

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-000092**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0090**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Tower Diaphragm 28/38 Meter
Procedural	Procedural	Descriptor:	Heat straightening with active force.

Description of Non-Conformance:

ABF has allowed ZPMC to utilize active force while heat straightening (HS) diaphragm plates observed on 19-MAR-08 and 20-MAR-08. The manner in which the ABF/ZPMC used the counter weights is not an acceptable practice and was not included as part of the ABF/ZPMC approved Distortion Control Plan or Heat Straightening Reports for the following Tower Diaphragm plates: (1) 28 Meter bottom SA270(S) ZPMC (HS) Report Number HSR1(T)-197, (2) 28 Meter top SA334(S), ZPMC (HS) Report Number HSR1(T)-197, (3) 38 Meter top SA227(S), ZPMC (HS) Report Number HSR1(T)-188.

Applicable reference:

Special Provisions, Sections, 8-3, "WELDING", and 10-1.59, "STEEL STRUCTURES"

Who discovered the problem: Sherri Brannon, Quality Assurance Inspector**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Scott Kennedy, Structure Representative**Time and method of notification:** 20-MAR-08, 1100 hours, Verbal Notification**QC Inspector's Name:** Xu Jun**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



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge/Fluor Enterprises, a JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 22-Mar-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000058

Subject: NCR No. ZPMC-0090

Reference Description: Tower Diaphragm 28/38 Meter / Heat Straightening - Active Force Applied

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved - No Response Required.

Remarks:

Material Location: Tower **Lift:** 01

Non-Conformance:

ABF has allowed ZPMC to utilize active force while heat straightening (HS) diaphragm plates observed on 19-MAR-08 and 20-MAR-08. The manner in which the ABF/ZPMC used the counter weights is not an acceptable practice and was not included as part of the ABF/ZPMC approved Distortion Control Plan or Heat Straightening Reports for the following Tower Diaphragm plates: (1) 28 Meter bottom SA270(S) ZPMC (HS) Report Number HSR1(T)-197, (2) 28 Meter top SA334(S), ZPMC (HS) Report Number HSR1(T)-197, (3) 38 Meter top SA227(S), ZPMC (HS) Report Number HSR1(T)-188.

Action Required and/or Action Taken:

Please refer to attached Non-Conformance Report for details.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0090

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe, Jason Tom

File: 05.03.06

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000058

Subject: NCR No. ZPMC-0090

Dated: 25-Aug-2008

Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000098 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been notified that heat straightening shall be in accordance with the approved Distortion Control Plan or Heat Straightening Reports

ZPMC has been notified that heat straightening shall be in accordance with the approved Distortion Control Plan or Heat Straightening Reports

Submitted by: Mackey, Kim

Attachment(s): ABF-NPR-000098R00

Caltrans' comments:

Status: AAP

Date: 02-Nov-2008

The response is acceptable, but the Non-Conformance is not closed.

Provide documentation of dimensional checks performed to identify the requirement for straightening, provide documentation of the repairs performed, and confirm that the distortion has been corrected to within acceptable dimensional tolerances. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0090 at that time.

Submitted by: Wright, Doug

Date: 02-Nov-2008

Attachment(s):

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000058

Subject: NCR No. ZPMC-0090

Dated: 15-Dec-2008

Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000098 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC requests closure of this NCR based on attached documentation.

Please see attached.

Submitted by:

Attachment(s): ABF-NPR-000098R01; docs to close this NCR

Caltrans' comments:

Status: CLO

Date: 21-Dec-2008

The proposed resolution is acceptable. The documents requested in Rev 0 of NPR-0098 have been provided. The Department concurs that Non-Conformance ZPMC-0090 is closed.

Submitted by: Wright, Doug

Date: 22-Dec-2008

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 12/12/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: CALTRANS NCR FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.T-023 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000092(ZPMC-0090).
- (3) COPY OF ABF-NPR-000098
- (4) COPY OF HSRS
- (5) COPY OF THE REPORTS OF STEEL PLATE HEAT STRAIGHTENING PROCESS CHECKING

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

PLAN HOLDER

RECEIVED 12 DEC 2008

DATE



COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. T-023

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-12-12

REGARDING: NCR-092 ZPMC-090

ZPMC received NCR-092(ZPMC-090), it mentioned that ZPMC utilized active force while heat straightening diaphragm plates. The manner in which ZPMC used the counterweights is not an acceptable practice and was not included as part of the Distortion Control Plan.

ZPMC acknowledged this problem and we had informed the worker team and QC inspectors that using active force is forbidden during the heat straightening. If necessary, ZPMC shall submit Heat Straightening Report for engineer's approval.

So here ZPMC attached AB/F NCR proposed solution ABF-NPR-000098 and the HSRs concerning this NCR. The QCR records showed the dimension was accepted after heat straightening. Therefore, ZPMC hoped Caltrans can take a review of these reports and close this NCR.

ATTACHMENT:

NCR-000092 (ZPMC-0090)

ABF-NPR-000098

28M upper diaphragm plate: HSR1(T)-0152 & 787-T-QCR-203-T129

28M lower diaphragm plate: HSR1(T)-0188 & 787-T-QCR-203-T140

38M upper diaphragm plate: HSR1(T)-0197 & 787-T-QCR-203-T126

W. J. ...

2008-12-12

Thomas W. ...
ABF QCM
15 DEC. 08



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge/Fluor Enterprises, a JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 22-Mar-2008

Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000058

Subject: NCR No. ZPMC-0090

Reference Description: Tower Diaphragm 28/38 Meter / Heat Straightening - Active Force Applied

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved - No Response Required.

Remarks:

Material Location: Tower

Lift: 01

Non-Conformance:

ABF has allowed ZPMC to utilize active force while heat straightening (HS) diaphragm plates observed on 19-MAR-08 and 20-MAR-08. The manner in which the ABF/ZPMC used the counter weights is not an acceptable practice and was not included as part of the ABF/ZPMC approved Distortion Control Plan or Heat Straightening Reports for the following Tower Diaphragm plates: (1) 28 Meter bottom SA270(S) ZPMC (HS) Report Number HSR1(T)-197, (2) 28 Meter top SA334(S), ZPMC (HS) Report Number HSR1(T)-197, (3) 38 Meter top SA227(S), ZPMC (HS) Report Number HSR1(T)-188.

Action Required and/or Action Taken:

Please refer to attached Non-Conformance Report for details.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0090

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe, Jason Tom

File: 05.03.06

02 02 15 04
05.03.06-000058.NCT

Received
NCT-000058 22 Mar 08 Page 1 of 1

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 #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.25B



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000092

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-Mar-2008

Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

NCR #: ZPMC-0090

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Tower Diaphragm 28/38 Meter
 Procedural Procedural Description: Heat straightening with active force.

Description of Non-Conformance:

ABF has allowed ZPMC to utilize active force while heat straightening (HS) diaphragm plates observed on 19-MAR-08 and 20-MAR-08. The manner in which the ABF/ZPMC used the counter weights is not an acceptable practice and was not included as part of the ABF/ZPMC approved Distortion Control Plan or Heat Straightening Reports for the following Tower Diaphragm plates: (1) 28 Meter bottom SA270(S) ZPMC (HS) Report Number HSR1(T)-197, (2) 28 Meter top SA334(S), ZPMC (HS) Report Number HSR1(T)-197, (3) 38 Meter top SA227(S), ZPMC (HS) Report Number HSR1(T)-188.

Applicable reference:

Special Provisions, Sections, 8-3, "WELDING", and 10-1.59, "STEEL STRUCTURES"

Who discovered the problem: Sherri Brannon, Quality Assurance Inspector

Name of individual from Contractor notified:

Time and method of notification:

Name of Caltrans Engineer notified: Scott Kennedy, Structure Representative

Time and method of notification: 20-MAR-08, 1100 hours, Verbal Notification

QC Inspector's Name: Xu Jun

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

None at this time.

Comments:

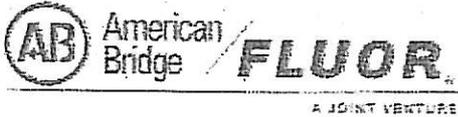
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Wahbeh, Mazen

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer



AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 23223 Oakland, CA 94623

Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Dated: 25-Aug-2008

Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Ref: 05.03.06-000058

Document No.: ABF-NPR-000098 Rev: 00

Subject: NCR No. ZPMC-0090

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been notified that heat straightening shall be in accordance with the approved Distortion Control Plan or Heat Straightening Reports

ZPMC has been notified that heat straightening shall be in accordance with the approved Distortion Control Plan or Heat Straightening Reports

Submitted by: Mackey, Kim

Attachment(s): ABF-NPR-000098R00

Caltrans' comments:

Status: AAP

Date: 02-Nov-2008

The response is acceptable, but the Non-Conformance is not closed.

Provide documentation of dimensional checks performed to identify the requirement for straightening, provide documentation of the repairs performed, and confirm that the distortion has been corrected to within acceptable dimensional tolerances. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0090 at that time.

Submitted by: Wright, Doug

Date: 02-Nov-2008

Attachment(s):





火工校正记录

Heat Straightening Record (HSR1)

报告号 Report #

HSR1(T)-0152

版本号 Revision #

0

日期 Date

2008.3.12

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:

质检代表/Quality Control Representative

部装 Sub-Assembly:

Xun Min

梁段 Girder:

The 1st lift

质检经理/Quality Assurance Manager-Approval

塔段 Tower:

28M TOP SA334(S)

Hu Gang

焊缝号 Weld No:

N/A

焊缝地图号 Weld Map No:

N/A

情况描述 Description of Condition

Cause 原因

Mill induced distortion 钢厂造成的变形

Type of Defect 缺陷类型

Mill distortion 出厂变形

Inspection Method 检查方法

Visual 目检

处置方法 Disposition

缺陷去除方法(Defect Removal Method):

Flame Straightening by natural gas

后续NDE(Post-Removal NDE):

Not required base metal only

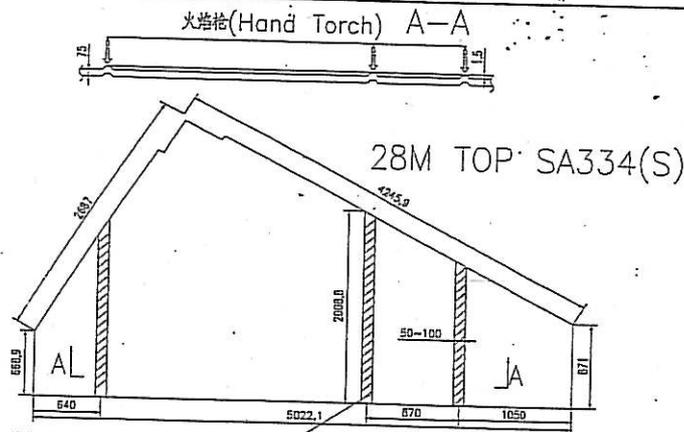
纠正措施(Corrective Action(s)):

Production material will be straightened by mechanical means

实施次数(Number of application): 2~3

最高温度(Maximum temperature): <600°C

简图 Sketch



校火区域: 此板最大变形量约1.5mm

Flame straightening area: the max deformation is about 1.5mm

纵向: 最大校火长度约2008.8mm, 宽度50~100mm

Longitudinal: the max length is about 2008.8mm, the width is 50~100mm

To be signed when Closing HSR~Verify compliance and all necessary reports are ready to attach

检验员 Inspector:	She zhi	签字 Signature:	计 攀
CWI #	07081551	Closing Date:	2008.3.21
II 级探伤 NDE Certification:	Level II	质检经理 QC Manager	Hu Gang
		审核日期 Review Date:	2008.3.26

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787--QCP-1101

Approved by Hu Gang

2008.3.12



火工校正记录

Heat Straightening Record (HSR1)

报告号 Report #

HSR1(T)-188

版本号 Revision #

0

日期 Date

2008.3.15

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:

质检代表/Quality Control Representative

部装 Sub-Assembly:

Milun

梁段 Girder:

The 1st lift

质检经理/Quality Assurance Manager-Approval

塔段 Tower:

38M TOP SA277(S)

Hu Gang

焊缝号 Weld No:

N/A

焊缝地图号 Weld Map No:

N/A

情况描述 Description of Condition

Cause原因 Mill induced distortion 钢厂造成的变形

Type of Defect缺陷类型 Mill distortion 出厂变形

Inspection Method检查方法 Visual 目检

处置方法 Disposition

缺陷去除方法(Defect Removal Method): Flame Straightening by natural gas

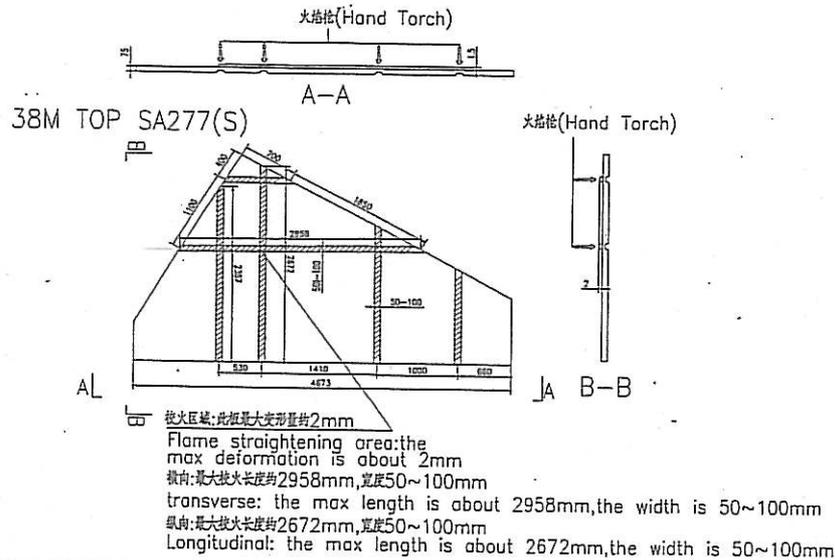
后续NDE(Post-Removal NDE): Not required base metal only

纠正措施(Corrective Action(s)): Production material will be straightened by mechanical means

实施次数(Number of application): 2~3

最高温度(Maximum temperature): <600°C

简图 Sketch



To be signed when Closing HSR-Verify compliance and all necessary reports are ready to attach

检验员 Inspector:	<i>Shu zhi</i>	签字 Signature:	<i>洪 斌</i>
CWI #	67081551	Closing Date:	2008.3.24
II 级探伤 NDE Certification:	Level II	审核日期 Review Date:	2008.4.1
质检经理 QC Manager	<i>Hu Gang</i>		

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787--QCP-1101

Approved by *Hu Gang* 2008.3.15



The report of steel plate heat straightening process checking

工程编号: 2906-787
 The serial no. of project: 2906-787
 图号: SA-277 (CS)
 The drawing no.: SA-277 (CS)
 材料: A70M-HPS-485WT-2
 Material: A70M-HPS-485WT-2
 炉批号: 07101675-N
 The heat no. of plate: 07101675-N
 材料是否平整: OK
 Material mark checking: OK
 轧制方向标注是否准确: OK
 Rolling direction checking: OK
 操作人员: 王磊
 Port name: 王磊
 日期: 28.3.17
 Date: 28.3.17

火工校正温度控制 The temperature record of heat straightening

测量点	1	2	3	4	5	6												
测量值	1335	1345	1340	1350	1533	1504	1504	1504	1504	1504	1504	1504	1504	1504	1504	1504	1504	1504
测量结果	476	518	532	540	501	535	517	523	546	513	520	524	529	529	529	529	529	529

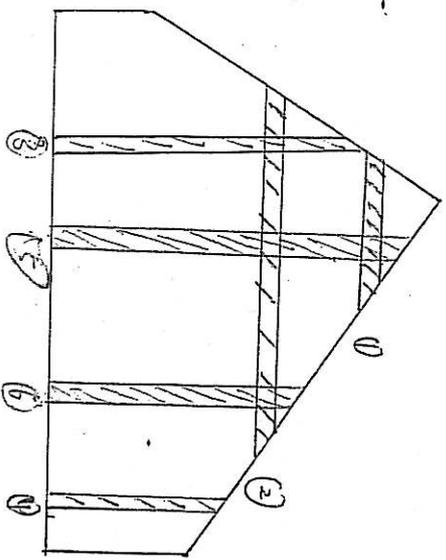
校正后平整度测量 Heatness checking after heat straightening (mm)

测量点	1	2	3	4	5	6												
测量值	0.3	0.5	0.3	0	0.5	0.3												

整体平整度/船板垂直度是否合格 ACC
 Heat straightening result: ACC
 校正人员: 王磊
 QC inspector: 王磊
 日期: 28.3.17
 Date: 28.3.17

若校正影响焊接, 请填写以下项目
 Fill the following items if the straightening affects the weld

NDT 报告编号	UT	MT	RT	NDT 校正员签字	NDT inspector:	日期	Date:
	NA	NA	NA				





美国钢桥-钢塔平整度大工校正检查记录卡

787-1-CCR 205-1140

The report of steel plate heat straightening process checking

工程编号: 图号: 材料名称:

The serial no. of project: RP06-787 The drawing no.: SA277 (5) Part name:

材质: 炉批号: 卷号名称:

Material: The heat no. of plate: Section name: 38M

移动是否准确: 轧制方向标注是否准确: 轧制方向标注是否准确:

Material mark checking: ok Rolling direction checking: ok

火工校正温度控制 The temperature record of heat straightening

检查时间	8:09	8:19	8:29	8:43	8:57	9:22	9:32	15:14	13:46	13:46
测量位置	523	509	54	507	514	537	501	512	523	498

校正前平整度测量 Flatness checking before heat straightening (mm)

测量位置										
测量结果										

校正后平整度测量 Flatness checking after heat straightening (mm)

测量位置										
测量结果										

校正平整度 / 校正垂直度是否合格: 检验员: 日期: 08.3.18

Heat straightening result: QC inspector: Date: 08.3.18

若校正影响焊缝, 请填写以下项目
Fill the following items if the straightening affects the weld

对应NDT报告编号	UT	NDT报告编号	日期
NDT report no.	MT	NDT inspector:	Date:
	RT		

zh



The report of steel plate heat straightening process checking

工程编号: 2706-787
 材料: A709-HPS-1
 规格: 8x12x1/2
 轧制是否正角: 正角
 材料平直度检查: 正角
 图号: SA270 (S)
 零件名称: 横隔板
 图批号: 07101675W
 基线名称: DSMF
 轧制方向标注是否正角: 正角
 轧制方向检查: 正角

火工校正温度控制 The temperature record of heat straightening

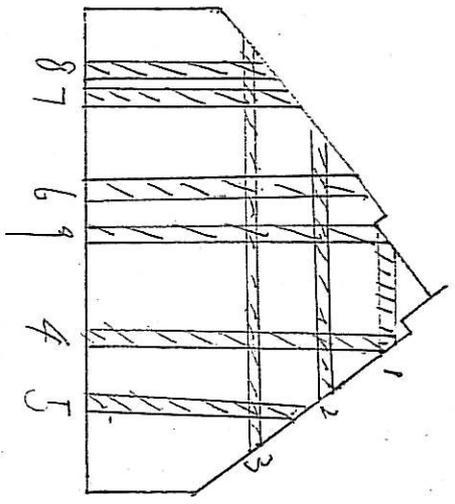
检查线	1'	2'	3'	4'	5'
测温点	14215	14225	14215	14225	14235
测温结果	495	493	501	500	532
校正前平整度测量					
平整度	1	2	3	4	5
测温点	14215	14225	14215	14225	14235
测温结果	495	493	501	500	532
校正后平整度测量					
平整度	1	2	3	4	5
测温点	14215	14225	14215	14225	14235
测温结果	495	493	501	500	532

平整度检查 after heat straightening (mm)

平整度	1	2	3	4	5	6	7	8	9
测温点	14215	14225	14215	14225	14235	14245	14255	14265	14275
测温结果	0.7	0.7	0.6	0.9	0.9	0.5	0.5	0.5	0.6

平整度/翘曲垂直度是否合格: ACC
 Heat straightening result: ACC
 校核工影响焊接, 请填写以下项目
 Fill the following items if the straightening affects the weld

NDT 报告编号: UT M/A, MT M/A, RT M/A
 NDT 检查员名字: _____
 NDT inspector: _____
 日期: 08.3.16
 Date: _____



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:** Changxing Island, Shanghai, PRC**Report No:** NCS-000131**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0090**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

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

ABF has allowed ZPMC to utilize active force while heat straightening (HS) diaphragm plates observed on 19-MAR-08 and 20-MAR-08. The manner in which the ABF/ZPMC used the counter weights is not an acceptable practice and was not included as part of the ABF/ZPMC approved Distortion Control Plan or Heat Straightening Reports for the following Tower Diaphragm plates: (1) 28 Meter bottom SA270(S) ZPMC (HS) Report Number HSR1(T)-197, (2) 28 Meter top SA334(S), ZPMC (HS) Report Number HSR1(T)-197, (3) 38 Meter top SA227(S), ZPMC (HS) Report Number HSR1(T)-188.

Contractor's proposal to correct the problem:

ZPMC has been notified that heat straightening shall be in accordance with the approved Dimensional Control Plan or Heat Straightening Reports.

Corrective action taken:

ZPMC acknowledges this problem and has informed the worker teams and QC inspectors that using active force is forbidden during heat straightening. If necessary, ZPMC will submit a heat straightening report for engineer's approval. ZPMC has submitted HSRs indicating that the diaphragms have acceptable dimensions post heat straightening and the diaphragms have been green tagged.

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 Serge Sinevod, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Reviewed By: Sinevod,Serge

QA Reviewer