

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-000641**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0613**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 5CE T-Stiffener to Bottom Panel Weld
Procedural	Procedural	Description: Missed MT indication by QC	

Reference Description: 1 Missed MT Transverse Indication by QC on T-Stiffener to Bottom Panel Weld in Segment 5CE

Description of Non-Conformance:

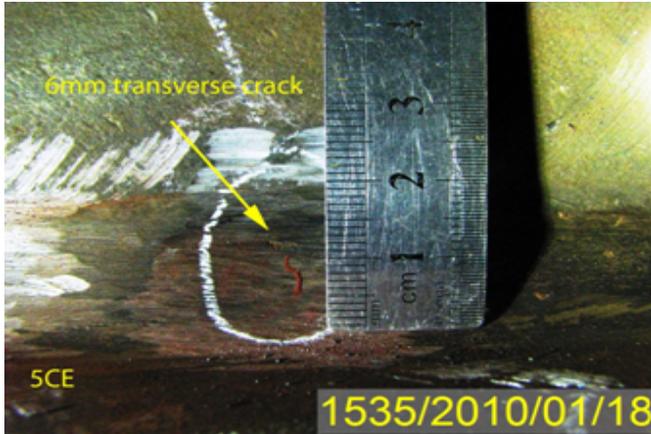
During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5BE+5CE hold back welds, this Quality Assurance Inspector (QA) discovered the following issues:

- 1 transverse crack indication measuring approximately 6mm in length.
- The weld is identified as BP112-001-001.
- The weld is a fillet weld.
- The weld is joining a T-Stiffener to bottom panel identified as BP115A.
- 6th T-stiffener off the bike path side of segment (@ E3 line).
- Y location of the transverse crack is noted to be 140mm off 5BE+5CE weld splice OBE5A-008.
- Lift 5 East is located in the OGB Trial Assembly Area.

The Notice of Witness Inspection Number (NWIT) is 005076. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform one hundred (100%) percent MT inspection of this weld.

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 6.26.2; "Welds that are subject to RT or MT in addition to visual inspection shall have no cracks and shall be unacceptable if the RT or MT shows any of the types of discontinuities described in 6.26.2.1, 6.26.2.2, 6.26.2.3, or 6.26.2.4".

AWS D1.5-2002 Section 6.26.1; "The weld shall have no cracks."

Who discovered the problem: Joe Alaniz

Name of individual from Contractor notified: CK Chan

Time and method of notification: 1630 hours, 01/18/10, Verbal

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 0830 hours, 01/19/10, Verbal

QC Inspector's Name: Wang Li Yang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
Reviewed By:	Wahbeh, Mazen	SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 666 Feng Bin Road Room 708, Changxing Island
 Shanghai 201913 PR China
 Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
 375 BURMA ROAD
 OAKLAND CA 95607

Date: 24-Jan-2010

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: 05.03.06-000605

Subject: NCR No. ZPMC-0613

Reference Description: 1 Missed MT Transverse Indication by QC on T-Stiffener to Bottom Panel Weld in Segment 5CE

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:** 05

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5BE+5CE hold back welds, this Quality Assurance Inspector (QA) discovered the following issues:

- 1 transverse crack indication measuring approximately 6mm in length.
- The weld is identified as BP112-001-001.
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- The weld is joining a T-Stiffener to bottom panel identified as BP115A.
- 6th T-stiffener off the bike path side of segment (@ E3 line).
- Y location of the transverse crack is noted to be 140mm off 5BE+5CE weld splice OBE5A-008.
- Lift 5 East is located in the OGB Trial Assembly Area.

The Notice of Witness Inspection Number (NWIT) is 005076. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform one hundred (100%) percent MT inspection of this weld.

Please see attached NCR ZPMC-613 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0613

NCT

(Continued Page 2 of 2)

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000605

Subject: NCR No. ZPMC-0613

Dated: 08-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000558 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The ABFJV QCM has instituted training sessions for ZPMC inspectors. In addition to training, ABF has purchased new equipment to standardize both ABF and ZPMC with the equipment used by Caltrans.

ZPMC and ABFJV have taken steps to reduce the number of both MT and UT missed indications. The ABFJV QCM has instituted training sessions for ZPMC inspectors to reinforce key points of performing UT and MT, the most recent was held in December 2009. The ZPMC Level III has conducted training with the inspectors as well. In addition to training, ABF has purchased new equipment to standardize both ABF and ZPMC with the equipment used by Caltrans. Examples of this are the powder bulbs with magnetic caps, and the same transducers used by Caltrans. Documents of the acceptable NDT will be provided when they are available at a later date. Based on this ZPMC requests that this NCR be approved with actions pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000558R00;

Caltrans' comments:

Status: AAP

Date: 08-Feb-2010

AAP approved.

Submitted by: Howe, Bill

Date: 08-Feb-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 Zhongqiang	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 Cheng Gong	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	



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		
马建 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			
解文 jie wen			
周海周 zhou hai zhou			
徐峰 xu feng			

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000605

Subject: NCR No. ZPMC-0613

Dated: 03-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000558 Rev: 01

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-000558R01;

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-635

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-3

REGARDING: NCR-000641(ZPMC-0613)

With this letter of response, ZPMC requests closure of CT NCR-000641(ZPMC-0613) what mentioned that CT inspector observed missed MT indication by ZPMC QC.

- CWR was issued reflecting to this indication. Please refer to B-CWR1157.
- Attached NDT documentation shows this indication was accepted after repair..
- Punch List Item 397 what mentioning this NCR has been confirmed and closed by CT.

Base on the taken actions and responses above, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-000641(ZPMC-0613)

B787-MT-18203R1

A handwritten signature in black ink, appearing to be 'L. J. ...' followed by a flourish.

3/3/10

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-000641**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0613**Type of problem:**Welding Concrete Other Welding Curing Procedural **Bridge No:** 34-0006Joint fit-up Coating Other **Component:** Segment 5CE T-Stiffener to Bottom Panel WeldProcedural Procedural **Description:** Missed MT indication by QC

Reference Description: 1 Missed MT Transverse Indication by QC on T-Stiffener to Bottom Panel Weld in
Segment 5CE

Description of Non-Conformance:

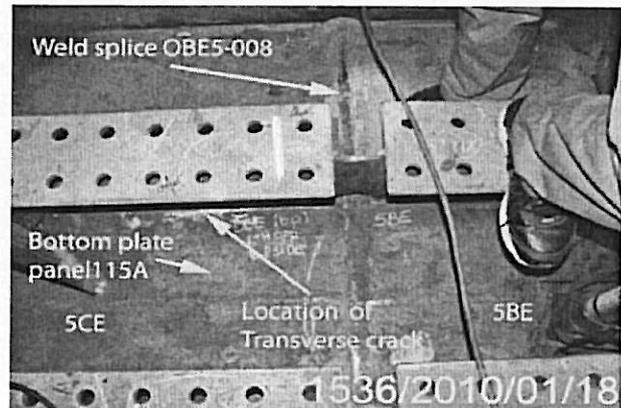
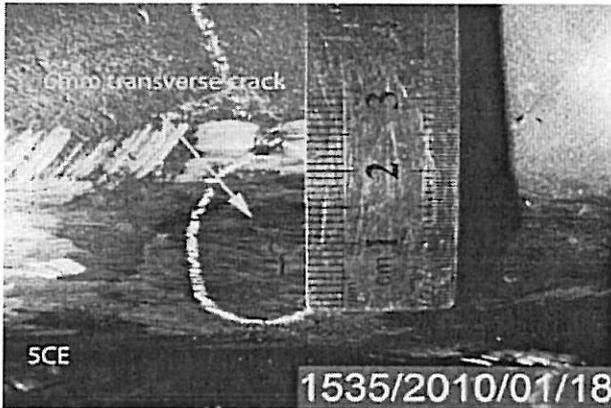
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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AWS D1.5-2002 Section 6.26.2; "Welds that are subject to RT or MT in addition to visual inspection shall have no cracks and shall be unacceptable if the RT or MT shows any of the types of discontinuities described in 6.26.2.1, 6.26.2.2, 6.26.2.3, or 6.26.2.4".

AWS D1.5-2002 Section 6.26.1; "The weld shall have no cracks."

Who discovered the problem: Joe Alaniz

Name of individual from Contractor notified: CK Chan

Time and method of notification: 1630 hours, 01/18/10, Verbal

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 0830 hours, 01/19/10, Verbal

QC Inspector's Name: Wang Li Yang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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Inspected By:	Tsang, Eric	SMR
Reviewed By:	Wahbeh, Mazen	SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 24-Jan-2010

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: 05.03.06-000605

Subject: NCR No. ZPMC-0613

Reference Description: 1 Missed MT Transverse Indication by QC on T-Stiffener to Bottom Panel Weld in Segment 5CE

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: 05

Remarks:

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Please see attached NCR ZPMC-613 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0613

NCT

(Continued Page 2 of 2)

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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-18203R1 DATE日期 2010.03.02 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. 图号: BP112A CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4
5CE BOTTOM PLATE

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, 2010

EQUIPMENT 设备: MT YOKE MANUFACTURER 制造商: PARKER MODEL NO. 样式编号: B310S SERIAL NO. 连续编号: 5395 5617 5620

MAGNETIZING METHOD 磁化方法: Continuous magnetic yoke 磁轭式连续法 CURRENT 电流: AC

PARTICLE TYPE 磁粉类型: Dry magnet powder 干磁粉 YOKE SPACING 磁轭间距: 70~150mm

MATERIAL TO BE EXAMINED 检测材料: WELDING 焊接件 Material & thickness 母材,厚度: A709M-345T2-X
 CASTING 铸件 10/20mm
 FORGING 锻造

WELDING PROCESS 焊接方法: SMAW TYPE OF JOINT 焊缝类型: T-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			
BP112A-001-001	1R1			ACC.		100%MT

AFTER B-CWR1157

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EXAMINED BY 主探 Ding Acheng <i>Ding A Cheng</i> 2010.03.02 LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>S.W. Wei</i> 2010.03.02 LEVEL-II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

DEPARTMENT OF TRANSPORTATION

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(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-000600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0613**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 18-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 5BE+5CE hold back welds, this Quality Assurance Inspector (QA) discovered the following issues:

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Contractor's proposal to correct the problem:

Repair said indication and perform NDT required to verify weld quality.

Corrective action taken:

Contractor submitted post repair NDT report verifying the weld is 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?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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
