

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-000244**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0218**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Deck Panels on 3AW, 3AE, 4BW**Procedural****Procedural****Description:****Reference Description:** Unapproved base metal welding and heat straightening**Description of Non-Conformance:**

Quality Assurance Inspector observed that the Contractor welded temporary stiffener plates to deck panels DP011A (segment 3AW), DP012A (segment 3AE), and DP047A (segment 4BW) at the crossbeam locations. These stiffener plates and deck panels had heat straightened marks. The placement of these stiffener plates were not shown in the shop drawings and the fabrication procedures. The heat straightening operations were also not approved by the Engineer.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002, Section 3.1.5 – “Welds shall be prohibited on the work except as follows:

- (1) Base-metal repair performed in conformance with AASHTO M160/M160M (ASTM A 6/A 6M), Specification for General Requirements for Rolled Steel Plates, Shapes, Sheet Piling, and Bars for Structural Use, Article 9, by the mill or fabricator
- (2) All welds detailed on approved shop drawings
- (3) Repair welds authorized by this code
- (4) Other welds approved by the Engineer”

AWS D1.5 2002, Section 3.7.3 – “Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the Engineer.”

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 2009/04/07, 13:30, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 2009/04/07, 13:00, Verbal

QC Inspector's Name: Wang Lu

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) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	Wahbeh, Mazen	SMR
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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: 10-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: 05.03.06-000211

Subject: NCR No. ZPMC-0218

Reference Description: Unapproved base metal welding and heat straightening

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:

Quality Assurance Inspector observed that the Contractor welded temporary stiffener plates to deck panels DP011A (segment 3AW), DP012A (segment 3AE), and DP047A (segment 4BW) at the crossbeam locations. These stiffener plates and deck panels had heat straightened marks. The placement of these stiffener plates were not shown in the shop drawings and the fabrication procedures. The heat straightening operations were also not approved by the Engineer.

Action Required and/or Action Taken:

Please propose a resolution for the identified non-conformance.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0218

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000211

Subject: NCR No. ZPMC-0218

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000213 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been informed that welding outside the weld joint or welds that are not shown on drawings is prohibited by AWS D1.5. ZPMC has attached a copy of the heat straightening report.

ZPMC has been informed that welding outside the weld joint or welds that are not shown on drawings is prohibited by AWS D1.5. ZPMC has attached a copy of the heat straightening report. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000213R00;

Caltrans' comments:

Status: AAP

Date: 03-Jun-2009

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

For the areas where the temporary welds were removed, please provide documentation of the weld repairs that were performed and that the areas have been accepted by MT. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0218 at that time.

Submitted by: Wright, Doug

Date: 03-Jun-2009

Attachment(s):



No. B-346

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-5-15

REGARDING: NCR-000244 (ZPMC-0218)

With this letter of response, ZPMC requests closure for caltrans NCR-000244 (ZPMC-0218) . In main opinion that prevent the more of the deformation in the process of welding the stiffener on the below side, we fixed the temperature stiffener with the more thickness on the top of the deck plate nearby the crossbeam in the transverse direction, and before we install the temporary stiffener we adjusted the flatness by heat straight, with the survey of our QC guy that the max deformation is within the tolerance that only provide an record by ZPMC and approved with the QAM, that's only we have to submit the HSR to engineer approval when the deformation is more than over the tolerance in the special provision.

So base on the heat straight reports, ZPMC applies to close NCR-000244 (ZPMC-0218) .

Please reference attached documentation for acceptance and closure the NCR-000244 (ZPMC-0218) .

ATTACHMENT:

NCR-000244 (ZPMC-0218)

The corresponding heat straight records

Zhu Shuangbao

2009. 5.15



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 IV
375 BURMA ROAD
OAKLAND CA 95607

Date: 10-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: 05.03.06-000211

Subject: NCR No. ZPMC-0218

Reference Description: Unapproved base metal welding and heat straightening

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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.

Material Location: OBG

Lift:

Remarks:

Quality Assurance Inspector observed that the Contractor welded temporary stiffener plates to deck panels DP011A (segment 3AW), DP012A (segment 3AE), and DP047A (segment 4BW) at the crossbeam locations. These stiffener plates and deck panels had heat straightened marks. The placement of these stiffener plates were not shown in the shop drawings and the fabrication procedures. The heat straightening operations were also not approved by the Engineer.

Action Required and/or Action Taken:

Please propose a resolution for the identified non-conformance.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0218

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

File: 05.03.06

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Contract #: 04-0120F4
 City: 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-000244
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 07-Apr-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0218

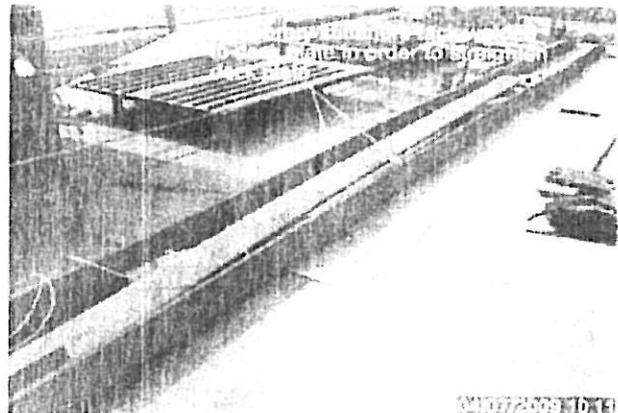
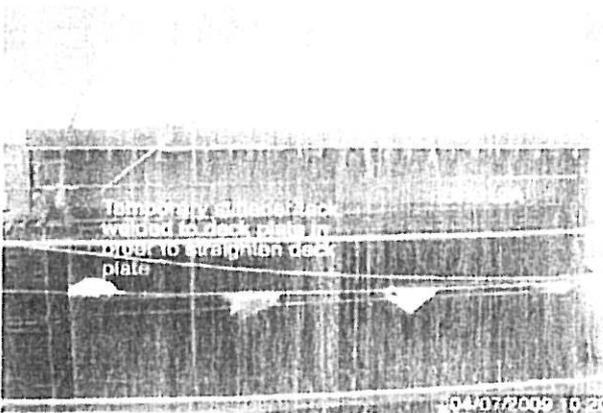
Type of problem:

- Welding Concrete Other
- Welding Curing Procedural Bridge No: 34-0006
- Joint fit-up Coating Other Component: Deck Panels on 3AW, 3AE, 4BW
- Procedural Procedural Description:

Reference Description: Unapproved base metal welding and heat straightening

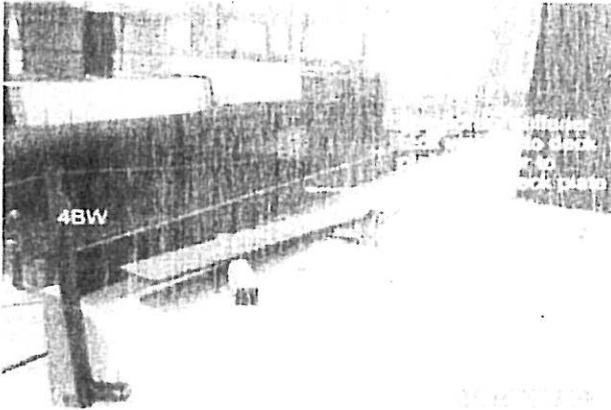
Description of Non-Conformance:

Quality Assurance Inspector observed that the Contractor welded temporary stiffener plates to deck panels DP011A (segment 3AW), DP012A (segment 3AE), and DP047A (segment 4BW) at the crossbeam locations. These stiffener plates and deck panels had heat straightened marks. The placement of these stiffener plates were not shown in the shop drawings and the fabrication procedures. The heat straightening operations were also not approved by the Engineer.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002, Section 3.1.5 -- "Welds shall be prohibited on the work except as follows:

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- (4) Other welds approved by the Engineer"

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Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 2009/04/07, 13:30, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 2009/04/07, 13:00, Verbal

QC Inspector's Name: Wang Lu

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) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



火工校正记录 Heat Straightening Record(HSR1)

报告号 Record#

HSR1(B)-5761

版本号 Revision #

0

日期 Date

2009.03.26

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:	Xu Jun
梁段 Gird: 4BW DP47(A)	质检经理/Quality Assurance Manager-Approval
塔段 Tower: N/A	Lu Jianhua
焊缝号 Weld No: 038.039.040.041	
焊缝地图号 Weld Map No: SEG019	

情况描述 Description of Condition

Cause原因 Welding distortion 焊接变形

Type of Defect缺陷类型 Welding distortion 焊接变形

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 oxygen acetylene

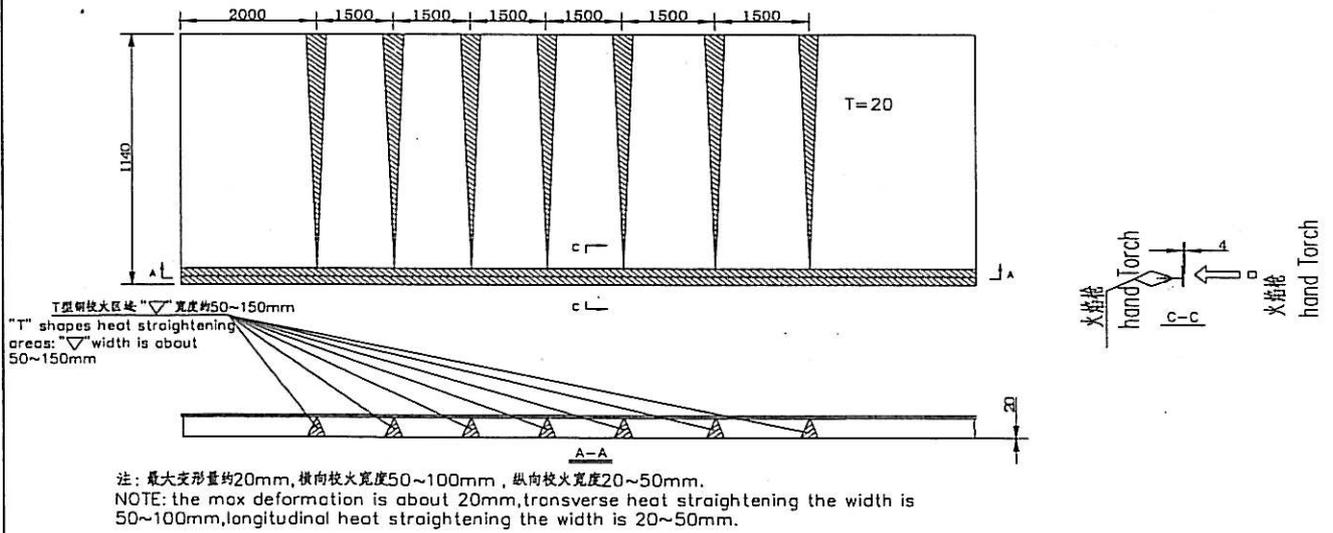
后续NDE(Post-Removal NDE): After finishing heat straightening, the weld of the heat area shall perform NDT according to the approved shop drawing

纠正措施(Corrective Action(s)): Control current, voltage and weld speed according to relevant WPS. If necessary anti-deformation or hold down device can be added.

实施次数(Number of application): 1~3

最高温度(Maximum temperature): <650°C

简图 Sketch



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

检验员 Inspector:		签字 Signature:	
CWI #		Closing Date:	
II 级探伤 NDE Certification:	Level II		
质检经理 QC Manager		审核日期 Review Date:	

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 Lu Jianhua 3.26



火工校正记录

Heat Straightening Record(HSR1)

报告号 Record #

HSR1(B)-6071

版本号 Revision #

0

日期 Date

2009.04.14

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:

Fu/Whong 2009.4.14

梁段 Gird: 3AE PL9B

质检经理/Quality Assurance Manager~Approval

塔段 Tower:

N/A

Lujianhua

焊缝号 Weld No:

045.046.047.048

焊缝地图号 Weld Map No:

SEG014

情况描述 Description of Condition

Cause 原因 Welding distortion 焊接变形

Type of Defect 缺陷类型 Welding distortion 焊接变形

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 oxygen acetylene

后续NDE(Post-Removal NDE):

After finishing heat straightening, the weld of the heat area shall perform NDT according to the approved shop drawing

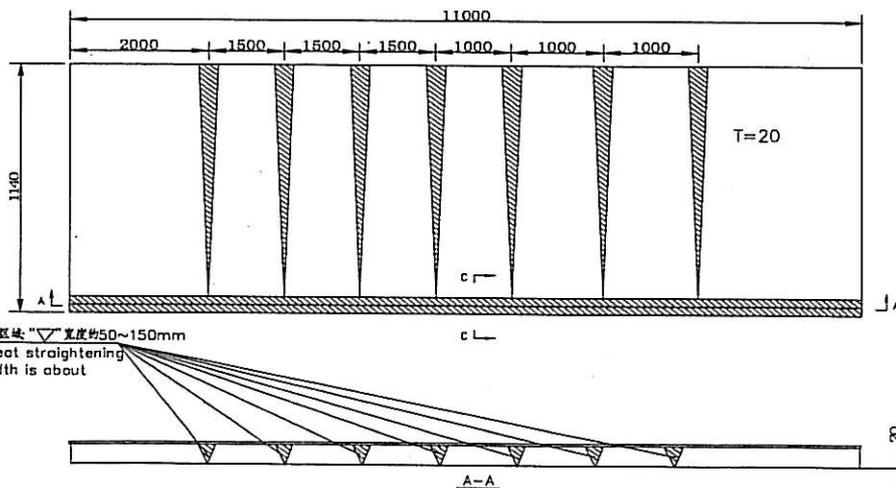
纠正措施(Corrective Action(s)):

Control current, voltage and weld speed according to relevant WPS. If necessary anti-deformation or hold down device can be added.

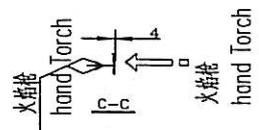
实施次数(Number of application): 1~3

最高温度(Maximum temperature): <650°C

简图 Sketch



T型梁火工区域: "T" 宽度的50~150mm
 "T" shapes heat straightening areas: "T" width is about 50~150mm



注: 最大变形量约20mm, 横向枝火宽度50~100mm, 纵向枝火宽度20~50mm.
 NOTE: the max deformation is about 20mm, transverse heat straightening the width is 50~100mm, longitudinal heat straightening the width is 20~50mm.

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

检验员 Inspector:

签字 Signature:

CWI #

II 级探伤 NDE Certification:

Level II

Closing Date:

质检经理 QC Manager

审核日期 Review Date:

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 Lujianhua 04/14/09



火工校正记录

Heat Straightening Record(HSR1)

报告号 Record #

HSR1(B)-5780

版本号 Revision #

0

日期 Date

2009.03.17

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:	<i>In Yehong Aug. 3. 17</i>
梁段 Gird: 3AW DP11(A)	质检经理/Quality Assurance Manager-Approval
塔段 Tower: N/A	<i>Cujianhua</i>
焊缝号 Weld No: 045.046	
焊缝地图号 Weld Map No: SEG013	

情况描述 Description of Condition

Cause 原因: Welding distortion 焊接变形
 Type of Defect 缺陷类型: Welding distortion 焊接变形
 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 oxygen acetylene

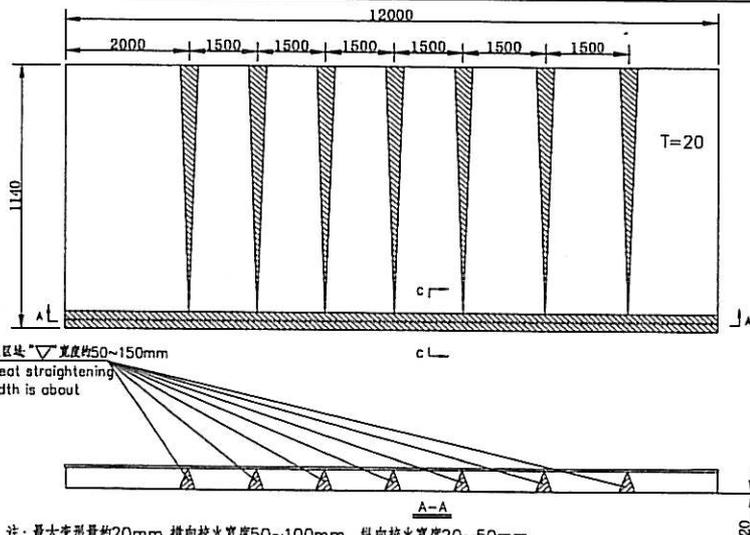
后续 NDE (Post-Removal NDE): After finishing heat straightening, the weld of the heat area shall perform NDT according to the approved shop drawing

纠正措施 (Corrective Action(s)): Control current, voltage and weld speed according to relevant WPS. If necessary anti-deformation or hold down device can be added.

实施次数 (Number of application): 1~3

最高温度 (Maximum temperature): <650°C

简图 Sketch



T型钢热火区: "T" shapes heat straightening areas: "V" width is about 50~150mm

注: 最大变形量约20mm, 横向热火宽度50~100mm, 纵向热火宽度20~50mm.
 NOTE: the max deformation is about 20mm, transverse heat straightening the width is 50~100mm, longitudinal heat straightening the width is 20~50mm.

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

检验员 Inspector:		签字 Signature:	
CWI #		Closing Date:	
II 级探伤 NDE Certification:	Level II		
质检经理 QC Manager		审核日期 Review Date:	

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 Cujianhua 3-17

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000211

Subject: NCR No. ZPMC-0218

Dated: 27-Jul-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000213 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000213R01;

Caltrans' comments:

Status: CLO

Date: 10-Aug-2009

The proposed resolution is acceptable. The inspection documents requested in Rev 0 of NPR-0213 have been provided. The Department concurs that Non-Conformance ZPMC-0218 is closed.

Submitted by: Wright, Doug

Date: 10-Aug-2009

Attachment(s):



No. B-409

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-7-20

REGARDING: NCR-000244 (ZPMC-0218)

With this letter of response, ZPMC requests closure for Caltrans **NCR-000244 (ZPMC-0218)**. As the comments of the NPR "please provide the documentation of the weld repairs that were performed and that the repairs were acceptable", we have removed the temporary stiffener and repair the tack point, after confirm by ZPMC MT inspection we also notify the caltrans inspector to recheck by the MT method. we submit the corresponding MT reports to support the good quality and accepted by visual and NDT inspection of all parties.

So base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report **NCR-000244 (ZPMC-0218)**.

Please reference attached documentation for acceptance and closure the **NCR-000244 (ZPMC-0218)**.

ATTACHMENT:

NCR-000244 (ZPMC-0218)

The final MT report

zhao Shuangbao

2009. 7. 20

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-000244
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 07-Apr-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0218

Type of problem:

- Welding Concrete Other
- Welding Curing Procedural **Bridge No:** 34-0006
- Joint fit-up Coating Other **Component:** Deck Panels on 3AW, 3AE, 4BW
- Procedural Procedural Description:

Reference Description: Unapproved base metal welding and heat straightening

Description of Non-Conformance:

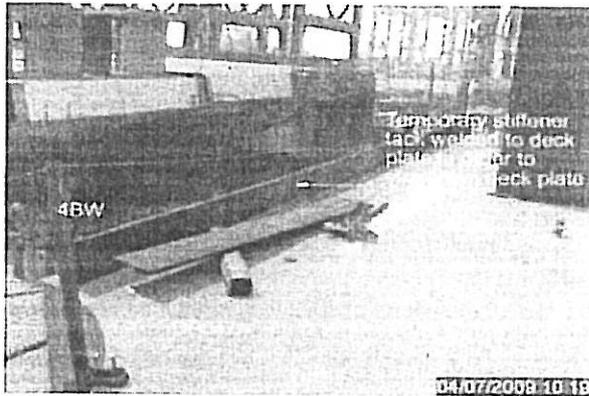
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WRR/CWR
NT 报告

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002, Section 3.1.5 – “Welds shall be prohibited on the work except as follows:

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Time and method of notification: 2009/04/07, 13:30, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 2009/04/07, 13:00, Verbal

QC Inspector's Name: Wang Lu

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) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12376		DATE日期 2009.06.20	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: 3AW/3AE/4BW DP011A/DP012A/DP047A		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 ST , 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	<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-X 20	
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	BASE METAL	

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			
DP011A				ACC.		temporary stiffener tack weld
DP012A				ACC.		temporary stiffener tack weld
DP047A				ACC.		temporary stiffener tack weld
BLANK						

EXAMINED BY主探 Jin Jianting <i>Jin Jianting</i> LEVEL - II SIGN 签名 / DATE日期 2009.06.20	REVIEWED BY 审核 <i>[Signature]</i> LEVEL-II SIGN / DATE日期 2009.06.20
质量经理 / QCM 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
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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-000291**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0218**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: 07-Apr-2009**Description of Non-Conformance:**

Quality Assurance Inspector observed that the Contractor welded temporary stiffener plates to deck panels DP011A (segment 3AW), DP012A (segment 3AE), and DP047A (segment 4BW) at the crossbeam locations. These stiffener plates and deck panels had heat straightened marks. The placement of these stiffener plates were not shown in the shop drawings and the fabrication procedures. The heat straightening operations were also not approved by the Engineer.

Contractor's proposal to correct the problem:

Contractor has acknowledged that the issue must be addressed, and it has been added to the Master Punchlist.

Corrective action taken:

Completion of work is being tracked by Master Punchlist. Submission of documentation being tracked by Documentation Punchlist.

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 Jim Simonis, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer