

**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:** Changxing Island, Shanghai, PRC**Report No:** NCR-000047**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0046**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 L/R
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Tower-89m Mockup
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	MUSB-MA22- Skin D, Connection Plates welds

**Description of Non-Conformance:**

ABF/ZPMC accepted weld passes that were not sufficiently cleaned while welding the MUSB-MA22-Skin D connection plate attachment welds (weld numbers MUSB-MA22 B/B-13 thru 20) on the Tower 89-m mock-up.

As required by the AWS D1.5-2002 code, Section 3.2.1, "Surfaces to be welded and surfaces adjacent to a weld shall be free from loose or thick scale, slag, rust, moisture, grease and other foreign material that would prevent proper welding or produce objectionable fumes.

**Applicable reference:**

AWS D1.5-2002, Section 3.2.1

**Who discovered the problem:** John Tracy**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Joshua Ishibashi Tai-Lin Liu, Asst. Structure Representative verbally notified on 12/26/07**Time and method of notification:** 12/26/07, 1330, Verbal**QC Inspector's Name:** Ye Yong Jun**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:** Cuellar, Robert

Quality Assurance Inspector

**Reviewed By:** Wahbeh, Mazen

QA Reviewer

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 File #: xx.25A

**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**

**Location:** Changxing Island, Shanghai, PRC **Report No:** NCS-000093  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV **Date:** 24-Sep-2008  
**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0046

**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 L/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:** 26-Dec-2007

**Description of Non-Conformance:**

ABF/ZPMC accepted weld passes that were not sufficiently cleaned while welding the MUSB-MA22-Skin D connection plate attachment welds (weld numbers MUSB-MA22 B/B-13 thru 20) on the Tower 89-m mock-up. As required by the AWS D1.5-2002 code, Section 3.2.1, "Surfaces to be welded and surfaces adjacent to a weld shall be free from loose or thick scale, slag, rust, moisture, grease and other foreign material that would prevent proper welding or produce objectionable fumes.

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

None, NCR was not issued to Contractor.

**Corrective action taken:**

METS has discussed this issue with ABF/ZPMC on numerous occasions, it still appears that the Contractor is not stressing the importance of proper weld cleaning techniques with their welders and welding operators. Now that the welding of the mock-ups has completed, METS will only be able to monitor the weld cleaning techniques of the welders during production welding and readdress the issue with the Contractor if the issue continues.

**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 Joshua Ishibashi, who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	Ishibashi, Josh	Quality Assurance Inspector
<b>Reviewed By:</b>	Smith, Ryan	QA Reviewer