

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-000393
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 19-Aug-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0367

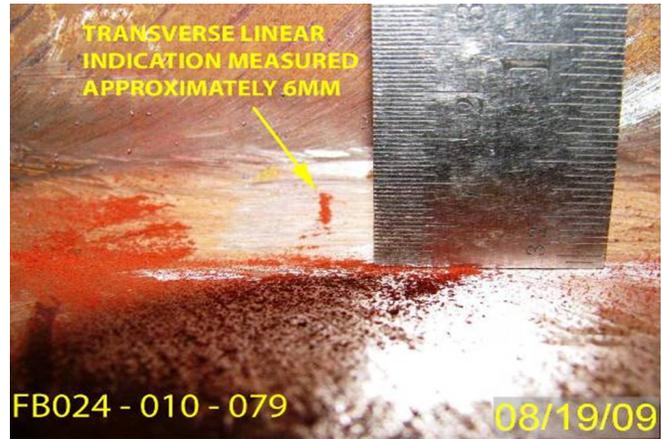
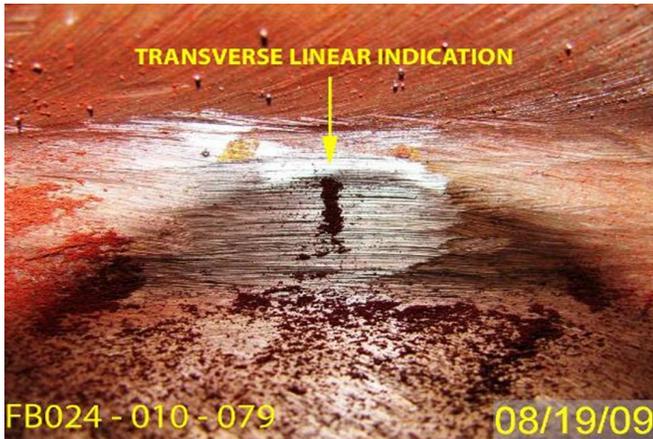
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Floorbeam 24
Procedural	Procedural	Description: Missed MT indication	

Reference Description: Missed MT transverse indication by QC on OBG Floorbeam 24

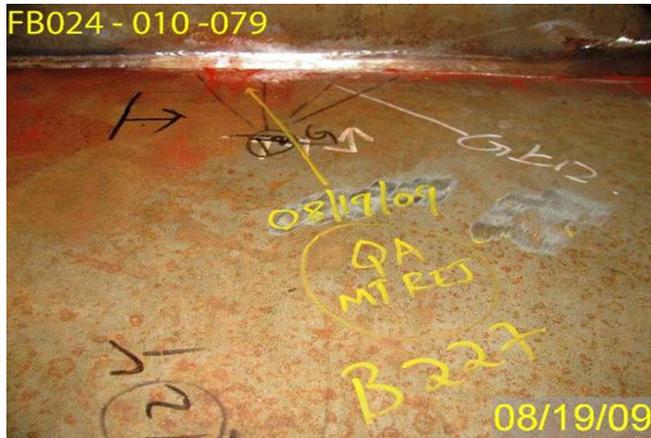
Description of Non-Conformance:

During random verification Magnetic Particle Testing (MT) for the OBG Floor Beam at Bay # 3, this Caltrans Quality Assurance Inspector (QA) observed one (1) transverse linear indication approximately 6mm in length in the weld metal on FB024-010-079. This area has been previously tested and accepted by ZPMC MT Technician.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Luo Gui Lin

Time and method of notification: 15:00, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 13:00 Email

QC Inspector's Name: Yang Qing Feng

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



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: 01-Sep-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: 05.03.06-000355

Subject: NCR No. ZPMC-0367

Reference Description: Missed MT transverse indication by QC on OBG Floorbeam 24

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:

During random verification Magnetic Particle Testing (MT) for the OBG Floor Beam at Bay # 3, this Caltrans Quality Assurance Inspector (QA) observed one (1) transverse linear indication approximately 6mm in length in the weld metal on FB024-010-079. This area has been previously tested and accepted by ZPMC MT Technician.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval.
Note: Missing MT indications by ZPMC QC is an on going problem.

Transmitted by: Bill Howe

Attachments: ZPMC-0367

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: 05.03.06-000355

Subject: NCR No. ZPMC-0367

Dated: 21-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000363 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: As for the specific welds related to this NCR, ZPMC will perform the necessary repairs and submit the repair and inspection documents at a later date for closure of this NCR.

ZPMC MT technicians have undergone training and testing due to the amount of missed indications found, ABF has implemented overchecks on several welds within the OBG to prevent unacceptable welds from being passed on to CT. ABF has also performed an investigation regarding cracks found during ZPMC, ABF and CT inspections to find a means to prevent these defects from occurring in the first place. As for the specific welds related to this NCR, ZPMC will perform the necessary repairs and submit the repair and inspection documents at a later date for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000363R00

Caltrans' comments:

Status: AAP

Date: 22-Sep-2009

Will review and confirm the acceptance when the repair documentation is submitted.

Submitted by: Chao, Ching

Date: 22-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000355

Subject: NCR No. ZPMC-0367

Dated: 14-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000363 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: The indication was removed with grinding. ZPMC is submitting NDT documents to show that the weld is acceptable.

ZPMC QA has issued an internal NCR to the QC Department for missing the indication. In order to improve identification of these indications ABFJV's QCM has conducted training with ZPMC's MT inspectors and submitted the training agenda and sign in sheet to the Department. Refresher training will be conducted to continue the emphasis on performing quality inspections. In addition, ABFJV has implemented NDT verification of welds in the OBG to ensure that welds are acceptable prior to being inspected by the Engineer. In this specific case, the indication was removed with grinding. ZPMC is submitting NDT documents to show that the weld is acceptable. As an important note, the weld identified in the non conformance was incorrect. FB024-010-079 is a floorbeam splice weld, the weld referenced in the picture of the NCR is FB024-010-099. ZPMC is submitting the MT report for FB024-010-099. Based on these actions, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000363R01;

Caltrans' comments:

Status: CLO

Date: 27-Dec-2009

Documentation recieved for the repair is correct and therefore this NCR is closed. It should be noted however that the NCR has an error referencing the 79 weld when in fact it was the 99 weld. The letter of response does not reference the correct NCR.

Submitted by: Howe, Bill

Attachment(s):

Date: 27-Dec-2009



No. B-524

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-12-10

REGARDING: NCR-000393(ZPMC-0367) NCR-000310(ZPMC-0284)

With this letter of response, ZPMC requests closure for CALTRANS NCR-000393(ZPMC-0367) & NCR-000310(ZPMC-0284) what mentioned that QA observed missed MT indication & improper cleaning of weld areas prior to MT.

ZPMC acknowledged these problems and has issued internal NCRs.

For regarding of NCR-000393(ZPMC-0367), ZPMC arranged grinder and removed the linear indication by a little grinding on site. After repair MT were done to warrant this weld's quality.

For regarding of NCR-000310(ZPMC-0284), ZPMC cleaned the welds areas then MT was performed again. As required form ABF-NPR-000310 R0., ZPMC will provide NDT documentation to CALTRANS.

And to enhance our MT inspection, training was performed to all the MT inspectors by ABF's QCM. So ZPMC provide internal NCRs, MT documentations and Training Record, hoping CALTRANS could take a review and consider close these NCRs.

ATTACHMENT:

NCR-B-253

NCR-B-187

NCR-000393(ZPMC-0367)

NCR-000310(ZPMC-0284)

B787-MT-16603

B787-MT-12018

ABF-NPR-000310 R0.

Ly
12/10/09



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: 01-Sep-2009

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0367
Document No: 05.03.06-000355

Reference Description: Missed MT transverse indication by QC on OBG Floorbeam 24

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:

During random verification Magnetic Particle Testing (MT) for the OBG Floor Beam at Bay # 3, this Caltrans Quality Assurance Inspector (QA) observed one (1) transverse linear indication approximately 6mm in length in the weld metal on FB024-010-079. This area has been previously tested and accepted by ZPMC MT Technician.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval.

Note: Missing MT indications by ZPMC QC is an on going problem.

Transmitted by: Bill Howe

Attachments: ZPMC-0367

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

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

Bay Area Branch
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000393

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 19-Aug-2009

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

NCR #: ZPMC-036

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: OBG Floorbeam 24
 Procedural Procedural Description: Missed MT indication

Reference Description: Missed MT transverse indication by QC on OBG Floorbeam 24

Description of Non-Conformance:

During random verification Magnetic Particle Testing (MT) for the OBG Floor Beam at Bay # 3, this Caltrans Quality Assurance Inspector (QA) observed one (1) transverse linear indication approximately 6mm in length in the weld metal on FB024-010-079. This area has been previously tested and accepted by ZPMC MT Technician.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Luo Gui Lin

Time and method of notification: 15:00, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 13:00 Email

QC Inspector's Name: Yang Qing Feng

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

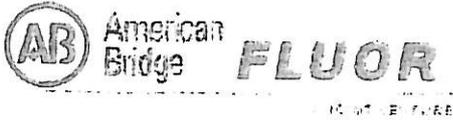
N/A

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



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: 05.03.06-000274

Document No.: ABF-NPR-000310 Rev: 00

Subject: NCR No. ZPMC-0284

Contractor's Proposed Resolution:

Reference Resolution: ABF QCM has had several discussions with ZPMC MT technicians regarding MT over coatings and MT over contaminants. ABF has instructed ZPMC to clean the weld as required and re-MT.

ABF QCM has had several discussions with ZPMC MT technicians regarding MT over coatings and MT over contaminants. ABF has instructed ZPMC to clean the weld as required and re-MT. ZPMC will submit MT reports at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000310R00

Caltrans' comments:

Status: AAP

Date: 31-Aug-2009

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

Please provide documentation of the weld in question is acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0284 at that time.

Submitted by: Wright, Doug

Date: 31-Aug-2009

Attachment(s):





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-187
 (NCR-000310)

Item: Improper Cleaning of Weld
 Area Prior to MT
 名称描述: MT 前表面未清理干净

Item Number:
 件号: N/A

Drawing:
 图号: CB202C-001-003

Location: OBG Crossbeam CB5
 位置: OBGCB5

Date:
 日期: 2009-06-19

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

Caltrans Inspector observed that the Contractor has performed magnetic particle testing prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (CROSSBEAM CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.

加州检验员发现车间人员在进行 MT 前没有对母材及焊缝进行合适的清理。焊缝编号为 CB202C-001-003 (扭曲横梁 CB5)。焊缝以及邻近的母材上覆盖着 UT 耦合剂残留物。

参考标准: AWS D1.5 章节 6.7.6.3 "MT 之前, 必须检验表面, 至少被检表面邻近 25mm 区域内必须干燥, 并且无诸如油、润滑脂、铁锈、砂粒、氧化皮、棉线头、厚漆层、焊接飞溅等污染物"。

Work By: Li Li ming Prepared by: Li Li ming Reviewed by QCE: Zhaoshuangbao
 施工方: 2009.06.19 准备: 6/19/09 质量工程师批准: 6.19
 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: 去除污染物后重新检测. Remove dirty and re-inspection.

Prepared by: Li Li ming Approved by QCA: _____
 准备: 2009.06.19 质量经理批准

Reason for Nonconformance:

不符合原因: 检测表面未清理干净. Didn't clean inspection surface completely.

预防措施: 加强教育培训. Enhance education and training.
 Approved by/批准: Li Li ming 2009.06.19

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

回用或返修的技术依据:

附件

无附件

Reviewed /批准: _____

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
 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: 14-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: 05.03.06-000274

Subject: NCR No. ZPMC-0284

Reference Description: Improper Cleaning of Weld Areas Prior to MT, Weld CB202C-001-003, Crossbeam CB5

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:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor has performed magnetic particle testing (MT) prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (Crossbeam CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.

See NCR report No. ZPMC-284 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

Transmitted by: Ching Chao

Attachments: ZPMC-0284

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao
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
 (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-000310

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 08-Jun-2009

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

NCR #: ZPMC-0284

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: OBG Crossbeam CB5

Procedural Procedural Description:

Reference Description: Improper Cleaning of Weld Areas Prior to MT, Weld CB202C-001-003, Crossbeam
 CB5

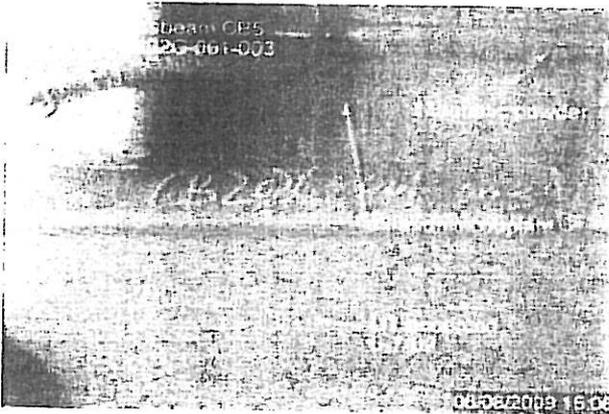
Description of Non-Conformance:

Caltrans Quality Assurance QA) Inspector observed that the Contractor has performed magnetic particle testing (MT) prior to properly cleaning the base metal and weld. The affected weld is identified as CB202C-001-003 (Crossbeam CB5). The weld and adjacent base metal are coated with ultrasonic testing couplant residue.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002 Section 6.7.6.3 "Prior to MT, the surface shall be examined, and any adjacent area within at least 25 mm [1 in.] of the surface to be tested, shall be dry and free of contaminants such as oil, grease, loose rust, loose sand, loose scale, lint, thick paint, welding flux, and weld spatter."

ASTM E709: Paragraphs 9.1 and 15.1.2

Who discovered the problem: Steve Hall
Name of individual from Contractor notified: Peter Ferguson
Time and method of notification: 06/08/09, 17:00, Email
Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 06/09/09, 10:00, 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.

Inspected By: Guest, Skyler	SMR
Reviewed By: Wahbeh, Mazen	SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-12018 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: CB202C CALTRANS CONTRACT NO.: 04-0120F4
 CB5 CROSS BEAM 加州工程编号

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 Material & thickness 母材, 厚度: A709M-345F2-X
 CASTING 铸件 12mm
 FORGING 锻造

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

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			
CB202C-001-003				ACC.		100%MT

AFTER HSR1 (B) -6670

BLANK

EXAMINED BY 主探: Shang Xueqiang SIGN 签名: <i>Shang Xueqiang</i> DATE 日期: 09.06.29	REVIEWED BY 审核: Sun Goh Chong SIGN 签名: <i>Sun Goh Chong</i> DATE 日期: 09.06.29
质量经理 / QCM: <i>[Signature]</i>	用户 CUSTOMER: _____
签字 SIGN / 日期 DATE: <i>[Signature]</i> DATE: 09.06.29	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-000392**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0367**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: 19-Aug-2009**Description of Non-Conformance:**

During random verification Magnetic Particle Testing (MT) for the OBG Floor Beam at Bay # 3, this Caltrans Quality Assurance Inspector (QA) observed one (1) transverse linear indication approximately 6mm in length in the weld metal on FB024-010-079. This area has been previously tested and accepted by ZPMC MT Technician.

Contractor's proposal to correct the problem:

ABFJV has implemented NDT verification of welds in the OBG to ensure that welds are acceptable prior to being inspected by the Engineer.

Corrective action taken:

The weld in question is FB024-010-099. ZPMC submitted MT report to prove the acceptance of this weld. This FB024 has been repaired with acceptable NDT result.

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