

**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-000337  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV **Date:** 24-Jun-2009  
**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0311

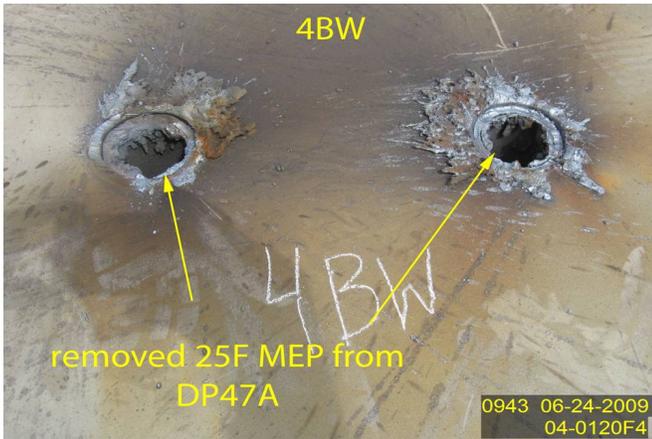
**Type of problem:**

<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 Segment 4BW
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** MEP Removal, DP47A, Segment 4BW

**Description of Non-Conformance:**

Caltrans Quality Assurance Inspector observed four (4) 25F MEP threaded penetrations being removed on Segment 4BW at DP47A by carbon arc air gouging the weld. The contractor failed to notify the engineer prior to removing the welds and the MEP pipe sleeves. The removal is not necessary as the previously approved RFI indicated that the current installed MEPs are acceptable.



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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 3.7.5 Repairs: “The Engineer shall be notified before improperly fitted and welded members are cut apart”

Request For Information (RFI) – ABF-RFI-001789R00 Threaded Pipe Sleeves

Description- “During the installing the pipe sleeves for MEP penetration, ZPMC has installed 4 threaded pipe sleeves, 25F at the location which should use 25C in Shop Drawing DP4 and MEP P1. The only difference between 25F and 25C is 25F is threaded and 25C is unthreaded. It is understood by ZPMC that this won’t affect the usage of MEP penetration”.

Response- “It is acceptable to leave the above mentioned pipe sleeves 25F in place of the unthreaded 25C. Note that proper corrosion protection of the pipe sleeves threaded ends will be necessary”.

**Who discovered the problem:** Dan Hernandez

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

**Time and method of notification:** 1530 hours, 06-24-09, Email

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

**Time and method of notification:** 1330 hours, 06-25-09, 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.

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**Inspected By:** Guest, Skyler

SMR

**Reviewed By:** 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:** 05-Jul-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:** 05.03.06-000300

**Subject:** NCR No. ZPMC-0311

**Reference Description:** MEP Removal, DP47A, 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:** 04

### Remarks:

Caltrans Quality Assurance Inspector observed four (4) 25F MEP threaded penetrations being removed on Segment 4BW at DP47A by carbon arc air gouging the weld. The contractor failed to notify the engineer prior to removing the welds and the MEP pipe sleeves. The removal is not necessary as the previously approved RFI indicated that the current installed MEPs are acceptable. Please see attached NCR ZPMC-311 for details.

### Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to ensure that the base metal was not damaged and prevent future occurrences.

**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0311

**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:** 05.03.06-000300

**Subject:** NCR No. ZPMC-0311

**Dated:** 27-Jul-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000273 **Rev:** 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

**Submitted by:**

**Attachment(s):** ABF-NPR-000273R00;

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**Caltrans' comments:**

**Status:** CLO

**Date:** 07-Aug-2009

The proposed resolution is acceptable. The welding repair report is included, and the welds in question have been accepted by VT and MT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0311 is closed.

**Submitted by:** Wright, Doug

**Date:** 07-Aug-2009

**Attachment(s):**



No. B-414

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2009-7-22**

**REGARDING: NCR-000337 (ZPMC-0311)**

With this letter of response, ZPMC requests closure for Caltrans NCR-000337 (ZPMC-0311). We agree what describe in the non-conformance report, but should remind that we have removed the MEP treaded penetrations prior received the response of the RFI, which agree the contractor leave the MEP situation as it is without any repair, that's why happen in the non-conformance report.

We have also provided the WWR and final VT/MT report to support the good quality of the corresponding renew weld and have been accepted by the caltrans inspector after the second re-inspection.

So base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report NCR-000337 (ZPMC-0311).

Please reference attached documentation for acceptance and closure the NCR-000337 (ZPMC-0311).

**ATTACHMENT:**

**NCR-000337 (ZPMC-0311)**

**ZPMC internal NCR**

**The closed welding repair report**

**The final VT/MT report**

*Chao Shuangbao*

*2009. 7.22*



# 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-213 (ZPMC-0311)

Item: MEP Removal, DP47A  
名称描述: 刨除 4BW 上的 MEP

Item Number:  
件号: N/A

Drawing:  
图号: 4BW

Location: Trail assembly yard  
位置: 总拼后场

Date:  
日期: 2009-07-08

### Description of Nonconformance:

不符合项状态描述:

Caltrans Quality Assurance Inspector observe four 25F MEP threaded penetrations being removed on Segment 4BW at DP47A by carbon arc air gouging the weld. The contractor failed to notify the engineer prior to removing the welds and the MEP pipe sleeves, The removal is not necessary as the previously approved RFI indicated that the current installed MEP's are acceptable.

加州检验员发现 DP47A 上的 4 个管线穿越孔套管被刨开。ZPMC 没有在刨除之前通知加州工程师批准。同时根据已批准的 RFI，更没必要刨除管线穿越孔套管。

Work By: Wang Sheng Prepared by: Wang Reviewed by QCE: Zhao Shuangbao  
施工方: 准备: 质量工程师批准: 09-7-9

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:

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

Reason for Nonconformance: per gouging DP47A four 25F MEP, Note QA to contact Caltrans Engineer  
不符合原因: 在 DP47A 上的 4 个管线穿越孔套管被刨开，在刨开之前没有通知 QA 也联系加州工程师到现场，但是没有来。在收到 RFI 之前

预防措施: 已刨好。现场处加州工程师已看过 OK.  
Caltrans Engineer accepted.

Approved by/批准: Geo Jun 09.7.5

Technical Justification for Use-As-Is/Repair:  Attachment  Non-attachment

回用或返修的技术依据: 在收到 RFI 之前，现场以按 WR 8 技术进行，附件  
before receiving RFI, repair according to B-WRS 25. 无附件

Reviewed /批准: Tang Yangbo

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  
566 Feng Bin Road Room 706, Changxing Island  
Shanghai 201913 PR China  
Tel: 021-56856666 ext 207061 Fax:

*Ed/K/004*

## NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 05-Jul-2009

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

Job Name: SAS Superstructure

Document No: 05.03.06-000300

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0311

Reference Description: MEP Removal, DP47A, Segment 4BW

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- Non-Conformance Resolved.

Material Location: OBG

Lift: 04

### Remarks:

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Transmitted by: Ching Chao

Attachments: ZPMC-0311

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

02:02:15.04  
05.03.06-000300,NCT

Received  
NCT-000300 06 Jul 09 Page 1 of 1

DEPARTMENT OF TRANSPORTATION  
DIVISION OF ENGINEERING SERVICES  
Office of Structural Materials  
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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  
City: 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-000337

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 24-Jun-2009

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

NCR #: ZPMC-0311

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural

Joint fit-up  Coating  Other

Procedural  Procedural  Description:

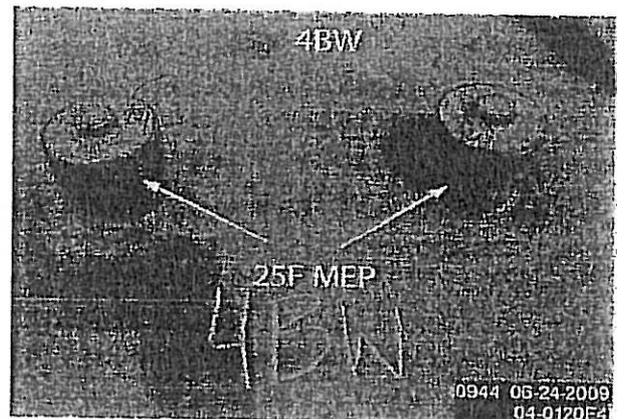
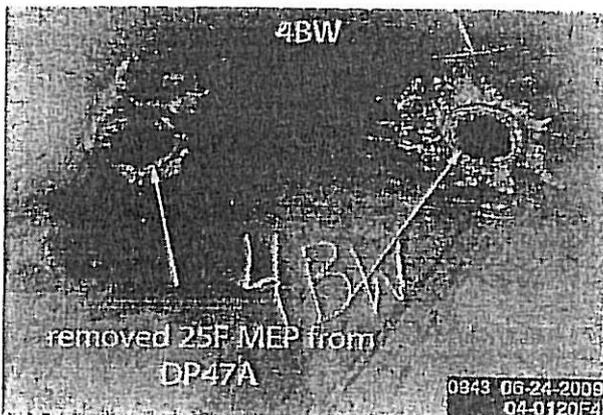
Bridge No: 34-0006

Component: OBG Segment 4BW

Reference Description: MEP Removal, DP47A, Segment 4BW

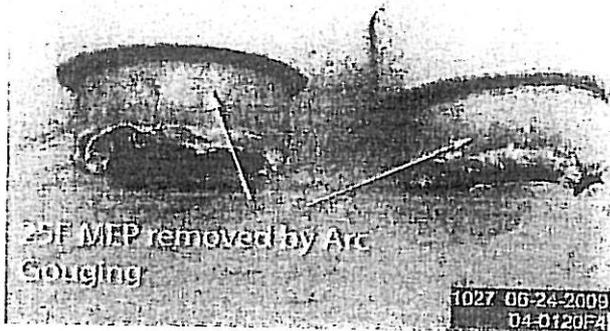
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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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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

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# 焊缝返修报告

版本 Rev. No.

## Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	4AW/4BW	报告编号 Report No.	B-WR5825
合同号 Contract No.:	04-0120F4	部件名称 Items Name	MEP管 MEP Pipe	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

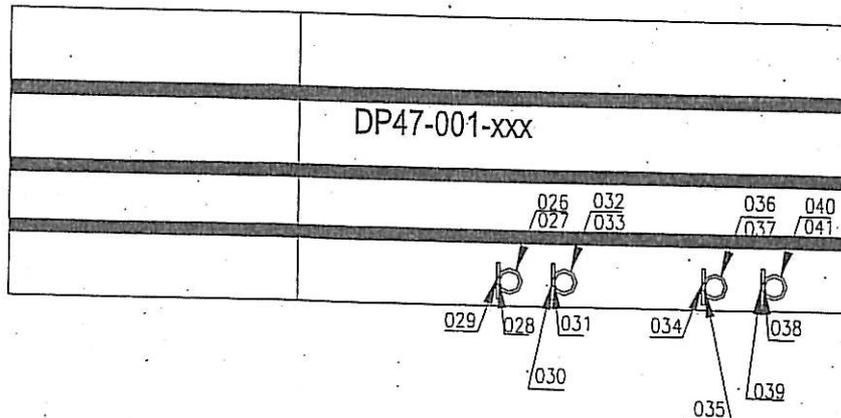
4AW/4BW顶板DP47A上的MEP管装错, 25C装配成25F, PP26-PP28四处(南侧), 现需要刨除。

MEP pipe was assembly error at 4AW/4BW deck plate DP47A; 25c assembly error as 25F, relevant four position form PP26 to PP28 at south side.

*Yang Ding*  
 检验员 (Inspector): Yang Ding 日期(Date): 09.06.21

焊缝返修位置示意图:

Draft of welding discontinuity:



产生原因:

**Caused:**

工人在装配时, 没有看清楚图纸要求, 导致装配错误。

Worker didn't review drawing carefully caused assembly error.

车间负责人(Foreman): *Guo Jun*

日期(Date): *09.06.28*

**处理意见**

**Disposition :**

1. 采用碳刨或火焰切割的方法割除MEP管, 碳刨前应根据相应的WPS进行预热, 切勿伤及顶板母材;
2. 对修补区域作100%VT检测;
3. 重新安装MEP管, 根据批准的返修焊接工艺规程 (WPS) 进行预热及焊接;
4. 对修补区域作100%VT,MT,UT检测,保证焊缝没有缺陷;
5. 将修补区域打磨与母材或相邻焊缝平齐;
6. 按照图纸要求检测焊缝 ;

1. Remove the MEP pipe by the way of gouging or Oxygen cutting, preheat according to the WPS prior to gouging . do not gouge the base metal.
2. Perform 100%VT inspection of the repaired area.
3. Afresh install MEP pipe , , preheat and weld according to the relevant WPS.
4. Perform VT,MT and UT inspections after welding.
5. Grind and blend the repaired area flush with base metal and adjacent weld.
6. Check the welds according to the working drawings.

工艺: *Xu Dong Kar*  
Technical engineer:  
*09.06.28*

审核:  
Approved by

*Le Zhe*

日期  
Date

*2009.06.28*

#R787-QCP-900



# 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	4AW/4BW	报告编号 Report No.	B-WR5825
合同号 Contract No.:	04-0120F4	部件名称 Items Name	MEP管 MEP Pipe	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:**

培训和教育装配工, 提高装配质量。

Train and educate assembly to improve assembly quality.

车间负责人(Foreman): *Geo Jun*日期(Date): *09.06.28*

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-2 G(2F)-Repair WPS-345-SMAW-2 G(4F)-Repair-1	工艺员 technologist	<i>XU Dongkai</i> <i>09.06.28</i>
返修(碳刨)前预热温度 Preheat temperature before gouging.	<i>69°C</i>	返修的缺陷 Description of discontinuity	<i>MEP Pipe was assembly error</i>
焊前处理检查 Inspection before welding	<i>是</i>	焊前预热温度 Preheat temperature before welding	<i>70°C</i>
最大碳刨深度 Max. depth of gouging	<i>NA</i>	碳刨总长 Total length of gouging	<i>173</i>
焊工 welder <i>050433</i>	焊接类型 welding type <i>SMAW</i>	焊接位置 position <i>2F/4F</i>	
焊接电流 Current <i>167/170</i>	焊接电压 Voltage <i>24.2/24.5</i>	焊接速度 Speed <i>115/117</i>	
返修后检查 Inspection After repairing:			
外观检查 VT result <i>是</i>	检验员 Inspector <i>Li Yanhua</i> <i>07120701</i>	日期 Date <i>2009.06.30</i>	
NDT复检 NDT result	探伤员 NDT person <i>Jin Jian ting</i>	日期 Date <i>09.6.30</i>	
见证: Witness/Review:			
备注: Remark:			

#R787-QCP-900



B-VT 32071

周数  
日期

86  
2009.06.26

**Visual Weld Inspection Report**  
焊缝目视检查报告

Girder/梁:  
Tower/塔:

OBG Plate Panel Splice

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:  
Li Yun Inna 0720701

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	Overlap 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
DP047-001-026	050433	4F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-027	050433	2F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-028	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-029	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-030	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-031	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-032	050433	4F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-033	050433	2F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-034	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-035	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-036	050433	4F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-037	050433	2F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-038	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-039	050433	1F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-040	050433	4F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
DP047-001-041	050433	2F	THJ506Fe-1ø4.0	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA

After root weld  
 After CWR or WRR No.: 6-wR5825  
 After cover pass  
 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-11992      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: DP47 OBG 4B TUBE		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4	
REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 <sup>ST</sup> , 2009
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
MATERIAL TO BE EXAMINED 检测材料	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 母材, 厚度	A709M-345T2-X 8/20 mm
WELDING PROCESS 焊接方法	SMAW	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			
DP047-001-034				ACC.		100%MT
DP047-001-035				ACC.		100%MT
DP047-001-036				ACC.		100%MT
DP047-001-037				ACC.		100%MT
DP047-001-038				ACC.		100%MT
DP047-001-039				ACC.		100%MT
DP047-001-040				ACC.		100%MT
DP047-001-041				ACC.		100%MT
DP047-001-026				ACC.		100%MT
DP047-001-027				ACC.		100%MT
DP047-001-028				ACC.		100%MT
DP047-001-029				ACC.		100%MT
DP047-001-030				ACC.		100%MT
DP047-001-031				ACC.		100%MT
DP047-001-032				ACC.		100%MT
DP047-001-033				ACC.		100%MT

AFTER B-WR5825

EXAMINED BY主探 Jin Jianting <i>Jin Jianting</i> LEVEL - II SIGN 签名 / DATE日期 09.06.29	REVIEWED BY 审核 <i>Sun Gong shang</i> LEVEL-II SIGN / DATE日期 09.06.29
质量经理 / QCM <i>L...</i>	用户CUSTOMER
签字 SIGN / 日期 DATE <i>09.07.08</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-000418**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0311**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>Description:</b>	

**Date the Non-Conformance Report was written:** 24-Jun-2009**Description of Non-Conformance:**

Caltrans Quality Assurance Inspector observed four (4) 25F MEP threaded penetrations being removed on Segment 4BW at DP47A by carbon arc air gouging the weld. The contractor failed to notify the engineer prior to removing the welds and the MEP pipe sleeves. The removal is not necessary as the previously approved RFI indicated that the current installed MEPs are acceptable.

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

Contractor performed the work according to the RFI.

**Corrective action taken:**

The work was done according to the RFI. Contractor provided Welding Repair Report and NDT documentation. The work is acceptable.

**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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

**Inspected By:** Tsang, Eric **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**