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-000290
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 30-May-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0264

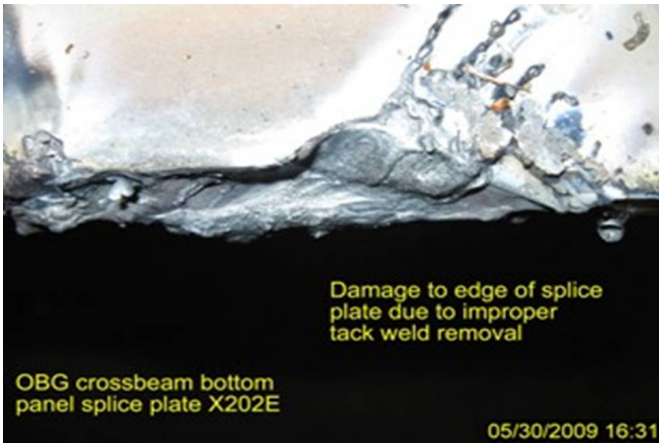
Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☑	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:** Splice Plate X202E, Crossbeam CB3/Segment 4BW
Procedural	☐	**Procedural**	☐	**Description:**		

Reference Description: Base Metal Damage During Tack Weld Removal, Crossbeam CB3/Segment 4BW

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel removing temporary tack welds from SPCM Splice Plate X202E. This splice plate was temporarily tack welded to the outside of the bottom panel on the north end of Crossbeam CB3 and OBG Segment 4BW. The worker was using an oxy/fuel torch to remove the tack welds. The edge of the splice plate was damaged at 16 areas where the tack welds were removed.



Applicable reference:

AWS D1.5 2002 section 3.3.7.3 “Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair.”

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Ping Xing Chi

Time and method of notification: 17:00, 05-30-09, Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 16:00, 06-01-09, 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 Skyler Guest, (86) 1500.042.2360, who represents the Office of Structural Materials for your project.

Inspected By:	Guest,Skyler	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:**	05-Jun-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:**	05.03.06-000254
Subject:	NCR No. ZPMC-0264		

Reference Description: Base Metal Damage During Tack Weld Removal, Crossbeam CB3/Segment 4BW

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 ZPMC personnel removing temporary tack welds from SPCM Splice Plate X202E. This splice plate was temporarily tack welded to the outside of the bottom panel on the north end of Crossbeam CB3 and OBG Segment 4BW. The worker was using an oxy/fuel torch to remove the tack welds. The edge of the splice plate was damaged at 16 areas where the tack welds were removed.

Action Required and/or Action Taken:

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

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0264

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, 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: 05.03.06-000254

Subject: NCR No. ZPMC-0264

Dated: **21-Jul-2009**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000263 Rev: 00**

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-000263R00;

Caltrans' comments:

Status: CLO

Date: 10-Aug-2009

The proposed resolution is acceptable. The approved critical weld repair report is included, and the areas of the plates in question have been accepted by VT, MT, and UT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0264 is closed.

Submitted by: Wright, Doug

Date: 10-Aug-2009

Attachment(s):

No. B-402

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-7-16

REGARDING: NCR-000290（ZPMC-0264）

With this letter of response, ZPMC requests closure for caltrans **NCR-000290（ZPMC-0264）**. According to the technology procedure we have to fix the segment deck plate with the splice plate by tack weld, but during the cause of the removing by flame, the base metal were damage with the workers' irresponsibility. Therefore we agree what describe in the non-conformance report.

We have submitted the CWR for the engineer approval, and repair the damage area or notch after received the response, right now provide the corresponding documentation to support the weld repair already done and the NDT inspection all accepted by three parties.

So base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report **NCR-000290（ZPMC-0264）**.

Please reference attached documentation for acceptance and closure the **NCR-000290（ZPMC-0264）.**

ATTACHMENT:
NCR-000290（ZPMC-0264）
ZPMC internal NCR
The approval and closed CWR
The final VT/MT/UT inspection report

Zhao Shuangbao

2009.7.16

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-B-184 (NCR-000290)

Item: Base Metal Damage Tack Weld Removal, CB3/4BW 名称描述:	Item Number: 件号: N/A	Drawing: 图号: CB3/4BW

Location: Trial assembly 位置: 外场	Date: 日期: 2009-06-11

Description of Nonconformance:

不符合项状态描述:

Caltrans Quality Assurance inspector observed ZPMC personnel removing temporary tack welds from SPCM Splice plate X202E.This splice plate was temporarily tack welded to the outside of the bottom panel on the north end of Crossbeam CB3 and OBG Segment 4BW. The worker was using on oxy/fuel torch to remove the tack welds, The edge of the splice plate was damaged at 16 areas where the tack welds were removed.

加州检验员发现 ZPMC 私自对 CB3 与 4BW 连接的连接板 SPCM X202E 去除。这块板是北侧 CB3 与 4BW 的连接板。工人用氧切割去除点焊，且对连接母材伤害多达 16 处位置。

Work By: 09.6.12 Prepared by: 6.6.11 Reviewed by QCE: Zhaoshuangbao 6.11

施工方: Xiafa Tin 准备: 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: ☐ Use as is 回用 ☐ Repair 返修 ☐ Reject 拒收

处理措施:

Recommendation:

建议: ①去除点焊之前必须通知工检师见证. ②对母材损伤返修，进行返修. 禁止再使用氧切割. ① Note engineer before removing tack welding ② repair gouged area and forbide cut by use of oxygen.

Prepared by: Du Wenbing 准备

Approved by QCA: 质量经理批准

Reason for Nonconformance:

不符合原因: 因CB3与4BW连接的连接板SPCMX202E私自去除.且用割刀去除点焊点，导致母材受伤. (Personnel removing tack weld at CB3 and 4BW connect plate X202E (SPCM) which caused base metal gouged.

预防措施: Enhance supervision and inspection on-site, and educate the worker. 加强现场监督检查，对其工教育.

Approved by/批准: Gao Jun 09.06.12

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: 对母材进行返修，此后不得用氧切割去除点焊， Repair base metal, and forbid removing tack welds by us of oxygen cutting.

Reviewed /批准: Zhaoshuangbao 6.11.09

Verification: ☑ Acceptable 可接受 ☐ Unacceptable 不可接受

确认:

Verified by QCI/质检确认: Wu zhicheng 0802751 Reviewed by QCA/质检主任审核:

#R787-QCP-1300

CB3 25

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:	05-Jun-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:	05.03.06-000254
Subject:	NCR No. ZPMC-0264		

Reference Description: Base Metal Damage During Tack Weld Removal, Crossbeam CB3/Segment 4BW

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- ☐ Non-Conformance Resolved.

Material Location: OBG Lift:

Remarks:

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Action Required and/or Action Taken:

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

Transmitted by: Stanley Ku Sr. Bridge Engineer
Attachments: ZPMC-0264

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, Jason Tom, Ching Chao
File: 05.03.06

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY Arnold Schwarzenegger, Governor

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
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Contract #: 04-0120E4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China Report No: NCR-000290
Prime Contractor: American Bridge/Fluor Enterprises, a JV Date: 30-May-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island NCR #: ZPMC-0264

Type of problem:

Welding	☐	Concrete	☐	Other	☑	
Welding	☐	Curing	☐	Procedural	☑	Bridge No: 34-0006
Joint fit-up	☐	Coating	☐	Other	☐	Component: Splice Plate X202E, Crossbeam CB3/Segment 4BW
Procedural	☐	Procedural	☐	Description:		

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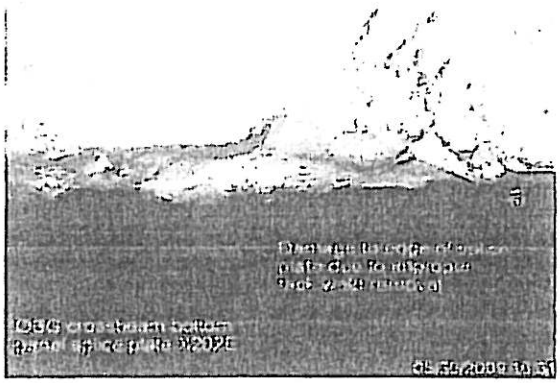
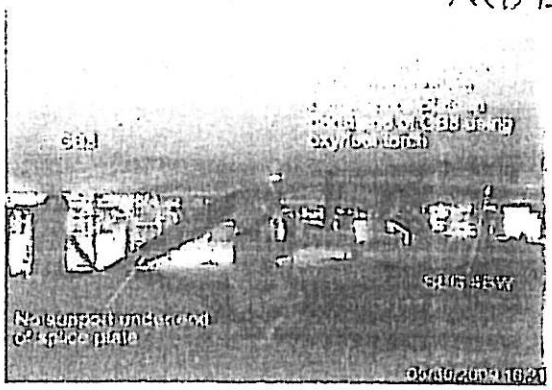
要求需修改
AWS, 报告报告





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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Time and method of notification: 16:00, 06-01-09, Verbal
QC Inspector's Name: Wang Lu
Was QC Inspector aware of the problem: ☐ Yes ☑ No
Contractor's proposal to correct the problem:

Comments:
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Inspected By:	Guest,Skyler	SMR
Reviewed By:	Wahbeh,Mazen	SMR

ZPMC	关键焊缝返修报告 Critical Welding Repair Report (CWR)				版本 Rev. No.: 1
项目名称 Project Name:	英国海湾大桥 SFOBB	部件图号 Drawing No.:	CB3	报告编号 Report No.:	B-CWR562
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	X202D,X202E Top Flange and Bottom Flange	NDT 报告编号 NDT Report No.:	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

CB3连接板X202D,X202E在去除点焊时，有局部母材损伤，最大深度5MM. 见下图:

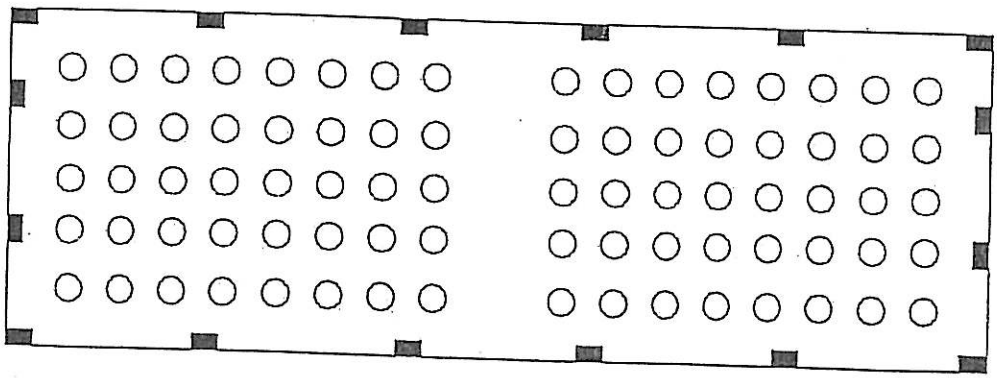
After inspection CB3 connect X202D and X202E, the base metal was gouged, maximum 5mm in depth, 500mm in length, total 4 parts, see the following draft.

检验员 (Inspector): Wang Jie Wang Jie

日期 (Date): 2009.06.13

焊缝返修位置示意图:

Draft of Welding Discontinuity:



X202D,X202E

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial [illegible] Date: 6/22/9

产生原因:

Cause:

碳刨工在去除点焊时，错误操作，导致母材损伤.

The gouger operated inappropriately during removing tack welds, which leaded to the base metal damaged.

车间负责人 (Foreman): Li zhigang 日期 (Date): 09.06.18

处理意见

Disposition :

1. QA CWI必须到现场。
2. 准备一个正确的接头型式，具体参照相应的返修WPS;
3. 将返修区域打磨光滑，开始和结束的接头交错布置;
4. 打磨后，对修补区域进行VT与MT检测;
5. 对于SPCM构件，根据批准的返修焊接工艺规程（WPS）进行预热及焊接;
6. 将修补区域打磨与母材或相邻焊缝平齐;
7. 按照AWS D1.5.3.2.2.3, 返修区域的表面和边缘，承受拉伸和反向压力的构件，返修后必须做UT和MT检测。

1. QA CWI Presence.
2. Prepare excavation according to the approved repair WPS.
3. Grind the repair area to a smooth and shiny finish, with tapered ends, to ensure staggered st arts and stops.
4. VT and MT the repair area after grinding.
5. Preheat and weld according to the relevant repair WPS for SPCM member.
6. Grind the repaired area flush with base metal or the adjacent weld.
7. Per AWS D1.5.3.2.2.3, welded repairs to the surfaces and edges of tension and reversal of stress Members shall be subject to UT and MT;

工 艺:
Technical Engineer: Nie Tiefang

审核:
Approved By: Liu Yanhua for chenbin

日期:
Date: 09.06.19

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial [illegible] Date: 6/22/9

关键焊缝返修报告
Critical Welding Repair Report (CWR)

ZPMC				版本 Rev. No.:	1
项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	CB3	报告编号 Report No.:	B-CWR562
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	X202D,X202E Top Flange and Bottom Flange	NDT 报告编号 NDT Report No.:	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

培训和教育碳刨工，提高技术和水平，加强构件制作过程中的监控，减少误差。

Train and educate gouger to improve technology and skill and enhance supervision and controlling in process of fabrication to reduce error.

车间负责人 (Foreman): Li Zhiqing 日期 (Date): 09.6.18

参照的WPS编号 Repair WPS No.:	WPS-SMAW-345-1G(1F) -Repair WPS-FCAW-345-1G(1F)- Repai-1 WPS-SMAW-345-1G(1F)-SPCM-Repair WPS-FCAW-345-1G(1F)-SPCM-Repai-1	工艺员 Technologist:	Niu Tianfang 09.06.19
返修（碳刨）前预热温度 Preheat Temperature Before Gouging:	90°C	返修的缺陷 Description of Discontinuity:	Base metal is damaged 母材损伤.
焊前处理检查 Inspection Before Welding:	ACC	焊前预热温度 Preheat Temperature Before Welding:	110°C
最大碳刨深度 Max. Depth of Gouge:	8mm	碳刨总长 Total Length of Gouge:	900 mm

焊工 Welder:	048659	焊接类型 Welding Type:	SMAW	焊接位置 Position:	1G
焊接电流 Current:	165	焊接电压 Voltage:	24.5	焊接速度 Speed:	132

返修后检查 Inspection After Repair:

外观检查 VT Result:	ACC	检验员 Inspector:	Wen Zhao Gang 07120761	日 期. Date:	09.06.19
NDT复检 NDT Result:	OK	探伤员 NDT Person:	Gaofeng	日期 Date:	09.7.7

见证： Witness/Review:

备注： Remark :

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial [illegible] Date: 6/22/09

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号 B787-UT-7521	DATE 2009.07.07	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 部件名称 OBG PLATE PANEL SPLICE	DRAWING NO.: 图号 CB3	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号
REFERENCING CODE 参考规范 AWS D1.5-2002	ACCEPTANCE STANDARD接受标准 AWS D1.5-2002(Table 6.3)	PROCEDURE NO. 程序编号 ZPQC-UT-01
WELDING PROCESS 焊接方法 NA	JOINT TYPE 焊缝类型 NA	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28ST ,2009

EQUIPMENT 设备 UT SCOPE	MANUFACTURER 制造商 PANAMETRICS	MODEL NO. 样式编号 EPOCH-4B	SERIAL NO. 序列编号 071565311, 061488510, 061495811, 070152011,
CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE Ⅱ	COUPLANT 耦合剂 C.M.C	MATERIAL/THICKNESS 材料厚度 A709M-345F2-X 22mm	

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	18×18mm				
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	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
X202D		0				20								ACC.	100%
X202E		0				20								ACC.	100%

BASE METAL PER B-CWR562

BLANK

EXAMINED BY主探 Han Feng 09.07.07 LEVEL - II SIGN / DATE	REVIEWED BY 审核 Huang Jin 09.07.07 LEVEL - II SIGN / DATE
质量经理 / QCM 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

B3T3315

ZPMC		周数	87
		日期	2009.06.28

Visual Weld Inspection Report 焊缝目视检查报告	Girder/ 梁:	OBG PlatePanelSplice	
	Tower/ 塔:		
Caltrans Contract No. 加州合同编号: 04-0120F4	Quality Control Representative: 质检代表:		
Project No.: 项目名称: San Francisco Oakland Bay Bridge 美国海湾大桥	CWI: 检验员:	Luan zhao gang 07120761	
Project No.: 项目编号: ZP06-787	Quality Assurance Manager ~Approval 质量控制经理:		

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 返修后接受或拒收
NA	048659	1G	THJ506Fe-14(Ø4.0)	√	√	√	√	√	√	√	√	√	√

☐ After root weld ☐ After cover pass

☑ After CWR or WRR No.:B-CWR562 ☐ After HSR No.: ☐ Others

#R787-QCP-603

" √ " is no defects. " X " is defects. "NA" is not applicable.

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12155	DATE日期 2009.06.14	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:	CB3 OBG CORSS BEAM	CALTRANS CONTRACT NO.: 加州工程编号	04-0120F4

REFERENCING CODE 参考规范编码	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号	CALIBRATION DUE DATE 仪器校正有效期
AWS D1.5-2002	AWS D1.5-2002	ZPQC-MT-01	Dec. 28ST ,2009

EQUIPMENT 设备	MANUFACTURER 制造商	MODEL NO. 样式编号	SERIAL NO. 连续编号
MT YOKE	PARKER	B310S	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-345F2-X 16/22 mm
WELDING PROCESS 焊接方法	SMAW/FCAW	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			
X202D/E				ACC.		AFTER GOUGING
AFTER B-CWR562						
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Jin Jianting Jin Jianting 09.06.1X	Sun Gongchang Sun Gongchang 09.06.1X
LEVEL - II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
质量经理 / QCM	用户CUSTOMER
签字 SIGN / 日期 DATE	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
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 #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCS-000267
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 25-Aug-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0264

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: 30-May-2009

Description of Non-Conformance:
Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel removing temporary tack welds from SPCM Splice Plate X202E. This splice plate was temporarily tack welded to the outside of the bottom panel on the north end of Crossbeam CB3 and OBG Segment 4BW. The worker was using an oxy/fuel torch to remove the tack welds. The edge of the splice plate was damaged at 16 areas where the tack welds were removed.

Contractor's proposal to correct the problem:
Repair area in question and perform subsequent NDT.

Corrective action taken:
Contractor submitted CWR along with VT, MT, and UT reports verifying repair was performed in conformance with Contract requirements.

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