

**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 #: 1x.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island**Report No:** NCR-000014**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Nov-2007**Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0001**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> OBG Deck
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b> Acceptance of non-conforming material.	

**Description of Non-Conformance:**

ABF's Quality Control accepted welds from the Weld Procedure Trials completed on 01-Nov-07 that do not conform to the surface profile requirements of AWS D1.5.

**Applicable reference:**

Special Provisions, Section 10-1.59, Shop Welding, Welding of Closed Ribs to Box Shell Plate, B. Weld Procedure Trials (page 328 - 329): "Closed rib welds shall conform to the following: ... The surface profile shall meet AWS D1.5, Section 6.26.1 for a weld in a primary member with tension transverse to the weld axis. A maximum of 0.25 mm undercut is permitted."

AWS D1.5, Section 3.6.

**Who discovered the problem:** Ady Velasco, Structural Materials Representative

**Name of individual from Contractor notified:**

**Time and method of notification:**

**Name of Caltrans Engineer notified:**

**Time and method of notification:**

**QC Inspector's Name:**

**Was QC Inspector aware of the problem:** Yes No

**Contractor's proposal to correct the problem:**

**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 Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

**Inspected By:** Velasco, Abifhram

Quality Assurance Inspector

**Reviewed By:** Lowry, Patrick

QA Reviewer

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island**Report No:** NCS-000371**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Nov-2009**Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0001**Type of problem:**

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

**Date the Non-Conformance Report was written:** 07-Nov-2007**Description of Non-Conformance:**

ABF's Quality Control accepted welds from the Weld Procedure Trials completed on 01-Nov-07 that do not conform to the surface profile requirements of AWS D1.5.

**Contractor's proposal to correct the problem:**

Contractor has hired additional NDT technicians to perform MT overchecking and is in the process of investigating the cause of recurring cracks.

**Corrective action taken:**

Contractor submitted Critical Weld Repair (CWR 654) along with required MT report confirming that the repair is in conformance with Contract requirements.

**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:**

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**Inspected By:** Simonis, Jim Quality Assurance Inspector**Reviewed By:** Wahbeh, Mazen QA Reviewer