

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:** Shanghai, China**Report No:** NCR-000007**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Sep-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0007**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 114 Meter Mock-Up
Procedural	Procedural	Descriptor:	UT angle determination and Db Scanning Levels

Description of Non-Conformance:

The Contractor's Quality Control Inspectors were not following the approved ultrasonic procedure in the WQCP. The calibration block does not show the 2 degree markings on either side of the major angles used (45, 60 and 70). Inspectors were also not utilizing the scanning levels shown in Table 6.3, AWS D1.5.

Applicable reference:

AWS D1.5 paragraphs 6.15.7.3, 6.21.2.2 for transducers angles and paragraph 6.19.6 and table 6.3 & 6.4 for scanning levels.

Who discovered the problem: QA Inspector Bruce J. Berger**Name of individual from Contractor notified:** Fo Yo Hhong**Time and method of notification:** 1900 Verbal**Name of Caltrans Engineer notified:****Time and method of notification:****QC Inspector's Name:** Bing Xu**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: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: 510-622-5158 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge/Fluor Enterprises, a JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 26-Oct-2007

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Michael Flowers Project Executive

Document No: 05.03.06-000069

Subject: NCR No. ZPMC-0007

Reference Description: QC not following the approved UT procedure on 114m Mock-up

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 - No Response Required.

Material Location:

Lift:

Remarks:

Originally sent by State letter 05.03.01-000757

Action Required and/or Action Taken:

Transmitted by: Keith Osantowski Sr. Engineer

Attachments: ZPMC-0007

cc:

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000069

Subject: NCR No. ZPMC-0007

Dated: 05-Dec-2007

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000003 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has procured an acceptable IIVW block to perform calibrations correctly.

ZPMC UT technicians not using appropriate IIVW block nor were they scanning using the correct db scanning levels contrary to the AWS D1.5 code nor their own UT procedure.

ABF JV has informed ZPMC of this nonconformance. ZPMC has since procured an acceptable IIVW block to perform calibrations correctly. ABF JV has reviewed the AWS D1.5 code and the ZPMC UT procedure with ZPMC UT technicians to gain understanding of the scanning levels required. Attached is the ZPMC internal NCR addressing this nonconformance.

Submitted by: Flowers, Michael

Attachment(s): ABF-NPR-000003R00; ABF-NCR-000003-01

Caltrans' comments:

Status: Approved
Date: 24-Mar-2008

See State Letter 05.03.01-001406

Submitted by: Pursell, Gary

Attachment(s): 05.03.01-001406; TC-20 5,7,8

Date: 22-Feb-2008

14-Feb-2008

ABF-CAL-LTR-000444

Mr. Gary Pursell
Resident Engineer
California Department of Transportation
333 Burma Road,
Oakland, CA 94607, USA

PROJECT: San Francisco Oakland Bay SAS Bridge Superstructure
Caltrans Contract No. 04-0120F4
ABF Job No. 660110

SUBJECT: RESPONSE TO NCR-0005, 0007 AND 0008

Gentlemen:

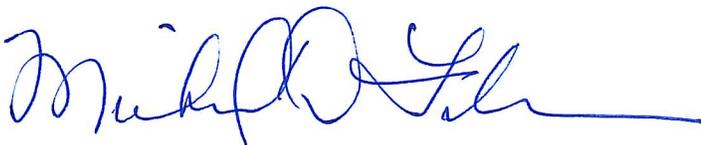
American Bridge / Fluor Enterprises Inc. a Joint Venture (ABFJV) acknowledges receipt of the Department's Letter No.05.03.01-000757 dated October 26, 2007 forwarding the Department's Non-Compliance Report NCR-0005, 0007 and 0008

The attached documents the response to the subject NCRs and closure by the Engineer's China Fabrication Team. Based on the attached ABFJV is requesting written confirmation from the Engineer that these NCR are closed.

If you need any more information, please call Chuck Kanapicki at (510) 808-4609.

Sincerely,

AMERICAN BRIDGE/FLUOR ENTERPRISES, INC. A JOINT VENTURE



Michael Flowers
Project Director
MF/CK/cc

File: 02.01, 02.28.4
Enclos: Response to NCR- 0005, 0007 and 0008

DEPARTMENT OF TRANSPORTATION

CHINA FABRICATION TEAM
506 Shangcheng Rd., Pudong New District
Shanghai 200120, PRC



REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Dave Williams, American Bridge – Fluor, a Joint Venture
Gary Pursell, Resident Engineer

Review Date: 12/20/2007From: Joshua Ishibashi, Structural Materials RepresentativeContract No.: 04-0120F4Date/Time Submittal Received: 12/05/2007 1315
 China Standard Time
(GMT+08:00)
Contractor's Transmittal #: TL-07-0704 Rev. # 0

<input checked="" type="checkbox"/>	substantially complies with contract requirements and is approved			
<input type="checkbox"/>	substantially complies with contract requirements and is approved as noted.			
<input type="checkbox"/>	Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmittal			
Verbal Notification		<input type="checkbox"/> No	<input checked="" type="checkbox"/> Yes	Date: <u>01/18/08</u> Time: <u>1200</u>
Name of individual from Contractor Notified: <u>Steve Lawton</u>				
This submittal is a:		<input type="checkbox"/> Welding Report	<input type="checkbox"/> Critical Weld Repair	
		<input type="checkbox"/> Request for Information	<input type="checkbox"/> Heat Straightening Request	
		<input type="checkbox"/> Fabrication Procedures	<input checked="" type="checkbox"/> Other: <u>NCR Closure</u>	
Submitting Contractor: <u>ZPMC</u>				
ITEMS REVIEWED		COMPLIES		COMMENTS
1.	ABF-SL-07-0236 NCR Resolution for ZPMC 05, 07, 08	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Approved
2.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
3.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
4.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
5.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
6.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
7.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
8.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
9.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	
10.		<input type="checkbox"/> Yes	<input type="checkbox"/> No	

Remarks: METS has completed the review of ABF-TL-07-0752. This NCR was closed in PMIV on 12/20/07. At the request of ABF China METS is generating a TC20 to document this closure. METS recommends the aforementioned NCR be closed.

JT
Reviewer: Joshua Ishibashi

Date: 01/18/2008

Construction Concurrence: u Initial 1/18/08 Date



A JOINT VENTURE

December 05, 2007

California Department of Transportation
666 Feng Bin Road, Room 708
Changxing Island, Shanghai China

Reply to: SL-ABF-07-0236

Attention: Gary Pursell

Reference: San Francisco Oakland Bay SAS Bridge Superstructure
Caltrans Contract No. 04-0120F4
ABF Job No. 660110

Subject: State Letter 05.03.01-000757

Mr. Purcell:

American Bridge / Fluor (ABF) Quality Assurance Department is in receipt of State Letter 05.03.01-000757 October 26, 2007 providing ABF notification regarding Nonconformance Report (NCR) No.005, 007 and 008.

This letter is issued to provide formal response addressing the proposed resolution to each of the mentioned NCR's for Engineer's review and approval.

NCR-00005 - 77M Mock-up Long Stiffener to Skin Plate welds.

Rejects in Stiffener to Skin Plate welds exceeded 10%, repairs were made contrary to contract requirements.

ABFJV has reviewed the Mock-up section of the Special Provisions with ZPMC to gain understanding of this requirement which is different from the requirements for production. Both ABFJV and ZPMC now understand this requirement. ZPMC initiated an internal NCR to address this nonconformance. ZPMC also conducted internal tests and has submitted a plan to improve weld quality. Attached for review is the ZPMC Internal NCR and the written plan to improve weld quality.

NCR-00007 - UT angle determination and db Scanning Levels

ZPMC UT technicians not using appropriate IIW block nor were they scanning using the correct db scanning levels contrary to the AWS D1.5 code nor their own UT procedure.

ABFJV has informed ZPMC of this nonconformance. ZPMC has since procured an acceptable IIW block to perform calibrations correctly. ABFJV has reviewed the AWS D1.5 code and the ZPMC UT procedure with ZPMC UT technicians to gain understanding of the scanning levels required. Attached is the ZPMC

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Initial *u* Date: 1/18/08

AMERICAN BRIDGE / FLUOR JV

Page 2

internal NCR addressing this nonconformance.

NCR-00008 - 114M Mock-up.

Rejects in Stiffener to Skin Plate welds exceeded 10%, repairs were made contrary to contract requirements.

ABFJV has reviewed the Mock-up section of the Special Provisions with ZPMC to gain understanding of this requirement which is different from the requirements for production. Both ABFJV and ZPMC now understand this requirement. ZPMC initiated an internal NCR to address this nonconformance. ZPMC also conducted internal tests and has submitted a plan to improve weld quality. Attached for review is the ZPMC Internal NCR and the written plan to improve weld quality.

If you have any questions or need additional information, please contact this office

Sincerely,



AMERICAN BRIDGE / FLUOR JV

Steve Lawton

Foreign Quality Assurance Manager

cc: file

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State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial *SL* Date: *1/18/08*

STATE OF CALIFORNIA-BUSINESS, TRANSPORTATION AND HOUSING AGENCY
DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program
333 Burma Rd.
Oakland, CA 94607
(510) 622-5660, (510) 286-0550 fax

ARNOLD SCHWARZENEGGER, Governor



Flex your power
Be energy efficient!

October 26, 2007

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.01-000757

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

Dear Michael Flowers,

NCRs 5, 7 & 8 - Zhenhua Port Machinery Company, Ltd.

This letter is issued to provide a formal notification to American Bridge/Fluor Enterprises (ABF) of the issuance of non-conformance reports (NCRs) at the Zhenhua Port Machinery Company, Ltd. (ZPMC) facility in Shanghai, China. Verbal notification was previously provided to ABF representatives on site. The following is a summary of the NCRs which have been attached to this document:

NCR 5 - 77m Mock-up Longitudinal Stiffener to Skin Plate Welds

The Contractor allowed the Fabricator to make repairs to rejectable indications found in the complete joint penetration welds between the longitudinal stiffener and Skin Plates A and E of the 77m mock-up at lengths greater than 10% of the cumulative length of the welds.

NCR 7 - 114m Mock-up UT Angle Determination and Db Scanning Levels

The Contractor's Quality Control Inspectors were not following the approved UT procedure.

NCR 8 - 114m Mock-up Skin Plate Welds

The Contractor allowed the Fabricator to make repairs to a number of welds for Skin Plates A MA-106 and B MA-101 that had defects with cumulative lengths in excess of 10% of the weld lengths without notifying the Department.

ABF shall provide a formal response addressing the proposed resolution to each of these NCRs for the Engineer's review and approval.

Sincerely,

GARY PURSELL
Resident Engineer

Attachment

cc: Rick Morrow, Brian Boal
file: 05.03.01, 09.01.06

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State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 6-1.02 of the
Standard Specifications
Initial *u* Date: 1/18/08



LETTER OF RESPONSE

DATE: 2007.11.26

To: AB/F Steve Lawton

From: ZPMC Li Liming

Subject: Response to CT NCR-000007-CT

Mr. Lawton:

ZPMC has generated internal NCR-CT-005 in Response to CT NCR-000007-CT, Regarding use of UT calibration block without 2 degree increments to determine major angles used. (45° and 70°). ZPMC has borrowed ABF II W block until such time as ZPMC purchase our own correct block. Also scanning levels per table 10.3 of AWS 1.5 were not being complied with. ZPMC has informed UT operators to use scanning levels per AWS D1.5 table 10.3. Attached you will find a copy of ZPMC internal NCR.

If further information is needed, Please contact me.

Sincerely

Li Liming *Li Liming* 2007.11.26

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Pursuant Section 5-1.02 of the
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Initial *u* Date: *1/18/08*

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)649-5453

Contract #: 04-0120F4
 Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6
 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Shanghai, China

Report No: NCR-000007

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 29-Sep-2007

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

NCR #: NCR-000007

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: 114 Meter Mock-Up
 Procedural Procedural Descripton: UT angle determination and Db Scanning Levels

Description of Non-Conformance:

The Contractor's Quality Control Inspectors were not following the approved ultrasonic procedure in the WQCP. The calibration block does not show the 2 degree markings on either side of the major angles used (45, 60 and 70). Inspectors were also not utilizing the scanning levels shown in Table 6.3, AWS D1.5.

Applicable reference:

AWS D1.5 paragraphs 6.15.7.3, 6.21.2.2 for transducers angles and paragraph 6.19.6 and table 6.3 & 6.4 for scanning levels.

Who discovered the problem: QA Inspector Bruce J. Berger

Name of individual from Contractor notified: Fo Yo Hhong

Time and method of notification: 1900 Verbal

Name of Caltrans Engineer notified:

Time and method of notification:

QC Inspector's Name: Bing Xu

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: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer

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 Pursuant Section 5-1.02 of the
 Standard Specifications
 Initial *u* Date: *1/18/08*



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-CT-005
NCR 编号: (NCR-000007-CT)

Item: ultrasonic procedure
名称描述: UT 探伤

Item Number: NA
件号: NA

Drawing Number:
图号: NA

Location: CT Mock Up
位置: 加州模型段

Date: 2007-10-17
日期:

Description of Nonconformance:

不符合项状态描述:

The Contractor Quality Control Inspectors were not following the approved ultrasonic procedure in the WQCP. The calibration block does not show the 2 degree markings on either side of the major angles used (45, 60 and 70). Inspectors were also not utilizing the scanning levels shown in Table 6.3 AWS D1.5.

承包商质检员没有根据 WQCP 中批准的超声波检测程序检测。在主要角度 (45, 60, 70) 两边试块没有体现 2 级标记。检验员也没有利用 AWS D1.5 表 6.3 中的扫描等级。

Work By: Li Li ming Prepared by: Zhao Chen Sun Reviewed by QCE: Fu Yuhong

施工方: 2007.10.17 准备: 2007.10.17 质量工程师批准: 2007.10.17
 Drawing Error Material Defect Fabrication Error Other
图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
处理措施: 回用 返修 拒收

Recommendation:

- Buy new II w calibration block with ± 2 degree marking on either side of the major angle used.
- Perform strictly as the scanning levels show in the Table 6.3 AWS D1.5.

Prepared by: Li Li ming 2007.10.17 Approved by QCA: Hu Gang
准备 质量经理批准 2007.10.17

Reason for Nonconformance:

不符合原因:

- II w calibration block without ± 2 degree marking on either side.
- The defect is not easy to be observed and distinguished with too high scanning level.

Prevention of Re-occurrence:

预防措施:

- Buy new II w calibration block with ± 2 degree marking on either side of the major angle used.
- Scan on different areas, each area with different scanning level.

Approved by/批准: Li Li ming 2007.10.17

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

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State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial u Date: 11/8/08

Reviewed /批准: _____

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

Verified by QCI/质检确认: _____ Reviewed by QCA/质检主任审核: _____



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-CT-005
(NCR-000007-CT)

Item: ultrasonic procedure
名称描述: UT 探伤

Item Number:
件号: NA

Drawing Number:
图号: NA

Location: CT Mock Up
位置: 加州模型段

Date:
日期: 2007-10-17

Description of Nonconformance:

不符合项状态描述:

The Contractor Quality Control Inspectors were not following the approved ultrasonic procedure in the WQCP. The calibration block does not show the 2 degree markings on either side of the major angles used (45, 60 and 70). Inspectors were also not utilizing the scanning levels shown in Table 6.3 AWS D1.5.

承包商质检员没有根据 WQCP 中批准的超声波检测程序检测。在主要角度 (45, 60, 70) 两边试块没有体现 2 级标记。检验员也没有利用 AWS D1.5 表 6.3 中的扫描等级。

Work By: Li Liming 2007.10.17 Prepared by: Zhao Chen Sun Reviewed by QCE: Fu Yuhong 2007.10.17
施工方: 准备: 质量工程师批准:

- Drawing Error Material Defect Fabrication Error Other
图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
处理措施: 回用 返修 拒收

Recommendation:

建议 购买新 IW 试块, 在主要角度两边有 $\pm 2^\circ$ 标记。
严格按照 AWS D1.5 表 6.3 中的扫描等级扫描。

Prepared by: Li Liming 2007.10.17 Approved by QCA: Hu Gang
准备 质量经理批准 2007.10.17

Reason for Nonconformance:

不符合原因: IW 试块上无 $\pm 2^\circ$ 刻度线。
扫描等级太高, 缺陷不易观察、分辨。

Prevention of Re-occurrence:

预防措施: 购买有 $\pm 2^\circ$ 刻度的 IW 试块, 按 AWS D1.5 执行,
扫描分区域进行, 每一区域加以不同的扫描等级。

Approved by/批准: Li Liming 2007.10.17

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

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State of California
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Pursuant Section 5-1.02 of the
Standard Specifications
Initial W Date: 1/18/08

Reviewed /批准: _____

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

Verified by QCI/质检确认: _____ Reviewed by QCA/质检主任审核: _____

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!*

February 22, 2008

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.01-001406

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

Dear Michael Flowers,

Response to NCRs 1, 5, 7, 8, 9, 10, 11, 12 & 13

This letter is issued as a response to ABF-CAL-LTR-000443, 444, 445, dated February 14, 2008, and ABF-CAL-LTR-000446, dated February 15, 2008, requesting written confirmation from the Engineer that the referenced Non-Conformance Reports (NCRs) at Zhenhua Port Machinery Company, Ltd (ZPMC) have been closed. The Department considers the following ZPMC NCRs closed:

NCR No.	State Letter No.	ABF Document No.	Description
1	05.03.01-000123	ABF-CAL-LTR-000443	Radiographic Testing issues (IQI placement, source type, etc.)
5	05.03.01-000757	ABF-CAL-LTR-000444	Repairs to longitudinal stiffener welds greater than 10% in length on the 77m Mock-up
7	05.03.01-000757	ABF-CAL-LTR-000444	QC not following the approved UT procedure on 114m Mock-up
8	05.03.01-000757	ABF-CAL-LTR-000444	Repairs to skin plate welds greater than 10% in length on the 114m Mock-up
9	05.03.01-000795	ABF-CAL-LTR-000445	Third time repairs to Skin B sub-assemblies on the 114m Mock-up without Engineer approval
10	05.03.01-000795	ABF-CAL-LTR-000445	Repairs to longitudinal stiffener welds greater than 10% in length on the 114m Mock-up
11	05.03.01-000795	ABF-CAL-LTR-000446	Failure to document fit-up of longitudinal stiffener on Mock-up
12	05.03.01-000795	ABF-CAL-LTR-000446	Repairs to skin plate welds greater than 10% in length on the 114m Mock-up
13	05.03.01-000795	ABF-CAL-LTR-000446	Welding electrode used on 89m Strut Sub-Assembly not in compliance

American Bridge/Fluor Enterprises, a JV
February 22, 2008
Page 2 of 2

Please contact us if you have any questions.

Sincerely,

A handwritten signature in cursive script that reads "Gary Purcell".

GARY PURSELL
Resident Engineer

cc: Rick Morrow
Brian Boal
Gary Lai
Mark Woods

file: 05.03.01

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:** Shanghai, China**Report No:** NCS-000009**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0007**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: 29-Sep-2007**Description of Non-Conformance:**

The Contractor's Quality Control Inspectors were not following the approved ultrasonic procedure in the WQCP. The calibration block does not show the 2 degree markings on either side of the major angles used (45, 60 and 70). Inspectors were also not utilizing the scanning levels shown in Table 6.3, AWS D1.5.

Contractor's proposal to correct the problem:

None at the time of the NCR.

Corrective action taken:

ABFJV has informed ZPMC of this non conformance. ZMPC has since procured an acceptable IIW block to perform calibrations correctly. ABFJV has reviewed the AWS D1.5 code and the ZPMC UT procedure with ZPMC UT technicians to gain an understanding of the scanning levels required.

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:**

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: Ishibashi, Josh **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**