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, P.R. China **Report No:** NCR-000242
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 13-Mar-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0216

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☑	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:** Segment 3AE Corner Assembly
Procedural	☐	**Procedural**	☐	**Description:**		

Reference Description: QC failed to recognize linear indications by MT

Description of Non-Conformance:

On March 10, 2009, ZPMC Quality Control (QC) representative Mr. Wang Lu notified Caltrans Quality Assurance (QA) inspector of the re-inspection of the corner assembly components by Magnetic Particle Testing (MT) of the linear indications discovered by QA inspectors on Segment 3AE Green Tag #8. Caltrans QA performed MT the second time on the following corner assembly welds: CSD4-PP22-069, CSD4-PP22-071, CSD4-PP22-073 and CSD4-PP22-134. Caltrans QA Inspector discovered additional linear indications ranging from 10 to 25mm long.

Applicable reference:

AWS D1.5 (02) Section 6.26.2 – "Welds that are subject to MT in addition to visual inspection shall have no cracks."

Who discovered the problem: Rodney Patterson
Name of individual from Contractor notified: Man Kit Li
Time and method of notification: 03/11/09, 1600 hours, In person

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 03/11/09, 1830 hours, In person

QC Inspector's Name: Li Yan Hua

Was QC Inspector aware of the problem: ☐ **Yes** ☑ **No**

Contractor's proposal to correct the problem:

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 Eric Tsang, +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang,Eric	SMR
Reviewed By:	Wahbeh,Mazen	SMR

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To:	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	**Date:**	06-Apr-2009
		Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Dear:	Mr. Charles Kanapicki	**Job Name:**	SAS Superstructure
Attention:	Mr. Thomas Nilsson Project Manager - OBG	**Document No:**	05.03.06-000208
Subject:	NCR No. ZPMC-0216		

Reference Description: QC failed to recognize linear indications by MT

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: OBG **Lift:**

Remarks:

On March 10, 2009, ZPMC Quality Control (QC) representative Mr. Wang Lu notified Caltrans Quality Assurance (QA) inspector of the re-inspection of the corner assembly components by Magnetic Particle Testing (MT) of the linear indications discovered by QA inspectors on Segment 3AE Green Tag #8. Caltrans QA performed MT the second time on the following corner assembly welds: CSD4-PP22-069, CSD4-PP22-071, CSD4-PP22-073 and CSD4-PP22-134. Caltrans QA Inspector discovered additional linear indications ranging from 10 to 25mm long.

Action Required and/or Action Taken:

A response for the resolution of this issue is expected within 14 days.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0216

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, Ching Chao

File: 05.03.06

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000208

Subject: NCR No. ZPMC-0216

Dated: **18-May-2009**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000210 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has generated an internal NCR for this nonconformance, repaired and re-inspected the welds as required. ZPMC requests this NCR be closed.

ZPMC has generated an internal NCR for this nonconformance, repaired and re-inspected the welds as required. Attached is documentation of work performed regarding this NCR. ZPMC requests this NCR be closed.

Submitted by:

Attachment(s): ABF-NPR-000210R00;

Caltrans' comments:

Status: CLO

Date: 03-Jun-2009

The proposed resolution is acceptable. An internal ZPMC NCR was written, and the welds in question have been accepted by MT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0216 is closed.

Submitted by: Wright, Doug

Date: 03-Jun-2009

Attachment(s):

ZPMC

No. B-341

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-5-7

REGARDING: NCR-000242/000237/000238（ZPMC-0216/0211/0212）

With this letter of response, ZPMC requests closure for caltrans' **NCR-000242/000237/000238（ZPMC-0216/0211/0212）**. we have instructed our NDT operators with the requirement of AWS，especially for the checks and calibration of equipment, and as the additional we add up the some weld NDT inspection to 100 percent, but we have to point out that some of the indication in the NCR description did not in the random of the ZPMC's inspection areas.

We have done the new inspection for all of the indication areas until not any defects was been founded.

Basic on the attached documentation we apply to close the caltrans's **NCR-000242/000237/000238（ZPMC-0216/0211/0212）**,all of the final NDT report should be proved the good quality for the corresponding welds.

Please check the attached documentation for acceptance and close the **NCR-000242/000237/000238（ZPMC-0216/0211/0212）.**

ATTACHMENT:
ZPMC internal NCR
NCR-000242/000237/000238（ZPMC-0216/0211/0212）
The final complete VT/MT/UT inspection report
The reports for the weld repair

Liujiankuo 5/15/09

Nonconformance Report
不符合项报告

Project Name: S.F.O.B.B 项目名称: 美国加州海湾大桥	NCR Number: ZPMC-0216 NCR 编号: NCR-B-139 (NCR-00242)
Item: MT indications 名称描述: MT 漏检 / Item Number: 件号:	Drawing: 图号:3AE
Location: 位置: 3AE	Date: 日期: 2009-04-15

Description of Nonconformance:

On March 10,2009,ZPMC Quality Control representative Mr. Wang Lu notified Caltrans Quality Assurance inspector of the re-inspection of the corner assembly components by Magnetic Particle Testing of the linear indications discovered by QA inspectors on Segment 3AE Green Tag #8.Caltrans QA performed MT the second time on the following corner assembly welds:CSD4-PP22-069,CSD4-PP22-071,CSD4-PP22-073 andCSD4-PP22-134.Caltrans QA Inspector discovered additional linear indications ranging from 10 to 25 mm long.

3.10 号 ZPMC 通知加州检验员对 3AE TAG#8 中角单元处做 MT 后再次发现裂纹，加州 QA 在第二次做 MT 发现以下焊缝有裂纹：CSD4-PP22-069,CSD4-PP22-071,CSD4-PP22-073 和 CSD4-PP22-134，长度在 10~25 mm 不等。

Work By: 施工方: 2009.4.14 Prepared by: 准备: 2009.4.15 Reviewed by QCE: 质量工程师批准:

☐ Drawing Error 图纸错误 ☐ Material Defect 材料缺陷 ☐ Fabrication Error 制作错误 ■ Other 其他原因

Disposition: 处理措施: ☐ Use as is 回用 ☐ Repair 返修 ☐ Reject 拒收

扩大比例检测，对有裂纹的地方进行返修.

Enlarge inspection rate, and repair the crack area.

Recommendation:
建议:

加强NDT人员培训，降低检测速度.

Train NDT personel and redue inspection speed.

Prepared by: 准备 2009.04.14

Approved by QCA: 质量经理批准 4.17

Reason for Nonconformance:

不符合原因:

1. NDT人员漏检,

2 角单元焊接后未进行检测,

1. NDT personel didn't inspect transverse linear indication.

2. Didn't inspect after fixing corner assembly.

Prevention of Re-occurrence:

预防措施:

加强NDT人员业务培训,严格控制MT检测时机,保证在焊缝完全完工后再检测。

Train NDT personel and controling inspect time. it should be inspection after finishing fixing welds.

Approved by/批准: _____ 2024.04.24

Technical Justification for Use-As-Is/Repair: ☐ **Attachment** 附件 ☐ **Non-attachment** 无附件

回用或返修的技术依据:

Reviewed /批准: _____

Verification: ☐ **Acceptable** 可接受 ☐ **Unacceptable** 不可接受

确认:

Verified by QCI/质检确认: _____ **Reviewed by QCA/质检主任审核:** _____

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To:	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	**Date:**	06-Apr-2009
		Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Dear:	Mr. Charles Kanapicki	**Job Name:**	SAS Superstructure
Attention:	Mr. Thomas Nilsson Project Manager - OBG	**Document No:**	05.03.06-000208
Subject:	NCR No. ZPMC-0216		

Reference Description: QC failed to recognize linear indications by MT

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- ☑ Recurring QC issue that constitutes a systematic problem in quality control.
- ☐ Non-Conformance Resolved.

Material Location: OBG **Lift:**

Remarks:

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Action Required and/or Action Taken:

A response for the resolution of this issue is expected within 14 days.

Transmitted by: Stanley Ku Sr. Bridge Engineer
Attachments: ZPMC-0216

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, Ching Chao
File: 05.03.06

DEPARTMENT OF TRANSPORTATION
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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, P.R. China **Report No:** NCR-000242
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 13-Mar-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0216

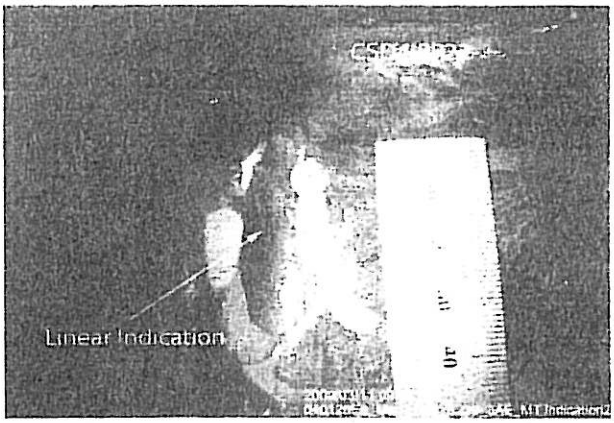
Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☑	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:** Segment 3AE Corner Assembly
Procedural	☐	**Procedural**	☐	**Description:**		

Reference Description: QC failed to recognize linear indications by MT

Description of Non-Conformance:

On March 10, 2009, ZPMC Quality Control (QC) representative Mr. Wang Lu notified Caltrans Quality Assurance (QA) inspector of the re-inspection of the corner assembly components by Magnetic Particle Testing (MT) of the linear indications discovered by QA inspectors on Segment 3AE Green Tag #8. Caltrans QA performed MT the second time on the following corner assembly welds: CSD4-PP22-069, CSD4-PP22-071, CSD4-PP22-073 and CSD4-PP22-134. Caltrans QA Inspector discovered additional linear indications ranging from 10 to 25mm long.



Applicable reference:

AWS D1.5 (02) Section 6.26.2 – "Welds that are subject to MT in addition to visual inspection shall have no cracks."

Who discovered the problem: Rodney Patterson

Name of individual from Contractor notified: Man Kit Li

Time and method of notification: 03/11/09, 1600 hours, In person

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 03/11/09, 1830 hours, In person
QC Inspector's Name: Li Yan Hua
Was QC Inspector aware of the problem: ☐ Yes ☑ No
Contractor's proposal to correct the problem:

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 Eric Tsang, +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang,Eric	SMR
Reviewed By:	Wahbeh,Mazen	SMR

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-8107	DATE日期 2009.03.10	PAGE OF页码 1/5	Revision No: 0

PROJECT NO. 工程编号:	ZP06-787	CONTRACTOR: 用 户:	CALTRANS
DRAWING NO. 图号:	CA002 OBG PLATE PANEL SPLICE	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. 28ST ,2009
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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	√ WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2-X/A709M-345F2-X 18/20/22/24/28/32/36 mm
WELDING PROCESS 焊接方法	FCAW,SMAW	TYPE OF JOINT 焊缝类型	T-JOINT

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			
CSD4-PP022-130				ACC.		100%MT
CSD4-PP022-131				ACC.		100%MT
CSD4-PP022-132				ACC.		100%MT
CSD4-PP022-133				ACC.		100%MT
CSD4-PP022-134				ACC.		100%MT
CSD4-PP022-068				ACC.		100%MT
CSD4-PP022-069				ACC.		100%MT
CSD4-PP022-070				ACC.		100%MT
CSD4-PP022-071				ACC.		100%MT
CSD4-PP022-072				ACC.		100%MT
CSD4-PP022-073				ACC.		100%MT
CSD4-PP022-074				ACC.		100%MT
CSD4-PP022-087				ACC.		100%MT
CSD4-PP022-088				ACC.		100%MT
CSD4-PP022-135				ACC.		100%MT

EXAMINED BY主探 LEVEL - II SIGN 签名 / DATE日期 2009.3.10	REVIEWED BY 审核 Cai Xinxin LEVEL-II SIGN / DATE日期 09.03.10
质量经理 / QCM Hugh 2009.03.16 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-8107	DATE日期 2009.03.10	PAGE OF页码 2/5	Revision No: 0

PROJECT NO. 工程编号:	ZP06-787	CONTRACTOR: 用 户:	CALTRANS
DRAWING NO. 图号:	CA002 OBG PLATE PANEL SPLICE	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. 28ST ,2009
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
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	√ WELDING 焊接件 ☐ CASTING 铸件 ☐ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2-X/A709M-345F2-X 18/20/22/24/28/32/36 mm
WELDING PROCESS 焊接方法	FCAW,SMAW	TYPE OF JOINT 焊缝类型	T-JOINT

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			
CSD4-PP022-136				ACC.		100%MT
CSD4-PP022-091				ACC.		100%MT
CSD4-PP022-092				ACC.		100%MT
CSD4-PP022-137				ACC.		100%MT
CSD4-PP022-138				ACC.		100%MT
CSD4-PP022-108				ACC.		100%MT
CSD4-PP022-109				ACC.		100%MT
CSD4-PP022-139				ACC.		100%MT
CSD4-PP022-140				ACC.		100%MT
CSD4-PP022-110				ACC.		100%MT
CSD4-PP022-111				ACC.		100%MT
CSD4-PP022-141				ACC.		100%MT
CSD4-PP022-142				ACC.		100%MT
CSD4-PP022-112				ACC.		100%MT
CSD4-PP022-113				ACC.		100%MT
CSD4-PP022-143				ACC.		100%MT

EXAMINED BY主探 [signature] LEVEL - II SIGN 签名 / DATE日期 2009.3.10	REVIEWED BY 审核 Cai Xinxin LEVEL-II SIGN / DATE日期 09.03.10
质量经理 / QCM Hugh 2009.03.16 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

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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	√ WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2-X/A709M-345F2-X 18/20/22/24/28/32/36 mm
WELDING PROCESS 焊接方法	FCAW,SMAW	TYPE OF JOINT 焊缝类型	T-JOINT

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			
CSD4-PP022-082				ACC.		100%MT
CSD4-PP022-083				ACC.		100%MT
CSD4-PP022-084				ACC.		100%MT
CSD4-PP022-085				ACC.		100%MT
CSD4-PP022-086				ACC.		100%MT
CSD4-PP022-089				ACC.		100%MT
CSD4-PP022-090				ACC.		100%MT
CSD4-PP022-093				ACC.		100%MT
CSD4-PP022-094				ACC.		100%MT
CSD4-PP022-106				ACC.		100%MT
CSD4-PP022-107				ACC.		100%MT
CSD4-PP022-118				ACC.		100%MT
CSD4-PP022-119				ACC.		100%MT
CSD4-PP022-120				ACC.		100%MT
CSD4-PP022-121				ACC.		100%MT
CSD4-PP022-122				ACC.		100%MT

EXAMINED BY主探 BOTINYUI LEVEL - II SIGN 签名 / DATE日期 2009.3.10	REVIEWED BY 审核 Cai Xinxin LEVEL-II SIGN / DATE日期 09.03.10
质量经理 / QCM Hugh 2009.3.16 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

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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	√ WELDING 焊接件 □ CASTING 铸件 □ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2-X/A709M-345F2-X 18/20/22/24/28/32/36 mm
WELDING PROCESS 焊接方法	FCAW,SMAW	TYPE OF JOINT 焊缝类型	T-JOINT

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			
CSD4-PP022-123				ACC.		100%MT
CSD4-PP022-124				ACC.		100%MT
CSD4-PP022-125				ACC.		100%MT
CSD4-PP022-126				ACC.		100%MT
CSD4-PP022-127				ACC.		100%MT
CSD4-PP022-128				ACC.		100%MT
CSD4-PP022-129				ACC.		100%MT
BLANK						

EXAMINED BY主探 BO TINMU LEVEL - II SIGN 签名 / DATE日期 2009. 3. 10	REVIEWED BY 审核 Cai Xinxin LEVEL-II SIGN / DATE日期 09.03.10
质量经理 / QCM Hu Wen 2009.03.16 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCS-000232
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 28-Jul-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0216

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☑	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:**
Procedural	☐	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 13-Mar-2009

Description of Non-Conformance:
On March 10, 2009, ZPMC Quality Control (QC) representative Mr. Wang Lu notified Caltrans Quality Assurance (QA) inspector of the re-inspection of the corner assembly components by Magnetic Particle Testing (MT) of the linear indications discovered by QA inspectors on Segment 3AE Green Tag #8. Caltrans QA performed MT the second time on the following corner assembly welds: CSD4-PP22-069, CSD4-PP22-071, CSD4-PP22-073 and CSD4-PP22-134. Caltrans QA Inspector discovered additional linear indications ranging from 10 to 25mm long.

Contractor's proposal to correct the problem:
ZPMC will conduct training for QC inspectors in regards to performing NDT inspections in conformance with Section 6 of AWS D1.5.

Corrective action taken:
QC inspectors attended training session in regards to performing inspections in conformance with Section 6 of AWS D1.5. After the repair, the areas are now 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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By:	Lowry,Patrick	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer