

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-000048**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0047**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006 L/R
Joint fit-up	Coating	Other	Component: Tower-89m Mockup
Procedural	Procedural	Descriptor:	SA215 Doubler Plate to MA38- Skin E attachment wel

Description of Non-Conformance:

ABF has allowed ZPMC to exceed the maximum inner-pass temperature, as shown on the approved Welding Procedure Specification (WPS), while welding Weld ID# MUB-MA21 B/J-1 on the Tower 89-m mock-up. This was verified using a 232-degree Centigrade Tempilstik Temperature Indicator which readily melted. A 316-degree Centigrade Tempilstik Temperature Indicator was also used, however it did not melt.

Applicable reference:

WPS-B-T-4312-TC-P4-2-SMAW, AWS D1.5-2002 and the Welding Quality Control Plan (WQCP), Section 8, Revision 0-July 2007

Who discovered the problem: John Tracy**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Joshua Ishibashi, ISMR Tai-Lin Liu, Asst. Structure Representative verbally notified**Time and method of notification:** 12/26/07, 1300, Verbal**QC Inspector's Name:** Zhang Lei**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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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000092**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0047**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006 L/R
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 20-Jan-2008**Description of Non-Conformance:**

ABF has allowed ZPMC to exceed the maximum inner-pass temperature, as shown on the approved Welding Procedure Specification (WPS), while welding Weld ID# MUB-MA21 B/J-1 on the Tower 89-m mock-up. This was verified using a 232-degree Centigrade Tempilstik Temperature Indicator which readily melted. A 316-degree Centigrade Tempilstik Temperature Indicator was also used, however it did not melt.

Contractor's proposal to correct the problem:

None, NCR not issued to the Contractor by Construction.

Corrective action taken:

METS has discussed this issue with the Contractor's Quality Control Inspector and it appears to have been an isolated incident. METS will continue to monitor and make random inspections of the inner pass temperatures during welding operations to ensure the Contractor's Quality Control Inspectors are correcting deficiencies. If this issue should become systemic, METS will elevate the issue.

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: Ishibashi, Josh

Quality Assurance Inspector

Reviewed By: Smith, Ryan

QA Reviewer