

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



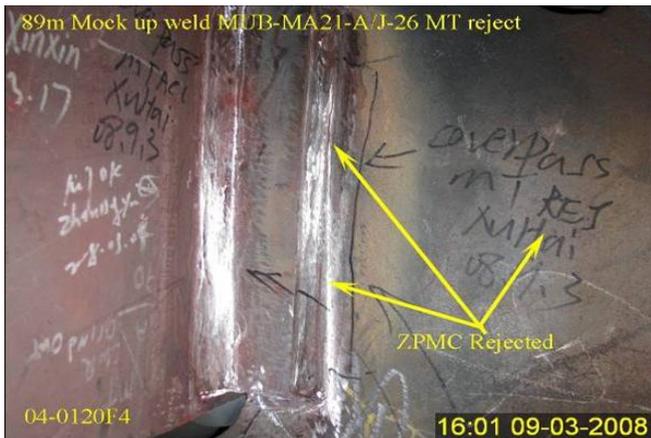
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000195**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0176**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 89m Fit Lug Partial Mock-up
Procedural	Procedural	Descriptor: 89m Partial Mock-up	

Reference Description: 04-0120F4 Special Provisions, AWS D1.5 2002**Description of Non-Conformance:**

ABF/ZPMC welded the 89m Partial mock-up fit lug to diaphragm connection (MUB-MA21-A/J-26) on 09/02/08 and performed the MT inspection 24 hours after completion welding on 09/03/08. During the MT inspection a 250 mm crack was discovered. Weld cracks, as defined by AWS D1.5, are considered unsatisfactory is not in conformance according to Special Provisions, Section 10-1.59, "Fabrication/Erection Procedure and Mock-Ups", Page 313, paragraph B.1. and AWS D1.5 sec. 6.26.1.1.

**Applicable reference:**

Special Provisions, Section 10-1.59, "Fabrication/Erection Procedure and Mock-Ups", Page 313, paragraph B.1. and AWS D1.5 sec. 6.26.1.1.

Who discovered the problem: Ken Riley, Quality Assurance Inspector**Name of individual from Contractor notified:** Yang Yiheng**Time and method of notification:** 09/03/2008; 1430; Present at time of incident**Name of Caltrans Engineer notified:** Scott Kennedy, Structures Construction

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 09/04/2008; 0700; Verbal

QC Inspector's Name: Zhu Zhong Hai

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

Inspected By:	Ishibashi,Josh	SMR
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Reviewed By:	Smith,Ryan	SMR
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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-000094**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0176**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: 04-Sep-2008**Description of Non-Conformance:**

ABF/ZPMC welded the 89m Partial mock-up fit lug to diaphragm connection (MUB-MA21-A/J-26) on 09/02/08 and performed the MT inspection 24 hours after completion welding on 09/03/08. During the MT inspection a 250 mm crack was discovered. Weld cracks, as defined by AWS D1.5, are considered unsatisfactory is not in conformance according to Special Provisions, Section 10-1.59, "Fabrication/Erection Procedure and Mock-Ups", Page 313, paragraph B.1. and AWS D1.5 sec. 6.26.1.1.

Contractor's proposal to correct the problem:

ABF has rejected this fit lug weld and concurs with the Department that it is unacceptable.

Corrective action taken:

None required, ABF has rejected the cracked fit lug.

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