四号纵向筋连接板垫板。

The involved work team privately used unapproved material as the shim plate, without permission of production department.

Prevention of Re-occurrence:

预防措施:

① 对责任施工队带班作严肃处理并将检讨书备案

① Doing heavy punishment on involved foreman, and make self-examination.

② 今后对责任施工队所制作的的所有纵向筋连接板垫板

进行复查 避免出现存在不明材料的情况

② Performing fully check on all the shim plate for the sake of such unauthorized material mixed in the shims.

③ 加强该施工队的其它方面质量控制

③ Enhance the management of workteam and inspector.

Lu yefei

Approved by/批准:

2010.10.27

Technical Justification for Use-As-Is/Repair:

Attachment

Non-attachment

回用或返修的技术依据:

附件

无附件

重新制作一件。

Refabricate a new shim plate.

Reviewed /批准:

胡红峰 10.27/10

Verification:

Acceptable

Unacceptable

确认:

可接受

不可接受

Verified by QCI/质检确认:

陈明

10/27/2010

Reviewed by QCA/质检主任审核:

陈明 10/28/10

#R787-QCP-1300

会议纪要 Meeting memo

会议时间：2010-10-27

会议地点：104 会议室

会议主题：关于 114M 栓接段东塔箱体内部纵向筋联接板垫板用料错误问题的会议
Regarding the improper material was used on shim plate of 114m splice of East Tower

会议主持：付国刚

参加人员：陈浩 (QC)、石瑜 (QC)、杨磊磊、程长远、程斌、王小坤、陈国举、丁文安、陈静、张卫星、钱超

会议内容纲要：



关于第三四吊装段垫板材质被私自更换问题，公司领导都非常重视，由于施工队在施工过程中，对于细节问题的重视不足，导致这起质量问题的发生，为了防止同类问题的再次发生，同时再次明确质量过程控制的重要性，对于参与美国钢塔预拼装的主要人员明确并重审我们的质量要求。

1. 施工过程中一定要严格按照工艺和技术要求执行，如垫板安装位置、方向等。
2. 遇到质量问题要及时与现场质检沟通，采取正当途径解决，不可擅作主张。
3. 为防止再出现此类情况，要求施工队，在垫板配钻结束后，通知质检人员进行确认后，才可以转入下道工序。

质检一站

2010-10-22

Meeting Memo

With regarding to the improper material was used on shim plate of 114m splice of East Tower, this case caused highly concerning by Production and Quality. After investigation, it was the neglect and un-responsible by work team during progress.

In order to prevent such issue appears again in the future, all the involved people were trained and required to enhance management during daily work.

1. It should strictly perform according to related procedure and criteria during working, such as the material of plate, and installation orientation and stamp marking.
2. Once related quality issue happens, it must be required to contact with site QC inspector, to take proper method and mustn't take action privately.
3. Once current progress is completed, such as shim plate complete match drill, marking, etc, it's required to inform site QC inspector, after permission, the progress could shift next process.

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000824

Subject: NCR No. ZPMC-0829

Dated: 05-Nov-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000825 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: Per the Department's comments, ZPMC is providing the MTRs for all shim plates at the splice location. Based on this ZPMC requests closure of this NCR

Per the Department's comments, ZPMC is providing the MTRs for all shim plates at the splice location. Based on this ZPMC requests closure of this NCR

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000825R01;

Caltrans' comments:

Status: CLO

Date: 08-Nov-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0829 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 08-Nov-2010



TRANSMITTAL LETTER

PROJECT: S.F.O.B.B.

DATE:2010-11-05

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: TOWER NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

(01) LR: No. T-177

(02) NCR-000867(ZPMC-829)

(03) MTRs

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

lee

COMPANY:



PLAN NUMBER:N/A
#R787-QCP-102

RECEIVED 05 NOV 2010

DATE:

9:31

PHONE NO.



No. T-177

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-11-05

REGARDING: NCR-000867 (ZPMC-829)

ZPMC received NCR-000867(ZPMC-829), it mentioned that CT inspectors found unidentified material was used for shim plate.

According to ABF-NPR-000825, here, we provide related reports, hope CT could take review and close this NCR.

ATTACHMENT:

MTRs.

Zhang Waeli

2010.11.05

南京钢铁股份有限公司

Nanjing Iron & Steel Company Limited

质量证明书

Quality Certificate

证书号: PP2007063000399
 Certificate No: PP2007063000399
 品种名称: 桥梁用碳锰和高强度低合金结构型钢、钢板、钢管
 Name of Product: Carbon and High-Strength Low-Alloy Structural Steel Shapes, Plates, and Bars and Quenched-and-Tempered Alloy Structural Steel Plates for Bridges
 执行标准: ASTM A709
 Voluntary Standards
 生产许可证编号: 上海振华港口机械(集团)股份有限公司
 Manufacturing License: Shanghai Zhenhua Port Machinery (Group) Co., Ltd.
 收货单位: 热轧
 Purchaser: 热轧
 交货状态: 热轧
 Condition of Supply: HOT ROLLED

UST 探伤标准: UST Standards
 UST 试样尺寸 (mm): 5*10*55
 冲击试样尺寸 (mm): 5*10*55
 Size of Sample (mm)

质量记录编号: JJLJ20508/A
 Tab of Quality
 合同编号: HC0700821
 Contract No.
 提货单编号: GP070629005
 Bill of lading No.
 车/册号: YU
 Train / Ship No.
 目的地:
 Destination
 日期: 2007-6-30 11:48
 Date

产品号 Plate No	牌号 Steel Grade	规格 (mm) Dimensions (T.NVAL)	件数 Piece	重量 Weight (mt)	化学成分 (%) Chemical Compositions																																																															
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5	6.215	质检员 Works Inspector																																																																		
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合计 (Total)					A56265															日期: 日期:																																																
注: 产品牌号以质量证明书为准																																																																				

南京钢铁股份有限公司

Nanjing Iron & Steel Company Limited

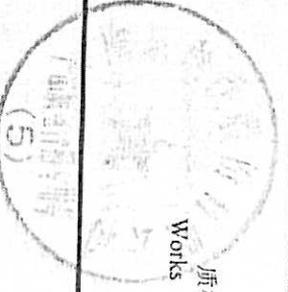
质量证明书

证明书号: PP2007063000082
 Certificate No
 品种名称: 桥梁用碳钢和高强度低合金结构型钢、钢板、钢棒
 Name of Product: Carbon and High-Strength Low-Alloy Structural Steel Shapes, Plates, and Bars and Quenched and Tempered Alloy Structural Steel Plates for Bridges
 执行标准: ASTM A709M-2005
 Voluntary Standards
 生产许可证编号: 上海振华港口机械(集团)股份有限公司
 Manufacturing License
 收货单位: 控轧
 Purchaser
 交货状态: 控轧
 Condition of Supply: CONTROLLED ROLLED

质量证明书
 Quality Certificate
 UST 探伤标准: ASTM A 578/A578M-96 C级
 UST Standards:
 冲击试样尺寸 (mm): 5*10*55
 Size of Sample (mm)

质量记录编号: JJJZ0508/A
 Tab of Quality
 合同编号: H60700407
 Contract No
 提货单编号: G0070627166
 Bill of lading No
 车/船号: YU
 Train / Ship No
 目的地:
 Destination
 日期: 2007-10-25 21:24
 Date

产品号 Plate No	牌号 Steel Grade	规格 (mm) Dimensions (TxWxL)	件数 Piece	重量 Weight (mt)	化学成分 (%) Chemical Compositions											晶粒 度 Gr. HARD	硬度 HARD			
					冲击功 Impact Test (AKV(J))			时效冲击功 Ageing Impact Value (J)			Z向断面收缩率 Z-R.A. (%)									
					C	Mn	P	S	Si	Nb	Alt	Mo	Cu	Ni	Cr			V	Ti	N
072045076101	A709M-345T2-X	10*2600*10100	1	2.061	16	133	16	1	27	25	-	-	-	-	-	-	-	39	-	27
072045076101	A709M-345T2-X	10*2600*10100	1	2.061	16	133	16	1	27	25	-	-	-	-	-	-	-	39	-	27
072045076102	A709M-345T2-X	10*2600*10100	1	2.061	16	133	16	1	27	25	-	-	-	-	-	-	-	39	-	27
072045076102	A709M-345T2-X	10*2600*10100	1	2.061	16	133	16	1	27	25	-	-	-	-	-	-	-	39	-	27
072045076102	A709M-345T2-X	10*2600*10100	1	2.061	16	133	16	1	27	25	-	-	-	-	-	-	-	39	-	27
产品号 Plate No		屈服强度 Y.S. (MPa)	抗拉强度 T.S. (MPa)	伸长率 E.L. (%)	冷弯 B.T.	探伤 UST	冲击功 Impact Test (AKV(J))			时效冲击功 Ageing Impact Value (J)			Z向断面收缩率 Z-R.A. (%)					晶粒 度 Gr. HARD	硬度 HARD	
072045076101	380	565	29.5	OK	OK	C	1#	2#	3#	平均	C	1#	2#	3#	平均	1#	2#	3#	平均	
072045076101	380	565	29.5	OK	OK		75	75	78	76		-	-	-	-	-	-	-	8.5	-
072045076102	380	565	29.5	OK	OK		75	75	78	76		-	-	-	-	-	-	-	8.5	-
072045076102	380	565	29.5	OK	OK		75	75	78	76		-	-	-	-	-	-	-	8.5	-
072045076102	380	565	29.5	OK	OK		75	75	78	76		-	-	-	-	-	-	-	8.5	-
本页总计 (Page Total)		380	565	29.5	OK	OK	4	75	75	76		-	-	-	-	-	-	-	8.5	-
件数 Piece	重量 (mt) Weight	证明章 Quality Prove Seal																		
5	10.305	质检员 Works Inspector																		
		发新红 发货员:																		
		吕玮玮																		



备注
Remarks
合计 (Total)

注: 产品牌号以质量证明书为准



武汉钢铁股份有限公司
WUHAN IRON & STEEL COMPANY LIMITED

产品质量证明书

CERTIFICATE OF PRODUCT QUALITY

地址: 中国, 武汉, 青山
ADDRESS: QINGSHAN WUHAN P.R.C.
邮编: 430083
POST CODE: 430083
电话: (027) 96894499
TELEPHONE: 96894499

H0088-01

107A

订货单位 SOLD TO	武汉市	产品名称 PRODUCT	热轧合金厚钢板 Low Alloy Shim Plate
收货单位 EXCISEE		订单编号 ORDER NO.	SHD18886B
技术条件 SPECIFICATION	GB/T3274-1988-Q345B-普通精度: 切边: h < 8.0mm 不提供冲许值; 控轧: Impact test values are not provided; Controlled rolling	客户编号 CUSTOMER NO.	4300128855
检验 INSPECTION	钢板检验 (WISCO INSPECTION)	发货日期 DATE OF DELIVERY	2008.05.19
		合同号 CONTRACT NO.	
		证明日期 THE ISSUE DATE	2008.05.20

项号 ITEM NO.	产品序号 PRODUCT NO.	规格及重量 MATERIAL DESCRIPTION			炉号 HEAT NO.	钢卷号 COIL NO.	检验批号 BATCH NO.	化学成分 CHEMICAL ANALYSIS %					试样 SAMPLE	状态 STATUS	厚度 THICKNESS	宽度 WIDTH	长度 LENGTH	重量 WEIGHT	*RA 弯曲 B-25 130D	
		厚度 THICK mm	宽度 WIDTH mm	长度 LENGTH mm				数量 QTY	重量 WEIGHT t	C	Si	Mn								P
01	H118013130	5.00	1500	5000	7.065	C813159	82850870	A	170	389	143	18	7	7	360	360	360	530	29.0	OK
01	H118013132	5.00	1500	5000	7.065	C813159	82850870	A	170	389	143	18	7	360	360	360	530	29.0	OK	
01	H118013133	5.00	1500	5000	7.418	C813159	82850870	A	170	389	143	18	7	360	360	360	530	29.0	OK	
01	H118013134	5.00	1500	5000	7.065	C813158	82850869	A	162	402	157	25	9	370	370	370	525	33.0	OK	
01	H118013135	5.00	1500	5000	7.065	C813158	82850869	A	162	402	157	25	9	370	370	370	525	33.0	OK	
01	H118013136	5.00	1500	5000	7.065	C813158	82850869	A	162	402	157	25	9	370	370	370	525	33.0	OK	
01	H118013137	5.00	1500	5000	7.065	C813158	82850869	A	162	402	157	25	9	370	370	370	525	33.0	OK	
01	H118013140	5.00	1500	5000	7.065	C813158	82850869	A	162	402	157	25	9	370	370	370	525	33.0	OK	
合计 TOTAL		数量 QTY		161	重量 WEIGHT		166.873 t													

备注
MARK

解释
NOTES

公差
TOLERANCE

屈服强度
Y.S. = YIELD STRENGTH

抗拉强度
T.S. = TENSILE STRENGTH

伸长率
EL. = ELONGATION

钢板
GAUGE LENGTH

5655: 5.655ORS

*DA BEND TEST

CR CONTROL ROLLING

TRANSVERSE

MIDDLE

弯曲试验
BEND TEST

横乳状态
HEAD END

轧制方向中部
MIDDLE



Dong Wang

金盛普
SUNEVOR TO

质量检验中心主任
GENERAL MANAGER QUALITY INSPECTION CENTER

我们证明本表所列产品, 均以产品标准制造及试验, 并符合标准之要求。
We here certify that the material herein described has been manufactured, sampled, tested and inspected in accordance with the requirements of specifications and purchased order and meet the requirements.

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, PR China**Report No:** NCS-000785**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 05-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0829**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: 18-Oct-2010**Description of Non-Conformance:**

During random visual inspection in Blast Shop #2, this Quality Assurance Inspector (QA) discovered the following issue:

- Shim plate was presented for blast inspection prior to being painted at which time inspector discovered raised areas on the faying surface.
- Shim plate was made from unidentifiable material (checkered plate) with the raised areas partially ground flush.
- Piece is marked E-D4-T-N-SA4-2
- Material is 5mm thick.
- The member was located in Blast Bay #2.
- The Notice of Inspection Number is T1236.

Contractor's proposal to correct the problem:

Contractor proposes to replace the unidentified shim plate, identify if there are other locations using similar material, educate and discipline the workers. For all related shim plates similar to the splice location, MTRs will be provided to the Department.

Corrective action taken:

Contractor has replaced the shim plate, performed thorough check on all shim plates of the same splice location.

Contractor provided MTRs for all the shim plates related to the splice location and material has been confirmed to meet contract requirements. The responsible personnel have been disciplined.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?**

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Yes No

Comments:

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

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer