

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-000323

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2009

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

NCR #: ZPMC-0297

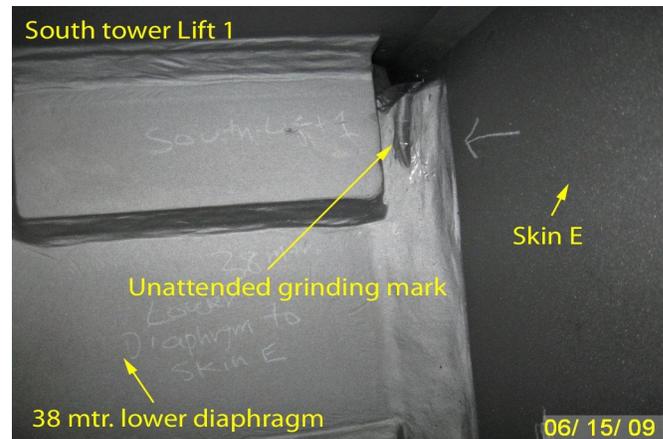
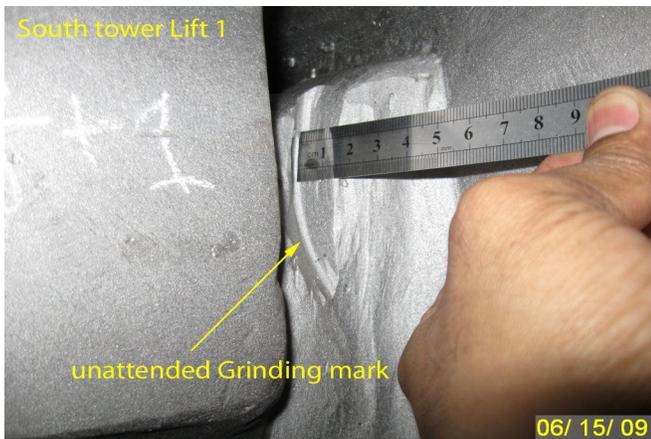
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: South Tower, Lift 1
Procedural	Procedural	Description: South Tower, Lift 1 weld gouge	

Reference Description: Tower, Lift 1, 38m diaphragm to skin E weld gouge

Description of Non-Conformance:

QA observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel.



Applicable reference:

AWS D 1.5-2002, Section 3.7.1 - "The removal of weld metal or portions of the base metal may be done by machining, air carbon arc cutting and gouging, thermal cutting, chipping, or grinding. It shall be done in such a manner that the remaining weld metal or base metal is not nicked or undercut..."

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."

Who discovered the problem: Baskar Govindarajan

Name of individual from Contractor notified: ZhangBin Jian

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 6-15-09, 13:34; Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 6-17-09, 8:00; Verbal

QC Inspector's Name: Ken Zhang

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: 18-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: 05.03.06-000286

Subject: NCR No. ZPMC-0297

Reference Description: Gouge Weld Metal / South Shaft Lift 1 / 38m Diaphragm to Skin E 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 observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel.

AWS D 1.5-2002, Section 3.7.1 - "The removal of weld metal or portions of the base metal may be done by machining, air carbon arc cutting and gouging, thermal cutting, chipping, or grinding. It shall be done in such a manner that the remaining weld metal or base metal is not nicked or undercut..." 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."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance including documentation that the weld has been brought into compliance with the contract requirements. Additionally address actions that will be taken to limit future occurrences.

In addition to the material/workmanship non-conformance, propose a resolution that addresses the failure of Quality Control to identify the gouge during visual inspection of the weld. Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

Recent failures by Quality Control to identify deficiencies during visual inspection have resulted in the issuance of NCR ZPMC-0250, ZPMC-0292 (Tower) and ZPMC-0258 (OBG).

Transmitted by: Scott Kennedy Sr. Bridge Engineer
Attachments: ZPMC-0297

NCT

(Continued Page 2 of 2)

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000286

Subject: NCR No. ZPMC-0297

Dated: 13-Jul-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000258 **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-000258R00;

Caltrans' comments:

Status: AAP

Date: 07-Aug-2009

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

The 12mm deep excavation in the weld would have been required a repair. Please provide documentation of the weld repairs that were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0297 at that time.

Submitted by: Wright, Doug

Date: 07-Aug-2009

Attachment(s):



No. T-030

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-6-25

REGARDING: NCR-000323 ZPMC-0297

ZPMC received NCR-000323(ZPMC-0297), the original contents is: "QA observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel".

In fact it couldn't be any arc gouging or welding in the blasting shop, so the original words "QA observed a 12mm deep gouge" is unreasonable. such weld has already been checked and green tagged by ZPMC, AB/F and finally verified by CT before blasting. So the original sentence: "This weld was previously accepted by ZPMC QC personnel" is unfair to both ZPMC and AB/F.

After investigating with AB/F and CT site inspector, the truth is that after blasting, CT inspector found some indications on the weld surface, so ZPMC production performed grinding to remove it. It's normal and acceptable that some indications can be revealed after blasting which previously couldn't be found by VT, also it's allowable to perform grinding in order to remove the indication.

So ZPMC request CT could withdraw this NCR.

ATTACHMENT:

NCR: ZPMC-0297

Zhang Jw di 2009.6.25

CI 100
FCP



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:	18-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-0297	Document No:	05.03.06-000286
Reference Description:	Gouge Weld Metal / South Shaft Lift 1 / 38m Diaphragm to Skin E 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 observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel.

AWS D 1.5-2002, Section 3.7.1 - "The removal of weld metal or portions of the base metal may be done by machining, air carbon arc cutting and gouging, thermal cutting, chipping, or grinding. It shall be done in such a manner that the remaining weld metal or base metal is not nicked or undercut..." 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."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance including documentation that the weld has been brought into compliance with the contract requirements. Additionally address actions that will be taken to limit future occurrences.

In addition to the material/workmanship non-conformance, propose a resolution that addresses the failure of Quality Control to identify the gouge during visual inspection of the weld. Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

Recent failures by Quality Control to identify deficiencies during visual inspection have resulted in the issuance of NCR ZPMC-0250, ZPMC-0292 (Tower) and ZPMC-0258 (OBG).

Transmitted by: Scott Kennedy Sr. Bridge Engineer
Attachments: ZPMC-0297

02.07.09 05:04 06-000286,NCT

Received
NCT-000286 18 Jun 09 Page 1 of 2

NCT

(Continued Page 2 of 2)

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

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
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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, PRC

Report No: NCR-000323

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2009

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

NCR #: ZPMC-0297

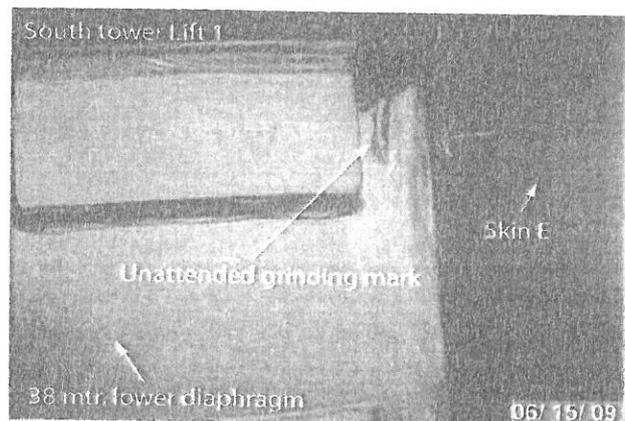
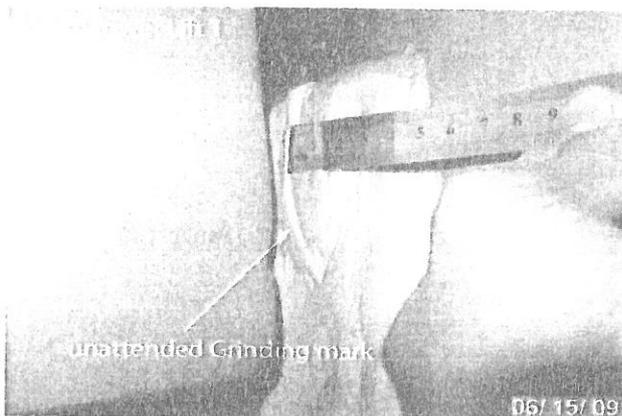
Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: South Tower, Lift 1
 Procedural Procedural Description: South Tower, Lift 1 weld gouge

Reference Description: Tower, Lift 1, 38m diaphragm to skin E weld gouge

Description of Non-Conformance:

QA observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel.



Applicable reference:

AWS D 1.5-2002, Section 3.7.1 - "The removal of weld metal or portions of the base metal may be done by machining, air carbon arc cutting and gouging, thermal cutting, chipping, or grinding. It shall be done in such a manner that the remaining weld metal or base metal is not nicked or undercut..."

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."

Who discovered the problem: Baskar Govindarajan

Name of individual from Contractor notified: ZhangBin Jian

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 6-15-09, 13:34; Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 6-17-09, 8:00; Verbal

QC Inspector's Name: Ken Zhang

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000286

Subject: NCR No. ZPMC-0297

Dated: 18-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000258 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: Per Caltrans comments to ABF-NPR-000258R00, ZPMC is providing repair documents and NDT documents to show that the 12mm excavation was repaired and the weld is acceptable.

Per Caltrans comments to ABF-NPR-000258R00, ZPMC is providing repair documents and NDT documents to show that the 12mm excavation was repaired and the weld is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000258R01;

Caltrans' comments:

Status: AAP

Date: 20-Dec-2009

The Department agrees that it is not unusual to be able to visually locate more indications after grit blasting. However, this NCR was issued due to the fact the QC inspectors were not able to locate this 12mm gouge prior to the Department's QA inspection. The Department still sees this as the failure of Quality Control. As such, please address this apparent failure by Quality Control and the steps/action taken by the Quality Control Manager to prevent future occurrences.

Submitted by: Lee, Ken

Attachment(s):

Date: 20-Dec-2009



No. T-103

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-12-15

REGARDING: NCR-000323 ZPMC-0297

ZPMC received NCR-000323(ZPMC-0297), the original contents is: "QA observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel".

After investigating with AB/F and CT site inspector, the truth was that after blasting, CT inspector found indication on the weld surface, so ZPMC production performed grinding to remove it. It's normal and acceptable that some indications can be revealed after blasting which previously couldn't be found by VT, also it's allowable to perform grinding in order to remove the indication.

As a result, ZPMC performed re-welding on this pot hole, and this weld was finally rechecked by ZPMC, AB/F and CT and already been green tagged. Here attached the NDT report to prove the weld was sound.

So ZPMC request CT could take a review and close the NCR.

ATTACHMENT:

T787-MT-7433

Zhang Jindai
2009.12.15



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: 18-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: 05.03.06-000286

Subject: NCR No. ZPMC-0297

Reference Description: Gouge Weld Metal / South Shaft Lift 1 / 38m Diaphragm to Skin E Weld

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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:** 01

Remarks:

QA observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel.

AWS D 1.5-2002, Section 3.7.1 - "The removal of weld metal or portions of the base metal may be done by machining, air carbon arc cutting and gouging, thermal cutting, chipping, or grinding. It shall be done in such a manner that the remaining weld metal or base metal is not nicked or undercut..." 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."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance including documentation that the weld has been brought into compliance with the contract requirements. Additionally address actions that will be taken to limit future occurrences.

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Recent failures by Quality Control to identify deficiencies during visual inspection have resulted in the issuance of NCR ZPMC-0250, ZPMC-0292 (Tower) and ZPMC-0258 (OBG).

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0297

2.02415.04 05.06-000286,NCT

Received Page 1 of 2
 NCT-000286 18 Jun 09

NCT

(Continued Page 2 of 2)

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

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, PRC

Report No: NCR-000323

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2009

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

NCR #: ZPMC-0297

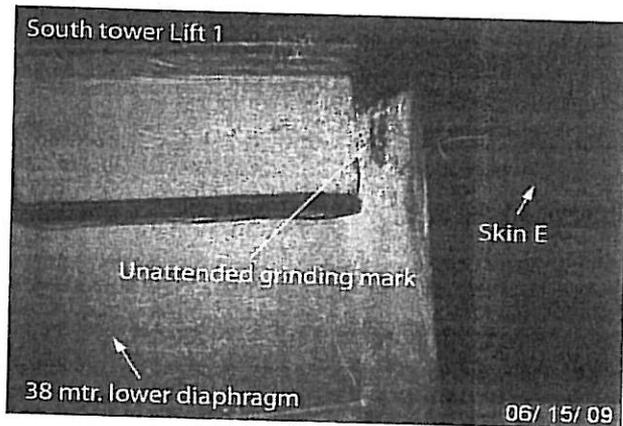
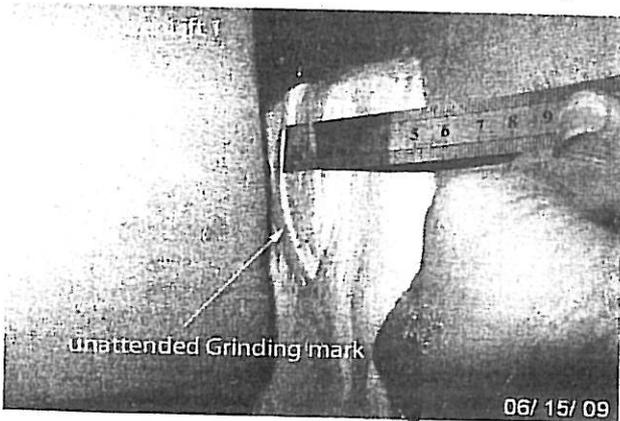
Type of problem:

- | | | | | | | |
|--------------|--------------------------|------------|--------------------------|--|-------------------------------------|---------------------------------------|
| Welding | <input type="checkbox"/> | Concrete | <input type="checkbox"/> | Other | <input checked="" type="checkbox"/> | |
| Welding | <input type="checkbox"/> | Curing | <input type="checkbox"/> | Procedural | <input checked="" type="checkbox"/> | Bridge No: 34-0006 |
| Joint fit-up | <input type="checkbox"/> | Coating | <input type="checkbox"/> | Other | <input type="checkbox"/> | Component: South Tower, Lift 1 |
| Procedural | <input type="checkbox"/> | Procedural | <input type="checkbox"/> | Description: South Tower, Lift 1 weld gouge | | |

Reference Description: Tower, Lift 1, 38m diaphragm to skin E weld gouge

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Who discovered the problem: Baskar Govindarajan

Name of individual from Contractor notified: ZhangBin Jian

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 6-15-09, 13:34; Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 6-17-09, 8:00; Verbal

QC Inspector's Name: Ken Zhang

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000286

Subject: NCR No. ZPMC-0297

Dated: 14-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000258 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: ABF QCM has notified the ZPMC QA and QC staff to be more thorough with inspections prior to and after sand blasting, to use proper lighting and understand where problem areas are

The ABF QCM has notified the ZPMC QA and QC staff to be more thorough with inspections prior to and after sand blasting, to use proper lighting and understand where problem areas are most likely to occur based on welding position, welding processes and accessibility of welding. The ABF QCM has also discussed these same topics with the ABF lead inspectors as well as our subcontract line inspectors to prevent future occurrences. ZPMC requests closure of this NCR.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000258R02

Caltrans' comments:

Status: CLO

Date: 14-Jan-2010

The proposed resolution is acceptable. The Department concurs that Non-conformance ZPM-0297 is closed.

Submitted by: Lee, Ken

Attachment(s):

Date: 14-Jan-2010

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-000301**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0297**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 observed a 12mm deep gouge in 38m diaphragm to skin E weld during after grit blast random verification of South Tower, Lift 1. This weld was previously accepted by ZPMC QC personnel.

Contractor's proposal to correct the problem:

Repair affected weld.

Corrective action taken:

The affected weld has been repaired 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
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Reviewed By:	Wahbeh, Mazen	QA Reviewer
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