

**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-000496**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Oct-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0469**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Segment 6AW**Procedural****Procedural****Description:** Found MT indications after Contractor's acceptance**Reference Description:** Crater and Linear Indications discovered in 6AW with MT after the contractor's NDT acceptance**Description of Non-Conformance:**

During a random Magnetic Particle (MT) verification of OBG Segment 6AW, the Caltrans Quality Assurance (QA) Inspectors observed fifteen (15) Crater Indications on the Deck Panel U rib to Diaphragm welds at panel point 38 and 39. The Crater Indications ranged from 10mm to 30mm in length and these welds were tested and accepted by ZPMC QC MT.

The following weld designations and length of indications were observed.

DP084-001-059 (10mm), DP111-001-067 (30mm), 062 (30mm), 059 (20mm), 092 (10mm) DP165-001-086 (20mm), DP273-001-056 (20mm), 051 (20mm), 048 (30mm), 038 (20mm), 084 (20mm) DP246-001-094 (30mm), 081 (15mm), 065 (10mm), 060 (10mm).

During a random verification Magnetic Particle Testing of the internal components of OBG segment 6AW, the Caltrans Quality Assurance (QA) Inspector discovered a total of two (2) Transverse Indications that measured from 5mm to 20mm in length. These welds were previously tested accepted by ZPMC (MT) technicians.

The non-complying weld designations are as follows:

Open Rib Stiffener to corner assembly web plate weld- CSD2-PP38.5-010 (1) 5mm Transverse Indication.

Longitudinal Girder to panel point 38 Weld -SEG027M-018 (1) 20mm Transverse Indication.

# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 3 )



## 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.”

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 3 of 3 )

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-AWS D1.5 (02) - 6.26.1; "The weld shall have no cracks."

**Who discovered the problem:** Larry Viars and Rodney Patterson

**Name of individual from Contractor notified:** Peter Shaw

**Time and method of notification:** 1630 hours, Verbal

**Name of Caltrans Engineer notified:** Ching Chao and Bill Howe

**Time and method of notification:** 1730 hours, Verbal

**QC Inspector's Name:** Zhong Wei

**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.

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<b>Inspected By:</b>	Carreon,Albert	Lead Reviewer/Task Leader
<b>Reviewed By:</b>	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**

<b>To:</b>	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	<b>Date:</b>	11-Dec-2009
<b>Dear:</b>	Mr. Charles Kanapicki	<b>Contract No:</b>	04-0120F4 04-SF-80-13.2 / 13.9
<b>Attention:</b>	Mr. Thomas Nilsson Project/Fabrication Manager	<b>Job Name:</b>	SAS Superstructure
<b>Subject:</b>	NCR No. ZPMC-0469	<b>Document No:</b>	05.03.06-000459

**Reference Description:** Crater and Linear Indications discovered in 6AW with MT after the contractor's NDT acceptance

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:** 06

**Remarks:**

During a random Magnetic Particle (MT) verification of OBG Segment 6AW, the Caltrans Quality Assurance (QA) Inspectors observed fifteen (15) Crater Indications on the Deck Panel U rib to Diaphragm welds at panel point 38 and 39. The Crater Indications ranged from 10mm to 30mm in length and these welds were tested and accepted by ZPMC QC MT.

The following weld designations and length of indications were observed.

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During a random verification Magnetic Particle Testing of the internal components of OBG segment 6AW, the Caltrans Quality Assurance (QA) Inspector discovered a total of two (2) Transverse Indications that measured from 5mm to 20mm in length. These welds were previously tested accepted by ZPMC (MT) technicians.

The non-complying weld designations are as follows:

Open Rib Stiffener to corner assembly web plate weld- CSD2-PP38.5-010 (1) 5mm Transverse Indication.

Longitudinal Girder to panel point 38 Weld –SEG027M-018 (1) 20mm Transverse Indication.

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

- Submit a repair procedure to the engineer for approval. Missing MT indications by ZPMC MT technicians is a chronic problem.
- Provide training to ensure these occurrences are minimized.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0469

**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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000459

**Subject:** NCR No. ZPMC-0469

**Dated:** 18-Jan-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000493 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** As a means of preventing future occurrences, the ABF QCM has performed refresher MT training. See attached MT training agenda and attendance roster.

As it is necessary to respond to the NCR with a proposed plan of action, ABF is doing so without all of the repair documentation at this time. As a means of preventing future occurrences, the ABF QCM has performed refresher MT training. See attached MT training agenda and attendance roster. The ABF QCM has been discussing missed MT indications with the ZPMC QCM and related NDT supervisory personnel. The ZPMC level III is in the process of assessing personnel, techniques and equipment. Preliminary findings have resulted in ZPMC taking immediate action by performing 100% overchecks of the previously tested areas beginning the week of 18 January 09 as a means of preventing future NCR's for missed indications. ABF has purchased powder dispensers for all the ZPMC MT technicians as a means to help control the amount of powder applied during MT testing. ZPMC requests this NCR be placed in the Approved Action Pending status category until such time that all the repair documents have been assembled and submitted.

**Submitted by:** Lawton, Steve

**Attachment(s):** ABF-NPR-000493R00;

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### Caltrans' comments:

**Status:** AAP

**Date:** 25-Jan-2010

The preventative measures taken by the QCM and the proposed resolution for closing NCR submitted by the contractor are acceptable. The NCR will be closed upon completion of the repair and review of the repair documents by the Engineer when submitted by the contractor.

**Submitted by:** Chao, Ching

**Date:** 25-Jan-2010

**Attachment(s):**

# Tool Box Training Agenda

**Subject:** MT Techniques

**Reason for Training:** Several CT NCR's of indications missed during ZPMC NDT inspection.

## 1. Safety

- a. Safety Glasses
- b. Gloves (if required)
- c. Knee Pads
- d. Electrical shock

## 2. Tools

- a. Lighting
- b. MT Powder.                      Red for ambient,      Yellow for High Temperature.
- c. Powder Bulb
- d. Powder Blower
- e. MT Yoke                      Adequate working condition
- f. Pie Gage

## 3. Inspection Techniques

- a. Lighting
- b. Position of body (distance of eyes to the weld surface)
- c. Application of Powder      removal of Powder
- d. Continuous method
- e. Two directions
- f. Both sides of weld
- g. Clean and dry surface



教育培训纪录

培训编号: MT-22-Dec-09

培训内容:	MT Techniques
培训对象:	项目质检
授课人员:	Steve Lawton
培训类型:	内部培训
培训时间:	22-Dec-09 5:00 PM
计划培训地点:	ZPMC QC office

人员签到:

姓名	部门	姓名	部门
孙力杰 Sunlei	钢桥	狄坤伦 Di Kunlun	钢桥
孙广强 Sun Guangqiang	钢桥	蔡新鑫 Cai Xinxin	钢桥
徐海 Xu Hai	钢桥	傅春强 Fu Chunqiang	钢桥
卞源源 Bian Yuanyuan	钢桥	顾云武 Gu Yunwu	钢桥
许兵 Xu Bing	钢桥	金建廷 Jin Jianting	钢桥 MT
李振华 Li Zhenhua	钢桥	常方杰 Chang Fangjie	钢桥
李坤阳 Li Xunyang	QA	袁俊 Yuan Jun	钢桥
王威 Wang Wei	钢桥	刘章敏 Liu Zhangmin	
孙林 Sun Lin	钢桥 MT	徐华祥 Xu Huaxiang	钢桥
丁阿成 Ding A Cheng	钢桥 MT	周东超 Zhou Dongchao	钢桥
贺佳佳 He Jiajia	钢桥	赵成功 Zhao Chenggong	钢桥
黄瑞 Huang Rui	钢桥	孙广强 Sun Guangqiang	钢桥
李黎明 Li Liming	钢桥	徐辉 Xu Hui	钢桥
李昌涛 Li Changtao		刘宏斌 Liu Hongbin	

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000459

**Subject:** NCR No. ZPMC-0469

**Dated:** 03-Mar-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000493 Rev: 01

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC has repaired the missed indications present and retested the welds for acceptability. Attached is documentation showing the welds are sounds. Based on that ZPMC requests closure of this NCR.

ZPMC has repaired the missed indications present and retested the welds for acceptability. Attached is documentation showing the welds are sounds. Based on that ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000493R01;

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**Caltrans' comments:**

**Status:** CLO

**Date:** 07-Mar-2010

The documentation received is sufficient to close this NCR.

**Submitted by:** Howe, Bill

**Date:** 07-Mar-2010

**Attachment(s):**



No. B-638

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-3-3**

**REGARDING: NCR-000496 (ZPMC-0469)**

With this letter of response, ZPMC requests closure of CT NCR-000496 (ZPMC-0469) what mentioned that Missed MT indications were observed by CT inspector.

- CWRs were issued reflecting to these defections. The defections have been removed, repaired, tested and accepted after then. Please refer to B-CWR1068, B-CWR1069, B-CWR1070, B-CWR1071, B-CWR1072, B-CWR1073.
- The punch list item 184 what mentioned this NCR has been confirmed and closed by CT inspector.
- To improve the MT method, refresh training was performed to ZPMC's MT personnel by ABF QCM.

Base on the taken actions and attached documentations, ZPMC requests closure of this NCR.

**ATTACHMENT:**

NCR-000496 (ZPMC-0469)

B787-MT-17839 R1

B787-MT-17843 R1

  
3/3/10



**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:** 11-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:** 05.03.06-000459  
**Subject:** NCR No. ZPMC-0469

**Reference Description:** Crater and Linear Indications discovered in 6AW with MT after the contractor's NDT acceptance

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:** 06

**Remarks:**

During a random Magnetic Particle (MT) verification of OBG Segment 6AW, the Caltrans Quality Assurance (QA) Inspectors observed fifteen (15) Crater Indications on the Deck Panel U rib to Diaphragm welds at panel point 38 and 39. The Crater Indications ranged from 10mm to 30mm in length and these welds were tested and accepted by ZPMC QC MT.

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Open Rib Stiffener to corner assembly web plate weld- CSD2-PP38.5-010 (1) 5mm Transverse Indication.

Longitudinal Girder to panel point 38 Weld -SEG027M-018 (1) 20mm Transverse Indication.

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

Submit a repair procedure to the engineer for approval. Missing MT indications by ZPMC MT technicians is a chronic problem.

Provide training to ensure these occurrences are minimized.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0469

**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-000496

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

**Date:** 28-Oct-2009

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

**NCR #:** ZPMC-0469

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural  Bridge No: 34-0006

Joint fit-up  Coating  Other  Component: Segment 6AW

Procedural  Procedural  Description: Found MT indications after Contractor's acceptance

**Reference Description:** Crater and Linear Indications discovered in 6AW with MT after the contractor's NDT acceptance

### Description of Non-Conformance:

During a random Magnetic Particle (MT) verification of OBG Segment 6AW, the Caltrans Quality Assurance (QA) Inspectors observed fifteen (15) Crater Indications on the Deck Panel U rib to Diaphragm welds at panel point 38 and 39. The Crater Indications ranged from 10mm to 30mm in length and these welds were tested and accepted by ZPMC QC MT.

The following weld designations and length of indications were observed.

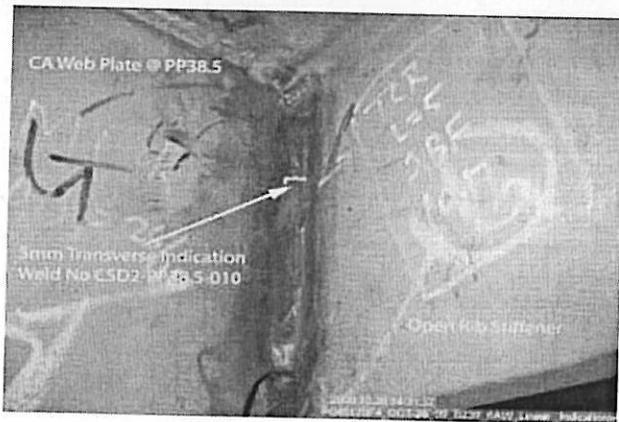
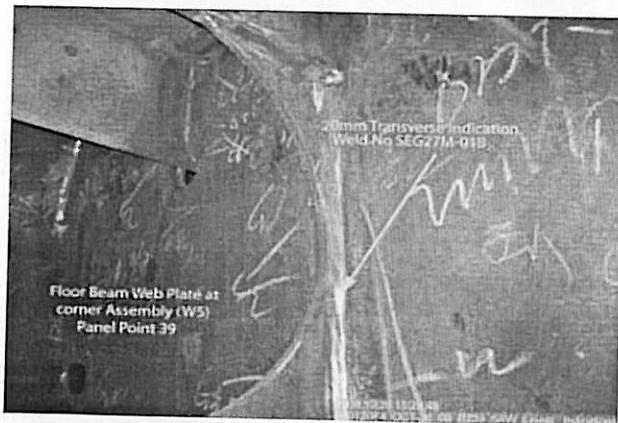
DP084-001-059 (10mm), DP111-001-067 (30mm), 062 (30mm), 059 (20mm), 092 (10mm) DP165-001-086 (20mm), DP273-001-056 (20mm), 051 (20mm), 048 (30mm), 038 (20mm), 084 (20mm) DP246-001-094 (30mm), 081 (15mm), 065 (10mm), 060 (10mm).

During a random verification Magnetic Particle Testing of the internal components of OBG segment 6AW, the Caltrans Quality Assurance (QA) Inspector discovered a total of two (2) Transverse Indications that measured from 5mm to 20mm in length. These welds were previously tested accepted by ZPMC (MT) technicians. The non-complying weld designations are as follows:

Open Rib Stiffener to corner assembly web plate weld- CSD2-PP38.5-010 (1) 5mm Transverse Indication.  
 Longitudinal Girder to panel point 38 Weld -SEG027M-018 (1) 20mm Transverse Indication.

# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



## 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.”

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 3 of 3 )

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-AWS D1.5 (02) - 6.26.1; "The weld shall have no cracks."

**Who discovered the problem:** Larry Viars and Rodney Patterson

**Name of individual from Contractor notified:** Peter Shaw

**Time and method of notification:** 1630 hours, Verbal

**Name of Caltrans Engineer notified:** Ching Chao and Bill Howe

**Time and method of notification:** 1730 hours, Verbal

**QC Inspector's Name:** Zhong Wei

**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.

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**Inspected By:** Carreon,Albert

Lead Reviewer/Task Leader

**Reviewed By:** Wahbeh,Mazen

SMR

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# REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-17839R1

DATE日期 2010.02.07

PAGE OF页码 1/1

Revision No: 0

PROJECT NO.

ZP06-787

CONTRACTOR:

CALTRANS

工程编号:

DRAWING NO.

DP084/DP111/DP165/DP273/DP246

CALTRANS CONTRACT NO.:

04-0120F4

图号:

6AW PLATE PANEL SPLICE

加州工程编号

REFERENCING CODE

ACCEPTANCE STANDARD

PROCEDURE NO.

CALIBRATION DUE DATE

参考规范编码

接受标准

程序编号

仪器校正有效期

AWS D1.5-2002

AWS D1.5-2002

ZPQC-MT-01

Dec. 28<sup>ST</sup>, 2010

EQUIPMENT 设备

MANUFACTURER 制造商

MODEL NO. 样式编号

SERIAL NO. 连续编号

MT YOKE

PARKER

B310S

5395 5617 5620

MAGNETIZING METHOD

Continuous magnetic yoke

CURRENT

磁化方法

磁轭式连续法

电流

AC

PARTICLE TYPE

Dry magnet powder

YOKE SPACING

磁粉类型

干磁粉

磁轭间距

70~150mm

MATERIAL TO BE

WELDING 焊接件

Material & thickness

EXAMINED

CASTING 铸件

母材, 厚度

A709M-345T2-X

检测材料

FORGING 锻造

12/14mm

WELDING PROCESS

SMAW

TYPE OF JOINT

T-JOINT

焊接方法

焊缝类型

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			
DP084-001-059	1R1			ACC.		100%MT
DP111-001-059	1R1			ACC.		100%MT
DP111-001-062	1R1			ACC.		100%MT
DP111-001-067	1R1			ACC.		100%MT
DP111-001-092	1R1			ACC.		100%MT
DP165-001-086	1R1			ACC.		100%MT
DP273-001-038	1R1			ACC.		100%MT
DP273-001-048	1R1			ACC.		100%MT
DP273-001-051	1R1			ACC.		100%MT
DP273-001-056	1R1			ACC.		100%MT
DP273-001-084	1R1			ACC.		100%MT
DP246-001-060	1R1			ACC.		100%MT
DP246-001-065	1R1			ACC.		100%MT
DP246-001-081	1R1			ACC.		100%MT
DP246-001-094	1R1			ACC.		100%MT

AFTER B-CWR1067-1071

EXAMINED BY 主探

Sun Gongchang *gan gong chang*

REVIEWED BY 审核

*zhao chang jun*

LEVEL - II SIGN 签名 / DATE日期 2010.2.7

LEVEL-II SIGN / DATE日期 2010.2.7

质量经理 / QCM

用户 CUSTOMER

签字 SIGN / 日期 DATE

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 #: 04-0120F4Cty: 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-000524**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0469**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:** 28-Oct-2009**Description of Non-Conformance:**

During a random Magnetic Particle (MT) verification of OBG Segment 6AW, the Caltrans Quality Assurance (QA) Inspectors observed fifteen (15) Crater Indications on the Deck Panel U rib to Diaphragm welds at panel point 38 and 39. The Crater Indications ranged from 10mm to 30mm in length and these welds were tested and accepted by ZPMC QC MT.

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The non-complying weld designations are as follows:

Open Rib Stiffener to corner assembly web plate weld- CSD2-PP38.5-010 (1) 5mm Transverse Indication.

Longitudinal Girder to panel point 38 Weld -SEG027M-018 (1) 20mm Transverse Indication.

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

Repair said indications and perform NDT required to verify weld quality

**Corrective action taken:**

Contractor has submitted NDT records verifying the welds are now in conformance with Contract specifications. Additional training was also provided to NDT Technicians in regards to this issue.

**Did corrective action require Engineer's approval?** Yes No

**If so, name of Engineer providing approval:**

**Date:**

**Is Engineer's approval attached?**

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**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.

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<b>Inspected By:</b>	Simonis,Jim	Quality Assurance Inspector
<b>Reviewed By:</b>	Wahbeh,Mazen	QA Reviewer

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