

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



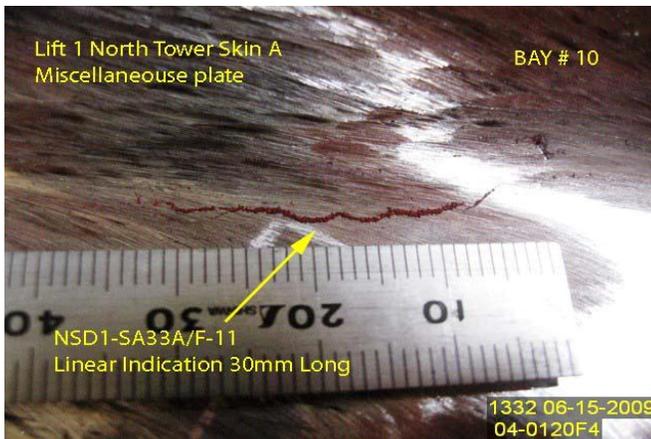
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000320**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0294**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: North Tower, Lift 1
Procedural	Procedural	Description: Missed MT indication on North Tower, Lift 1	

Reference Description: Missed MT indication on North Tower, Lift 1, Skin A plate weld**Description of Non-Conformance:**

QA discovered an approximately 30mm long linear indication during random verification Magnetic Particle Testing (MT) of North Tower, Lift 1, Skin A plate weld NSD1-SA33A/F-11. This weld was previously tested and accepted by ZPMC QC MT Technicians.

**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 D1.5-2002, Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Who discovered the problem: Dhanasingh Sukanthan**Name of individual from Contractor notified:** Liu Cheng

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 6/15/09, 13:45; Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 6/16/09, 8:00; Verbal

QC Inspector's Name: Lu Yang

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:	16-Jun-2009
Dear:	Mr. Charles Kanapicki	Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Attention:	Mr. Thomas Nilsson Project/Fabrication Manager	Job Name:	SAS Superstructure
Subject:	NCR No. ZPMC-0294	Document No:	05.03.06-000283

Reference Description: Linear Indication (MT) / North Shaft Lift 1 / Skin A Plate Weld

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:** 01

Remarks:

QA discovered an approximately 30mm long linear indication during random verification Magnetic Particle Testing (MT) of North Tower, Lift 1, Skin A plate weld NSD1-SA33A/F-11. This weld was previously tested and accepted by ZPMC QC MT Technicians.

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AWS D1.5-2002, Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Action Required and/or Action Taken:

Propose a resolution for this systematic non-conformance that addresses the failure of Quality Control to identify the linear indication (MT). Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

In addition to the Quality Control failure, propose a resolution for the identified material/workmanship non-conformance, documenting that the repaired weld is in compliance with the contract requirements.

Recent failures by Quality Control to identify linear indications have resulted in the issuance of NCR ZPMC-0212, ZPMC-0216, ZPMC-0231, ZPMC-0223, ZPMC-0234, ZPMC-0235, ZPMC-0291 and ZPMC-0293 related to Tower and ZPMC-0244, ZPMC-0245, ZPMC-0258, ZPMC-0278, ZPMC-0279, ZPMC-0281, ZPMC-0285, ZPMC-0289 and ZPMC-0290 related to OBG.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0294

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe

NCT

(Continued Page 2 of 2)

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000283

Subject: NCR No. ZPMC-0294

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000312 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has notified ZPMC of the missed MT indications and ZPMC has completed the necessary repairs. ABF is also conducting an investigation of why ZPMC is experiencing cracking of welds.

ABF has notified ZPMC of the missed MT indications and ZPMC has completed the necessary repairs. ABF has taken action by hiring several MT technicians to perform overchecks of several types of welds due to the amount of missed indications. ABF is also conducting an investigation of why ZPMC is experiencing cracking of welds. This investigation is being performed by both onsite ABF personnel as well as welding experts hired by ABF for this purpose. Recently CT has brought in their own welding consultant to discuss ABF findings and preventive actions. Preventive actions such as increased preheats have been discussed with ZPMC. When the investigation is completed, ABF will submit the findings to ZPMC and CT. ABF will continue to perform overchecks until we are sure this issue is corrected and preventive actions are implemented. ZPMC will submit the repair documents at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000312R00

Caltrans' comments:

Status: REJ

Date: 01-Sep-2009

The Department will consider closure of this NCR once the repair documents are submitted, reviewed and found to be acceptable.

Submitted by: Lee, Ken

Date: 01-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000283

Subject: NCR No. ZPMC-0294

Dated: 18-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000312 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has now included the necessary documentation to provide objective evidence repair work has been completed. ZPMC requests closure of this NCR.

ZPMC has now included the necessary documentation to provide objective evidence repair work has been completed. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000312R01;

Caltrans' comments:

Status: CLO

Date: 20-Sep-2009

The proposed resolution is acceptable. The welding repair report is included, and the weld in question has been accepted by MT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-294 is closed.

Submitted by: Lee, Ken

Date: 20-Sep-2009

Attachment(s):



No. T-060

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-9-17

REGARDING: NCR-000320(ZPMC-0294)

ZPMC received NCR-000320(ZPMC-0294), they mentioned that CT inspector discovered an approximately 30mm length linear indication on Lift 1 North Tower Skin A weld, which were previously tested and accepted by ZPMC. The relational welds were NSD1-SA33A/F-11.

ZPMC acknowledged this problem, and already put forward ZPMC's NCR-T-052. As a result, ZPMC had removed the defect by grinding and repaired them, then performed final inspection by MT. Also these welds were re-inspected by CT inspector and green tagged. In order to avoid such problem occurs again ZPMC will perform NDT work according to related procedures strictly, and enhance QC be more responsible. Here attached the WRR and MT Reports to prove the welds are qualified after repairing.

So ZPMC hope Caltrans could have a review and close this NCR.

ATTACHMENT:

NCR-000320(ZPMC-0294)

ZPMC NCR: NCR-T-052

T-WRR2173

T787-MT-5892


2009-9-17

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: 16-Jun-2009
Contract No: 04-0120F4
04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0294

Job Name: SAS Superstructure
Document No: 05.03.06-000283

Reference Description: Linear Indication (MT) / North Shaft Lift 1 / Skin A Plate Weld

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Lift: 01

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Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0294

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe

05.03.06-000283,NCT

NCT

(Continued Page 2 of 2)

File: 05.03.06

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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-000320

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2009

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

NCR #: ZPMC-0294

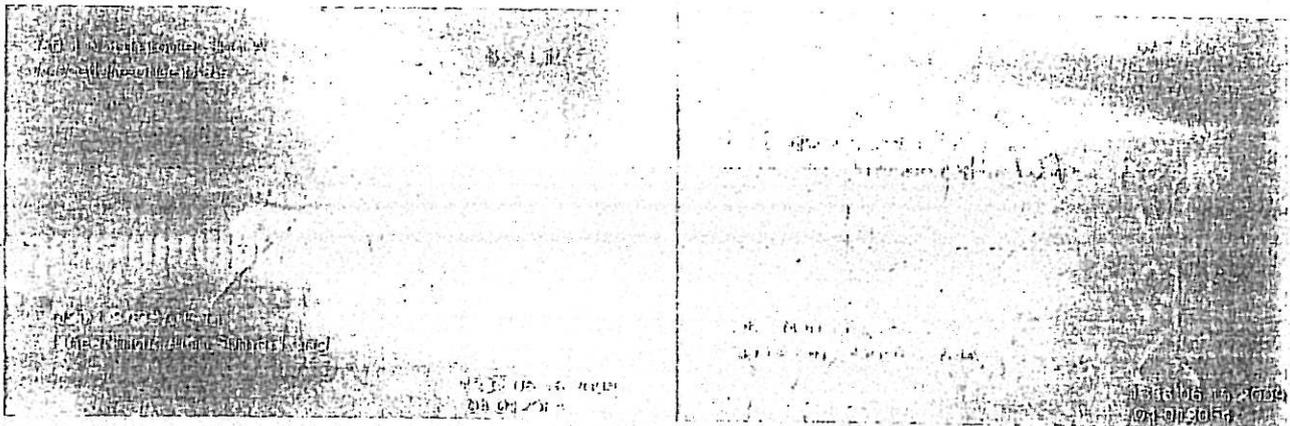
Type of problem:

Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: North Tower, Lift 1
Procedural Procedural Description: Missed MT indication on North Tower, Lift 1

Reference Description: Missed MT indication on North Tower, Lift 1, Skin A plate weld

Description of Non-Conformance:

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Applicable reference:

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Who discovered the problem: Dhanasingh Sukanthan

Name of individual from Contractor notified: Liu Cheng

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 6/15/09, 13:45; Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 6/16/09, 8:00; Verbal

QC Inspector's Name: Lu Yang

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-052 (ZPMC-0294)
Item: miss MT linear indication 名称描述: MT 漏检	Item Number: 件号: North shaft lift 1 Skin A Plate Weld	Drawing: 图号: NSD1-SA33A/F-11
Location: bay 10 位置: 10#车间		Date: 日期: 2009-06-17

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

CT inspector discovered an approximately 30mm long linear indication during random verification Magnetic Particle Testing of North Tower, Lift 1, Skin A plate weld NSD1-SA33A/F-11. This weld was previously tested and accepted by ZPMC QC MT technicians.

Special Provisions Section 8.3: Quality Control 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 D1.5-2002, Section 6.26.2: Welds that are subject to MT in addition to visual inspection shall have no cracks.

CT 检验员在对北一 A 面电器孔焊缝 NSD1-SA33A/F-11 进行 MT 复探时发现了 30mm 长的线性缺陷。

根据标书规定: 承包方有必须对焊缝做好检验工作以保证焊缝符合标书和工艺文件的要求; 根据 AWS 规定: 除目检之外进行 MT 检测的焊缝严禁有裂纹。

Work By: <u>Li Liming</u> 施工方: <u>2009.06.17</u>	Prepared by: <u>Zhang Junchen</u> 准备: <u>2009.06.17</u>	Reviewed by QCE: 质量工程师批准:
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: 处理措施:	<input type="checkbox"/> Use as is 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
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Recommendation:

建议:

复检确认是否返修

Re-inspection and repair it if it affirms.

Prepared by: <u>Li Liming</u> 准备: <u>2009.06.17</u>	Approved by QCA: _____ 质量经理批准
--	----------------------------------

Reason for Nonconformance:

不符合原因:

线性缺陷没有检测到。

Linear indication wasn't been inspected.

Prevention of Re-occurrence:

预防措施:

加强专业学习, 加强现场监督。

Enhance professional Learning and supervision on-site.

Approved by/批准:

Li Li 2009.9.6.

Technical Justification for Use-As-Is/Repair:

回用或返修的技术依据:

Attachment

附件

Non-attachment

无附件

Reviewed /批准: _____

Verification:

Acceptable

确认:

可接受

Unacceptable

不可接受

Verified by QCI/质检确认: _____

Reviewed by QCA/质检主任审核: _____

#R787-QCP-1300

产生原因:

Caused:

打磨工操作失误, 导致母材损伤。

Operator operated error caused base metal gouged.

车间负责人(Foreman): *Lishiqian* 日期(Date): *09-09-15*

处理意见

Disposition :

1. QC shall monitor and direct the welder and the grinder doing the repair operation.
2. Preheat before gouging; the temperature shall be at least 65°C.
3. Gouge the weld to remove identified defects.
4. Joint details shall refer to the approved WPS repair.
5. Grind the gouged areas to a smooth and shiny surface.
6. Verify with VT and MT to ensure no defects remain in the weld joint prior to welding.
7. QC shall monitor all welding passes being deposited.
8. QC shall ensure all slag has been removed prior the deposition of next pass.
9. Preheat and maintain interpass temperature control in accordance with the WPS.
10. Blend the weld repaired areas into the adjacent weld or base metal by grinding.
11. Perform VT, MT and UT NDT inspection to the repaired areas.

- 1、在返修过程中, QC 应该监控和指导焊工和打磨工;
- 2、碳刨之前必须先进行预热, 温度不低于 65° C;
- 3、碳刨去除缺陷;
- 4、缺陷被完全清除后, 必须准备一个正确的接头型式, 具体接头型式请参见对应的修补焊接工艺规程(WPS);
- 5、将碳刨面打磨光滑;
- 6、在准备好焊接接头焊接前, 用 VT 和 MT 检测缺陷被完全清除;
- 7、在返修过程中, QC 确认焊道清理干净;
- 8、在进入下到焊缝前, QC 应该保证所有的缺陷已经去除;
- 9、根据 WPS 控制预热和焊道的温度;
- 10、打磨返修区域与临近焊缝和母材其平;
11. VT, MT 和其它 NDT 检测焊缝。

工艺: *Li Changping* *9.15/09*
Technical engineer

审核: *Lu Jianhua*
Approved by *09.9.15*

日期
Date



焊缝返修报告

Welding Repair Report

版本 Rev. No.

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	p967	报告编号 Report No.	T-WR2173
合同号 Contract No.:	04-0120F4	部件名称 Items Name	北塔一吊A面板 Tower(N) first lifting Skin A	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

培训和教育操作工, 提高操作水平。

Train and educate operator to improve skill.

 车间负责人(Foreman): *Li Shiqian* 日期(Date): *09.09.15*

参照的WPS编号 Repair WPS No.	WPS-345-FCAW -1G (1F)-Repair WPS-345-FCAW -2G (2F)-Repair WPS-345-FCAW -3G (3F)-Repair WPS-345-FCAW -4G (4F)-Repair	工艺员 technologist	<i>Li Changping 9.15/09</i>
返修(碳刨)前预热温度 Preheat temperature before gouging	<i>grain clean</i>	返修的缺陷 Description of discontinuity	<i>slag</i>
焊前处理检查 Inspection before welding	<i>VT Acc MT Acc</i>	焊前预热温度 Preheat temperature before welding	<i>205 °C</i>
最大碳刨深度 Max. depth of gouging	<i>NA</i>	碳刨总长 Total length of gouging	<i>NA</i>
焊工 welder	<i>040333</i>	焊接类型 welding type	<i>SAW</i>
焊接电流 Current	<i>170A</i>	焊接电压 Voltage	<i>25.4 V</i>
		焊接位置 position	<i>2G</i>
		焊接速度 Speed	<i>105 mm/min</i>
返修后检查 Inspection After repairing:			
外观检查 VT result	<i>VT Acc</i>	检验员 Inspector	<i>Li Changping</i>
NDT复检 NDT result	<i>MT Acc</i>	探伤员 NDT person	<i>Li Changping</i>
日期 Date		日期 Date	<i>09.09.15</i>
日期 Date		日期 Date	<i>09.09.16</i>
见证: Witness/Review:			
备注: Remark:			



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-5892 DATE日期 2009.09.16 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-SA33A/F THE 1ST LIFTING TOWER (N) 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
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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
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MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
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PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
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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 50/70 mm
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WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT
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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-SA33A/F-11				ACC.		100%MT

AFTER T- WR 2173

BLANK

EXAMINED BY 主探 Gu Yunwu <i>Gu Yunwu</i> 09.09.16. LEVEL - II SIGN 签名 / DATE 日期	REVIEWED BY 审核 <i>Cai xin xia</i> 09.09.16. LEVEL-II SIGN / DATE 日期
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质量经理 / QCM <i>Lu Jianhua</i> 09.09.16 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE
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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, PRC**Report No:** NCS-000303**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0294**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: 15-Jun-2009**Description of Non-Conformance:**

QA discovered an approximately 30mm long linear indication during random verification Magnetic Particle Testing (MT) of North Tower, Lift 1, Skin A plate weld NSD1-SA33A/F-11. This weld was previously tested and accepted by ZPMC QC MT Technicians.

Contractor's proposal to correct the problem:

Repair affected weld and submit NDT results indicating sound weld.

Corrective action taken:

NDT results indicating sound welds have been submitted. The weld has been verified by QA and subsequently green tagged.

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