

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 #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Shanghai, China**Report No:** NCR-000030**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0029**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG - Deck Mock-Up
Procedural	Procedural	Descriptor:	

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

American Bridge / Fluor (ABF) allowed ZPMC to use unqualified welding operators for the welding of OBG Deck Mock-Up closed ribs to deck plate.

Applicable reference:

AWS D1.5, Section 5.21: "Welders, welding operators, and tack welders using SMAW, SAW, GMAW, FCAW, ESW, and EGW welding processes shall be qualified by the tests described in Part B. "

Who discovered the problem: Alfredo Acuna**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:** Steve Lawton**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Unknown 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

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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-000029**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0029**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: 03-Jan-2008**Description of Non-Conformance:**

American Bridge / Fluor (ABF) allowed ZPMC to use unqualified welding operators for the welding of OBG Deck Mock-Up closed ribs to deck plate.

Contractor's proposal to correct the problem:

Contractor agreed to the following on Closed Rib Welder Qualifications

- Closed rib welders must be qualified for SAW in 1G prior to performing their first closed rib Production Monitoring Test (PMT). Macros of first PMT must be acceptable for welder to be qualified in closed rib welding.
- Personnel who performed welding on Weld Trail #2 (WT#2) and/or Deck Panel Mock-Up are considered qualified.
- Qualified welders must still perform PMTs at the beginning of each shift.

Corrective action taken:

Per conversations with the Contractor (Gang Jiao) on 14-Feb-08, the Contractor acknowledged that the Closed Rib Welder shall be qualified based on agreed criteria (confirmation email dated 14-Feb-08).

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: Liu, Chengwen

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer