

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



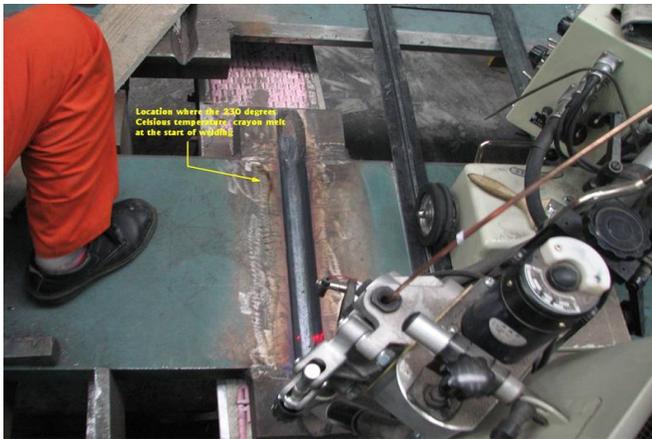
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000141**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0134**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Tower South Lift 1, Skin A Stiffener Plate
Procedural	Procedural	Descriptor: Subassembly SA-15	

Reference Description: Longitudinal Stiffener Skin A Butt Weld**Description of Non-Conformance:**

ZPMC was observed performing Submerged Arc Welding (SAW) at the stiffener complete joint penetration (CJP) butt joint # SSD1-SA-15-A/F-15A with an interpass temperature that exceeds the maximum interpass temperature allowed by AWS D1.5 (2002) of 230° C.

**Applicable reference:**

AWS 1.5 (2002), Section 4.2.2

Who discovered the problem: Alfredo Acuna, Quality Assurance Inspector**Name of individual from Contractor notified:** Chung Keung Chan, ABF Quality Control Inspector**Time and method of notification:** 5/28/08, 1045, Verbal**Name of Caltrans Engineer notified:** Scott Kennedy**Time and method of notification:** 5/29/08, 1500, Verbal**QC Inspector's Name:****Was QC Inspector aware of the problem:**

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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	SMR
Reviewed By:	Wahbeh,Mazen	SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 11-Jun-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: 05.03.06-000116

Subject: NCR No. ZPMC-0134

Reference Description: Longitudinal Stiffener Skin A Butt Weld

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.

Material Location: Tower **Lift:** 01

Remarks:

ZPMC was observed performing Submerged Arc Welding (SAW) at the stiffener complete joint penetration(CJP) butt joint # SSD1-SA-15-A/F-15A with an interpass temperature that exceeds the maximum interpass temperature allowed by AWS D1.5 (2002) of 230° C.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences and provide documentation of the corrective measures taken.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0134

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000116

Subject: NCR No. ZPMC-0134

Dated: 18-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000068 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC acknowledges that this inter-pass temperature was too high and has instructed the CWI performing the weld monitoring of this issue.

Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000068R00;

Caltrans' comments:

Status: CLO

Date: 22-Aug-2008

Quality Control inspectors have been instructed to monitor interpass temperature more closely, and the weld in question has since been tested using visual, magnetic particle and ultrasonic testing and found to be acceptable. The Department concurs that Non-Conformance ZPMC-0134 is closed.

Submitted by: Wright, Doug

Attachment(s):

Date: 22-Aug-2008

DEPARTMENT OF TRANSPORTATION

CHINA FABRICATION TEAM
506 Shangcheng Rd., Pudong New District
Shanghai 200120, PRC



REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Dave Williams, American Bridge – Fluor, a Joint Venture
Gary Pursell, Resident Engineer

Review Date: 07/28/2008

From: Joshua Ishibashi, Structural Materials Representative

Contract No.: 04-0120F4

Date/Time Submittal Received: 07/25/2008/ 1300

China Standard Time
(GMT+08:00)

Contractor's Transmittal #: TL-08-1567 Rev. # 0

<input checked="" type="checkbox"/>	substantially complies with contract requirements and is approved		
<input type="checkbox"/>	substantially complies with contract requirements and is approved as noted.		
<input type="checkbox"/>	Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmital		
Verbal Notification	<input checked="" type="checkbox"/> No	<input type="checkbox"/> Yes	Date: _____ Time: _____
Name of individual from Contractor Notified: _____			
This submittal is a:	<input type="checkbox"/> Welding Report	<input type="checkbox"/> Critical Weld Repair	
	<input type="checkbox"/> Request for Information	<input type="checkbox"/> Heat Straightening Request	
	<input type="checkbox"/> Fabrication Procedures	<input checked="" type="checkbox"/> Other: NCR Resolution	
Submitting Contractor: <u>ZPMC</u>			
ITEMS REVIEWED	COMPLIES		COMMENTS
1. Serial Letter ABF-SL-08-0133	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	ZPMC NCR Resolution #ZPMC-0134
2.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
3.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	

Remarks: METS recommends that ABF-TRN-TL-08-1567 be accepted. Testing of the weld after it was completed using visual, magnetic particle and ultrasonic testing showed that there were no defects in the weld.

JJI

Reviewer: Joshua Ishibashi

Date: 07/28/2008

Construction Concurrence: Initials DLW Date 2008-07-28

Received by (ABFJV): [Signature] Date 7/28/08 Time 1350

<input checked="" type="checkbox"/> APPROVED
<input type="checkbox"/> APPROVED AS NOTED
<input type="checkbox"/> RETURNED FOR CORRECTION
Pursuant to Section 5-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION
Division of Engineering Service
Office of Structure Construction
<u>DLW for PM</u>
Structure Representative
Date <u>7/28/08</u>

25 July 2008

Reply to: SL-ABF-08-0133

Attention: Gary Pursell

Reference: San Francisco Oakland Bay SAS Bridge Superstructure
Caltrans Contract No. 04-0120F4
ABF Job No. 660110

Subject: NCR# ZPMC-0134

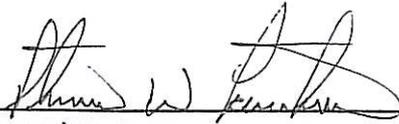
Mr. Pursell:

This letter is issued to provide formal response addressing the proposed resolution to NCR # ZPMC-0134.

ZPMC was observed performing Submerged Arc Welding (SAW) at the stiffener complete joint penetration (CJP) butt joint #SSD1-SA-15-A/F-15A with an interpass temperature that exceeds the maximum interpass temperature allowed by AWS D1.5 (2002) of 230° C.

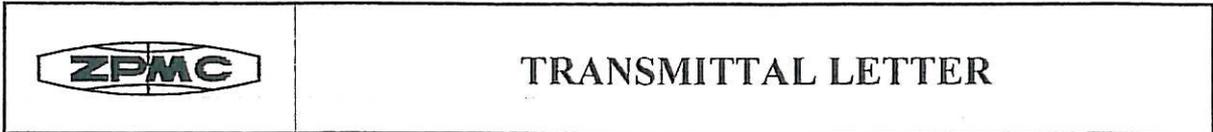
ZPMC acknowledges that this inter-pass temperature was too high and has instructed the CWI performing the weld monitoring of this issue. The weld was subsequently VT, MT and UT inspected with acceptable results.

If further clarifications are needed, please contact me.



Steve Lawton
Foreign Quality Assurance Manager
American Bridge Fluor Joint Venture

<input checked="" type="checkbox"/>	APPROVED
<input type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION	
Division of Engineering Service	
Office of Structure Construction	
<i>DW</i>	<i>7/28/08</i>
Structure Representative	Date



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 07/09/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000141(ZPMC-0134)FOR CLOSURE

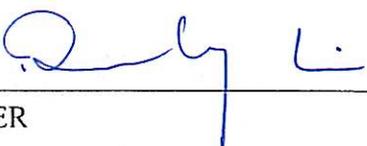
SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.T-015FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000141(ZPMC-0134).
- (3) COPY OF UT REPORT T787-UT-170 AND MT REPORT T787-MT-230

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



 PLAN HOLDER

RECEIVED 09 JUL 2008
 (42)

 DATE



 COMPANY

 PHONE NO.

PLAN NUMBER: N/A
 #R787-QCP-102

<input checked="" type="checkbox"/>	APPROVED
<input type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION	
Division of Engineering Service	
Office of Structure Construction	
<i>DW</i>	<i>7/68/08</i>
Structure Representative	Date



No. T-015

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-7-9

REGARDING: NCR-000141 (ZPMC-0134)

ZPMC received Caltran's NCR-000141 on 8-July-2008, it mentioned ZPMC was observed performing SAW at the stiffener complete joint penetration butt joint SSD1-SA15 A/F-15A with an inter-pass temperature that exceeds the maximum inter-pass temperature allowed by AWS D1.5(2002) of 230°C.

ZPMC acknowledged this inter-pass temperature issue, and had reminded the site QC personnel not to ease the mind on the temperature checking during the welding. As ZPMC got this NCR after the completion of the part's NDT, the result showed the inter-pass temperature issue did not influence the weld quality. Here the UT report and the MT report for this weld are attached to let CT review.

So ZPMC requests Caltrans can close NCR-000141 basing on the attached documents.

ATTACHMENT:

NCR-000141 (ZPMC-0134)

T787-UT-170

T787-MT-230

Xijun

2008-7-9

<input checked="" type="checkbox"/> APPROVED	
<input type="checkbox"/> APPROVED AS NOTED	
<input type="checkbox"/> RETURNED FOR CORRECTION	
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION	
Division of Engineering Service	
Office of Structure Construction	
<i>DLW RSK KM</i>	<i>7/28/08</i>
Structure Representative	Date



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

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
 375 BURMA ROAD
 OAKLAND CA 95607

Date: 11-Jun-2008

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

Dear: Mr. Charles Kanapicki
 Attention: Mr. Dave Williams Consultant
 Subject: NCR No. ZPMC-0134

Job Name: SAS Superstructure
 Document No: 05.03.06-000116

Reference Description: Longitudinal Stiffener Skin A Butt Weld

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.

Material Location: Tower

Lift: 01

Remarks:

ZPMC was observed performing Submerged Arc Welding (SAW) at the stiffener complete joint penetration(CJP) butt joint # SSD1-SA-15-A/F-15A with an interpass temperature that exceeds the maximum interpass temperature allowed by AWS D1.5 (2002) of 230° C.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences and provide documentation of the corrective measures taken.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0134

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

File: 05.03.06

05.03.06-000116,NCT

APPROVED
 APPROVED AS NOTED
 RETURNED FOR CORRECTION
 Pursuant to Section 5-1.02
 of the Standard Specifications
 State of California
 DEPARTMENT OF TRANSPORTATION
 Division of Engineering Service
 Office of Structure Construction
 DLW PER RM 7/28/08
 Structure Representative 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 #: 04-0120F4
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-000141

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-May-2008

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

NCR #: ZPMC-0134

Type of problem:

Welding **Concrete** **Other**

Welding **Curing** **Procedural**

Bridge No: 34-0006

Joint fit-up **Coating** **Other**

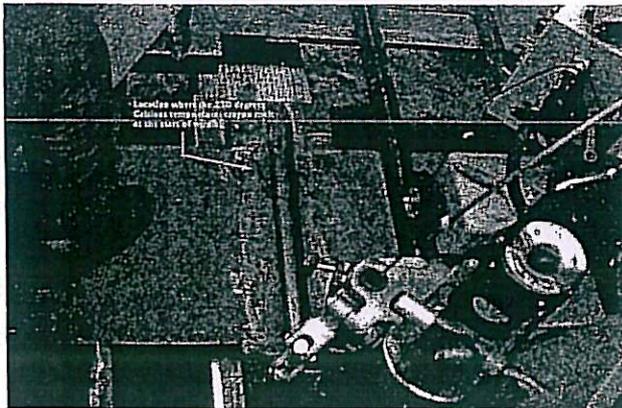
Component: Tower South Lift 1, Skin A Stiffener Plate

Procedural **Procedural** **Descriptor:** Subassembly SA-15

Reference Description: Longitudinal Stiffener Skin A Butt Weld

Description of Non-Conformance:

ZPMC was observed performing Submerged Arc Welding (SAW) at the stiffener complete joint penetration (CJP) butt joint # SSD1-SA-15-A/F-15A with an interpass temperature that exceeds the maximum interpass temperature allowed by AWS D1.5 (2002) of 230° C.



Applicable reference:

AWS 1.5 (2002), Section 4.2.2

Who discovered the problem: Alfredo Acuna, Quality Assurance Inspector

Name of individual from Contractor notified: Chung Keung Chan, ABF Quality Control Inspector

Time and method of notification: 5/28/08, 1045, Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 5/29/08, 1500, Verbal

QC Inspector's Name:

Was QC Inspector aware of the problem:

<input checked="" type="checkbox"/>	APPROVED
<input type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02	
of the Standard Specifications	
State of California	
DEPARTMENT OF TRANSPORTATION	
Division of Engineering Service	
Office of Structure Construction	
<i>DW</i>	<i>7/9/08</i>
Structure Representative	Date

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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	SMR
Reviewed By:	Wahbeh,Mazen	SMR

<input checked="" type="checkbox"/> APPROVED
<input type="checkbox"/> APPROVED AS NOTED
<input type="checkbox"/> RETURNED FOR CORRECTION
Pursuant to Section 5-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION
Division of Engineering Service
Office of Structure Construction
<i>D.W. H. K. M. 7/18/00</i>
Structure Representative



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO.报告编号 T787-UT-170

DATE 2008.06.10

PAGE 1 OF 2

Revision No: 0

PROJECT NO.:工程编号 ZP06-787

CONTRACTOR: CALTRANS

ITEMS NAME: FIRST LIFTING LONGITUDINAL OF
部件名称 SKIN A

DRAWINGNO.: SSD1-SA159F/J+
图号 SSD1-SA15A/F

CALTRANS CONTRACT NO.: 04-0120F4
加州工程编号

REFERENCING CODE 参考规范
AWS D1.5-2002

ACCEPTANCE STANDARD 接受标准
AWS D1.5-2002(Table 6.3)

PROCEDURE NO. 程序编号
ZPQC-UT-01

WELDING PROCESS 焊接方法
SAW+FCAW

JOINT TYPE 焊缝类型
BUTT

CALIBRATION DUE DATE 仪器校正有效期
DEC. 28ST, 2008

EQUIPMENT 设备
UT SCOPE

MANUFACTURER 制造商
PANAMETRICS

MODEL NO. 样式编号
EPOCH-4B

SERIAL NO. 序列编号
071565311,061488510,
061495811, 070152011,

CALIBRATION BLOCK 试块
AWS IIV BLOCK TYPE II

COUPLANT 耦合剂
C.M.C

MATERIAL/THICKNESS 材料厚度
A709M-345T2-Z / 65/75mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70 °	2.5 MHz	18*18 mm	Changchao	45 °	2.5 MHz	18*18 mm
Changchao	0 °	2.5 MHz	20 mm	Reference Level 参考灵敏度			20dB

Base metal inspected per AWS D1.5-2002 Section 6.19.5

0 ° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY						
									不连续位置(mm)						
a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y							
SSD1-SA15A/F-15A/15B		69.2				34								ACC.	
		44.7				32								ACC.	
SSD1-SA159F/J-23A/23B		69.2				34								ACC.	
		44.7				32								ACC.	
SSD1-SA159F/J-24A/24B		69.2				34								ACC.	
		44.7				32								ACC.	
SSD1-SA159F/J-7A/7B		69.2				34								ACC.	

APPROVED
APPROVED AS NOTED
RETURNED FOR CORRECTION
Pursuant to Section 5-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION
Division of Engineering Service
Office of Structure Construction
D. Liu
Date 7/23/08

EXAMINED BY 主探

REVIEWED BY 审核:

LEVEL-II SIGN /

DATE 2008.6.10

LEVEL-II SIGN /

DATE

质量经理 / QCM

用户CUSTOMER

签字 SIGN / 日期 DATE

签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-230		DATE日期 2008.06.11	PAGE OF页码 1/1	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: SSD1-SA159F/J;SSD1-SA15A/F FIRST LIFTING LONGITUDINAL SKIN A		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4		
REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28, 2008	
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617	
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC	
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm	
MATERIAL TO BE EXAMINED 检测材料	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2-Z 75/65mm	
WELDING PROCESS 焊接方法	SAW	TYPE OF JOINT 焊缝类型	BUTT	

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
SSD1-SA15A/F-15A				ACC.		
SSD1-SA15A/F-15B						*
SSD1-SA159F/J-22A				ACC.		
SSD1-SA159F/J-22B						*

*SSD1-SA15A/F-15A ; SSD1-SA159F/J-22A were MT inspection and ACC, which is the result of required 25% MT.
 *SSD1-SA15A/F-15A ; SSD1-SA159F/J-22A焊缝经MT抽检合格, 且累积检测长度已经达到了此批要求的25%检测长度。

BLANK

APPROVED
 APPROVED AS NOTED
 RETURNED FOR CORRECTION
 Pursuant to Section 5-1.02
 of the Standard Specifications
 State of California

DEPARTMENT OF TRANSPORTATION
 Division of Engineering Service
 Office of Structure Construction

DW for RM 7/22/08
 Structure Representative Date

EXAMINED BY主探 <u>Cai Xinxin</u> LEVEL - II SIGN 签名 / DATE日期 2008.06.11	REVIEWED BY 审核 <u>Wang Wei</u> LEVEL - II SIGN / DATE日期 2008.06.11
质量经理 / QCM <u>Hu Kang</u> 2008.6.17 签字 SIGN / 日期 DATE	用户CUSTOMER _____ 签字 SIGN / 日期 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-000057**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0134**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: 28-May-2008**Description of Non-Conformance:**

ZPMC was observed performing Submerged Arc Welding (SAW) at the stiffener complete joint penetration (CJP) butt joint # SSD1-SA-15-A/F-15A with an interpass temperature that exceeds the maximum interpass temperature allowed by AWS D1.5 (2002) of 230 degrees Celsius.

Contractor's proposal to correct the problem:

ZPMC has notified the CWI of this deficiency and will conduct non destructive testing to verify the soundness of the weld.

Corrective action taken:

ZPMC has reminded their Quality Control inspectors to monitor interpass temperature and the weld in question has since been tested using visual, magnetic particle and ultrasonic testing and found to be acceptable.

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 (011-86-1376-471-0411), who represents the Office of Structural Materials for your project.

Inspected By: Ishibashi, Josh

Quality Assurance Inspector

Reviewed By: Ishibashi, Josh

QA Reviewer