

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-000652

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 25-Jan-2010

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

NCR #: ZPMC-0623

Type of problem:

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

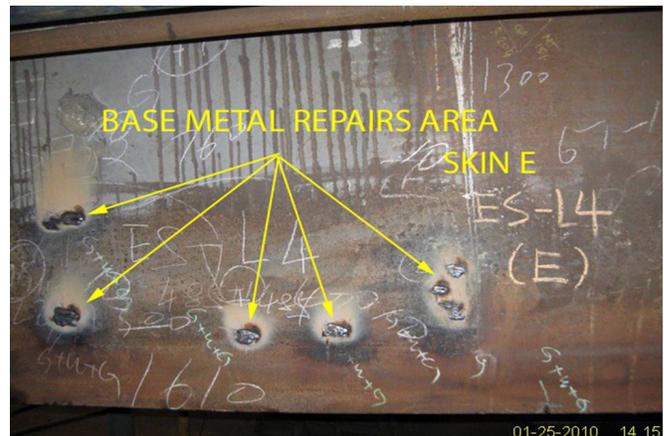
Bridge No: 34-0006

Component: East Tower, Lift 4, Skin E

Reference Description: Base Metal Repair without Engineer's Approval, East Tower, Lift 4, Skin E

Description of Non-Conformance:

Caltrans Quality Assurance (QA) observed base metal repairs were performed without prior approval from the Engineer. These repairs were performed using the Shielded Metal Arc Welding (SMAW) process at East Tower, Lift 4, Skin E, on Seismic Performance Critical Member (SPCM) 485 grade material.



Applicable reference:

AWS D1.5-2002 Section 3.7.4; "Prior approval of the Engineer shall be obtained for repairs to base metal."

ZPMC Welding Quality Control Plan (WQCP), Weld Repair Procedures, Section 9.2.1.2; "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Shailesh Gaikwad

Name of individual from Contractor notified: Man Kam Hen

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 14:15 hours, 01-25-2010, verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 8:20 hours, 01-26-2010, verbal

QC Inspector's Name: An Qing Xiang

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 Skyler Guest, 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Guest, Skyler	SMR
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Reviewed By:	Wahbeh, Mazen	SMR
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DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 26-Jan-2010

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-0623

Job Name: SAS Superstructure
Document No: 05.03.06-000611

Reference Description: Base Metal Repair without Engineer's Approval/ East Shaft Lift 4,/ Skin E

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: Tower **Lift:** 04

Remarks:

The Caltrans Quality Assurance (QA) inspector observed base metal repairs being performed without prior approval from the Engineer. These repairs were performed using the Shielded Metal Arc Welding (SMAW) process at East Shaft, Lift 4, Skin E, on Seismic Performance Critical Member (SPCM) 485 grade material.

AWS D1.5-2002 Section 3.7.4; "Prior approval of the Engineer shall be obtained for repairs to base metal."

ZPMC Welding Quality Control Plan (WQCP), Weld Repair Procedures, Section 9.2.1.2; "Prior approval of the Engineer shall be obtained for repairs to base metal."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance, documenting that the repaired base metal / welding repair is in compliance with the contract requirements. Documentation provided for the Engineer's review of the acceptability of the weld repair shall at a minimum include the procedure utilized/CWR and the NDT results.

In addition to the material/workmanship non-conformance, address the failure by both Production and Quality Control in proceeding with base metal repair without prior approval from the Engineer. Provide documentation of the steps/actions taken by Production and Quality Control to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

Transmitted by: Ken Lee Transportation Engineer
Attachments: ZPMC-0623

NCT

(*Continued Page 2 of 2*)

cc: Rick Morrow, Gary Pursell, Mark Woods, Scott Kennedy

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000611

Subject: NCR No. ZPMC-0623

Dated: 11-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000594 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: Since this NCR was written the process for requesting base metal repair approval has been clarified and this issue has decreased in frequency. ZPMC requests closure of this NCR.

ZPMC has written an internal NCR regarding the unapproved base metal repair or temporary attachment areas to inform the production department of this issue. Since this NCR was written the process for requesting base metal repair approval has been clarified and this issue has decreased in frequency. ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000594R00

Caltrans' comments:

Status: REJ

Date: 11-Feb-2010

The Department will not consider closure of this NCR until all items listed on NCT are addressed.

Submitted by: Lee, Ken

Attachment(s):

Date: 11-Feb-2010

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000611

Subject: NCR No. ZPMC-0623

Dated: 13-Jul-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000594 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the requested CWR and NDT results to show that observed base metal repairs to temporary attachment areas are acceptable.

ZPMC is providing the requested CWR and NDT results to show that observed base metal repairs to temporary attachment areas are acceptable. To clarify, per the attached letter ZPMC is not required to provide a CWR when performing base metal repairs to temporary attachments of non SPCM material. This sub assembly that is referenced in the NCR is not SPCM material, as long as there is a WRR present and the on site inspector is notified the repair does not require Engineer approval. ZPMC QA has reiterated the requirement that the on site inspector be notified prior to repairs beginning to prevent this issue from occurring again. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000594R01;

Caltrans' comments:

Status: CLO

Date: 14-Jul-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0623 is closed.

Submitted by: Rizzardo, Gina

Attachment(s):

Date: 14-Jul-2010



No. T-153

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-07-12

REGARDING: NCR-000652(ZPMC-0623)

ZPMC received NCR-000652(ZPMC-0623), it mentioned that CT inspector observed ZPMC performed base metal repairs without prior approval from engineer.

Here ZPMC need to clarify, first, as we all know SPCM and 485 grade are different, but in this NCR it mentioned Lift 1 Skin E is SPCM, obviously it was an incorrect concept. Second, you can find in the NCR, visibly, the repair points were after temporary attachment removal and according to the letter attached below, CWR is required for SPCM temporary attachment removal area but no need for Non SPCM.

As a responsibly attitude ZPMC still issued CWR and conducted NDT, finally the component involved in this NCR was accepted by CT.

Basing on above information, ZPMC hope CT could take a review and close these NCR.

ATTACHMENT:

NCR-000652(ZPMC-0623)

T-CWR564

T787-UT-2617

T787-MT-7957

AFC-ZPM-LTR-000621

A handwritten signature in blue ink, appearing to read "Zhang [unclear]", is located below the list of attachments.

2010.7.12



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 26-Jan-2010

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

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0623

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In addition to the material/workmanship non-conformance, address the failure by both Production and Quality Control in proceeding with base metal repair without prior approval from the Engineer. Provide documentation of the steps/actions taken by Production and Quality Control to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

Transmitted by: Ken Lee Transportation Engineer
Attachments: ZPMC-0623

02.02.15.04 06-000611.NCT

Received Page 1 of 2
 NCT-000611 26 Jan 10

NCT

(Continued Page 2 of 2)

cc: Rick Morrow, Gary Pursell, Mark Woods, Scott Kennedy

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
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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-000652

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 25-Jan-2010

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

NCR #: ZPMC-0623

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

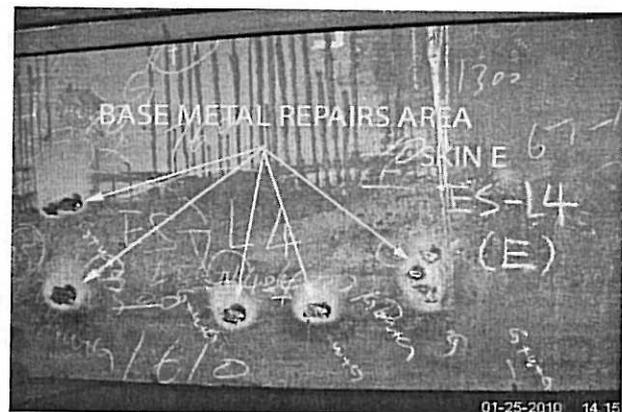
Bridge No: 34-0006

Component: East Tower, Lift 4, Skin E

Reference Description: Base Metal Repair without Engineer's Approval, East Tower, Lift 4, Skin E

Description of Non-Conformance:

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Who discovered the problem: Shailesh Gaikwad

Name of individual from Contractor notified: Man Kam Hen

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 14:15 hours, 01-25-2010, verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 8:20 hours, 01-26-2010, verbal

QC Inspector's Name: An Qing Xiang

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 Skyler Guest, 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Guest, Skyler	SMR
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Reviewed By:	Wahbeh, Mazen	SMR
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关键焊缝返修报告

版本 Rev. No.

Critical Welding Repair Report

1

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	FE4-13	报告编号 Report No.	T-CWR564
合同号 Contract No.:	04-0120F4	部件名称 Items Name	东塔第四吊装段E面板 Tower(E) fourth lifting Skin E	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:**Description of welding discontinuity:**

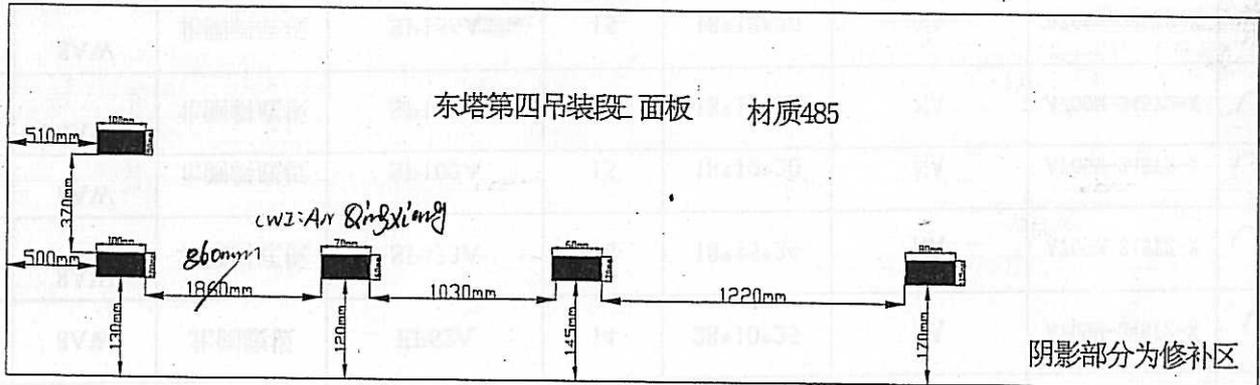
东塔第四吊装段E面板吊耳马脚割除后, 打磨后损伤母材, 深度3MM~8MM, 局部区需修补, 具体位置

Fourth lifting east tower Skin E, the base metal was found damaged after grinding, 3-8mm in depth and needed to repair, the detail see the draft.

检验员 (Inspector) *Zhaomaomao* (Date): 2010.01.25

焊缝返修位置示意图:**Draft of welding discontinuity:**

East tower fourth lifting Skin E metal degree 485



Repair area in shadow.

- APPROVED
- APPROVED AS NOTED
- RETURNED FOR CORRECTION

Permitted in Section 6-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION
Division of Engineering Services
Office of Structure Construction

SFR ER Am *elzslid*
Structure Representative Date

↑ SEE NOTES ON SHEET 2 OF CRITICAL WELDING REPAIR REPORT



关键焊缝返修报告

Critical Welding Repair Report

版本 Rev. N

0.

1

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	FE4-13	报告编号 Report No.	T-CWR564
合同号 Contract No.:	04-0120F4	部件名称 Items Name	东塔第四吊装段E面板 Tower(E) fourth lifting Skin E	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

培训和教育操作工, 提高操作水平。

Train and educate operator to improve operation skill.

车间负责人(Foreman): *Luyefei* 日期(Date): *2010.01.25*

参照的WPS编号 Repair WPS No.	WPS-485-SMAW-1 G(1F)- Repair-1 WPS-485-SMAW-2 G(2F)- Repair-1 WPS-485-SMAW-3 G(3F)- Repair-1 WPS-485-SMAW-4 G(4F)- Repair-1	工艺员 technologist	<i>Lichanping</i> <i>2010.01.25</i>
返修(碳刨)前预热温度 Preheat temperature before gouging	<i>NA</i>	返修的缺陷 Description of discontinuity	<i>修补</i>
焊前处理检查 Inspection before welding	<i>Am</i>	焊前预热温度 Preheat temperature before welding	<i>200°C</i>
最大碳刨深度 Max. depth of gouging	<i>NA</i>	碳刨总长 Total length of gouging	<i>NA</i>
焊工 welder <i>202323</i>	焊接类型 welding type <i>SMW φ9.0</i>	焊接位置 position <i>3G/3F</i>	
焊接电流 Current <i>170</i>	焊接电压 Voltage <i>23.5</i>	焊接速度 Speed <i>100</i>	

返修后检查

Inspection After repairing:

外观检查 VT result <i>Am</i>	检验员 Inspector <i>Am</i>	日期 Date <i>10.05.10</i>
NDT复检 NDT result <i>Am</i>	探伤员 NDT person <i>Daz Gous Sheng</i>	日期 Date <i>10.05.10</i>

见证:

Witness/Review:

备注:

Remark:

#R787-QCP-701



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 T787-UT-2617 DATE 2010.05.12 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: SKIN E DRAWING NO.: FE4-13 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
 NA NA Dec. 28ST, 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 IIW BLOCK TYPE II C.M.C A709M-HPS-485WT2-Z 90mm

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	45°	2.5MHz	18×18mm
Changchao	0°	2.5MHz	20mm				

Reference Level 参考灵敏度

20dB

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

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									a	b	c	d	Length 长度			Sound Path 声程
FE4-13		0	C			20									ACC.	100%

AFTER T-CWR564

BLANK

EXAMINED BY 主探 <i>Jay Xing Shan</i> / 2010.5.12 LEVEL - II SIGN / DATE	REVIEWED BY 审核 <i>Jay Xing Shan</i> / 2010.5.12 LEVEL - II SIGN / DATE
质量经理 / QCM <i>W. J. ...</i> / 2010.5.12 签字 SIGN / 日期 DATE	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-7957 DATE日期 2010.05.12 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: FE4-13 SKIN E		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4	
REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2010
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
MATERIAL TO BE EXAMINED 检测材料	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 母材, 厚度	A709M-HPS-485WT2-Z 90mm
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	NA

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			
FE4-13				ACC.		100%MT

AFTER T-CWR564

BLANK

EXAMINED BY 主探 <i>[Signature]</i> LEVEL - II SIGN 签名 / DATE日期	REVIEWED BY 审核 <i>[Signature]</i> LEVEL-II SIGN / DATE日期
质量经理 / QCM <i>[Signature]</i> 2010.5.12 签字 SIGN / 日期 DATE	用户CUSTOMER _____ 签字 SIGN / 日期 DATE

February 22, 2010

AFC-ZPM-LTR-000621

Attention: **Mr. Lujianhua**
Mr. XuJun

ZPMC
Steel Structure Department
Room 203, Building 2
Shanghai, China 200125

PROJECT: San Francisco Oakland Bay SAS Bridge Superstructure
Caltrans Contract No. 04-0120F4
ABF Job No. 660110

SUBJECT: Clarification letter regarding use of CWR or WRR for base metal repairs of temporary attachment removal areas and plate edge weld build up areas

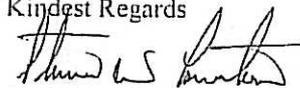
Mr. Lujianhua, Mr. XuJun

The following clarifications shall apply for completing WRR or CWR for base metal repair of Tower and OBG temporary attachment removal areas and plate edge weld build up areas.

1. Base metal repair – After removal of temporary attachments
 - a. SPCM
 - i. CWR required for SPCM temporary attachment removal areas requiring repair by welding.
 - b. Non SPCM
 - i. WRR is required for Non SPCM materials. CT onsite inspector must be notified prior to performing any weld repair then the CT inspector name noted on the WRR, the WRR and WPS must be present at the jobsite.
2. Base metal repair - Plate edge weld build up areas.
 - a. SPCM
 - i. WRR is required for weld build up of plate edges or to correct weld joint geometry if the deposition of weld metal up to 10mm or $\frac{1}{4}$ the base –metal thickness, whichever is less. CWR is required if these limitations are exceeded.
 - b. Non SPCM
 - i. WRR is required for Non SPCM materials as long as the weld build up does not exceed $\frac{1}{2}$ the base metal thickness or 20mm whichever is less. CT onsite inspector must be notified prior to performing any weld repair then the CT inspector name noted on the WRR, the WRR and WPS must be present at the jobsite. CWR is required if these limitations are exceeded.

If comments or clarifications are needed, please contact me.

Kindest Regards



American Bridge Company / Fluor Enterprises Inc., A Joint Venture
Steve Lawton
Foreign Quality Assurance Manager



375 Burma Road
Oakland, CA 94607 USA
Phone 510-808-4600
Fax 510-808-5601

February 22, 2010

AFC-ZPM-LTR-000621

Attention: **Mr. Lujianhua**
Mr. XuJun

ZPMC
Steel Structure Department
Room 203, Building 2
Shanghai, China 200125

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2. Base metal repair - Plate edge weld build up areas.
 - a. SPCM
 - i. WRR is required for weld build up of plate edges or to correct weld joint geometry if the deposition of weld metal up to 10mm or ¼ the base –metal thickness, whichever is less. CWR is required if these limitations are exceeded.
 - b. Non SPCM
 - i. WRR is required for Non SPCM materials as long as the weld build up does not exceed ½ the base metal thickness or 20mm whichever is less. CT onsite inspector must be notified prior to performing any weld repair then the CT inspector name noted on the WRR, the WRR and WPS must be present at the jobsite. CWR is required if these limitations are exceeded.

If comments or clarifications are needed, please contact me.

Kindest Regards

American Bridge Company / Fluor Enterprises Inc., A Joint Venture
Steve Lawton
Foreign Quality Assurance Manager

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-000881**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Jul-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0623**Type of problem:**

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

Date the Non-Conformance Report was written: 25-Jan-2010**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) observed base metal repairs were performed without prior approval from the Engineer. These repairs were performed using the Shielded Metal Arc Welding (SMAW) process at East Tower, Lift 4, Skin E, on Seismic Performance Critical Member (SPCM) 485 grade material.

Contractor's proposal to correct the problem:

Contractor proposes to provide the CWR and NDT report to prove the welds are acceptable.

Corrective action taken:

Contractor provided the sufficient CWR and NDT report. The NDT report shows the repairs are acceptable.

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 Wahbeh, Mazen 818-292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Ng, Michael

Quality Assurance Inspector

Reviewed By: Devey, Jim

QA Reviewer