

**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:** Zhenhua Port Machinery Company in Shanghai, China**Report No:** NCR-000028**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0027**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> 34-0006L/R
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> OBG Floor Beam
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	FB016-03, plate X7J to plate X94E, Weld Number 043

**Reference Description:****Description of Non-Conformance:**

During inspection of an OBG Floor Beam, ABF allowed ZPMC to exceed the maximum interpass welding temperature of 230° C. The actual interpass welding temperature observed and recorded by this QA Inspector was 275° C. This incident occurred on OBG Floor Beam identified as FB016-03.

**Applicable reference:**

AWS D1.5, Welding Procedure Specification WPS-B-T-2232-TC-U4B-F-1

**Who discovered the problem:** Paul Dawson, Caltrans Quality Assurance Inspector**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:** ZPMC QC Inspector Yi Ru**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

None at this time

**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:** Lowry,Patrick

SMR

**Reviewed By:** Lowry,Patrick

SMR

**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:** Zhenhua Port Machinery Company in Shanghai, China**Report No:** NCS-000056**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Jun-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0027**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> 34-0006L/R
<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:** 09-Jan-2008**Description of Non-Conformance:**

During inspection of an OBG Floor Beam, ABF allowed ZPMC to exceed the maximum interpass welding temperature of 230° C. The actual interpass welding temperature observed and recorded by this QA Inspector was 275° C. This incident occurred on OBG Floor Beam identified as FB016-03.

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

Construction decided not to forward NCR-ZPMC-0027 to the Contractor.

**Corrective action taken:**

N/A

**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 Abifhram Velasco, (858) 344-8746, who represents the Office of Structural Materials for your project.

**Inspected By:** Liu, Chengwen

Quality Assurance Inspector

**Reviewed By:** Velasco, Abifhram

QA Reviewer