

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



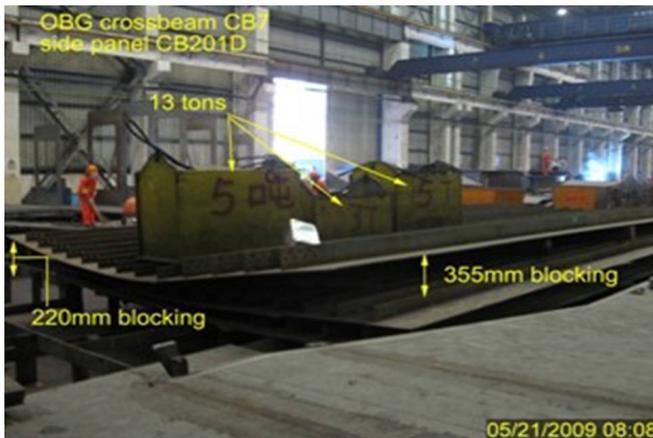
Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000279**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-May-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0253**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> Crossbeam CB7
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Heat Straightening Without Approved Procedure, Crossbeam CB7**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed heat straightening without an approved procedure on Crossbeam CB7 (Side Panel). The procedure presented to QA Inspector indicated that the distortion was 5mm on 18mm plate. Furthermore, the Contractor's personnel did not follow the available procedure on the shop floor. The procedure did not indicate the use of blocks under each edge of the panel as shown in the photo below.

**Applicable reference:**

1. ZPMC Heat Straightening Report number HSR1(B)-6427
2. 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."
3. Contract Special Provisions 8-3.01 "for material more than 16mm, the contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer."

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Who discovered the problem:** Steve Hall  
**Name of individual from Contractor notified:** Shen Ru Shan  
**Time and method of notification:** 0830, 05-21-09, Verbal  
**Name of Caltrans Engineer notified:** Stanley Ku  
**Time and method of notification:** 0730, 05-22-09, Verbal  
**QC Inspector's Name:** Shen Xuejun  
**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 Skyler Guest, +(86) 1500.042.2360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Guest, Skyler	SMR
<b>Reviewed By:</b>	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:** 28-May-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:** 05.03.06-000245

**Subject:** NCR No. ZPMC-0253

**Reference Description:** Heat Straightening Without Approved Procedure, Crossbeam CB7

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:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed heat straightening without an approved procedure on Crossbeam CB7 (Side Panel). The procedure presented to QA Inspector indicated that the distortion was 5mm on 18mm plate. Furthermore, the Contractor's personnel did not follow the available procedure on the shop floor. The procedure did not indicate the use of blocks under each edge of the panel as shown in the photo below.

### Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences.

**Transmitted by:** Stanley Ku Sr. Bridge Engineer

**Attachments:** ZPMC-0253

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, Jason Tom, Ching Chao

**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Dated:** 22-Jun-2009

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

**Attention:** Pursell, Gary  
Resident Engineer

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000247 **Rev:** 00

**Ref:** 05.03.06-000245

**Subject:** NCR No. ZPMC-0253

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### Contractor's Proposed Resolution:

**Reference Resolution:** ABF has instructed ZPMC to provide an HSR that properly documents the method of heat straightening, furthermore, ZPMC is to address all affected welds by providing the necessary NDT reports.

ABF has instructed ZPMC to provide an HSR that properly documents the method of heat straightening, furthermore, ZPMC is to address all affected welds by providing the necessary NDT reports. ZPMC has been instructed by the ABF QCM to perform heat straightening in strict accordance with the special provisions. ZPMC will provide the required documentation at a later date.

**Submitted by:**

**Attachment(s):** ABF-NPR-000247R00

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**Caltrans' comments:**

**Status:** AAP

**Date:** 25-Jun-2009

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

Please provide documentation of the heat straightening that was performed and inspection documents on all affected welds. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0253 at that time.

**Submitted by:** Wright, Doug

**Date:** 25-Jun-2009

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000245

**Subject:** NCR No. ZPMC-0253

**Dated:** 14-Dec-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000247 Rev: 01

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### Contractor's Proposed Resolution:

**Reference Resolution:** Per the comments from Caltrans, ZPMC is providing the HSR1 and NDT documentation which shows that the weld is now acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC QA has issued an NCR for the unapproved heat straightening to ZPMC QC Department to ensure that heat straightening is done in accordance with an approved procedure. Per the comments from Caltrans, ZPMC is providing the HSR1 and NDT documentation which shows that the weld is now acceptable. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000247R01;

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### Caltrans' comments:

**Status:** CLO

**Date:** 17-Dec-2009

Heat straightening information requested has now been provided.

**Submitted by:** Howe, Bill

**Date:** 17-Dec-2009

**Attachment(s):**



No. B-526

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2009-12-11**

**REGARDING: NCR-000279 (ZPMC-0253)**

With this letter of response, ZPMC requests closure for CALTRANS NCR-000279 (ZPMC-0253) what mentioned that QA observed Heat Straightening without approved procedure.

ZPMC acknowledged this problem and has issued internal NCR. ZPMC will enhance QC to control the Heat Straightening work according to approved procedure. To ensure the affected weld quality, ZPMC performed VT and MT on it.

According to CT's request in NPR, ZPMC providing internal NCR, HSR1 and NDT documentations, hoping CALTRANS could take a review and consider close the NCR.

**ATTACHMENT:**

NCR-B-160

NCR-000279(ZPMC-0253)

ABF-NPR-000247 R0.

HSR1(B)-6427

B-VT-30326

B787-MT-11711

*Jy*  
*12/11/09*



# 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: 2PMC-253  
 NCR 编号: NCR-B-160 (NCR-00279)

Item: Heat Straightening Without  
 Approved Produce  
 名称描述: 未批准校火工艺

Item Number:  
 件号: CB7

Drawing:  
 图号: CB7

Location: Bay 1  
 位置: 1 车间

Date: 2009-06-02  
 日期:

### Description of Nonconformance:

#### 不符合项状态描述:

Caltrans Inspector observed that the Contractor has performed heat straightening without an approved procedure on CROSSBEAM CB7 (side panel). The procedure presented to QA Inspector indicated that the distortion was 5mm on 18mm plate. Furthermore, the Contractor's personnel did not follow the available procedure on the shop floor. The procedure did not indicate the use of blocks under each edge of the panel as shown in the photo below.

加州检验员发现作业人员对 CB7 侧板在进行校火, 但是没有批准的校火工艺。工艺文件显示此处 18mm 厚的板存在 5mm 变形。此外, 作业人员在车间没有按校火工艺执行操作。工艺上没有说明使用垫块在板单元边缘。请见照片。参考文件 HSR1(B)-6427。

AWS D1.5 2002 版 3.7.3 “因焊接变形的构件, 必须用机械的方法矫直, 或者在工程师批准后, 在仔细监控下进行一定程度的局部加热来矫直”; 标书 8-3.01, “板厚超过 16mm 的板, 如果 1000 长度内变形超过 3, 需得到工程师批准后进行校火”。

Work By: Tianyingdhan Prepared by: Lan Tao Reviewed by QCE: Zhai Shunjun  
 施工方: Tianyingdhan 准备: 06/02/09 质量工程师批准:  
 Drawing Error  Material Defect  Fabrication Error  Other 6.2  
 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: 1) 校火前仔细审核报告, QC 到现场监控  
 1) Review heat straightening report before heat straightening and QC supervision.

Prepared by: Du Wenjun Approved by QCA: \_\_\_\_\_  
 准备 质量经理批准

### Reason for Nonconformance:

不符合原因: ①因未在校正之前没有仔细阅读校火报告; ②校火报告上没有明显需用  
 压块辅助校正  
 1) Didn't Review heat straightening report before heat straightening 2) Didn't mark  
 subsidiary clearly

预防措施: ①校火时通知 QC 到现场验证, 控制过程。②要求施工人员仔细阅读校  
 火报告 ③校火报告写出校正辅助设备等  
 Approved by: Huku Zhang

Technical Justification for Use-As-Is/Repair:  Attachment  Non-attachment  
 回用或返修的技术依据: carefully 2) Write subsidiary report 附件  
 1) Note QC supervision during heat straightening 2) Review heat straightening report  
 无附件

Reviewed / 批准: \_\_\_\_\_

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: \_\_\_\_\_

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:

*follow*

## NON-CONFORMANCE REPORT TRANSMITTAL

**To:** AMERICAN BRIDGE/FLUOR, A JV  
375 BURMA ROAD  
OAKLAND CA 95607

**Date:** 28-May-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:** 05.03.06-000245

**Subject:** NCR No. ZPMC-0253

**Reference Description:** Heat Straightening Without Approved Procedure, Crossbeam CB7

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:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed heat straightening without an approved procedure on Crossbeam CB7 (Side Panel). The procedure presented to QA Inspector indicated that the distortion was 5mm on 18mm plate. Furthermore, the Contractor's personnel did not follow the available procedure on the shop floor. The procedure did not indicate the use of blocks under each edge of the panel as shown in the photo below.

**Action Required and/or Action Taken:**

Propose a resolution for the identified non-conformance to prevent future occurrences.

**Transmitted by:** Stanley Ku Sr. Bridge Engineer

**Attachments:** ZPMC-0253

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, Jason Tom, Ching Chao

**File:** 05.03.06

**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


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**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

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Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000279

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 21-May-2009

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

NCR #: ZPMC-0253

**Type of problem:**Welding  Concrete  Other Welding  Curing  Procedural  Bridge No: 34-0006Joint fit-up  Coating  Other  Component: Crossbeam CB7Procedural  Description: 

Reference Description: Heat Straightening Without Approved Procedure, Crossbeam CB7

**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed heat straightening without an approved procedure on Crossbeam CB7 (Side Panel). The procedure presented to QA Inspector indicated that the distortion was 5mm on 18mm plate. Furthermore, the Contractor's personnel did not follow the available procedure on the shop floor. The procedure did not indicate the use of blocks under each edge of the panel as shown in the photo below.

**Applicable reference:**

1. ZPMC Heat Straightening Report number HSR1(B)-6427
2. 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."
3. Contract Special Provisions 8-3.01 "for material more than 16mm, the contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer."

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Who discovered the problem:** Steve Hall  
**Name of individual from Contractor notified:** Shen Ru Shan  
**Time and method of notification:** 0830, 05-21-09, Verbal  
**Name of Caltrans Engineer notified:** Stanley Ku  
**Time and method of notification:** 0730, 05-22-09, Verbal  
**QC Inspector's Name:** Shen Xuejun  
**Was QC Inspector aware of the problem:**  Yes  No  
**Contractor's proposal to correct the problem:**

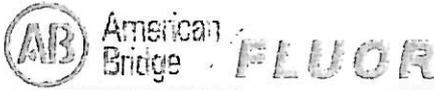
**Comments:**

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 Skyler Guest, +(86) 1500.042.2360, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Guest, Skyler	SMR
<b>Reviewed By:</b>	Wahbeh, Mazen	SMR

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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

Dated: 22-Jun-2009

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

Attention: Pursell, Gary  
Resident Engineer

Job Name: SAS Superstructure

Ref: 05.03.06-000245

Document No.: ABF-NPR-000247 Rev: 00

Subject: NCR No. ZPMC-0253

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### Contractor's Proposed Resolution:

Reference Resolution: ABF has instructed ZPMC to provide an HSR that properly documents the method of heat straightening, furthermore, ZPMC is to address all affected welds by providing the necessary NDT reports.

ABF has instructed ZPMC to provide an HSR that properly documents the method of heat straightening, furthermore, ZPMC is to address all affected welds by providing the necessary NDT reports. ZPMC has been instructed by the ABF QCM to perform heat straightening in strict accordance with the special provisions. ZPMC will provide the required documentation at a later date.

Submitted by:

Attachment(s): ABF-NPR-000247R00

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Caltrans' comments:

Status: AAP

Date: 25-Jun-2009

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

Please provide documentation of the heat straightening that was performed and inspection documents on all affected welds. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0253 at that time.

Submitted by: Wright, Doug

Date: 25-Jun-2009

Attachment(s):

VF-20326, MF-11711



火工校正记录

Heat Straightening Record (HSR1)

报告号 Record # HSR1(B)-6427  
 版本号 Revision # 0  
 日期 Date 2009.05.10

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:	
梁段 Gird: CB201D	质检经理/Quality Assurance Manager-Approval
塔段 Tower: N/A	
焊缝号 Weld No: 001.002	

焊缝地图号 Weld Map No: CB201D-007

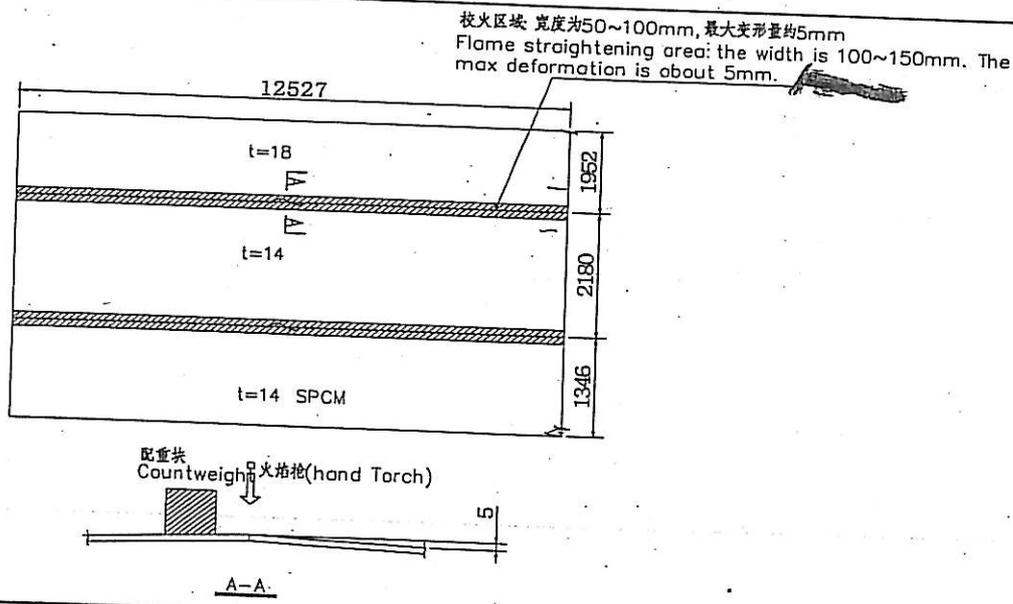
情况描述 Description of Condition

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): <600°C

简图 Sketch



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

检验员 Inspector: w.p. Huang	签字 Signature: w.p. Huang
CWI # 0208050	Closing Date: 2009.6.16.
II 级探伤 NDE Certification: Level II	
质检经理 QC Manager: [Signature]	审核日期 Review Date: [Signature]

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 [Signature] 5/10





REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-11711		DATE日期 2009.06.15		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: CB201D CROSS BEAM CB7			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 <sup>ST</sup> , 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-345F2-X 14mm			
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			
CB201D-007-002				ACC.		100%MT
AFTER HSR1(B)-6460						
BLANK						
EXAMINED BY主操 Tan Chaowei <i>Tan Chaowei</i>			REVIEWED BY 审核 <i>Sin Gong Chang</i>			
LEVEL - II SIGN 签名 / DATE日期 <i>09.06.15</i>			LEVEL-II SIGN / DATE日期 <i>09.06.15</i>			
质量经理 / QCM <i>[Signature]</i>			用户CUSTOMER			
签字 SIGN / 日期 DATE <i>09.06.15</i>			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  
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, P.R. China**Report No:** NCS-000428**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0253**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:** 21-May-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed heat straightening without an approved procedure on Crossbeam CB7 (Side Panel). The procedure presented to QA Inspector indicated that the distortion was 5mm on 18mm plate. Furthermore, the Contractor's personnel did not follow the available procedure on the shop floor. The procedure did not indicate the use of blocks under each edge of the panel as shown in the photo below.

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

Perform required NDT.

**Corrective action taken:**

Contractor submitted the HSR1 used for the heat straightening procedure as well as the NDT reports confirming that the affected welds are in compliance with Contract specifications. An internal NCR was also issued.

**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