

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-000654**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0625**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Crossbeam 4 Deck and Side Panel
Procedural	Procedural	Description:	

Reference Description: MT indications found in the weld and the weld near the base metal in CB4 Deck and Side Panel

Description of Non-Conformance:

During Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Cross Beam CB4, this QA Inspector discovered the following issues:

- One (1) Transverse Linear indication measuring approximately 15 mm in length.
- The indication is on the base metal near the weld is identified as: DP202-004-029.
- The weld is a fillet weld joining deck plate to stiffener plate.

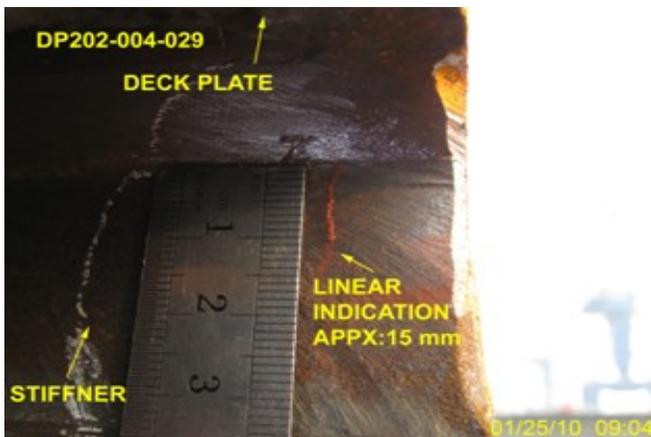
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- The weld is a fillet weld joining deck plate to stiffener plate.

- Two (2) Transverse Linear indications measuring approximately each indication 6 mm in length.
- The weld is identified as: SP203-004-056.
- The weld is a fillet weld joining deck plate to stiffener plate.

- The Notice of Witness Inspection Number (NWIT) is 005123. The indications are located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel by performing 25% MT inspection of these welds.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

-AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks”.

-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.”

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Zou hu

Time and method of notification: 18:40_01-25-10_Email

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 14:30_01-26-10_Email

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
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Reviewed By:	Wahbeh, Mazen	SMR
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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: 26-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: 05.03.06-000613

Subject: NCR No. ZPMC-0625

Reference Description: MT indications found in the weld and the weld near the base metal in CB4 Deck and Side Panel

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: Xbeam **Lift:**

Remarks:

During Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Cross Beam CB4, this QA Inspector discovered the following issues:

- One (1) Transverse Linear indication measuring approximately 15 mm in length.
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 - The Notice of Witness Inspection Number (NWIT) is 005123. The indications are located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel by performing 25% MT inspection of these welds.
- Please see attached NCR ZPMC-625 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.

NCT

(Continued Page 2 of 2)

Transmitted by: Ching Chao

Attachments: ZPMC-0625

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: 05.03.06-000613

Subject: NCR No. ZPMC-0625

Dated: 08-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000572 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-000572R00;

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	狄坤龙 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 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
戴斌 Dai Goufeng	江江 Jiang Jiang		
薛宇 Xuellanong	黄廷 Huang Ting		
马志长 Majizhang	黄廷 Huang Ting		
谭善 Tanxingshan	李黎明 Li Liming		
马健 Majian	李黎明 Li Liming		
孙金福 Sunjinfu	徐坤 Xu Kun		
沈健 Shenjian	李黎明 Li Liming		
黄宇 Huang Jiny			
金峰 Jing Feng			
吴文 Wuwen			
解坤 Jiekun			
周海周 Zhouhaijun			
徐坤 Xu Kun			

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: 05.03.06-000613

Subject: NCR No. ZPMC-0625

Dated: 09-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000572 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: Attached is documentation that the welds are acceptable. Based on this ZPMC requests closure of this NCR. ZPMC has implemented training to decrease the occurrences of missed indication. ZPMC and ABFJV both have conducted training with inspectors and there has been a decrease in the number of missed indications discovered by the Department. ZPMC will continue training to further decrease these incidences. ZPMC has issued an internal NCR to notify the QC department of this incident and has repired the indications. Attached is documentation that the welds are acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000572R01;

Caltrans' comments:

Status: CLO

Date: 18-Mar-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Attachment(s):

Date: 18-Mar-2010



No. B-647

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-8

REGARDING: NCR-000654 (ZPMC-0625)

With this letter of response, ZPMC requests closure of CT NCR-000654 (ZPMC-0625) 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-CWR1186, B-CWR1213.
- The punch list item 429 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-000654 (ZPMC-0625)

B787-MT-19128 R1

B787-MT-18619 R1

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

318110



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: 26-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: 05.03.06-000613

Subject: NCR No. ZPMC-0625

Reference Description: MT indications found in the weld and the weld near the base metal in CB4 Deck and Side Panel

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- Non-Conformance Resolved.

Material Location: Xbeam

Lift:

Remarks:

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Action Required and/or Action Taken:

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NCT

(Continued Page 2 of 2)

Transmitted by: Ching Chao

Attachments: ZPMC-0625

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

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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 (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-000654

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 25-Jan-2010

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

NCR #: ZPMC-0625

Type of problem:

Welding **Concrete** **Other**

Welding **Curing** **Procedural** **Bridge No:** 34-0006

Joint fit-up **Coating** **Other** **Component:** Crossbeam 4 Deck and Side Panel

Procedural **Procedural** **Description:**

Reference Description: MT indications found in the weld and the weld near the base metal in CB4 Deck and Side Panel

Description of Non-Conformance:

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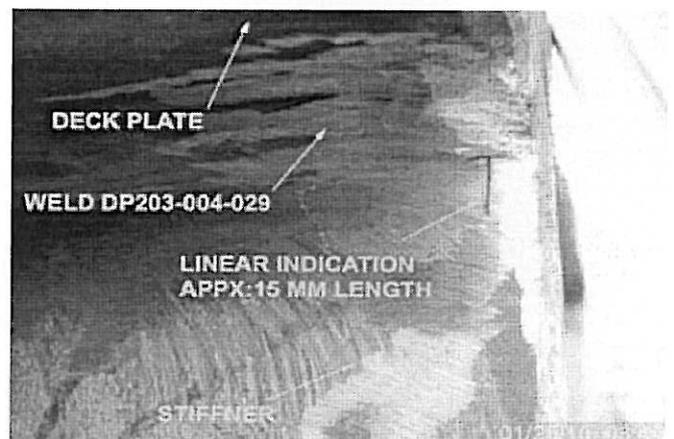
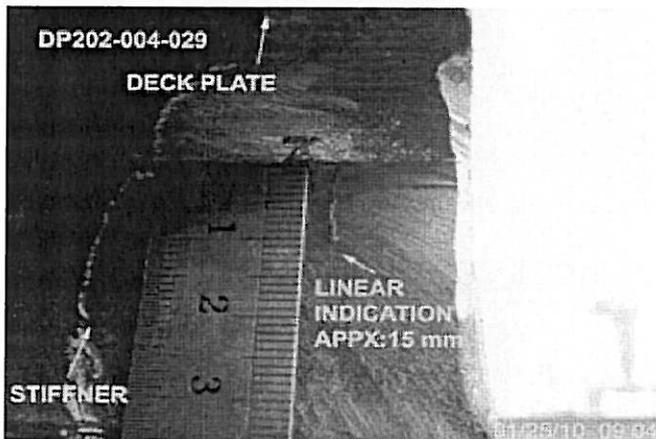
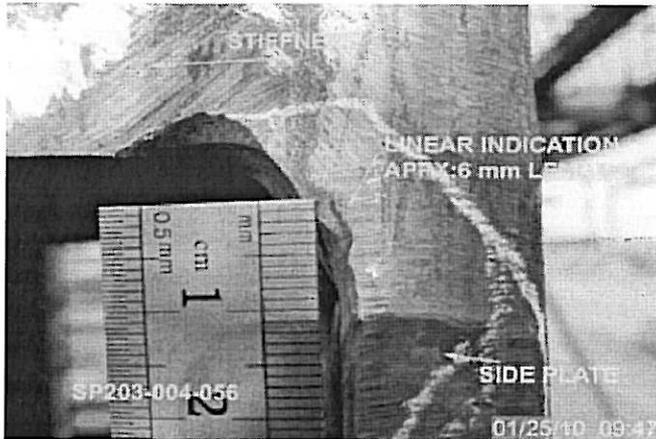
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

-AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks”.

-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.”

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Zou hu

Time and method of notification: 18:40_01-25-10_Email

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 14:30_01-26-10_Email

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

CURTISB
CWR 1213

18619
MT 17128. 123



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-427(ZPMC-0625)
Item: Miss MT indication 名称描述: MT 漏检	Item Number: 件号:	Drawing: CB4 图号:
Location: 位置: 外场总拼		Date: 日期: 2010-02-03

Description of Nonconformance:

During Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Cross Beam CB4, this QA Inspector discovered the following issues:

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The indications are located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel by performing 25% MT inspection of these welds.

在对 CB4 进行 MT 检验的过程中, 加州检验员发现以下问题:

一条横向线性缺陷长度将近 15mm。缺陷在母材上接近焊缝: DP202-004-029.这条焊缝是角焊缝连接顶板和筋板。

一条横向线性缺陷长度将近 15mm。该缺陷在母材上接近焊缝: DP203-004-029.该焊缝是角焊缝连接顶板和筋板。

两条横向线性缺陷长度将近 6mm。该焊缝是: SP203-004-056.这条焊缝是连接顶板和筋板。

这些缺陷位置之前已经被 ZPMC MT 人员所检验并接受。

Work By: 施工方: <i>Li Liming</i> 2010.03.07	Prepared by: 准备:	Reviewed by QCE: 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		

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

建议: *确认位置并返修.* Confirm position and repair.

Prepared by: <i>Li Liming</i> 准备: 2010.03.07	Approved by QCA: _____ 质量经理批准
---	----------------------------------

Reason for Nonconformance:

不符合原因:

焊缝后填补产生的不连续性缺陷未检测.
Fix after welding caused discontinuous defects.

Prevention of Re-occurrence:

预防措施:

加强焊接控制, 保证补焊后的 MT 检测。

Enhance controlling welding and inspect by use of MT after fix.

Approved by/批准: Li Liming
2010.03.07

Technical Justification for Use-As-Is/Repair:

Attachment

Non-attachment

回用或返修的技术依据:

附件

无附件

Reviewed /批准: _____

Verification:

Acceptable

Unacceptable

确认:

可接受

不可接受

Verified by QCI/质检确认: _____

Reviewed by QCA/质检主任审核: _____

#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-000556**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0625**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:**

During Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Cross Beam CB4, this QA Inspector discovered the following issues:

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- One (1) Transverse Linear indication measuring approximately 15 mm in length.
- The indication is on the base metal near the weld is identified as: DP203-004-029.
- The weld is a fillet weld joining deck plate to stiffener plate.

- Two (2) Transverse Linear indications measuring approximately each indication 6 mm in length.
- The weld is identified as: SP203-004-056.
- The weld is a fillet weld joining deck plate to stiffener plate.

- The Notice of Witness Inspection Number (NWIT) is 005123. The indications are located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel by performing 25% MT inspection of these welds.

Contractor's proposal to correct the problem:

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

Corrective action taken:

Contractor submitted NDT data verifying the welds were repaired in accordance with approved CWRs and are in conformance with Contract specifications. Additional training was provided to NDT Technicians and an internal NCR was also issued by the Contractor in regards to this issue.

