

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, China**Report No:** NCR-000060**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0058**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Tower-114 Meter Mockup
Procedural	Procedural	Descriptor:	

Description of Non-Conformance:

ABF/ZPMC QC failed to detect a "Class A" indication on complete joint penetration weld located at the skin plate A and B connection of the 114 meter tower mockup. ABF/ZPMC accepted the weld but later confirmed the presence of the indication on 02-03-2008.

Applicable reference:

AWS D1.5 (2002) Section 6 "Inspection", Tables 6.2 "Testing Angle" and 6.3 "UT Acceptance-Rejection Criteria-Tensile Stress.

Who discovered the problem: Alfredo Acuna, Quality Assurance Inspector**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Ching Chao, Structure Representative**Time and method of notification:** 2/6/08**QC Inspector's Name:** Xu Jun, ZPMC Quality Control Inspector**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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Wahbeh, Mazen

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, China**Report No:** NCS-000067**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0058**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-Feb-2008**Description of Non-Conformance:**

ABF/ZPMC QC failed to detect a "Class A" indication on complete joint penetration weld located at the skin plate A and B connection of the 114 meter tower mockup. ABF/ZPMC accepted the weld but later confirmed the presence of the indication on 02-03-2008.

Contractor's proposal to correct the problem:

ZPMC acknowledges the non conformance and will ensure that their QC department is diligent while performing UT.

Corrective action taken:

METS notified the Quality Control Inspector of the rejectable indication and on 03-FEB-08 the QC Inspector reexamined the area and also agreed the presence of the rejectable indication. METS will continue to perform random checks of this inspector and recommend remedial training if the issue becomes systemic. Additional missed indication will be documented with additional nonconformance reports.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Ching Chao, Structures Construction **Date:** 20-Feb-2008**Is Engineer's approval attached?** Yes No**Comments:**

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