

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-000251**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0225**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** North Shaft, Lift 3, Skin A**Procedural****Procedural****Description:** Longitudinal Stiffener A, LS3-6IN**Reference Description:** Excessive heat input during heat straightening for Longitudinal Stiffener LS3-6IN**Description of Non-Conformance:**

Quality Assurance observed that the contractor has performed heat straightening of Longitudinal Stiffener LS3-6IN. ZPMC Quality Control (QC) Inspector Mr. Jieng Xiao Bo informed the QA Inspector that ZPMC attempted to straighten the member but exceeded the maximum heat input limits causing base metal to melt and crater.

**Applicable reference:**

ZPMC QC Heat Straightening Control Procedure

AWS D1.5, Section 3.7.3: "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of localized heat as approved by the Engineer."

Who discovered the problem: Joe Alaniz**Name of individual from Contractor notified:** Steve Lawton**Time and method of notification:** Verbal, 13:30**Name of Caltrans Engineer notified:** Jim Reid

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: Verbal, 13:30

QC Inspector's Name: Jieng Xia Bo

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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Sinevod,Serge	ASMR
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Reviewed By:	Wahbeh,Mazen	SMR
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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: 28-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/Fabrication Manager

Document No: 05.03.06-000215

Subject: NCR No. ZPMC-0225

Reference Description: Heat Straightening / Excessive Heat Input / Tower North Shaft Lift 3 / Longitudinal Stiffener

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:** 03

Remarks:

Quality Assurance observed that the contractor has performed heat straightening of Longitudinal Stiffener LS3-6IN. ZPMC Quality Control (QC) Inspector Mr. Jieng Xiao Bo informed the QA Inspector that ZPMC attempted to straighten the member but exceeded the maximum heat input limits causing base metal to melt and crater.

Action Required and/or Action Taken:

While no further action with regard to the material is required, as per direction from ABFJV, the material has been removed and replaced. Provide the steps that have been or will be taken by the Quality Control Manager to prevent future occurrences.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0225

cc: Rick Morrow, Gary Pursell, Mark Woods, Jason Tom, Judy Li

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000215

Subject: NCR No. ZPMC-0225

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000221 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has cut this material back from the demolished base metal and welded in a new piece using a CJP with full inspection requirements for a CJP weld as well as documenting the weld via FCN.

ZPMC has cut this material back from the demolished base metal and welded in a new piece using a CJP with full inspection requirements for a CJP weld as well as documenting the weld via FCN. ZPMC requests closure of the NCR.

Submitted by:

Attachment(s): ABF-NPR-000221R00

Caltrans' comments:

Status: REJ

Date: 08-Jun-2009

The proposed resolution is not acceptable. This proposed resolution indicates that the weld will be documented through the FCN process. ABFJV has chosen not to participate in/abandoned the FCN process. In addition, the proposal does not address the steps taken to prevent future occurrences.

With the abandonment of the FCN process, provide the method to be utilized to document the weld and proceed with the process to ensure the weld is documented in the working drawings. Additionally, provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0225 at that time.

Submitted by: Wright, Doug

Date: 08-Jun-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000215

Subject: NCR No. ZPMC-0225

Dated: 21-Jul-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000221 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has responded to the NCR and has attached the necessary documents for closure. ZPMC requests closure of this NCR.

ZPMC has responded to the NCR and has attached the necessary documents for closure. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000221R01;

Caltrans' comments:

Status: CLO

Date: 05-Aug-2009

The proposed resolution is acceptable. The affected portion of the stiffener has been removed and a new steel plate has been spliced in its place. Also, the welds have been accepted by MT and UT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0225 is closed.

Submitted by: Wright, Doug

Date: 05-Aug-2009

Attachment(s):



No. T-028

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-5-16

REGARDING: NCR-000251 ZPMC-0225

ZPMC received NCR-000251(ZPMC-0225), it mentioned that ZPMC performed heat straightening on longitudinal stiffener LS3-6IN, it exceeded the maximum heat input limits causing base metal to melt and crater.

Once this situation happened, AB/F issued their NCR-09-012 to warn ZPMC, also ZPMC had verified and acknowledged this problem and put forward ZPMC's NCR-T-032. As the night shift people wasn't concentration during the heat straightening, which caused over heat input. ZPMC had already inculcated the work team to enhance the management, and they should arrange professional worker, and QC should be on-site during the heat straightening. Regarding the melting metal, ZPMC technique department had already given out the proposed disposition described on ZPMC's Inspection Report no. ZP06-787-J511, that the melting metal would be cut off and replaced by new part, also the old weld ID: NSD1-FASA3-1E/E-28 A/B was revised to the new weld ID: NSD1-FASA3-1E/E-28 A/B-1, and the subsequent NDT result is acceptable.

So ZPMC request to close this NCR, and here provided AB/F's NCR-09-012, ZPMC's Inspection Report, all the NDT reports, hoped Caltrans could take a review and close NCR ZPMC-0225.

ATTACHMENT:

NCR-000251 (ZPMC-0225)

AB/F's NCR-09-012

ZPMC's NCR-T-032

ZPMC's Inspection Report ZP06-787-J511

T787-MT-3763

T787-UT-1669

李國復



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: 28-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/Fabrication Manager
Document No: 05.03.06-000215

Subject: NCR No. ZPMC-0225

Reference Description: Heat Straightening / Excessive Heat Input / Tower North Shaft Lift 3 / Longitudinal Stiffener

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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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: Tower **Lift:** 03

Remarks:

Quality Assurance observed that the contractor has performed heat straightening of Longitudinal Stiffener LS3-6IN. ZPMC Quality Control (QC) Inspector Mr. Jieng Xiao Bo informed the QA Inspector that ZPMC attempted to straighten the member but exceeded the maximum heat input limits causing base metal to melt and crater.

Action Required and/or Action Taken:

While no further action with regard to the material is required, as per direction from ABFJV, the material has been removed and replaced. Provide the steps that have been or will be taken by the Quality Control Manager to prevent future occurrences.

Transmitted by: Scott Kennedy Sr. Bridge Engineer
Attachments: ZPMC-0225

cc: Rick Morrow, Gary Pursell, Mark Woods, Jason Tom, Judy Li
File: 05.03.06

02:15:07
05.03.06-000215.NCT

Received
NCT-000215 28 Apr 09 Page 1 of 1

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-000251

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 13-Apr-2009

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

NCR #: ZPMC-0225

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

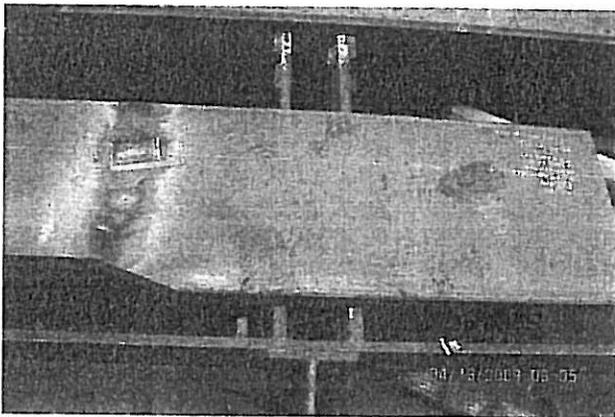
Joint fit-up Coating Other Component: North Shaft, Lift 3, Skin A

Procedural Procedural Description: Longitudinal Stiffener A, LS3-6IN

Reference Description: Excessive heat input during heat straightening for Longitudinal Stiffener LS3-6IN

Description of Non-Conformance:

Quality Assurance observed that the contractor has performed heat straightening of Longitudinal Stiffener LS3-6IN. ZPMC Quality Control (QC) Inspector Mr. Jieng Xiao Bo informed the QA Inspector that ZPMC attempted to straighten the member but exceeded the maximum heat input limits causing base metal to melt and crater.



Applicable reference:

ZPMC QC Heat Straightening Control Procedure

AWS D1.5, Section 3.7.3: "Members distorted by welding shall be straightened by mechanical means or by carefully supervised application of localized heat as approved by the Engineer."

Who discovered the problem: Joe Alaniz

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: Verbal, 13:30

Name of Caltrans Engineer notified: Jim Reid

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: Verbal, 13:30

QC Inspector's Name: Jieng Xia Bo

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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod,Serge

ASMR

Reviewed By: Wahbeh,Mazen

SMR



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: NCR 编号: NCR-T-032
Item: Overheated the tower stiffener 名称描述: 校火温度过高	Item Number: 件号: Skin A stiffener A3	Drawing: 图号: NSD1-FASA3
Location: bay 10 位置: 重型车间 1		Date: 日期: 2009-04-14

Description of Nonconformance: 不符合项状态描述:

The surface was melted due to overheating during the hear straightening process on lift 3 NSD1-Skin A stiffener A3.
北塔第三吊装段 A 面板 A3 筋板在校火时, 校火温度过高导致筋板表面被融化。

Work By: 施工方: 胡限施 2 队
Prepared by: 准备: 徐... 2009-4-14
Reviewed by QCE: 质量工程师批准: 赵双... 4.14

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

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

Recommendation:
建议:
加强对施工队的管理和教育, 校火时 QEC 必须在现场。
Enhance management and education work team, and QEC shall be on-site during heat straightening.

Prepared by: Li Shiguan Approved by QCA: _____
准备 7.04.14 质量经理批准

Reason for Nonconformance:
不符合原因:
Night shift wasn't concentration during heating straightening, which caused plate surface was melted at third lifting tower (N) skin A stiffener.
在夜校火中温度过高出现表面被融化。

Prevention of Re-occurrence:
预防措施:
施工队要安排专人持证操作, 并做好测温工作。(测温笔)
Arrange professional worker to heat straight, and it shall take measure tool (pyrometric torch and pen).

Approved by/批准: Li Shiquan
07.06.14

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
回用或返修的技术依据: 附件 无附件

将因校火温度过高导致筋板表面融化的区域割除, 换板, 具体见相关标准。

Remove the melt ^{要求} area and weld new plate, the detail requirement see relevant standard.

Reviewed /批准: 张令冬 5.13/09

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

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

#R787-QCP-1300

Quality Assurance- Non Conformance Report

Location: Zhenhua Port Machinery Company	NCR Number: NCR-09-012
Contractor: American Bridge/Flour, JV	Date: 4/13/2009
Fabricator: Zhenhua Port Machinery Company (ZPMC)	Drawing: NSD1-FASA3
<u>Type Of Problem:</u>	<u>Piece MK. / ID.</u>
Welding <input type="checkbox"/> Personnel <input type="checkbox"/>	Subassembly: N/A
Straightening <input checked="" type="checkbox"/> Equipment <input type="checkbox"/>	Assembly: Tower
Joint Fit-Up <input type="checkbox"/> NDT <input type="checkbox"/>	Segment: 6 to 7
Procedural <input type="checkbox"/> Other <input type="checkbox"/>	Lift: 3
	Weld ID: N/A

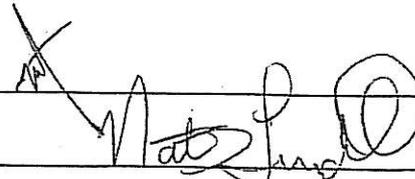
Description of Non-Conformance
 The surface was melted due to overheating during the heat straightening process on lift 3 NSD1-Skin A stiffener A3

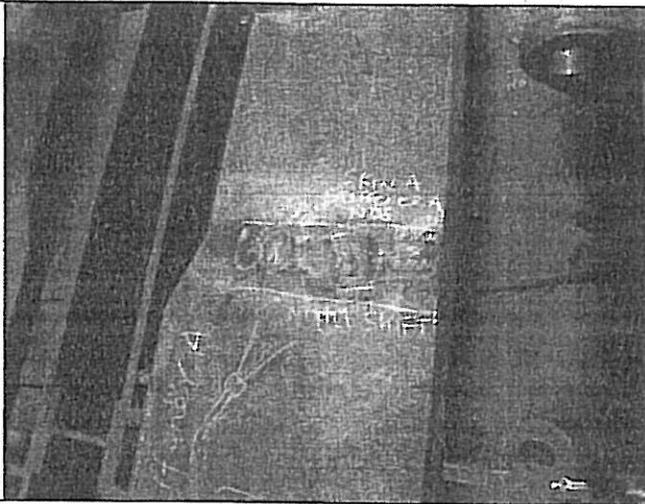
Applicable Reference: AASHTO/AWS D1.5M/D1.5 2002; Conformed Special Provisions, ZPMC WQCP

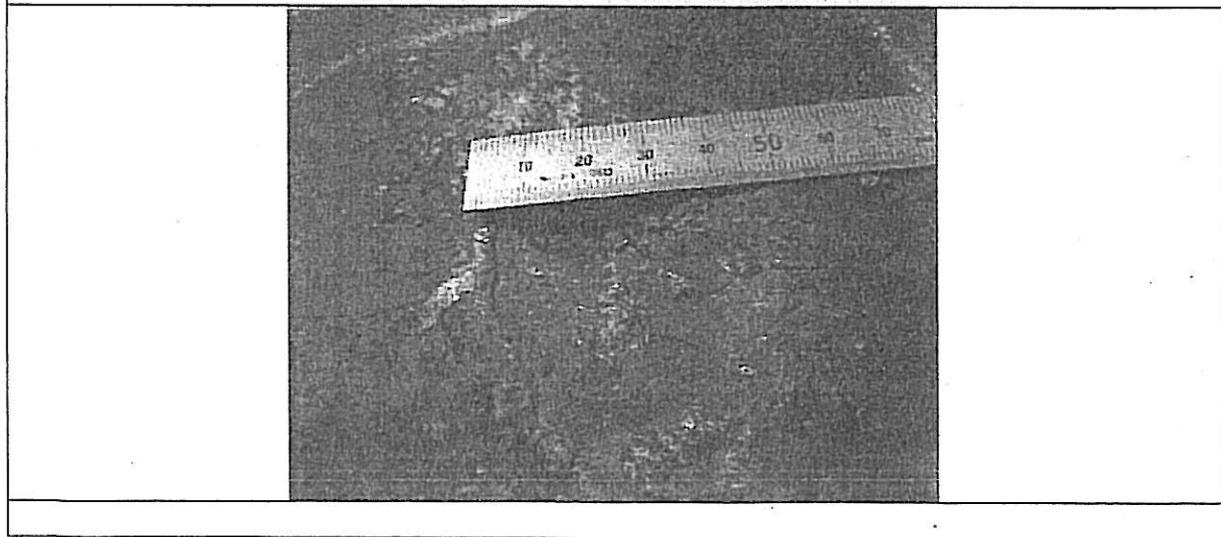
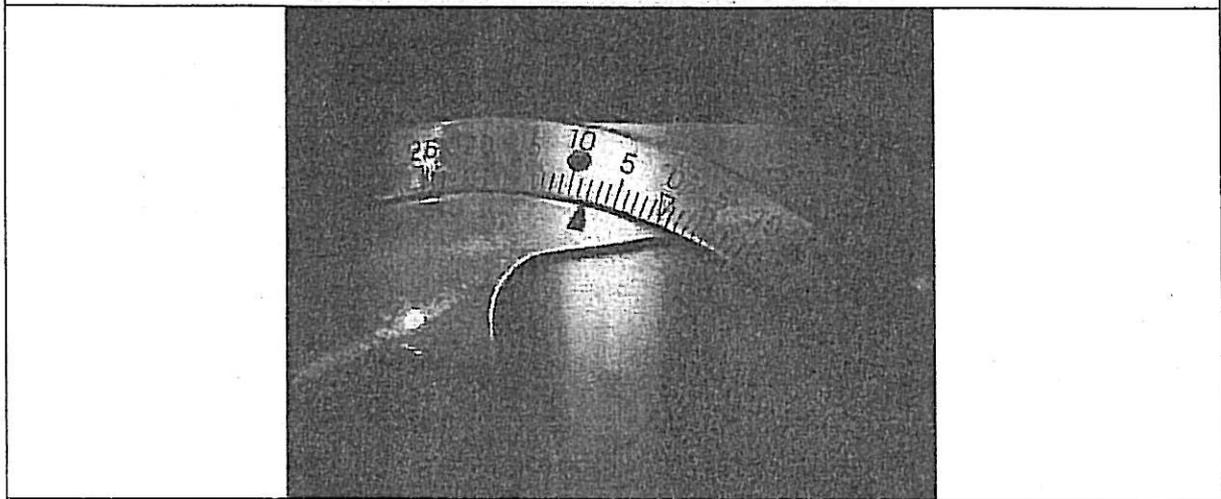
Individual who discovered the problem:	Jeff Chan
Name of individual from Fabricator notified:	Ken Zhang
Notification Method:	Verbal and E-mail
QC Inspector's Name:	Ken Zhang
Comments	

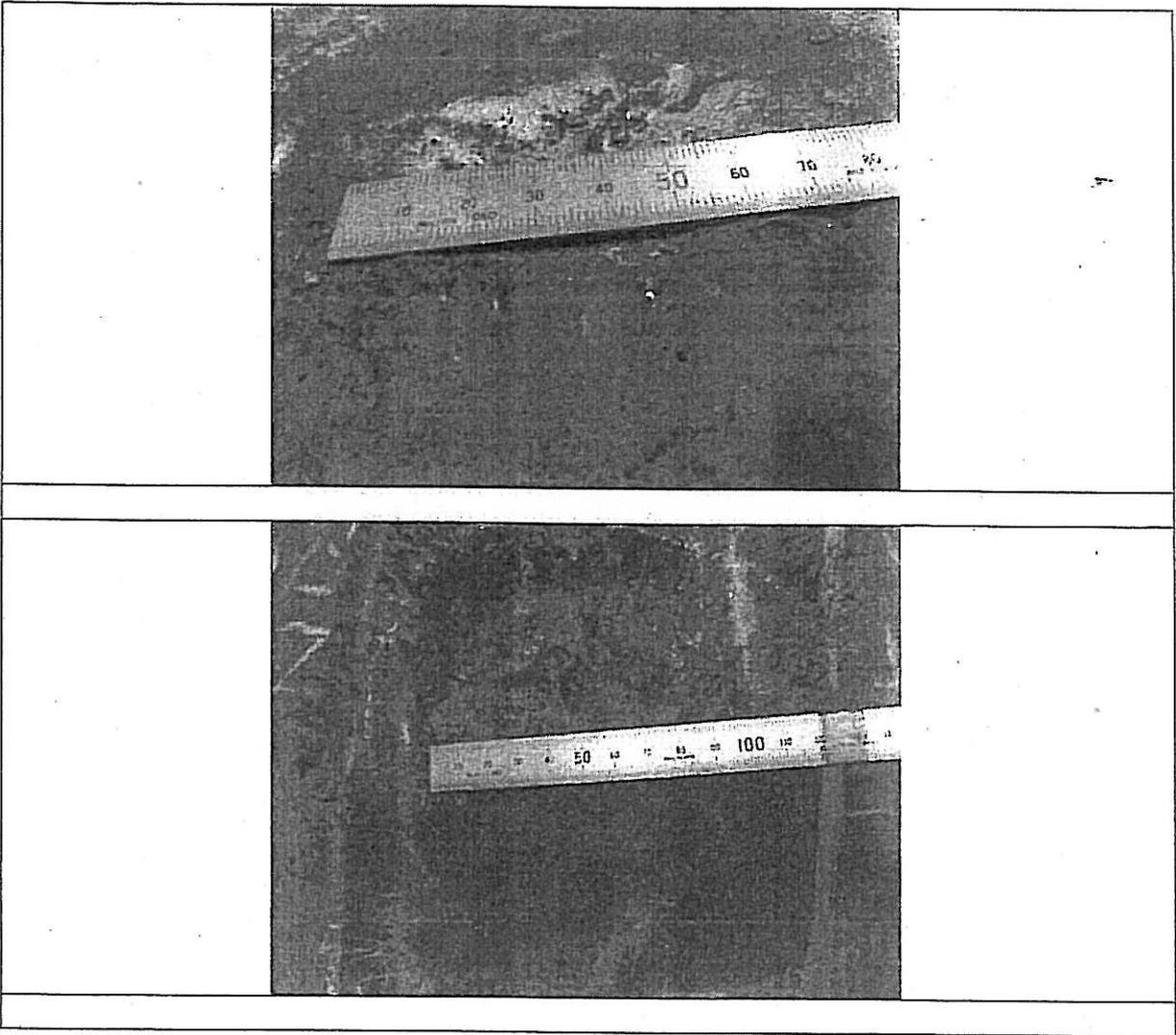
Disposition:
 Hardness test to the damaged area and weld repair.

Proposal to prevent re-occurrence:
 During the heat straightening process, ZPMC QC have to monitoring and check the temperature.

Inspected By: Jeff Chan		Date: 2009 Apr 14
Reviewed By: Nate Lindell		Date: 4/14/09









检 查 报 告

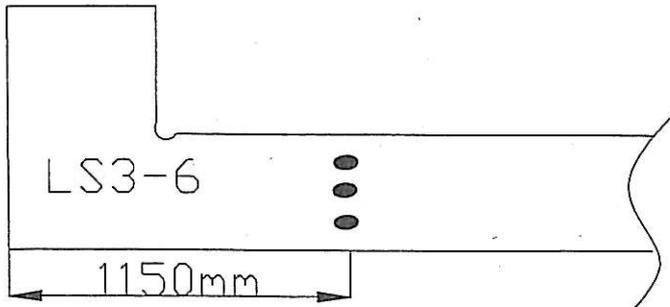
Inspection Report

产品名称: 美国海湾大桥 工程编号: ZP06-787
 Project Name: 美国海湾大桥 Project No.: ZP06-787
 构件名称: 北塔第三吊段 A 面板 构件图号: LS3-6
 Component Name: 北塔第三吊段 A 面板 Drawing No.: LS3-6
 生产部门: 胡震施工队 生产部门负责人签字: 陆叶飞
 Fabrication Dept.: 胡震施工队 Fabrication Manager: 陆叶飞

检查情况叙述 (包括发生的原因):

Description of quality problem (reasons):

北塔第三吊段, A 面板 A3 纵向筋, LS3-6 校火过烧。具体如图:



检验员: 李崇 室经理: 付网刚 日期: 09-04-21
 Q.C. Inspector Q.C. Manager Date

处理意见:

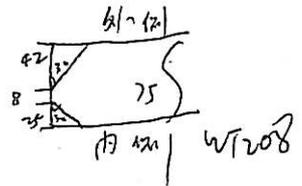
Proposed disposition

将 LS3-6 端部切除, 增加焊缝, 焊缝位置图打在 1700 处
 Cutting off the melting metal area for about 1700mm length, replace it with a part.
 请提交 ABF 确认。 焊缝的厚度为 WT208 距端部

工艺主管: 李崇 室经理: 付网刚 日期: 09-04-21
 Technical Engineer Technical Manager Date

缺损件处理意见:

Proposed disposition for the lose and broken pieces



分管副总: _____ 日期: _____
 Vice-General Manager Date

检验结果:

Check resule

检验员: _____ 项目主管: _____ 日期: _____
 Q.C. Inspector Q.C. Engineer Date



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-3763 DATE日期 2009.04.27 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: NSD1-FASA3-1E/E THE 3RD LIFT TOWER(N) SKIN A LONGITUDINAL		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 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 mm
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			
NSD1-FASA3-1E/E-28A/B-1				ACC.		100%MT
NSD1-FASA3-1E/E-28A/B						*
NSD1-FASA3-1E/E-24A/B						*
NSD1-FASA3-1E/E-21A/B						*

* NSD1-FASA3-1E/E-28A/B-1 was MT inspection and ACC, which is the result of required 25% MT.
* NSD1-FASA3-1E/E-28A/B- 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。

AFTER HSR1(T)-8370

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EXAMINED BY 主探 <i>Yuan Tao</i>	REVIEWED BY 审核 <i>Wangwei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>of. 09.27</i>	LEVEL-II SIGN / DATE日期 <i>09.4.27</i>
质量经理 / QCM <i>Lujianhui 2009.05.26</i>	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-1669 DATE 2009.04.26 PAGE 1 OF 1 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787 CONTRACTOR: CALTRANS

ITEMS NAME: THIRD LIFTING TOWER(N) A3 STIFFENER DRAWING NO.: NSD1-FASA3-1E/E CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 SAW BUTT Dec. 28ST, 2009

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709M-345T2-Z 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°	2.5MHz	18×77Mm	Changchao	45°	2.5MHz	18×77Mm
Changchao	0°	2.5MHz	20mm				

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
NSD1-FASA3-1E/E-28A/B-1		70				33									ACC.	100%
		45				33									ACC.	100%

AFTER HSR1(T)-8493

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EXAMINED BY 主探 REVIEWED BY 审核
Xu Ronggang *Zshu'gin*
 LEVEL - II SIGN / DATE LEVEL - II SIGN / DATE
9.24.26 *9.24.26*

质量经理 / QCM 用户CUSTOMER
 签字 SIGN / 日期 DATE 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
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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-000223**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Jul-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0225**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: 13-Apr-2009**Description of Non-Conformance:**

Quality Assurance observed that the contractor has performed heat straightening of Longitudinal Stiffener LS3-6IN. ZPMC Quality Control (QC) Inspector Mr. Jieng Xiao Bo informed the QA Inspector that ZPMC attempted to straighten the member but exceeded the maximum heat input limits causing base metal to melt and crater.

Contractor's proposal to correct the problem:

Remove the affected portion of the stiffener and splice a new steel plate in its place.

Corrective action taken:

The affected portion of the stiffener has been removed and a new steel plate has been spliced in its place. NDT results indicating a sound weld at the new weld joint (NSD1-FASA3-1E/E-28A/B-1) have been submitted.

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, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer