

**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-000310

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 08-Jun-2009

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

**NCR #:** ZPMC-0284

**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> OBG Crossbeam CB5
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Improper Cleaning of Weld Areas Prior to MT, Weld CB202C-001-003, Crossbeam CB5

**Description of Non-Conformance:**

Caltrans Quality Assurance QA) Inspector observed that the Contractor has performed magnetic particle testing (MT) prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (Crossbeam CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.

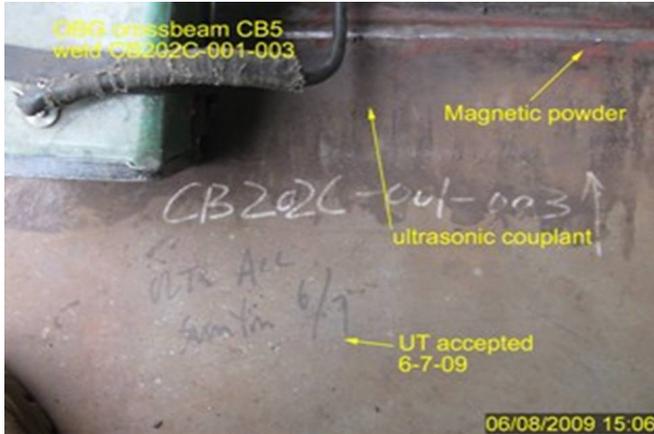


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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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## Applicable reference:

AWS D1.5 2002 Section 6.7.6.3 "Prior to MT, the surface shall be examined, and any adjacent area within at least 25 mm [i in.] of the surface to be tested, shall be dry and free of contaminants such as oil, grease, loose rust, loose sand, loose scale, lint, thick paint, welding flux, and weld spatter."

ASTM E709: Paragraphs 9.1 and 15.1.2

**Who discovered the problem:** Steve Hall

**Name of individual from Contractor notified:** Peter Ferguson

**Time and method of notification:** 06/08/09, 17:00, Email

**Name of Caltrans Engineer notified:** Stanley Ku

**Time and method of notification:** 06/09/09, 10:00, 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 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
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<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:** 14-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:** 05.03.06-000274

**Subject:** NCR No. ZPMC-0284

**Reference Description:** Improper Cleaning of Weld Areas Prior to MT, Weld CB202C-001-003, Crossbeam CB5

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:** Xbeam **Lift:** 06

### Remarks:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed magnetic particle testing (MT) prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (Crossbeam CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.

See NCR report No. ZPMC-284 for details.

### Action Required and/or Action Taken:

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

**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0284

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, 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:** 05.03.06-000274

**Subject:** NCR No. ZPMC-0284

**Dated:** 24-Aug-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000310 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ABF QCM has had several discussions with ZPMC MT technicians regarding MT over coatings and MT over contaminants. ABF has instructed ZPMC to clean the weld as required and re-MT.

ABF QCM has had several discussions with ZPMC MT technicians regarding MT over coatings and MT over contaminants. ABF has instructed ZPMC to clean the weld as required and re-MT. ZPMC will submit MT reports at a later date to close this NCR.

### Submitted by:

**Attachment(s):** ABF-NPR-000310R00

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### Caltrans' comments:

**Status:** AAP

**Date:** 31-Aug-2009

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

Please provide documentation of the weld in question is acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0284 at that time.

**Submitted by:** Wright, Doug

**Date:** 31-Aug-2009

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Dated:** 14-Dec-2009

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

**Attention:** Pursell, Gary  
Resident Engineer

**Job Name:** SAS Superstructure

**Ref:** 05.03.06-000274

**Document No.:** ABF-NPR-000310 **Rev:** 01

**Subject:** NCR No. ZPMC-0284

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### Contractor's Proposed Resolution:

**Reference Resolution:** Per the internal NCR the weld was cleaned and NDT was performed again after and found acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC QA has issued an internal NCR to the QC Department for improper cleaning of the weld prior to NDT. Per the internal NCR the weld was cleaned and NDT was performed again after and found acceptable. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000310R01;

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### Caltrans' comments:

**Status:** CLO

**Date:** 20-Dec-2009

Correct documentation for the weld in question has been received.

**Submitted by:** Howe, Bill

**Date:** 20-Dec-2009

**Attachment(s):**



No. B-524

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2009-12-10**

**REGARDING: NCR-000393(ZPMC-0367) NCR-000310(ZPMC-0284)**

With this letter of response, ZPMC requests closure for CALTRANS NCR-000393(ZPMC-0367) & NCR-000310(ZPMC-0284) what mentioned that QA observed missed MT indication & improper cleaning of weld areas prior to MT.

ZPMC acknowledged these problems and has issued internal NCRs.

For regarding of NCR-000393(ZPMC-0367), ZPMC arranged grinder and removed the linear indication by a little grinding on site. After repair MT were done to warrant this weld's quality.

For regarding of NCR-000310(ZPMC-0284), ZPMC cleaned the welds areas then MT was performed again. As required form ABF-NPR-000310 R0., ZPMC will provide NDT documentation to CALTRANS.

And to enhance our MT inspection, training was performed to all the MT inspectors by ABF's QCM. So ZPMC provide internal NCRs, MT documentations and Training Record, hoping CALTRANS could take a review and consider close these NCRs.

**ATTACHMENT:**

NCR-B-253

NCR-B-187

NCR-000393(ZPMC-0367)

NCR-000310(ZPMC-0284)

B787-MT-16603

B787-MT-12018

ABF-NPR-000310 R0.

*Ly*  
*12/10/09*





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:** 01-Sep-2009

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

**Dear:** Mr. Charles Kanapicki  
**Attention:** Mr. Thomas Nilsson Project/Fabrication Manager  
**Job Name:** SAS Superstructure

**Subject:** NCR No. ZPMC-0367  
**Document No:** 05.03.06-000355

**Reference Description:** Missed MT transverse indication by QC on OBG Floorbeam 24

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:**

During random verification Magnetic Particle Testing (MT) for the OBG Floor Beam at Bay # 3, this Caltrans Quality Assurance Inspector (QA) observed one (1) transverse linear indication approximately 6mm in length in the weld metal on FB024-010-079. This area has been previously tested and accepted by ZPMC MT Technician.

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

Submit a repair procedure to the engineer for approval.

Note: Missing MT indications by ZPMC QC is an on going problem.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0367

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao  
**File:** 05.03.06

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

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

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

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000393

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 19-Aug-2009

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

NCR #: ZPMC-036

### Type of problem:

Welding  Concrete  Other   
 Welding  Curing  Procedural  Bridge No: 34-0006  
 Joint fit-up  Coating  Other  Component: OBG Floorbeam 24  
 Procedural  Procedural  Description: Missed MT indication

Reference Description: Missed MT transverse indication by QC on OBG Floorbeam 24

### Description of Non-Conformance:

During random verification Magnetic Particle Testing (MT) for the OBG Floor Beam at Bay # 3, this Caltrans Quality Assurance Inspector (QA) observed one (1) transverse linear indication approximately 6mm in length in the weld metal on FB024-010-079. This area has been previously tested and accepted by ZPMC MT Technician.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )



**Applicable reference:**

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

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

**Who discovered the problem:** Naddi Sandeep Kumar

**Name of individual from Contractor notified:** Luo Gui Lin

**Time and method of notification:** 15:00, Verbal

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 13:00 Email

**QC Inspector's Name:** Yang Qing Feng

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

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

N/A

**Comments:**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

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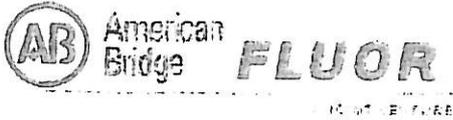
**Inspected By:** Tsang, Eric SMR

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**Reviewed By:** 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: 24-Aug-2009

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

Attention: Pursell, Gary  
Resident Engineer

Job Name: SAS Superstructure

Ref: 05.03.06-000274

Document No.: ABF-NPR-000310 Rev: 00

Subject: NCR No. ZPMC-0284

**Contractor's Proposed Resolution:**

**Reference Resolution:** ABF QCM has had several discussions with ZPMC MT technicians regarding MT over coatings and MT over contaminants. ABF has instructed ZPMC to clean the weld as required and re-MT.

ABF QCM has had several discussions with ZPMC MT technicians regarding MT over coatings and MT over contaminants. ABF has instructed ZPMC to clean the weld as required and re-MT. ZPMC will submit MT reports at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000310R00

Caltrans' comments:

Status: AAP

Date: 31-Aug-2009

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

Please provide documentation of the weld in question is acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0284 at that time.

Submitted by: Wright, Doug

Date: 31-Aug-2009

Attachment(s):





# 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-187  
 (NCR-000310)

Item: Improper Cleaning of Weld  
 Area Prior to MT  
 名称描述: MT 前表面未清理干净

Item Number:  
 件号: N/A

Drawing:  
 图号: CB202C-001-003

Location: OBG Crossbeam CB5  
 位置: OBGCB5

Date:  
 日期: 2009-06-19

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

Caltrans Inspector observed that the Contractor has performed magnetic particle testing prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (CROSSBEAM CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.

加州检验员发现车间人员在进行 MT 前没有对母材及焊缝进行合适的清理。焊缝编号为 CB202C-001-003 (扭曲横梁 CB5)。焊缝以及邻近的母材上覆盖着 UT 耦合剂残留物。

参考标准: AWS D1.5 章节 6.7.6.3 "MT 之前, 必须检验表面, 至少被检表面邻近 25mm 区域内必须干燥, 并且无诸如油、润滑脂、铁锈、砂粒、氧化皮、棉线头、厚漆层、焊接飞溅等污染物"。

Work By: Li Li ming Prepared by: Li Li ming Reviewed by QCE: Zhaoshuang  
 施工方: 2009.06.19 准备: 6/19/09 质量工程师批准: 6.19  
 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: 去除污染物后重新检测. Remove dirty and re-inspection.

Prepared by: Li Li ming Approved by QCA: \_\_\_\_\_  
 准备: 2009.06.19 质量经理批准

Reason for Nonconformance:

不符合原因: 检测表面未清理干净. Didn't clean inspection surface completely.

预防措施: 加强教育培训. Enhance education and training.  
 Approved by/批准: Li Li ming 2009.06.19

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

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:

**NON-CONFORMANCE REPORT TRANSMITTAL**

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

**Date:** 14-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:** 05.03.06-000274

**Subject:** NCR No. ZPMC-0284

**Reference Description:** Improper Cleaning of Weld Areas Prior to MT, Weld CB202C-001-003, Crossbeam CB5

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:** Xbeam

**Lift:** 06

**Remarks:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed magnetic particle testing (MT) prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (Crossbeam CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.

See NCR report No. ZPMC-284 for details.

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

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

**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0284

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, 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  
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Contract #: 04-0120F4  
 Cty: SF/ALA Rte: 80 PM: 13.2/13.9  
 File #: 69.25B

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

**Report No:** NCR-000310

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 08-Jun-2009

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

**NCR #:** ZPMC-0284

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural

**Bridge No:** 34-0006

Joint fit-up  Coating  Other

**Component:** OBG Crossbeam CB5

Procedural  Procedural  Description:

**Reference Description:** Improper Cleaning of Weld Areas Prior to MT, Weld CB202C-001-003, Crossbeam  
 CB5

### Description of Non-Conformance:

Caltrans Quality Assurance QA) Inspector observed that the Contractor has performed magnetic particle testing (MT) prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (Crossbeam CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.



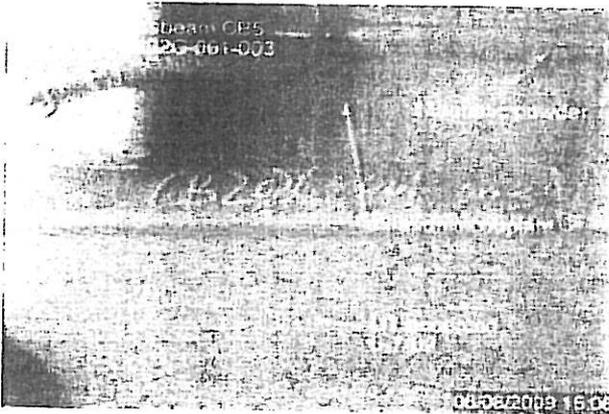
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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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(Continued Page 2 of 2)

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**Applicable reference:**

AWS D1.5 2002 Section 6.7.6.3 "Prior to MT, the surface shall be examined, and any adjacent area within at least 25 mm [1 in.] of the surface to be tested, shall be dry and free of contaminants such as oil, grease, loose rust, loose sand, loose scale, lint, thick paint, welding flux, and weld spatter."

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ASTM E709: Paragraphs 9.1 and 15.1.2

**Who discovered the problem:** Steve Hall  
**Name of individual from Contractor notified:** Peter Ferguson  
**Time and method of notification:** 06/08/09, 17:00, Email  
**Name of Caltrans Engineer notified:** Stanley Ku  
**Time and method of notification:** 06/09/09, 10:00, 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 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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REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12018      DATE日期 2009.06.29      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: CB202C      CALTRANS CONTRACT NO.: 04-0120F4  
 CB5 CROSS BEAM      加州工程编号

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:  WELDING 焊接件      Material & thickness 母材, 厚度: A709M-345F2-X  
 CASTING 铸件      12mm  
 FORGING 锻造

WELDING PROCESS 焊接方法: FCAW      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			
CB202C-001-003				ACC.		100%MT

AFTER HSR1 (B) -6670

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EXAMINED BY主探 Shang Xueqiang <i>Shang Xueqiang</i> LEVEL-II SIGN 签名 / DATE日期 09.06.29 质量经理 / QCM	REVIEWED BY 审核 <i>Sun Goh Chong</i> LEVEL-II SIGN / DATE日期 09.06.29 用户CUSTOMER
签字 SIGN / 日期 DATE <i>[Signature]</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-000429**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0284**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:** 08-Jun-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed magnetic particle testing (MT) prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (Crossbeam CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.

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

Remove indication by means of grinding.

**Corrective action taken:**

Indication was removed by grinding, NDT reports verifying the weld is now in conformance with Contract specifications was submitted and the NDT Technician received additional training.

**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