

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, P.R. China**Report No:** NCR-000379**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0353**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Crossbeam 6
Procedural	Procedural	Description:	

Reference Description: Missed MT Indication in the base metal on CB6 Intermediate Diaphragm**Description of Non-Conformance:**

During random verification of Magnetic Particle Testing (MT) at OBG Cross Beam # 06 Intermediate Diaphragm. Caltrans Quality Assurance (QA) Inspector discovered a 12mm long linear indication in the base metal near the weld (CB202G-010-184). These areas were previously tested and accepted by ZPMC Quality Control MT Technician.

**Applicable reference:**

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: Dhanasingh Sukanthan**Name of individual from Contractor notified:** Shen Rushan**Time and method of notification:** 1000 hours, verbal**Name of Caltrans Engineer notified:** Bill Howe**Time and method of notification:** 1430 hours, verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: Shen Xue June

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.

Inspected By:	Tsang, Eric	SMR
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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-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: 05.03.06-000342

Subject: NCR No. ZPMC-0353

Reference Description: Missed MT Indication in the base metal on CB6 Intermediate Diaphragm

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:

During random verification of Magnetic Particle Testing (MT) at OBG Cross Beam # 06 Intermediate Diaphragm. Caltrans Quality Assurance (QA) Inspector discovered a 12mm long linear indication in the base metal near the weld (CB202G-010-184). These areas were previously tested and accepted by ZPMC Quality Control MT Technician.

Action Required and/or Action Taken:

Submit weld repair to engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0353

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: 05.03.06-000342

Subject: NCR No. ZPMC-0353

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000347 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-000347R00

Caltrans' comments:

Status: AAP

Date: 10-Sep-2009

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

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-0353 at that time.

Submitted by: Wright, Doug

Date: 10-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000342

Subject: NCR No. ZPMC-0353

Dated: 30-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000347 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: As requested by CT, ZPMC has now included the appropriate inspection documentation for closure of this NCR.
As requested by CT, ZPMC has now included the appropriate inspection documentation for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000347R01;

Caltrans' comments:

Status: CLO

Date: 30-Dec-2009

Documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Date: 30-Dec-2009

Attachment(s):



No. B-462

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-26

REGARDING: NCR-000379 (ZPMC-353)

With this letter of response, ZPMC requests closure for Caltrans **NCR-000379 (ZPMC-353)**. We agree what describe in the non-conformance report, and have trained the corresponding NDT operator that should control the inspect speed and move the transducer more carefully, if find any suspected indication then will repeat the action until make issue that the internal indication is within the tolerance of the specification or not.

By the way we have submitted the CWR for the engineer approval prior the weld repair, per the comments of the CWR we performed the weld repair, and then complete with the MT inspection at final, we provide the weld repair report and NDT acceptable report to support the good quality of the welds.

so base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report **NCR-000379 (ZPMC-353)**.

Please reference attached document for acceptance and closure the **NCR-000379 (ZPMC-353)**.

ATTACHMENT:

ZPMC internal NCR

NCR-000379 (ZPMC-353)

The critical welding repair report

The complete MT report

Shao Shuangbao

2009. 8. 16



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-239 (ZPMC-0353)
Item: liner indicating in the base metal 名称描述: 母材上有裂纹	Item Number: 件号: OBG CB6	Drawing: 图号: OBG CB6
Location: OBG CB6 位置:		Date: 日期: 2009-8-6

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

During random verification of Magnetic Particle Testing (MT) at OBG Cross Beam # 06 Intermediate Diaphragm. Caltrans Quality Assurance (QA) Inspector discovered a 12mm long liner indication in the base metal near the weld (CB202G-010-184). These areas were previously tested and accepted by ZPMC Quality Control MT Technician.

在 CB6 中间隔板上随机做 MT 过程中。加州检验员发现一条 12MM 的裂纹在母材上靠近焊缝 CB202G-010-184。这些区域在之前已经被 ZPMC MT 检验员检验和接受。

Work By: Li Lin Prepared by: Zhang Wei Reviewed by QCE: Zhao Shuangbao
 施工方: 2009.08.21 准备: 2009.08.21 质量工程师批准: 8.21

Drawing Error / 图纸错误 Material Defect / 材料缺陷 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

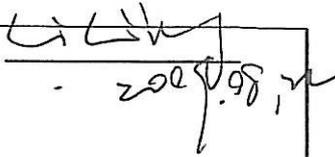
Recommendation:
 建议: 好报告后严格按照程序进行
 Issue repair ~~issue~~ report and perform accordingly to repair procedure.

Prepared by: Li Lin Approved by QCA: _____
 准备: 2009.08.21 质量经理批准

Reason for Nonconformance:
 不符合原因: 线性缺陷漏检
 Discover linear indication.

Prevention of Re-occurrence:
 预防措施: 仔细操作, 加强复检
 Operate carefully and enhance inspection.

Approved by/批准:


2025.08.27

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:

确认:

Acceptable

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



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-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: 05.03.06-000342

Subject: NCR No. ZPMC-0353

Reference Description: Missed MT Indication in the base metal on CB6 Intermediate Diaphragm

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Material Location: Xbeam

Lift: 06

Remarks:

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Transmitted by: Bill Howe

Attachments: ZPMC-0353

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

File: 05.03.06

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 Quality Assurance and Source Inspection



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 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-000379

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 06-Aug-2009

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

NCR #: ZPMC-0353

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

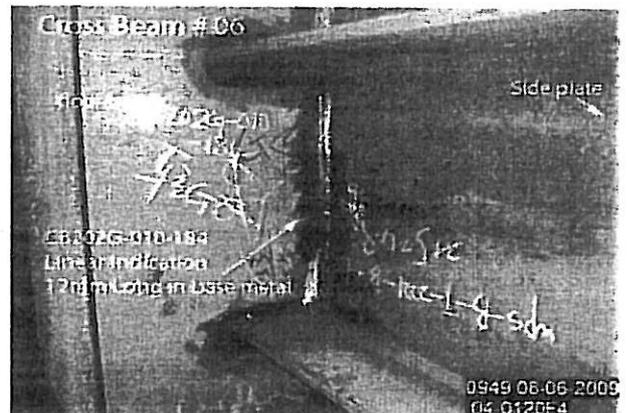
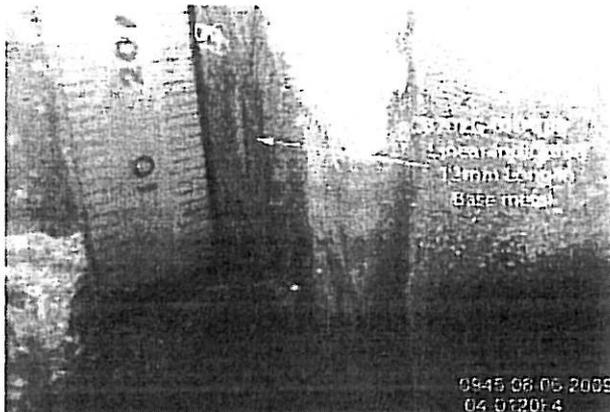
Bridge No: 34-0006

Component: Crossbeam 6

Reference Description: Missed MT Indication in the base metal on CB6 Intermediate Diaphragm

Description of Non-Conformance:

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Who discovered the problem: Dhanasingh Sukanthan

Name of individual from Contractor notified: Shen Rushan

Time and method of notification: 1000 hours, verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1430 hours, verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: Shen Xue June

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.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



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.:	CB6	报告编号 Report No.:	B-CWR656
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG CROSS BEAM	NDT 报告编号 NDT Report No.:	B787-MT-12340-1
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of Welding Discontinuity:

在对CB202G-010-184检测时, 发现1处纵向裂纹.

Welder ID No. (焊工编号): 215185

Position:(位置): 2F

One longitudinal crack was found by use of MT on CB202G-010-184.

Please see the detail data from MT report!

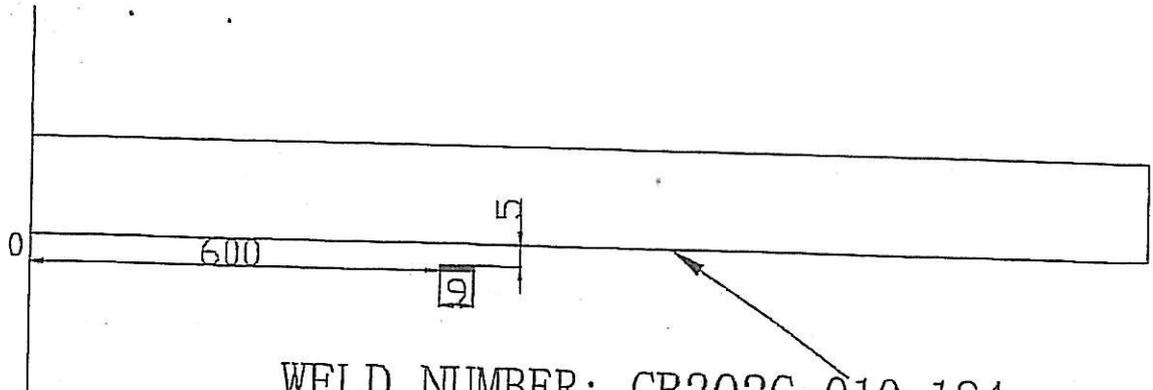
检验员 (Inspector): Chang Fangjie

Chang Fangjie

日期 (Date): 2009-08-06

焊缝返修位置示意图:

Draft of Welding Discontinuity:



WELD NUMBER: CB202G-010-184

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant to Section 5-1.02 of the
Standard Specifications
Initial SJE Date: 8/12/2009

产生原因:

Cause:

1. 火焰加热时, 水汽没有完全的去掉或者这个区域预热不够;
1. Moisture wasn't completely removed during drying operation (preheating) or the area wasn't preheated sufficiently.

车间负责人 (Foreman):

Lizhiyong

日期 (Date):

09.08.07

处理意见

Disposition:

1. 这次返修时, QC和Leader CWI到现场对打磨, 焊接进行指导和监控工作以保证返修按照处理意见进行;
 2. 整个返修的过程, QC和Leader CWI应该有批准CWR的复印件;
 3. 去除热影响区域上在各个方向上不小于25mm范围内的油漆;
 4. 采用打磨的方法去除裂纹. 打磨返修范围为沿缺陷焊缝每一端加50mm;
 5. 对返修区域及靠近裂纹的母材进行硬度测试, 在做硬度测试前应以口头和书面形式告知工程师, 并且在硬度测试后但在下一步修复工作前向加州代表递交测试结果;
 6. 如果去除裂纹过程中导致母材损伤深度超过3mm, 则按以下步骤进行母材返修;
 7. 焊接前按照焊接返修工艺规程(WPS)准备焊接接头形式;
 8. 返修前, VT和MT检测确认返修区域没有裂纹及其他缺陷存在;
 9. 按照批准的焊接返修工艺规程(WPS)进行预热和焊接;
 10. 将修补区域打磨与母材或相邻焊缝平齐;
 11. 返修后按照图纸要求对所有的修补焊缝进行NDT检测, 检测范围包括修补区域 (包括沿缺陷焊缝每一端加50mm) 的正反面焊缝及反面焊缝, 并按照合同10-1.59 "钢结构" 中的 "检测和试验" 注释3进行附加NDT检测.
1. QC and a Lead CWI shall be present, direct and supervise all grinding and welding operations during this repair to ensure the repair is per the disposition requirements.
 2. QC and a Lead CWI shall have an approved copy of the CWR in hand prior to the repair.
 3. Remove paint ≥ 25 mm in all direction of HAZ prior to MT.
 4. Remove cracks by grinding. Repair area shall extend a minimum of 50mm beyond each end of single crack repairs.
 5. Perform hardness testing at repair area and base metal laying abroad cracks, provide verbal and written notification to Engineer prior to performing hardness testing, and submit the testing result to Caltrans for review prior to repairing after testing.
 6. Perform base metal repair work as follows if base metal damage protrudes into the surface more than 3mm.
 7. Prepare excavation in accordance with an approved repair WPS prior to welding.
 8. Before this repair, Verify with VT and MT repair areas are defects free.
 9. Preheat and weld according to the approved repair WPS.
 10. Grind the repaired area flush with base metal or the adjacent weld.
 11. Perform relevant NDT inspection to all repaired weld (along with an additional 50mm at each end of the weld repair) as well as the weld which is in the opposite position of the repaired welds according to shop drawing and additional NDT requirement stated in special provision 10-1.59 "inspection testing" note 3 after repair.

工艺:

Technical Engineer:

Ni Defang

审核:

Approved By:

Ling Hanhua

日期:

Date: *09.08.07*

for Chenbin

This document is APPROVED
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant to Section 5-1.02 of the
 Standard Specifications

		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.:	CB6	报告编号 Report No.:	B-CWR656
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	OBG CROSS BEA M	NDT 报告编号 NDT Report No.:	B787-MT-12340-1
项目编号 Project No.:	ZP06-787				
纠正措施: Corrective Action to Prevent Re-occurrence: 1. 返修前, QC确认有效的预热, 以将水汽全部去除。 1. QC shall verify sufficient preheat has been applied, to remove moisture, prior to welding.					
车间负责人 (Foreman): <i>Hu Yuhang</i>			日期 (Date): <i>9.08.07</i>		
参照的WPS编号 Repair WPS No.:	WPS-345-SMAW-2G(2F)-Re pair WPS-345-FCAW-2G(2F)-Re pair-1		工艺员 Technologist:	<i>Nu Jiefeng</i> <i>9.08.07</i>	
返修(碳刨)前预热温度 Preheat Temperature Before Gouging:	<i>75°C</i>		返修的缺陷 Description of Discontinuity:	<i>裂纹</i>	
焊前处理检查 Inspection Before Welding:	<i>Acc</i>		焊前预热温度 Preheat Temperature Before Welding:	<i>85°C</i>	
最大碳刨深度 Max. Depth of Gouge:	<i>6mm</i>		碳刨总长 Total Length of Gouge:	<i>110mm</i>	
焊工 Welder:	<i>215248</i>	焊接类型 Welding Type:	Fillet	焊接位置 Position:	<i>2F</i>
焊接电流 Current:	<i>165A</i>	焊接电压 Voltage:	<i>25V</i>	焊接速度 Speed:	<i>150mm/in</i>
返修后检查 Inspection After Repair:					
外观检查 VT Result:	<i>Acc</i>	检验员 Inspector:	<i>Zhang Zhong</i>	日期 Date:	<i>2009.8.16</i>
NDT复检 NDT Result:	<i>Acc</i>	探伤员 NDT Person:	<i>Jin Jianrong</i>	日期 Date:	<i>9.8.17</i>
见证: Witness/Review:					
备注: Remark:					

#R787-QCP-900

This document is APPROVED
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant to Section 5.1.12 of the
 Standard Specifications
 Initial SJE Date: 8/12/2009



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12340-1R1		DATE日期 2009.08.17		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: CB6 OBG CROSS BEAM			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			
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/F2-X 14/12mm			
WELDING PROCESS 焊接方法	FCAW	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			
CB202G-010-184	1R1			ACC.		100%MT
AFTER B-CWR656						
BLANK						
EXAMINED BY主探 Jin jian ting <i>Jin Jian ting</i>			REVIEWED BY 审核 <i>Shu Weli</i>			
LEVEL - II SIGN 签名 / DATE日期 <i>09.28.17</i>			LEVEL-II SIGN / DATE日期 <i>09.28.17</i>			
质量经理 / QCM			用户CUSTOMER			
签字 SIGN / 日期 DATE			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-000431**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0353**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 06-Aug-2009**Description of Non-Conformance:**

During random verification of Magnetic Particle Testing (MT) at OBG Cross Beam # 06 Intermediate Diaphragm. Caltrans Quality Assurance (QA) Inspector discovered a 12mm long linear indication in the base metal near the weld (CB202G-010-184). These areas were previously tested and accepted by ZPMC Quality Control MT Technician.

Contractor's proposal to correct the problem:

Repair indication and perform required NDT.

Corrective action taken:

Contractor submitted CWR along with NDT documentation verifying the repair is in conformance with Contract requirements. QC NDT Technician also 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
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Reviewed By:	Wahbeh, Mazen	QA Reviewer
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