

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

333 Burma Rd.
Oakland, CA 94607
(510) 622-5660, (510) 286-0550 fax



*Flex your power
Be energy efficient!*

July 01, 2009

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.08-000020

Michael Flowers
Project Executive
American Bridge/Fluor, A JV
375 Burma Road
Oakland, CA 94607

Dear Michael Flowers,

Missed Magnetic Particle Indications by QC

This letter is issued to follow up the Department's notice provided at the Management Meeting on Changxing Island on June 16, 2009, regarding the increased incidence of cracks and relevant MT indications found by the Department's QA METS inspectors on welds previously inspected and approved as satisfactory by ZPMC's QC operation. Based upon our on-going inspection, the Department has discovered an increasing number of cracks and MT indications that have been missed by the QC staff. This issue may be widespread, affecting both the Orthotropic Box Girder (OBG) and Tower fabrication. The following summarizes the number of indications discovered to date by the Department's QA after acceptance by ZPMC's QC:

- **OBG:** 63 Missed MT Indications by QC since May 30, 2009
- **Tower:** 22 Missed MT Indications by QC since April 15, 2009

As discussed during our Management Meeting, QA has observed two procedural issues in the Fabricator's organization that are unacceptable. Primarily, the cracking of deposited weld indicates either a failed weld procedure or practice (for example, a number of NCR's have been issued for lack of preheat); and secondarily, the failure in not identifying and documenting these indications during their inspection of the welds.

Please investigate why these indications have gone undetected during the Magnetic Particle Inspection Procedure, and provide the Department of your findings. We are particularly interested to know, from a search of the QA/QC database, if the oversight is limited to a small number of personnel or whether it is widespread across the Fabricator's QC operation.

Please inform the Department, once personnel have been identified, what ABF's plan is moving forward and what involvement these individuals will have hereafter on the SAS Project. In addition, please inform the Department how ABF intends to handle the inspection work previously completed by these individuals on the SAS Project.

As OBG Lifts 1 through 4 are due to ship in the very near future, the Department desires to work closely with ABF to resolve this issue. Time is of the essence if the projected shipment date will be met. We request a meeting as soon as possible to discuss ABF's intended approach to mitigate this failure of ZPMC's MT inspection.

Please contact Doug Coe at 137-6132-2704 if you have any questions or would like to discuss this issue further.

Sincerely,

<<< ORIGINAL SIGNED >>>

GARY PURSELL
Resident Engineer

cc: Rick Morrow
Peter Siegenthaler
File: 05.03.08