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-000440
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 04-Oct-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0414

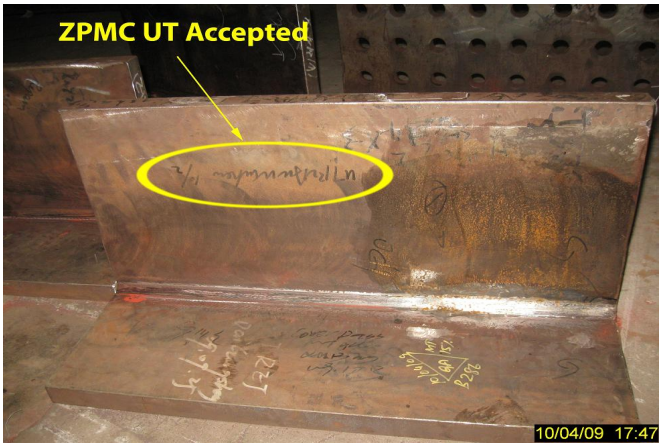
Type of problem:

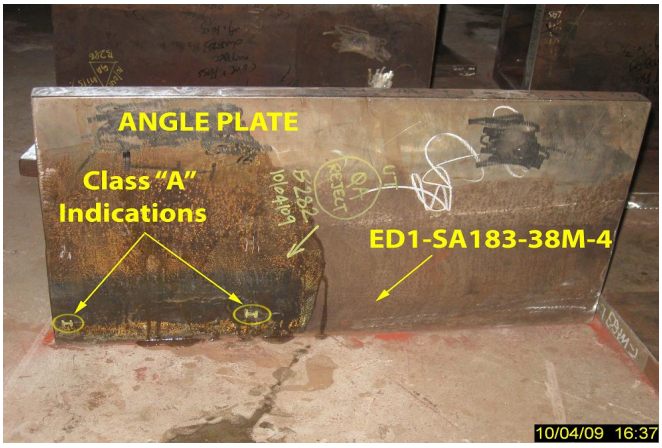
Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:** Strut Web Connection Angle
Procedural	☐	**Procedural**	☐	**Description:** Strut Web Connection Angle ED1-SA183-38M-4		

Reference Description: Missed Class A UT indications on Strut Web Connection Angle ED1-SA183-38M-4

Description of Non-Conformance:

During Ultrasonic Testing (UT) of Strut Web Connection Angle weld joint ED1-SA183-38M-4, QA discovered class “A” rejectable indications measuring approximately 12mm and 10mm in length. This weld was previously tested and accepted by ZPMC Quality Control (QC) UT technicians (NDT Inspection Notification Sheet #004346).





Applicable reference:

AWS D1.5-2002, Section 6.26.3.1 - "Welds that are subject to UT in addition to visual inspection shall be acceptable if they meet the following requirements: (1) Welds subject to tensile stress under any condition of loading shall conform to the requirements of Table 6.3)."

Contract Plans, Sheet 9, General Notes No. 4 - "Web Connection PL" is designated as TM/SRM (Tension Member/Stress Reversal Member)

AWS D1.5-2002, Section 6, Table 6.3 - UT Acceptance-Rejection Criteria - Tensile Stress

Who discovered the problem: Umesh Gaikwad

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Li Shi You
Time and method of notification: 10/4/2009, 16:30; Verbal
Name of Caltrans Engineer notified: Scott Kennedy
Time and method of notification: 10/6/09, 7:00; Verbal
QC Inspector's Name: Li Xiu Yang
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

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:**	06-Oct-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:**	05.03.06-000403
Subject:	NCR No. ZPMC-0414		

Reference Description: Missed Indications (UT) / Tower / Strut Angle

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:**

Remarks:

During Ultrasonic Testing (UT) of Strut Web Connection Angle weld joint ED1-SA183-38M-4, QA discovered class “A” rejectable indications measuring approximately 12mm and 10mm in length. This weld was previously tested and accepted by ZPMC Quality Control (QC) UT technicians (NDT Inspection Notification Sheet #004346).

AWS D1.5-2002, Section 6.26.3.1 - "Welds that are subject to UT in addition to visual inspection shall be acceptable if they meet the following requirements: (1) Welds subject to tensile stress under any condition of loading shall conform to the requirements of Table 6. 3)."

Contract Plans, Sheet 9, General Notes No. 4 - "Web Connection PL" is designated as TM/SRM (Tension Member/Stress Reversal Member)

AWS D1.5-2002, Section 6, Table 6.3 - UT Acceptance-Rejection Criteria - Tensile Stress

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance that addresses the failure of Quality Control to identify the linear indications (UT). Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

In addition to the Quality Control failure, propose a resolution for the identified material/workmanship non-conformance documenting that the repaired weld is in compliance with the contract requirements.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0414

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

File: 05.03.06

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000403

Subject: NCR No. ZPMC-0414

Dated: **16-Oct-2009**
Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9
Job Name: SAS Superstructure
Document No.: **ABF-NPR-000398 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution: ABF JV QCM has implemented training with ZPMC to improve the quality of inspections. ABF JV will provide documentation showing attendance by ZPMC QC inspectors and the subject of training.

ABF JV QCM has implemented training with ZPMC to improve the quality of inspections. ABF JV will provide documentation showing attendance by ZPMC QC inspectors and the subject of training. Topics to be covered during the instruction are: inspection of equipment prior to use, proper conditions for inspection, proper technique for MT, and UT. In addition, ABF JV has committed to perform overchecks in both the Tower and OBG. This will serve two purposes, first to monitor if the training is effective at reducing the number of missed indications and second to ensure missed indications are prevented.

Documentation of repairs and subsequent NDT specific to this report will be transmitted through Daily Welding Reports and will be available in the documentation data base. Based on this course of action, ZPMC is requesting that this proposed resolution be approved with action pending. Once training records are available to be transmitted, ZPMC will request closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000398R00

Caltrans' comments:

Status: REJ

Date: 19-Oct-2009

Even though the course of action is acceptable, the department will not consider closure of this NCR (ZPMC-0414) until all the repair documents and training documents are submitted and reviewed.

Submitted by: Lee, Ken

Date: 19-Oct-2009

Attachment(s):

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000403

Subject: NCR No. ZPMC-0414

Dated: **12-Nov-2009**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000398 Rev: 01**

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has provided NDT documentation of the weld showing that it is sound. Additionally, the weld has been green tagged and accepted by ABF JV, ZPMC and Caltrans since this NCR was written.

ZPMC has provided NDT documentation of the weld showing that it is sound. Additionally, the weld has been green tagged and accepted by ABF JV, ZPMC and Caltrans since this NCR was written. Based on this, ZPMC requests closure of the NCR.

Submitted by:

Attachment(s): ABF-NPR-000398R01;

Caltrans' comments:

Status: CLO

Date: 15-Nov-2009

In ZPMC's Letter of Reponse No. T-076, ZPMC stated that they did not agree with findings of the CT Inspector, Umesh Gaikward, class A indications measuring approximately 12mm and 10mm in length. So ZPMC requested a recheck, and when another CT Inspector, "William" (Will Clifford) retested with ABF and ZPMC witnessing, there was "no problem". ZPMC also stated that "he" promised that "no NCR will be issued and there's no need for it".

The Department would like to clarify this incidence so that their would be no misunderstanding. When the CT Inspector, Will Clifford, retested at ABF JV and ZPMC's request, he found that 12mm indication was just under the borderline but 10mm indication was clearly class A rejectable. He did inform ABF JV and ZPMC staff that 12mm indication was acceptable and there was no need for NCR for that 12mm indication. Unfortunately, the Department had already processed this NCR prior to receiving the revised information.

This NCR will not be considered as a failure of the Quality Contol, and therefore no additional information will be requred. The repair documents are acceptable. The Department concurs that Non-conformance ZPMC-0414 is closed.

Submitted by: Lee, Ken **Date:** 15-Nov-2009

Attachment(s):

No. T-076

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-11-12

REGARDING: NCR-000403(ZPMC-0414)

ZPMC received NCR-403(ZPMC-414), it mentioned that one CT inspector Umesh Gaikwad found a class "A" indication measuring approximately 12mm and 10mm in length during Ultrasonic Testing of weld joint ED1-SA183-38M-4.

And this result was different with ZPMC's, so CT inspector William was called to make a recheck when ABF and ZPMC all witness that. The result show that there's no problem for that. And he also promised that no NCR will be issued and there's no need for it. But we get a disappointed result.

Now this member has been green tagged. Here attached the UT and MT reports of re-inspection to prove the weld was perfect .And ZPMC hope Caltrans could take a review and consider close the NCR.

ATTACHMENT:

NCR-000403(ZPMC-0414)

T787-UT-2244R3

T787-MT-6346

Zhao jia heng

2009-11-12

American Bridge FLUOR

3740 Pudong Nanlu
Shanghai, China 200120

LETTER OF TRANSMITTAL

To: Zhenhua Port Machinery Co. 3261 Dong Fang Lu #201 Shanghai, China, 200125 **Attention:** Mr. Chen Bin **Project:** S.F.O.B.B. **Job #** 04-0120F4	**Transmittal No:** AFC-ZPM-TRN-004377 **Date:** 2009-10-8

Enclosed:

Qty.	Item	Qty.	Item
	CT NCR		
1	NCT403(ZPMC-0414)		

Sender: Date:08-Oct-2009

Recipient: Date: 2009.10.8 10:41

Please indicate receipt of the above mentioned items by signing and returning this transmittal to sender.

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:**	06-Oct-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:**	05.03.06-000403
Subject:	NCR No. ZPMC-0414		

Reference Description: Missed Indications (UT) / Tower / Strut Angle

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:**

Remarks:

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AWS D1.5-2002, Section 6.26.3.1 - "Welds that are subject to UT in addition to visual inspection shall be acceptable if they meet the following requirements: (1) Welds subject to tensile stress under any condition of loading shall conform to the requirements of Table 6. 3)."

Contract Plans, Sheet 9, General Notes No. 4 - "Web Connection PL" is designated as TM/SRM (Tension Member/Stress Reversal Member)

AWS D1.5-2002, Section 6, Table 6.3 - UT Acceptance-Rejection Criteria - Tensile Stress

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Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0414

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

05.03.06-000403,NCT

File: 05.03.06

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY Arnold Schwarzenegger, Governor

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
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

Report No: NCR-000440
Date: 04-Oct-2009
NCR #: ZPMC-0414

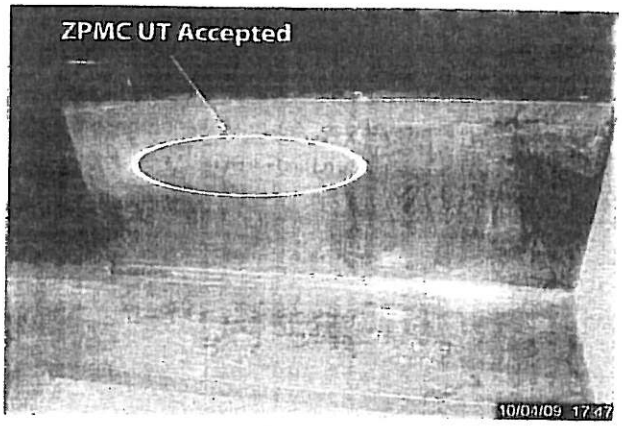
Type of problem:

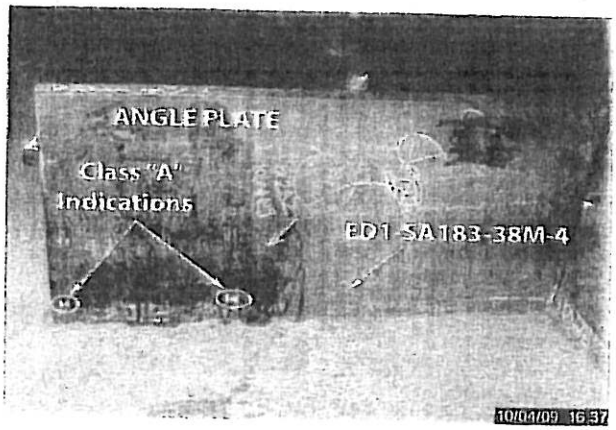
Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:** Strut Web Connection Angle
Procedural	☐	**Procedural**	☐			**Description:** Strut Web Connection Angle ED1-SA183-38M-4

Reference Description: Missed Class A UT indications on Strut Web Connection Angle ED1-SA183-38M-4

Description of Non-Conformance:

During Ultrasonic Testing (UT) of Strut Web Connection Angle weld joint ED1-SA183-38M-4, QA discovered class "A" rejectable indications measuring approximately 12mm and 10mm in length. This weld was previously tested and accepted by ZPMC Quality Control (QC) UT technicians (NDT Inspection Notification Sheet #004346).





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AWS D1.5-2002, Section 6, Table 6.3 - UT Acceptance-Rejection Criteria - Tensile Stress

Who discovered the problem: Umesh Gaikwad

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Li Shi You
Time and method of notification: 10/4/2009, 16:30; Verbal
Name of Caltrans Engineer notified: Scott Kennedy
Time and method of notification: 10/6/09, 7:00; Verbal
QC Inspector's Name: Li Xiu Yang
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

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号 T787-UT-2244R3	DATE 2009.10.10	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 部件名称 FIRST LIFTING TOWER(E)	DRAWING NO.: 图号 ED1-SA183	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS 焊接方法	JOINT TYPE 焊缝类型	CALIBRATION DUE DATE仪器校正有效期
SMAW	CORNER-JOINT	Dec. 28ST ,2009

EQUIPMENT 设备	MANUFACTURER 制造商	MODEL NO. 样式编号	SERIAL NO. 序列编号
UT SCOPE	PANAMETRICS	EPOCH-4B	071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度
AWS IIW BLOCK TYPE II	C.M.C	A709SL-GR485/GR485+ 32mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm				

Reference Level 参考灵敏度 20dB

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
ED1-SA183-38M-4-1A/B	1R3	70				32								ACC.	100%
AFTER T-CWR308 REV1															
BLANK															

EXAMINED BY主探 Xue hai rong Xue Hairong 2009.10.10
LEVEL - II SIGN / DATE

REVIEWED BY 审核 E Shiqing 2009.10.10
LEVEL - II SIGN / DATE

质量经理 / QCM Lu Zhen hua 2009.10.10
签字 SIGN / 日期 DATE

用户CUSTOMER
签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-6346	DATE日期 2009.10.12	PAGE OF页码 1/2	Revision No: 0

PROJECT NO. 工程编号:	ZP06-787	CONTRACTOR: 用 户:	CALTRANS
DRAWING NO. 图号:	ED1-SA183 The 1st lifting Tower(E)	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 5620 5395 5617
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	A709SL-Gr485+ A709SL-Gr485 32 mm
WELDING PROCESS 焊接方法	SMAW,SAW	TYPE OF JOINT 焊缝类型	CORNER 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			
ED1-SA183-18M-1-1A/B				ACC.		100%MT
ED1-SA183-18M-2-1A/B				ACC.		100%MT
ED1-SA183-18M-3-1A/B				ACC.		100%MT
ED1-SA183-18M-4-1A/B				ACC.		100%MT
ED1-SA183-28M-1-1A/B				ACC.		100%MT
ED1-SA183-28M-2-1A/B				ACC.		100%MT
ED1-SA183-28M-3-1A/B				ACC.		100%MT
ED1-SA183-28M-4-1A/B				ACC.		100%MT
ED1-SA183-23M-1-1A/B				ACC.		100%MT
ED1-SA183-23M-2-1A/B				ACC.		100%MT
ED1-SA183-23M-3-1A/B				ACC.		100%MT
ED1-SA183-23M-4-1A/B				ACC.		100%MT
ED1-SA183-33M-1-1A/B				ACC.		100%MT
ED1-SA183-33M-2-1A/B				ACC.		100%MT
ED1-SA183-33M-3-1A/B				ACC.		100%MT
ED1-SA183-33M-4-1A/B				ACC.		100%MT

EXAMINED BY主探 Wang Wei Wang Wei 2009.10.12 LEVEL - II SIGN 签名 / DATE日期	REVIEWED BY 审核 Chris Xu 2009/10/12 LEVEL-II SIGN / DATE日期
质量经理 / QCM Lu Jian hua 2009.10.12 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 T787-MT-6346	DATE日期 2009.10.12	PAGE OF页码 2/2	Revision No: 0

PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用 户: CALTRANS	
DRAWING NO. 图号: ED1-SA183 The 1st lifting Tower(E)		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 5620 5395 5617
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	A709SL-Gr485+ A709SL-Gr485 32 mm
WELDING PROCESS 焊接方法	SMAW,SAW	TYPE OF JOINT 焊缝类型	CORNER JOINT

WELD I.D. 焊缝编号	DISCONTINUITY不连续性 INDICATION 指示	TYPE 类型	LENGTH IN mm 长度	ACCEPT 接受	REJECT 拒收	REMARKS 备注
ED1-SA183-38M-1-1A/B				ACC.		100%MT
ED1-SA183-38M-2-1A/B				ACC.		100%MT
ED1-SA183-38M-3-1A/B				ACC.		100%MT
ED1-SA183-38M-4-1A/B				ACC.		100%MT
ED1-SA183-43M-1-1A/B				ACC.		100%MT
ED1-SA183-43M-2-1A/B				ACC.		100%MT
ED1-SA183-43M-3-1A/B				ACC.		100%MT
ED1-SA183-43M-4-1A/B				ACC.		100%MT
ED1-SA183-47.6M-1-1A/B				ACC.		100%MT
ED1-SA183-47.6M-2-1A/B				ACC.		100%MT
ED1-SA183-47.6M-3-1A/B				ACC.		100%MT
ED1-SA183-47.6M-4-1A/B				ACC.		100%MT
BLANK						

EXAMINED BY主探 Wang Wei 2009.10.12 LEVEL - II SIGN 签名 / DATE日期	REVIEWED BY 审核 2009.10.12 LEVEL-II SIGN / DATE日期
质量经理 / QCM 2009.10.12 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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 #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, PRC **Report No:** NCS-000329
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 16-Nov-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0414

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:**
Procedural	☐	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 04-Oct-2009

Description of Non-Conformance:
During Ultrasonic Testing (UT) of Strut Web Connection Angle weld joint ED1-SA183-38M-4, QA discovered class “A” rejectable indications measuring approximately 12mm and 10mm in length. This weld was previously tested and accepted by ZPMC Quality Control (QC) UT technicians (NDT Inspection Notification Sheet #004346).

Contractor's proposal to correct the problem:
Repair affected weld.

Corrective action taken:
The affected weld has been repaired, NDT results indicating a sound weld have been submitted, and the weld has been 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
Reviewed By:	Wahbeh,Mazen	QA Reviewer