

**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-000479**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Oct-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0452**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** 5AE Bike Path Cantilever Brackets BK1 @ PP29**Procedural****Procedural****Description:** Visual Cracks on Bike Path Cantilever Brackets**Reference Description:** Visual Cracks found on fillet welds of Bike Path Cantilever Brackets on 5AE PP29**Description of Non-Conformance:**

During a random visual inspection of OBG Segment 5AE Bike Path Cantilever Brackets (BK1), Caltrans Quality Assurance (QA) Inspector discovered visual cracks in the fillet welds on the top cope hole cover plates BKX4A and BKX4B at panel point 29. The visual crack observed on BKX4A measured 13mm in length and 15mm in length on BKX4B.



---

# 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 D1.5-2002 Section 6.26.1.1; The weld shall have no cracks.

**Who discovered the problem:** Daniel Hernandez

**Name of individual from Contractor notified:** Kevin Chen

**Time and method of notification:** 0930 hours, Verbal

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 1030 hours, Email

**QC Inspector's Name:** Xu Yumin

**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.

---

<b>Inspected By:</b>	Carreon,Albert	Lead Reviewer/Task Leader
<b>Reviewed By:</b>	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:** 17-Nov-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:** 05.03.06-000442

**Subject:** NCR No. ZPMC-0452

**Reference Description:** Visual Cracks found on fillet welds of Bike Path Cantilever Brackets on 5AE PP29

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:** Bike Path **Lift:** 05

**Remarks:**

During a random visual inspection of OBG Segment 5AE Bike Path Cantilever Brackets (BK1), Caltrans Quality Assurance (QA) Inspector discovered visual cracks in the fillet welds on the top cope hole cover plates BKX4A and BKX4B at panel point 29. The visual crack observed on BKX4A measured 13mm in length and 15mm in length on BKX4B.

**Action Required and/or Action Taken:**

Submit a repair procedure to the engineer for approval.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0452

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

**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Dated:** 18-Dec-2009

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

**Attention:** Pursell, Gary  
Resident Engineer

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000447 Rev: 00

**Ref:** 05.03.06-000442

**Subject:** NCR No. ZPMC-0452

---

### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC will provide repair documentation of the cracks. NDT documentation will be submitted to show the welds are acceptable when complete.

ZPMC will provide repair documentation of the cracks. NDT documentation will be submitted to show the welds are acceptable when complete. Based on this course of action, ZPMC requests that their proposal be accepted with actions pending.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000447R00

---

### Caltrans' comments:

**Status:** AAP

**Date:** 30-Dec-2009

Request accepted.

**Submitted by:** Howe, Bill

**Date:** 30-Dec-2009

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000442

**Subject:** NCR No. ZPMC-0452

**Dated:** 18-Mar-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000447 Rev: 01

---

### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC is providing the NDT of the fillet welds to show that they are acceptable. In addition, ZPMC has issued an internal NCR to notify the QC to monitor the cover plates welds more closely.

ZPMC is providing the NDT of the fillet welds to show that they are acceptable. In addition, ZPMC has issued an internal NCR to notify the QC to monitor the cover plates welds more closely. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000447R01;

---

### Caltrans' comments:

**Status:** CLO

**Date:** 24-Mar-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0450 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):** NPR CT Comments

**Date:** 24-Mar-2010



No. B-695

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-3-18**

**REGARDING: NCR-000479(ZPMC-0452) NCR-000493(ZPMC-0466)**

Visual cracks were found on the fillet welds of cover plates near the end of X4A & X4B. These cover plates are welded over the cope to seal the inner space. ZPMC acknowledged this problem and has instructed the QC/CWI to enhance to monitor of the welding for the cover plates. ZPMC is providing the NDT record shows the soundness of these fillet welds. Based on this, ZPMC is requesting closure of this NCR.

**ATTACHMENT:**

NCR-000479(ZPMC-0452)

NCR-000493(ZPMC-0466)

B787-MT-20831

A handwritten signature in black ink, appearing to be "J. W.", is written over the attachment list.

3/18/10



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:** 04-Dec-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:** 05.03.06-000456  
**Subject:** NCR No. ZPMC-0466

**Reference Description:** Repair of cracks without CWR on Cantilever Bike Path Bracket for Lift 5E

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:** Bike Path

**Lift:** 05

### Remarks:

During random visual inspection the Caltrans Quality Assurance (QA) Inspector observed weld repairs were performed on cracks in the fillet welds on the top cope hole cover plates on plates BKX4A and BKX4B of BK001-017. Carbon air arc gouging was used to remove the cracks. NDT was not performed on the excavated area to insure the defect was completely removed. The weld repair was performed with the Flux Cored Arc Welding (FCAW) process. The fillet welds of the cover plate do not have a designated weld numbers for identification. These repairs were performed without an approved welding procedure and the Engineer's approval. These cracks were found on Oct 15, 2009. (see NCR ZPMC-0452)

### Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0466

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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-000479

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 15-Oct-2009

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

**NCR #:** ZPMC-0452

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural  Bridge No: 34-0006

Joint fit-up  Coating  Other

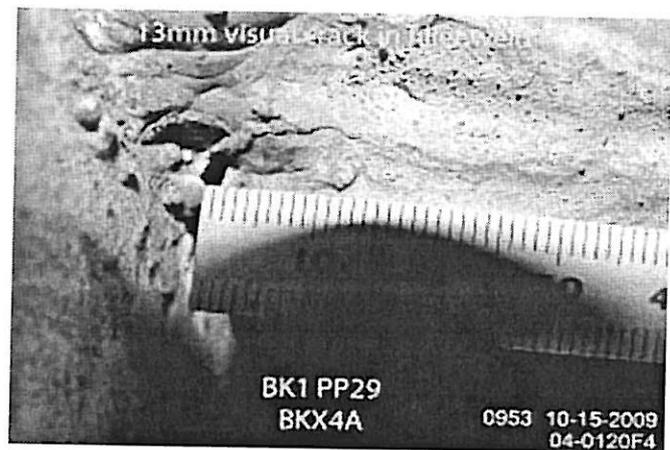
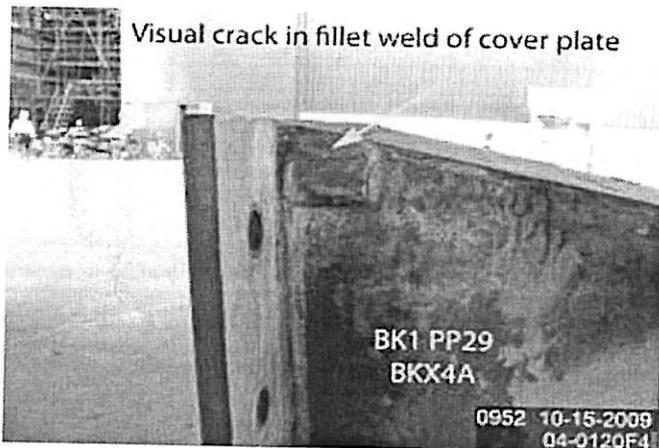
Component: 5AE Bike Path Cantilever Brackets BK1 @ PP29

Procedural  Procedural  Description: Visual Cracks on Bike Path Cantilever Brackets

Reference Description: Visual Cracks found on fillet welds of Bike Path Cantilever Brackets on 5AE PP29

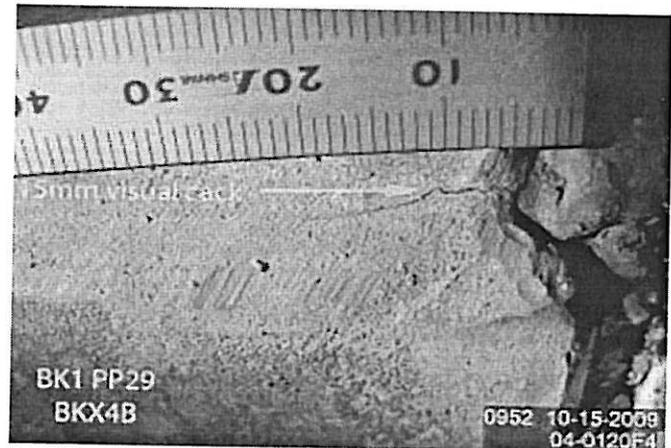
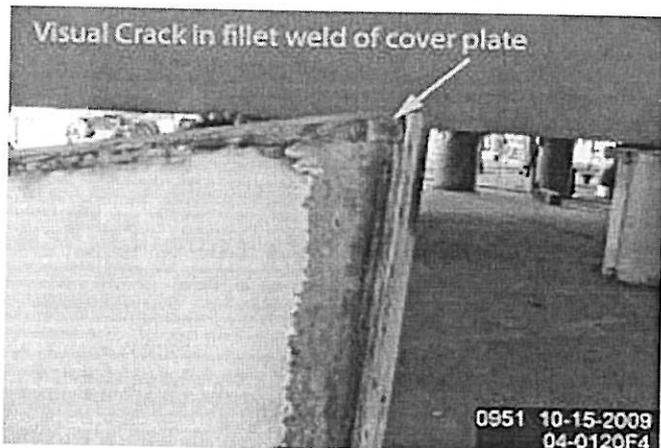
### Description of Non-Conformance:

During a random visual inspection of OBG Segment 5AE Bike Path Cantilever Brackets (BK1), Caltrans Quality Assurance (QA) Inspector discovered visual cracks in the fillet welds on the top cope hole cover plates BKX4A and BKX4B at panel point 29. The visual crack observed on BKX4A measured 13mm in length and 15mm in length on BKX4B.



# 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 D1.5-2002 Section 6.26.1.1; The weld shall have no cracks.

**Who discovered the problem:** Daniel Hernandez

**Name of individual from Contractor notified:** Kevin Chen

**Time and method of notification:** 0930 hours, Verbal

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 1030 hours, Email

**QC Inspector's Name:** Xu Yumin

**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:** Carreon, Albert

Lead Reviewer/Task Leader

**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:** 04-Dec-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:** 05.03.06-000456

**Subject:** NCR No. ZPMC-0466

**Reference Description:** Repair of cracks without CWR on Cantilever Bike Path Bracket for Lift 5E

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:** Bike Path **Lift:** 05

### Remarks:

During random visual inspection the Caltrans Quality Assurance (QA) Inspector observed weld repairs were performed on cracks in the fillet welds on the top cope hole cover plates on plates BKX4A and BKX4B of BK001-017. Carbon air arc gouging was used to remove the cracks. NDT was not performed on the excavated area to insure the defect was completely removed. The weld repair was performed with the Flux Cored Arc Welding (FCAW) process. The fillet welds of the cover plate do not have a designated weld numbers for identification. These repairs were performed without an approved welding procedure and the Engineer's approval. These cracks were found on Oct 15, 2009. (see NCR ZPMC-0452)

### Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0466

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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-000493

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 20-Oct-2009

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

**NCR #:** ZPMC-0466

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural

Joint fit-up  Coating  Other

Procedural  Procedural  Description:

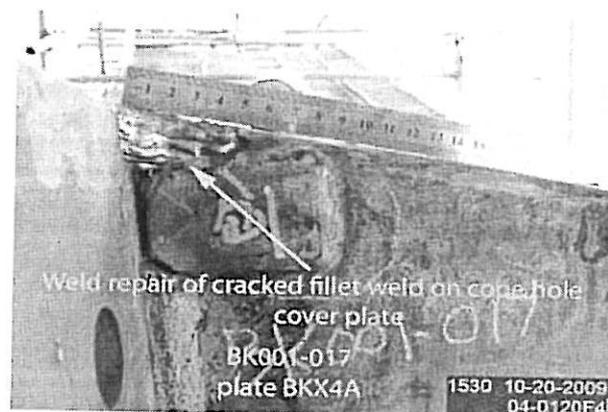
**Bridge No:** 34-0006

**Component:** OBG Lift 5E Cantilever Bike Path Bracket

**Reference Description:** Repair of cracks without CWR on Cantilever Bike Path Bracket for Lift 5E

### Description of Non-Conformance:

During random visual inspection the Caltrans Quality Assurance (QA) Inspector observed weld repairs were performed on cracks in the fillet welds on the top cope hole cover plates on plates BKX4A and BKX4B of BK001-017. Carbon air arc gouging was used to remove the cracks. NDT was not performed on the excavated area to insure the defect was completely removed. The weld repair was performed with the Flux Cored Arc Welding (FCAW) process. The fillet welds of the cover plate do not have a designated weld numbers for identification. These repairs were performed without an approved welding procedure and the Engineer's approval. These cracks were found on Oct 15, 2009. (see NCR ZPMC-0452)



### Applicable reference:

Special Provisions: SECTION 8-3 WELDING

"The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them. For requests to perform repairs, the Contractor shall include an engineering evaluation of the proposed repair. The engineering evaluation, at a minimum, shall include what is causing the

---

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

---

( Continued Page 2 of 2 )

---

defects, why the repairs will not degrade the material properties, and what steps are being taken to prevent similar defects from happening again in the future.”

**Who discovered the problem:** Dan Hernandez

**Name of individual from Contractor notified:** Kevin Chang

**Time and method of notification:** 1430 hours, Verbal

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 1600 hours, verbal

**QC Inspector's Name:** Xu Yumin

**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:** Carreon,Albert

Lead Reviewer/Task Leader

**Reviewed By:** Wahbeh,Mazen

SMR

---





# 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-312(ZPMC-0466)

**Item:** Repair of cracks without CWR on cantilever bike path bracket  
**名称描述:** 返修悬索支架上的裂纹没有开 CWR

**Item Number:**  
**件号:** 5E BK

**Drawing:**  
**图号:** N/A

**Location:** Assembly yard  
**位置:** 外场

**Date:**  
**日期:** 2009-12-18

### Description of Nonconformance:

#### 不符合项状态描述:

During random visual inspection the Caltrans Quality Assurance inspector observed weld repairs were performed on Cracks in the fillet welds on the top cope hole cover plates on plates BKX4A and BKX4B of BK001-017. Carbon air arc gouging was used to remove the cracks, NDT was not performed on the excavated area to insure the defect was completely removed, The weld repair was performed with the Flux Cored Arc Welding process, The fillet welds of of the cover plate do not have a designated weld numbers for identification. These repairs were performed without an approved welding procedure and the Engineer's approval, These cracks were found on Oct 15, 2009 (See NCR ZPMC-0452)

加州检验员发现 ZPMC 在去除悬臂梁上部靠近封板位置附近的过焊孔上的裂纹去除后并未作探伤用来保证裂纹完全消除。另外裂纹返修前也并未提交关键返修报告给加州工程师批准。

**Work By:** \_\_\_\_\_ **Prepared by:** \_\_\_\_\_ **Reviewed by QCE:** \_\_\_\_\_  
**施工方:** \_\_\_\_\_ **准备:** \_\_\_\_\_ **质量工程师批准:** \_\_\_\_\_

**Drawing Error**     **Material Defect**     **Fabrication Error**     **Other**  
**图纸错误**                      **材料缺陷**                      **制作错误**                      **其他原因**

**Disposition:**     **Use as is**                       **Repair**                       **Reject**  
**处理措施:**                      **回用**                      **返修**                      **拒收**

### Recommendation:

#### 建议:

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

### Reason for Nonconformance:

#### 不符合原因:

### Prevention of Re-occurrence:

#### 预防措施:

Approved by/批准: _____		
<b>Technical Justification for Use-As-Is/Repair:</b> 回用或返修的技术依据:	<input type="checkbox"/> <b>Attachment</b> 附件	<input type="checkbox"/> <b>Non-attachment</b> 无附件
Reviewed /批准: _____		
<b>Verification:</b> 确认:	<input type="checkbox"/> <b>Acceptable</b> 可接受	<input type="checkbox"/> <b>Unacceptable</b> 不可接受
Verified by QCI/质检确认: _____ Reviewed by QCA/质检主任审核: _____		

#R787-QCP-1300



# Nonconformance Report

## 不符合项报告

<b>Project Name:</b> S.F.O.B.B 项目名称: 美国加州海湾大桥		<b>NCR Number:</b> NCR 编号: NCR-B-304(ZPMC-0452)	
<b>Item:</b> Visual Cracks found on BK 名称描述: 悬臂梁目检发现裂纹	<b>Item Number:</b> 件号: N/A	<b>Drawing:</b> 图号: BKX4A/BKX4B	
<b>Location:</b> OBG Trial assembly yard 位置: OBG 总拼场地		<b>Date:</b> 日期: 2009-11-27	

### Description of Nonconformance:

#### 不符合项状态描述:

During a random visual inspection of OBG 5AE bike path cantilever brackets (BK1), CT inspector discovered visual cracks in the fillet welds on the top cope hole cover plates BKX4A and BKX4B at panel point 29. The visual crack observed on BKX4A measured 13mm in length and 15mm in length on BKX4B.

在对 OBG 5AE 自行车道悬臂梁 (BK1) 的随机目检中, 加州检验员发现在 PP29 位置, BKX4A 和 BKX4B 顶部角焊缝过焊孔处目检发现裂纹。BKX4A 处目检裂纹长度 13mm, BKX4B 处目检裂纹长度 15mm。

参考标准: 标书章节 8-3, AWS D1.5 章节 6.26.1.1

<b>Work By:</b> 施工方:	<b>Prepared by:</b> 准备:	<b>Reviewed by QCE:</b> 质量工程师批准:	
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误	<input type="checkbox"/> Other 其他原因

<b>Disposition:</b> 处理措施:	<input type="checkbox"/> Use as is 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
------------------------------	--	---------------------------------------	---------------------------------------

### Recommendation:

#### 建议:

<b>Prepared by:</b> _____ 准备	<b>Approved by QCA:</b> _____ 质量经理批准
---------------------------------	---

### Reason for Nonconformance:

#### 不符合原因:

### Prevention of Re-occurrence:

#### 预防措施:

<b>Approved by/批准:</b> _____		
<b>Technical Justification for Use-As-Is/Repair:</b> 回用或返修的技术依据:	<input type="checkbox"/> <b>Attachment</b> 附件	<input type="checkbox"/> <b>Non-attachment</b> 无附件
<b>Reviewed /批准:</b> _____		
<b>Verification:</b> 确认:	<input type="checkbox"/> <b>Acceptable</b> 可接受	<input type="checkbox"/> <b>Unacceptable</b> 不可接受
<b>Verified by QCI/质检确认:</b> _____ <b>Reviewed by QCA/质检主任审核:</b> _____		

#R787-QCP-1300

**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-000578**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0452**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Date the Non-Conformance Report was written:** 15-Oct-2009**Description of Non-Conformance:**

During a random visual inspection of OBG Segment 5AE Bike Path Cantilever Brackets (BK1), Caltrans Quality Assurance (QA) Inspector discovered visual cracks in the fillet welds on the top cope hole cover plates BKX4A and BKX4B at panel point 29. The visual crack observed on BKX4A measured 13mm in length and 15mm in length on BKX4B.

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

Repair said indications and perform NDT required to verify weld quality

**Corrective action taken:**

The Department issued NCR ZPMC-466 in regards to ZPMC personnel performing repairs without prior approval of the Engineer. Contractor submitted NDT report verifying the welds are now in conformance with Contract specifications.

**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 152. 1675.3703, who represents the Office of Structural Materials for your project.

**Inspected By:** Simonis, Jim **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**