

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-000358**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Jul-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0332**Type of problem:**

Welding	Concrete	Other
Welding	Curing	Procedural
Joint fit-up	Coating	Other
Procedural	Procedural	Description:

Bridge No: 34-0006**Component:** DP673A of CA065**Reference Description:** Flame Cutting Damage to DP**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed damage caused by Gas Flame Cutting to a Deck Plate identified as DP673A of CA065 in Segment 9DW. The damage measured 40mm in length and extended into the base metal approximately 65mm.

Please see the attached photos for details.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5-2002 section 3.2.2: "In all thermal cutting, the cutting flame shall be so adjusted and manipulated as to avoid cutting beyond (inside) the prescribed lines."

Who discovered the problem: Chandra Sudalaimuthu

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 1030 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1145 hours, Verbal

QC Inspector's Name: Steve Lawton

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 Mazen Wahbeh,(818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Simonis,Jim	QA Inspector
Reviewed By:	Wahbeh,Mazen	SMR



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: 05-Aug-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: 05.03.06-000325

Subject: NCR No. ZPMC-0332

Reference Description: Flame Cutting Damage to DP

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG **Lift:**

Remarks:

Caltrans Quality Assurance (QA) Inspector observed damage caused by Gas Flame Cutting to a Deck Plate identified as DP673A of CA065 in Segment 9DW. The damage measured 40mm in length and extended into the base metal approximately 65mm.

Action Required and/or Action Taken:

Contractor to submit repair procedure.

Transmitted by: Bill Howe

Attachments: ZPMC-0332

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: 05.03.06-000325

Subject: NCR No. ZPMC-0332

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000330 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC understands flame gouges can happen from time to time during cutting operations. Once identified they are repaired and repairs documented per established procedures.

ZPMC understands flame gouges can happen from time to time during cutting operations. Once identified they are repaired and repairs documented per established procedures. As shown in the pictures, this component is in the fit-up stage and in process and the gouge is not currently accessible for repair work. ABF does not understand why this condition is elevated to an NCR as it is not something that was overlooked as inspection has yet to occur. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000330R00

Caltrans' comments:

Status: AAP

Date: 20-Sep-2009

It's understood that the base metal will be repaired and documents will be submitted to the Department for review and acceptance once the repair work is completed.

Submitted by: Chao, Ching

Date: 20-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000325

Subject: NCR No. ZPMC-0332

Dated: 14-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000330 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: Per Caltrans comments ZPMC is providing documentation of the repair and NDT of the base metal which is acceptable. Based in this, ZPMC is requesting closure of this NCR.

Per Caltrans comments ZPMC is providing documentation of the repair and NDT of the base metal which is acceptable. Based in this, ZPMC is requesting closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000330R01;

Caltrans' comments:

Status: CLO

Date: 21-Dec-2009

Correct documentation has been submitted.

Submitted by: Howe, Bill

Date: 21-Dec-2009

Attachment(s):



No. B-531

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-12-12

REGARDING: NCR-000358 (ZPMC-0332)

With this letter of response, ZPMC requests closure for CALTRANS NCR-000358 (ZPMC-0332) what mentioned that QA observed base metal damage caused by flame cutting.

ZPMC acknowledged this problem and has issued internal NCR. ZPMC has arranged grinding & welding work to fix the base metal. After that NDT was performed to warrant welds' quality.

According to CT's comments in NPR, ZPMC providing internal NCR, CWR and NDT documentations, hoping CALTRANS could take a review and consider close the NCR.

ATTACHMENT:

NCR-B-228

NCR-000358 (ZPMC-0332)

ABF-NPR-000330 R0.

B-CWR682

B-VT-37803

B787-MT-13375

[Handwritten signature]
12/12/09



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-228 (ZPMC-0332)

Item: Flame Cutting Damage to DP
 名称描述: 顶板火焰切割损伤

Item Number:
 件号:
 OBG 9DW

Drawing:
 图号: OBG DP673

Location: OBG 9DW
 位置:

Date:
 日期: 2009-8-12

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

Caltrans Quality Assurance (QA) Inspector observed damage caused by Gas Flame Cutting to a Deck Plate identified as DP673A of CA065 in Segment 9DW. The damage measured 40mm in length and extended into the base metal approximately 65mm.

加洲检验员发现 9DW 箱体角单元 CA065 位置的顶板 DP673 被火焰切割损伤母材。焊缝区域受损长度 40 毫米，延伸到母材受损长度大约 65 毫米。

Work By: *Hu Yu*
 施工方: *2009.8.13*
 Drawing Error
 图纸错误

Prepared by: *Shen Xujun*
 准备: *2009.8.13*
 Material Defect
 材料缺陷

Reviewed by QCE: *Zhao Shuangbin*
 质量工程师批准: *2009.8.13*
 Fabrication Error
 制作错误
 Other
 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:
 不符合原因:

火焰切割损伤母材。切割工责任心不强。
 Base metal gouged during cutting by flame, and cutter wasn't responsibility.

Prevention of Re-occurrence:
 预防措施:

加强切割工培训
 Train up operators.

Approved by/批准: *[Signature]*

Technical Justification for Use-As-Is/Repair: <input type="checkbox"/> Attachment <input type="checkbox"/> Non-attachment 回用或返修的技术依据: 附件 无附件
根据返修报告 CWR 682 进行修补. Repair according to CWR 682
Reviewed /批准: <u>Nimble</u>
Verification: <input checked="" type="checkbox"/> Acceptable <input type="checkbox"/> Unacceptable 确认: 可接受 不可接受
已按返修报告整改 Repair according to report.
Verified by QCI/质检确认: <u>Zhuzhonghai 2007.07.18</u> Reviewed by QCA/质检主任审核: _____

#R787-QCP-1300

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

lath...

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 05-Aug-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: 05.03.06-000325

Subject: NCR No. ZPMC-0332

Reference Description: Flame Cutting Damage to DP

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Transmitted by: Bill Howe

Attachments: ZPMC-0332

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

05.03.06-000325.NCT

Received
NCT 000325 06 Aug 09

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-000358

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 09-Jul-2009

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

NCR #: ZPMC-0332

Type of problem:

Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:

Bridge No: 34-0006

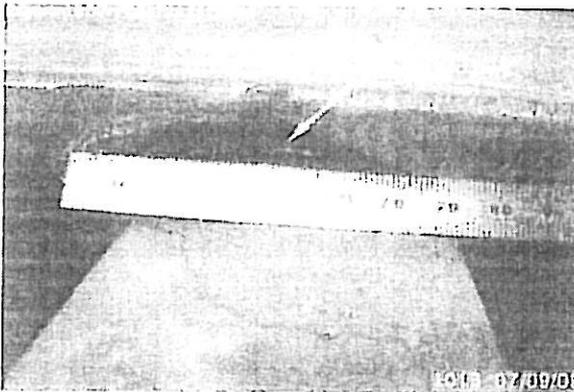
Component: DP673A of CA065

Reference Description: Flame Cutting Damage to DP

Description of Non-Conformance:

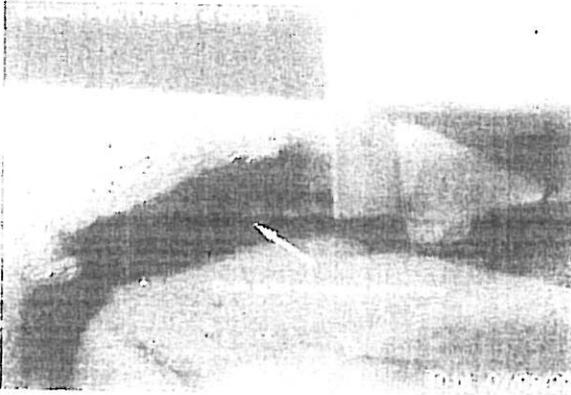
Caltrans Quality Assurance (QA) Inspector observed damage caused by Gas Flame Cutting to a Deck Plate identified as DP673A of CA065 in Segment 9DW. The damage measured 40mm in length and extended into the base metal approximately 65mm.

Please see the attached photos for details.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5-2002 section 3.2.2: "In all thermal cutting, the cutting flame shall be so adjusted and manipulated as to avoid cutting beyond (inside) the prescribed lines."

Who discovered the problem: Chandra Sudalaimuthu

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 1030 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1145 hours, Verbal

QC Inspector's Name: Steve Lawton

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim

QA Inspector

Reviewed By: Wahbeh, Mazen

SMR



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: 05.03.06-000325

Document No.: ABF-NPR-000330 Rev: 00

Subject: NCR No. ZPMC-0332

Contractor's Proposed Resolution:

Reference Resolution: ZPMC understands flame gouges can happen from time to time during cutting operations. Once identified they are repaired and repairs documented per established procedures.

ZPMC understands flame gouges can happen from time to time during cutting operations. Once identified they are repaired and repairs documented per established procedures. As shown in the pictures, this component is in the fit-up stage and in process and the gouge is not currently accessible for repair work. ABF does not understand why this condition is elevated to an NCR as it is not something that was overlooked as inspection has yet to occur. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000330R00

Caltrans' comments:

Status: AAP

Date: 20-Sep-2009

It's understood that the base metal will be repaired and documents will be submitted to the Department for review and acceptance once the repair work is completed.

Submitted by: Chao, Ching

Date: 20-Sep-2009

Attachment(s):





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

版本
Rev. No.:

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	DP673A	报告编号 Report No.:	B-CWR682
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	顶板 DECK PLATE	NDT 报告编号 NDT Report No.:	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

板单元DP673A在余量切割过程中, 施工队错误施工将母材割伤。具体损伤尺寸见下图:

The base metal of plate panel DP673A was damaged during the workers were cutting the allowance because of their errors. See details as following drawing:

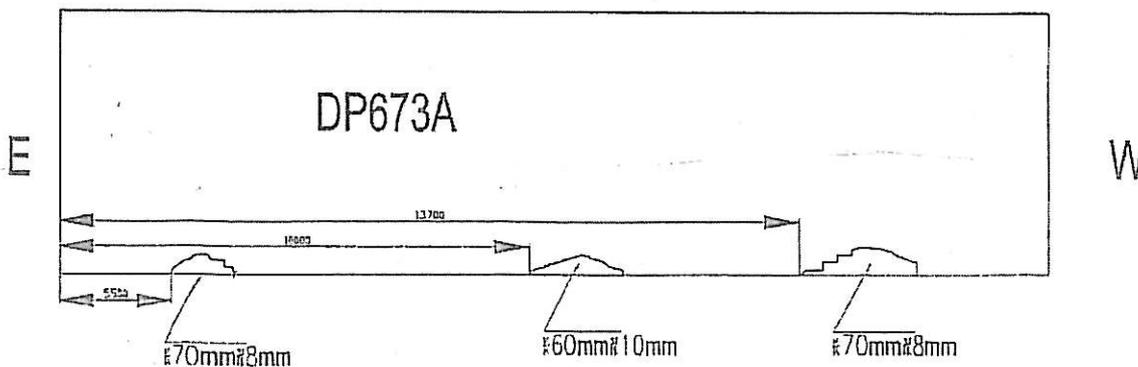
检验员 (Inspector): Shen Fuyou
shenfuyou

日期 (Date): 2009-8-22

焊缝返修位置示意图:

Draft of Welding Discontinuity:

<input type="checkbox"/>	APPROVED
<input checked="" type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION Division of Engineering Services Office of Structure Construction	
<u>STE Joe RJ</u>	<u>8/26/09</u>
Structure Representative	Date



产生原因:

Cause:

在余量切割过程中, 施工队错误施工导致割伤母材。

The workers made mistakes during cutting the allowance, leading to the base metal damaged.

车间负责人 (Foreman):

Lizhiqian

日期 (Date):

07.08.24

处理意见

Disposition:

1. 整个返修过程中, QC和CWI检测所有的打磨和焊接等工作;
2. 在返修时, QC和CWI必须在现场, 有CWR的复印件;
3. QC和CWI应该指导返修, 以保证按照返修的处理意见进行;
4. 根据批准的返修WPS打磨母材缺陷区域;
5. 按照返修的WPS准备正确的接头型式;
6. VT和MT检测所有的缺陷全部去除;
7. 按照返修的WPS进行预热和焊接;
8. 打磨返修后的焊缝与母材平齐;
9. 返修后, 按照图纸要求对返修区域进行VT,MT检测;

1. QC and a CWI shall be present and direct all grinding and welding operations during this repair.
2. QC and a CWI shall have an approved copy of the CWR in hand and shall be at the repair location during the entire repair.
3. QC and a CWI shall direct the repair to ensure the repair is per the disposition requirements.
4. Grind the defects of the base metal according to the approved repair WPS;
5. Prepare excavation according to the approved repair WPS.
6. Perform VT and MT inspection to ensure that repair area is free of defects.
7. Preheat and weld according to the relevant repair WPS.
8. Grind the repaired area flush with base metal.
9. Perform VT, MT inspection to repair area according to the shop drawing.

+ UT
8-25-09

<input type="checkbox"/>	APPROVED
<input checked="" type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION Division of Engineering Services Office of Structure Construction	
<i>STE for RM</i>	<i>8/26/09</i>
Structure Representative	Date

工艺:

Technical Engineer:

Nin Trufaj

审核:

Approved By:

*ing'ianhua
for chunbin*

日期:

Date:

07.08.24



关键焊缝返修报告

版本
Rev. No.:

Critical Welding Repair Report (CWR)

0

项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	DP673A	报告编号 Report No.:	B-CWR682
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	顶板 DECK PLATE	NDT 报告编号 NDT Report No.:	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Corrective Action to Prevent Re-occurrence:

- 对施工队加强培训, 提高工人的操作技能。
 - 加强对切割过程的质量监控。
- Train the workers in order to improve their skill.
 - Enhance the quality control during cutting.

车间负责人 (Foreman):

Li Zhigang

日期 (Date): 09.08.23

参照的WPS编号 Repair WPS No.:	WPS-B-P2211-B-U2 WPS-B-T-2231-B-U2-F-2 WPS-B-P-2211-B-U2a-1 WPS-B-T-2231-B-U2a-F-3	工艺员 Technologist:	Mia Trefaf 17.08.23
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返修(碳刨)前预热温度 Preheat Temperature Before Gouging:	NA	返修的缺陷 Description of Discontinuity:	base metal were cutting
焊前处理检查 Inspection Before Welding:	Acc	焊前预热温度 Preheat Temperature Before Welding:	168°C
最大碳刨深度 Max. Depth of Gouge:	NA	碳刨总长 Total Length of Gouge:	NA
焊工 Welder:	045268	焊接类型 Welding Type:	SMAW
焊接电流 Current:	148	焊接电压 Voltage:	23
		焊接位置 Position:	16
		焊接速度 Speed:	11.5

返修后检查

Inspection After Repair:

外观检查 VT Result:	Acc	检验员 Inspector:	Shangjun 080274	日期 Date:	09.8.28
NDT复检 NDT Result:	Acc	探伤员 NDT Person:	Shangjun		09.8.28

见证:
Witness/Review:备注:
Remark:

<input checked="" type="checkbox"/> APPROVED	09.8.28
<input checked="" type="checkbox"/> APPROVED AS NOTED	
<input type="checkbox"/> RETURNED FOR CORRECTION Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION Division of Engineering Services Office of Structure Construction	
SJE Gr RM	8/26/09
Structure Representative	Date

#R787-QCP-900

B-V 37803

		周数		95#									
		日期		2009.8.27									
Visual Weld Inspection Report 焊缝目视检查报告		Girder/梁: OBG Plate Panel Splice											
Caltrans Contract No. 加州合同编号 04-0120F4		Tower/塔:											
Project No.: 项目名称 San Francisco Oakland Bay Bridge 海湾大桥		Representative: 质检代表: 											
Project No.: 项目编号 ZP06-787		C.W.I.: 检验员: zhurhong (hnt) 02/01											
Quality Assurance Manager - Approval 质量控制经理:													
Weld No. 焊缝编号	Welder I.D.# 焊工工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 接受或拒收后返修
NA	045268	1G	THJ506 (Φ4.0)	✓	✓	✓	✓	✓	✓	✓	ACC	NA	NA
<input type="checkbox"/> After root weld													
<input checked="" type="checkbox"/> After CWR or WRR No. : B-CWR682													
<input type="checkbox"/> After cover pass													
<input type="checkbox"/> After HSR No. :													
<input type="checkbox"/> 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-13375 DATE日期 2009.08.28 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: DP673A OBG DECK PLATE 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. 28ST, 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 CASTING 铸件 FORGING 锻造 Material & thickness 母材, 厚度: A709M-345T2 20/40 mm

WELDING PROCESS 焊接方法: NA TYPE OF JOINT 焊缝类型: NA

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			
DP673A				ACC.		100%MT
DP673A				ACC.		100%MT
DP673A				ACC.		100%MT

AFTER B - CWR 682

BLANK

EXAMINED BY主探: Chang Fangjie *Chang Fangjie*
LEVEL-II SIGN 签名 / DATE日期: *09.08.28*

REVIEWED BY 审核: *S. Wei*
LEVEL-II SIGN / DATE日期: *09.08.28*

质量经理 / QCM: *L. ...*
签字 SIGN / 日期 DATE: *09.09.01*

用户CUSTOMER: _____
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
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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-000420**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0332**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: 09-Jul-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed damage caused by Gas Flame Cutting to a Deck Plate identified as DP673A of CA065 in Segment 9DW. The damage measured 40mm in length and extended into the base metal approximately 65mm.

Please see the attached photos for details.

Contractor's proposal to correct the problem:

Provide documentation of the repair and NDT of the base metal.

Corrective action taken:

ZPMC provided documentation of the repair and NDT of the base metal which 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