

**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-000209

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 20-Oct-2008

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

**NCR #:** ZPMC-0186

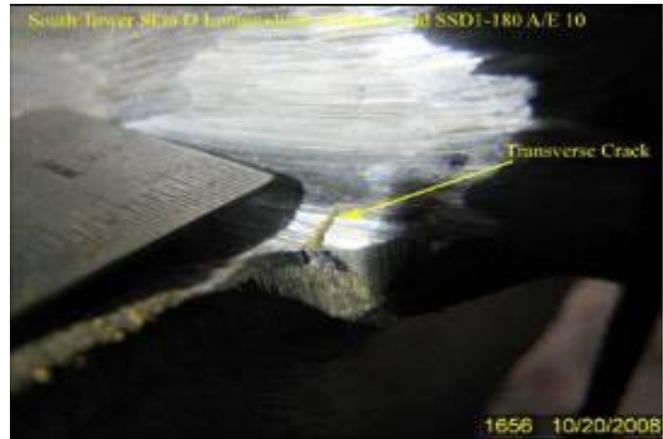
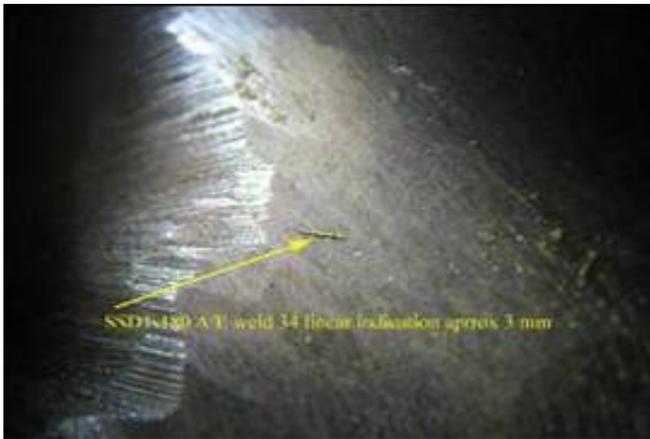
### Type of problem:

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> South Tower, Skin D
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b> Stiffener to Skin Welds	

**Reference Description:** AWS D1.5 2002

### Description of Non-Conformance:

ZPMC QC Inspectors accepted Partial Joint Penetration welds SSD1-SA180 A/E 10, 11 and 34 with linear indications (transverse and horizontal) on the South Tower Skin D longitudinal stiffener to skin welds. ZPMC QC Inspectors accepted the above mentioned welds on 10/20/08.



### Applicable reference:

AWS D1.5 2002, Section 6.5.4, "The Inspector shall, at suitable intervals, observe the joint preparation, assembly practice, welding techniques, and performance of each welder, welding operator, and tack welder to make certain that applicable requirements of this code are met...." and Section 6.26.1 "All welds shall be visually inspected. A weld shall be acceptable by visual inspection if it conforms to the following requirements:

6.26.1.1 The weld shall have no cracks.

**Who discovered the problem:** Larry Viars, Quality Assurance Inspector

**Name of individual from Contractor notified:** Mike Williams

---

---

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

---

---

**Time and method of notification:** 10/20/08; Verbal 1900

**Name of Caltrans Engineer notified:** Jun Xu

**Time and method of notification:** 10/23/08;0900;Verbal

**QC Inspector's Name:** Lay Tao

**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 Ryan Smith, who represents the Office of Structural Materials for your project.

---

---

<b>Inspected By:</b>	Ishibashi,Josh	SMR
----------------------	----------------	-----

<b>Reviewed By:</b>	Smith,Ryan	SMR
---------------------	------------	-----

---

---

**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-000382**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0186**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

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

ZPMC QC Inspectors accepted Partial Joint Penetration welds SSD1-SA180 A/E 10, 11 and 34 with linear indications (transverse and horizontal) on the South Tower Skin D longitudinal stiffener to skin welds. ZPMC QC Inspectors accepted the above mentioned welds on 10/20/08.

**Contractor's proposal to correct the problem:**

Repair affected welds.

**Corrective action taken:**

Affected welds have been repaired, verified by QA, and 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, 139-1686-1597, who represents the Office of Structural Materials for your project.

**Inspected By:** Sinevod, Serge

Quality Assurance Inspector

**Reviewed By:** Wahbeh, Mazen

QA Reviewer