

**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-000542

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

**Date:** 18-Dec-2009

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

**NCR #:** ZPMC-0515

### Type of problem:

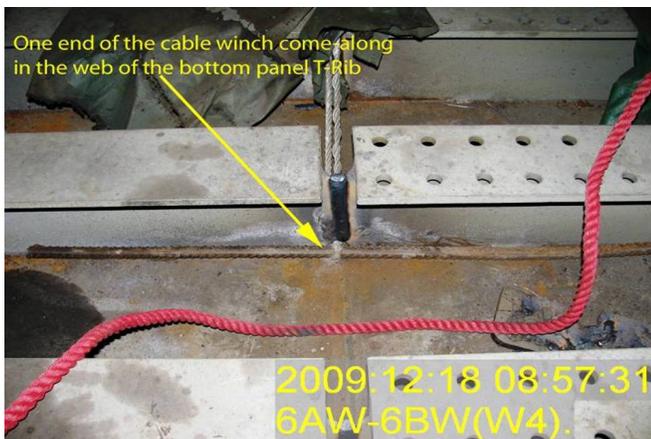
<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> OBG Lift 6 West
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Deviating from Approved HSR during Heat Straightening, L6W

### Description of Non-Conformance:

The Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel aligning the Longitudinal Diaphragms (LD) 6AW (LD16E) to 6BW (LD10A) by utilizing an approved Heat Straightening Report (HSR). ZPMC personnel rigged a hand operated cable/chain winch (come-along mechanical device) at the flange of LD10A and anchored it behind the web of the T-Rib at the Bottom Panel (BP) of 6AW to 6BW. This equipment and methods were not described in ZPMC's internal HSR procedure. Additional information identifying this non-conformance issue is listed below.

- The LD's were located at 6AW to 6BW splice weld at W4.
- The 6AW LD is identified as: LD16E
- The 6BW LD is identified as: LD10A
- The HSR was identified as HSR1 (B)-7992 Rev. 0, dated 11th Dec. 2009.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

The image shows a ZPMC Heat Straightening Record (HSR) form. The form includes fields for Record #, Revision #, Date, and various technical details. It features technical drawings of a heat straightening process. A prominent yellow timestamp '2009:12:18 09:07:27' is overlaid on the form, along with the text 'ZPMC HSR'.



## Applicable reference:

ZPMC Heat Straightening Report; "HSR1 (B)-7992 Rev. 0 dated 11th Dec. 2009."

Standard Specifications (99) section 55-3.02 Straightening of Material; "If straightening is necessary, it shall be done by methods acceptable to the Engineer. Details for the methods proposed for straightening shall be submitted in writing to the Engineer prior to their use."

**Who discovered the problem:** M. Manikandan

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

**Time and method of notification:** 1600 hours, 12-18-09, Verbal

**Name of Caltrans Engineer notified:** Bill Howe

**Time and method of notification:** 0900 hours, 12-21-09, 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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Guest,Skylar

SMR

**Reviewed By:** Wahbeh,Mazen

SMR

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## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000503

**Subject:** NCR No. ZPMC-0515

**Dated:** 11-Jan-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000454 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 UT training. See attached UT 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 UT training. See attached UT training agenda and attendance roster. The ABF QCM has been discussing missed UT indications with the ZPMC QCM and related NDT supervisory personnel. The ZPMC level III is in the process of assessing personnel, techniques and equipment. ABF has purchased GE Technology transducers to distribute to both ZPMC and ABF UT personnel in a cooperative effort to match the equipment of CT. These transducers will arrive to the job site approximately the end of January 10 at which time they will be put into immediate use. 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-000454R00;

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### Caltrans' comments:

**Status:** AAP

**Date:** 24-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

**Attachment(s):**

**Date:** 24-Jan-2010

# UT Refresher Training Agenda

**Subject:** UT Techniques

**Reason for Training:** Several CT NCR's for missed UT indications

**1. Safety**

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

**2. Tools**

- a. Calibrated UT Machine      condition of machine
- b. Coaxial cable                      condition of cable
- c. Transducer                      condition of transducer
- d. IIW Block
- e. Scraper
- f. UT couplant

**3. Inspection Techniques**

- a. Surface preparation
- b. Location of weld                      UT from beveled plate
- c. Scanning patterns
- d. Correct choice of Angles
- e. Calibration                      per ZPMC procedure at regular intervals
- f. Scanning speed
- g. Know where your sound is at.... First leg, second leg etc...

**4. Inspection Criteria**

- a. Table 6.3 or Table 6.4
- b. Are surface inspections complete    VT and or MT should always occur before UT
- c. Scanning Levels
- d. Criteria dictated by the thinner of the two members
- e. Planar flaws



教育培训纪录

培训编号:

培训内容:	UT复习培训教程 UT Techniques
培训对象:	ZPMC UT GUYS
授课人员:	STEVE LAWTON
培训类型:	UT Refresher Training Agenda
培训时间:	2009. 12. 24. 16:30
计划培训地点:	ZPMC NDT OFFICE

人员签到:

姓名	部门	姓名	部门
戴建 dai jian	江江 Jiang Jiang		
薛宇 xue yu	黄廷 Huang Ting		
马志长 ma zhi chang	黄廷 Huang Ting		
谭善 tan shan	李黎明 Li Liming		
马健 ma jian	李黎明 Li Liming		
王福 wang fu	徐军 Xu Jun		
沈健 shen jian	李黎明 Li Liming		
黄江 Huang Jiang			
金峰 jin feng			
吴文 wu wen			
解建 jie jian			
周海周 zhou hai zhou			
徐峰 xu feng			

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000503

**Subject:** NCR No. ZPMC-0515

**Dated:** 24-Feb-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000454 Rev: 01

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### Contractor's Proposed Resolution:

**Reference Resolution:** Since the HSR depicted a mechanical force being used ZPMC and ABFJV agrees that this is acceptable. ZPMC requests that this NCR be closed.

In lieu of the jack, ZPMC used other mechanical means in this case chains during heat straightening. Since the HSR depicted a mechanical force being used ZPMC and ABFJV agrees that this is acceptable. ZPMC requests that this NCR be closed.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000454R01

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### Caltrans' comments:

**Status:** REJ

**Date:** 24-Feb-2010

Provide NDT indicating weld soundness.

**Submitted by:** Howe, Bill

**Date:** 24-Feb-2010

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000503

**Subject:** NCR No. ZPMC-0515

**Dated:** 24-Mar-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000454 **Rev:** 02

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### Contractor's Proposed Resolution:

**Reference Resolution:** Per the Department's response to ZBF-NPR-00454R01, ZPMC is providing the NDT documents of the areas in question to show that they are acceptable. Based on this ZPMC requests closure of this NCR.

REVISED ATTACHMENT, 03/24/10

Per the Department's response to ZBF-NPR-00454R01, ZPMC is providing the NDT documents of the areas in question to show that they are acceptable. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000454R02;

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### Caltrans' comments:

**Status:** CLO

**Date:** 05-Apr-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0515 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 05-Apr-2010



No. B-665

## LETTER OF RESPONSE

**TO:** American Bridge/Flour

**DATE:** 2010-3-15

**REGARDING:** NCR-000542(ZPMC-0515)

According to ABF-NPR-000454, as requested by CT, ZPMC is providing NDT reports indicating the welds' soundness and requesting closure of CT NCR-000542(ZPMC-0515).

**ATTACHMENT:**

NCR-000542(ZPMC-0515)

ABF-NPR-000454

B787-MT-19791

B787-UT-11507

A handwritten signature in black ink, appearing to be "L. Wang" or similar, is written in a cursive style.

3/15/10



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:** 24-Dec-2009

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

**Dear:** Mr. Charles Kanapicki  
**Attention:** Mr. Thomas Nilsson Project/Fabrication Manager  
**Subject:** NCR No. ZPMC-0515

**Job Name:** SAS Superstructure  
**Document No:** 05.03.06-000503

**Reference Description:** Deviating from Approved HSR during Heat Straightening, L6W

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:**

The Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel aligning the Longitudinal Diaphragms (LD) 6AW (LD16E) to 6BW (LD10A) by utilizing an approved Heat Straightening Report (HSR). ZPMC personnel rigged a hand operated cable/chain winch (come-along mechanical device) at the flange of LD10A and anchored it behind the web of the T-Rib at the Bottom Panel (BP) of 6AW to 6BW. This equipment and methods were not described in ZPMC's internal HSR procedure. Additional information identifying this non-conformance issue is listed below.

- The LD's were located at 6AW to 6BW splice weld at W4.
- The 6AW LD is identified as: LD16E
- The 6BW LD is identified as: LD10A
- The HSR was identified as HSR 1 (B)-7992 Rev. 0, dated 11th Dec. 2009.

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

submit the details of the deviation from the approved HSR for approval by the engineer. A response for the resolution of this issue is expected within 7 days.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0515

**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**  
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 (707) 649-5453  
 (707) 649-5493

Contract #: 04-0120F4City: 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-000542

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 18-Dec-2009

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

NCR #: ZPMC-0515

### Type of problem:

Welding  Concrete  Other Welding  Curing  Procedural Joint fit-up  Coating  Other Procedural  Procedural  Description: 

Bridge No: 34-0006

Component: OBG Lift 6 West

Reference Description: Deviating from Approved HSR during Heat Straightening, L6W

### Description of Non-Conformance:

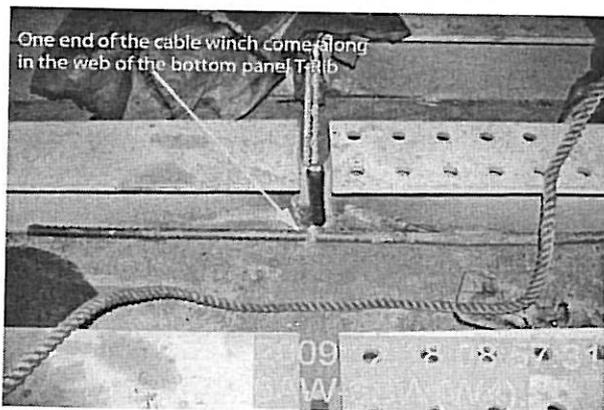
The Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel aligning the Longitudinal Diaphragms (LD) 6AW (LD16E) to 6BW (LD10A) by utilizing an approved Heat Straightening Report (HSR). ZPMC personnel rigged a hand operated cable/chain winch (come-along mechanical device) at the flange of LD10A and anchored it behind the web of the T-Rib at the Bottom Panel (BP) of 6AW to 6BW. This equipment and methods were not described in ZPMC's internal HSR procedure. Additional information identifying this non-conformance issue is listed below.

-The LD's were located at 6AW to 6BW splice weld at W4.

-The 6AW LD is identified as: LD16E

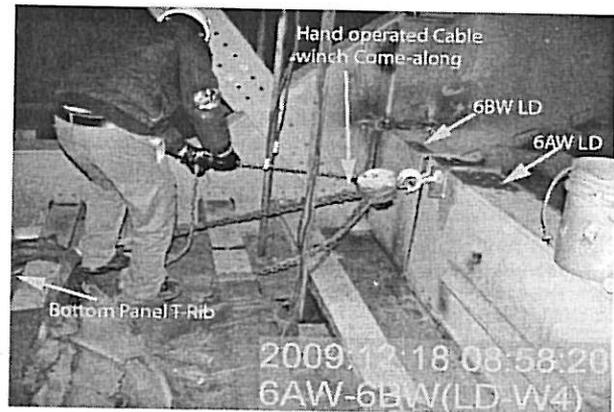
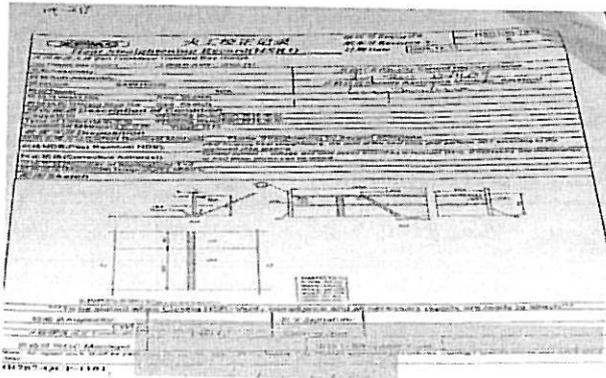
-The 6BW LD is identified as: LD10A

-The HSR was identified as HSR1 (B)-7992 Rev. 0, dated 11th Dec. 2009.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



### Applicable reference:

ZPMC Heat Straightening Report; "HSR1 (B)-7992 Rev. 0 dated 11th Dec. 2009."

Standard Specifications (99) section 55-3.02 Straightening of Material; "If straightening is necessary, it shall be done by methods acceptable to the Engineer. Details for the methods proposed for straightening shall be submitted in writing to the Engineer prior to their use."

Who discovered the problem: M. Manikandan  
Name of individual from Contractor notified: Kevin Chen  
Time and method of notification: 1600 hours, 12-18-09, Verbal  
Name of Caltrans Engineer notified: Bill Howe  
Time and method of notification: 0900 hours, 12-21-09, 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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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

---

## NCR PROPOSED RESOLUTION

To: California Department of Transportation  
333 Burma Road  
Oakland, CA 94607  
Attention: Pursell, Gary  
Resident Engineer  
Ref: 05.03.06-000503  
Subject: NCR No. ZPMC-0515

Dated: 24-Feb-2010  
Contract No.: 04-0120F4  
04-SF-80-13.2/13.9  
Job Name: Self-Anchored Suspension Bridge  
Document No: ABF-NPR-000454 Rev: 1

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### Contractor's Proposed Resolution:

Reference Resolution: Since the HSR depicted a mechanical force being used ZPMC and ABFJV agrees that this is acceptable. In lieu of the jack, ZPMC used other mechanical means in this case chains during heat straightening. Since the HSR depicted a mechanical force being used ZPMC and ABFJV agrees that this is acceptable. ZPMC requests that this NCR be closed.

Submitted By: Ishibashi, Joshua  
Attachment(s): ABF-NPR-000454R01

---

### Caltrans' comments:

Provide NDT indicating weld soundness.

Status: REJ  
Date: 24-Feb-2010

Submitted By: Howe, Bill  
Attachment(s): ABF-NPR-000454

Date: 24-Feb-2010



# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-19791

DATE日期 2010.03.04

PAGE OF页码 1/1

Revision No: 0

PROJECT NO.

ZP06-787

CONTRACTOR:

CALTRANS

工程编号:

用户:

DRAWING NO.

6BW+6AW LONGITUDINAL DIAPHRAGM

CALTRANS CONTRACT NO.:

04-0120F4

图号:

OBW6

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

AC

磁化方法

磁轭式连续法

电流

PARTICLE TYPE

Dry magnet powder

YOKE SPACING

70~150mm

磁粉类型

干磁粉

磁轭间距

MATERIAL TO BE

WELDING 焊接件

Material & thickness

A709M-345

EXAMINED

CASTING 铸件

母材, 厚度

检测材料

FORGING 锻造

20/14/25/30mm

WELDING PROCESS

FCAW

TYPE OF JOINT

CORNER -JOINT

焊接方法

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			
SEG029C-006						
SEG029C-032				ACC.		100%MT
SEG029C-030				ACC.		100%MT
SEG029C-057				ACC.		100%MT
SEG029C-050				ACC.		100%MT
SEG029C-051				ACC.		100%MT
SEG029C-038				ACC.		100%MT
SEG029C-039				ACC.		100%MT
SEF027F-301				ACC.		100%MT
SEF027F-302				ACC.		100%MT
SEF027F-303				ACC.		100%MT
BLANK						

EXAMINED BY主探  
*Li Shen Hua* 1003.04

LEVEL - II SIGN 签名 / DATE日期  
质量经理 / QCM

签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

REVIEWED BY 审核  
*Gmci* 1003.04

LEVEL-II SIGN / DATE日期

用户CUSTOMER

签字 SIGN / 日期 DATE

NCR-358



# REPORT OF ULTRASONIC EXAMINATION

## UT探伤报告

REPORT NO. 报告编号 B787-UT-11507      DATE 2010.03.07      PAGE 1 OF 1      Revision No: 0

PROJECT NO.: 工程编号 ZP06-787      CONTRACTOR: CALTRANS

ITEMS NAME: 6BW+6AW LONGITUDINAL DIAPHRAGM      DRAWING NO.: OBW6      CALTRANS CONTRACT NO.: 04-0120F4  
 部件名称      图号      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  
 FCAW      CORNER -JOINT      Dec. 28<sup>ST</sup>, 2010

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 IIV BLOCK TYPE II      C.M.C      A709M-345      25/30/14/20mm

**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		
SEG029C-006		70				32								ACC.	100%
SEG029C-032		70				32								ACC.	100%
SEG029C-030		70				32								ACC.	100%
SEG027F-303		70				32								ACC.	100%

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EXAMINED BY 主探 Tony King Shan 2010.03.07      REVIEWED BY 审核 XU Rong gang 2010.03.07  
 LEVEL - II SIGN / DATE      LEVEL - II SIGN / DATE

质量经理 / QCM      用户 CUSTOMER  
 签字 SIGN / 日期 DATE      签字 SIGN / 日期 DATE



**DEPARTMENT OF TRANSPORTATION**

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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-000612**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0515**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:** 18-Dec-2009**Description of Non-Conformance:**

The Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel aligning the Longitudinal Diaphragms (LD) 6AW (LD16E) to 6BW (LD10A) by utilizing an approved Heat Straightening Report (HSR). ZPMC personnel rigged a hand operated cable/chain winch (come-along mechanical device) at the flange of LD10A and anchored it behind the web of the T-Rib at the Bottom Panel (BP) of 6AW to 6BW. This equipment and methods were not described in ZPMC's internal HSR procedure. Additional information identifying this non-conformance issue is listed below.

- The LD's were located at 6AW to 6BW splice weld at W4.
- The 6AW LD is identified as: LD16E
- The 6BW LD is identified as: LD10A
- The HSR was identified as HSR1 (B)-7992 Rev. 0, dated 11th Dec. 2009.

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

Perform NDT required to verify weld quality.

**Corrective action taken:**

Contractor submitted NDT reports verifying welds affected by heat straightening procedures are 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.

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# QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**Inspected By:** Simonis,Jim

Quality Assurance Inspector

**Reviewed By:** Wahbeh,Mazen

QA Reviewer