

**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-000658

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

**Date:** 28-Jan-2010

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

**NCR #:** ZPMC-0629

### Type of problem:

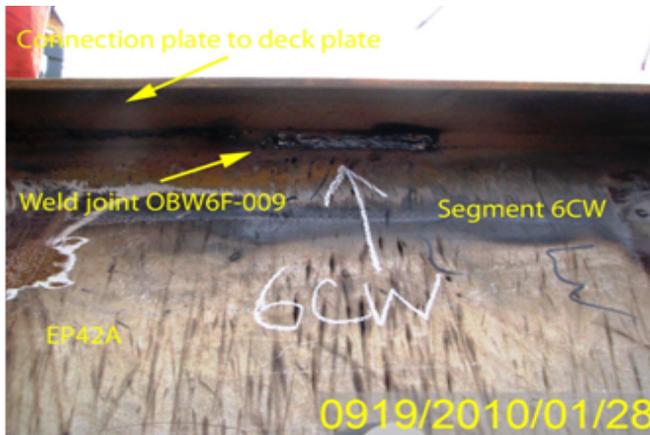
<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> 6CW counterweight connection plate
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Welder was not qualified to weld in 4F position for 6CW counterweight connection plate

### Description of Non-Conformance:

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- ZPMC welder Xiao Di # 066401 was observed welding in the 4F overhead welding position, which he is only qualified in 3F vertical position.
- Welding was performed on the Connection Plate to Deck Plate.
- The Deck Plate is identified as CA29A.
- The weld is identified as OBW6F-009.
- This weld is a Complete Joint Penetration (CJP).
- A total of eight (8) repairs were performed on the bottom side of weld joint OBW6F-009.
- These repairs are located on the Counter Weight side of segment 6CW at the W3 line.
- Lift 6W is located in the OGB Trial Assembly Area.



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



## Applicable reference:

Caltrans Special Provision 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) 5.22.2.3; 3F (Vertical). Qualification in the 3F (vertical) position shall qualify for flat, horizontal, and vertical position fillet welding of plate and structural shapes.

ZPMC Welding Repair Report B-WR9929; “QC or CWI shall be present to witness repair, direct and supervise all repair operation during this repair to ensure the repair is per the disposition requirements, and AWS D1.5 code requirements.”

**Who discovered the problem:** Joe Alaniz

**Name of individual from Contractor notified:** CK Chan

**Time and method of notification:** 0945 hours, 01/28/10, Verbal

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

**Time and method of notification:** 0930 hours, 01/29/10, 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



**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:** 29-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:** 05.03.06-000618

**Subject:** NCR No. ZPMC-0629

**Reference Description:** Welder was not qualified to weld in 4F position for 6CW counterweight connection plate

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 the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- ZPMC welder Xiao Di # 066401 was observed welding in the 4F overhead welding position, which he is only qualified in 3F vertical position.
- Welding was performed on the Connection Plate to Deck Plate.
- The Deck Plate is identified as CA29A.
- The weld is identified as OBW6F-009.
- This weld is a Complete Joint Penetration (CJP).
- A total of eight (8) repairs were performed on the bottom side of weld joint OBW6F-009.
- These repairs are located on the Counter Weight side of segment 6CW at the W3 line.
- Lift 6W is located in the OGB Trial Assembly Area.

Please attached NCR ZPMC-629 for details.

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

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences and also provide documentation to show that the weld quality conforms to contract requirements.

**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0629

**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:** 05.03.06-000618

**Subject:** NCR No. ZPMC-0629

**Dated:** 10-Mar-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000613 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** The welder in question for this non conformance report has been qualified in the 4F position. Attached is documentation of the test results of the welder qualifications which are acceptable.

REFLASH: REVISED ATTACHMENT, 3-29-10

The welder in question for this non conformance report has been qualified in the 4F position. Attached is documentation of the test results of the welder qualifications which are acceptable. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000613R00;

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**Caltrans' comments:**

**Status:** CLO

**Date:** 05-Apr-2010

This proposed resolution is acceptable. The documentation received for ZPMC Welder Liu Daiquan is sufficient and the Department concurs that Non-Conformance ZPMC-0629 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 05-Apr-2010



No. B-656

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-3-10**

**REGARDING: NCR-000632 (ZPMC-0605) NCR-000658(ZPMC-0629)**

With this letter of response, ZPMC requests closure of CT NCR-000632 (ZPMC-0605) NCR-000658(ZPMC-0629) what mentioned that welder was not qualified to weld in 4F position.

- The welder was identified to be MR. Xiao Di (203204). Please be noticed the welder ID addressed in ZPMC-0629 was incorrect. The weld ID for Mr. Xiao Di should be 203204.
- ZPMC has arranged welding test for Mr. Xiao Di to qualify his 4F position. CT inspector witnessed the welding and testing for the sample.
- Attached documentation shows Mr. Xiao Di has passed this test.

Basing on the responses above and attached documentations, ZPMC requests closure of these two NCRs.

**ATTACHMENT:**

NCR-000632 (ZPMC-0605)

NCR-000658(ZPMC-0629)

Test Record of Welder Qualification

Photos taken during welding and after testing

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

3/10/10



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:** 20-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:** 05.03.06-000599

**Subject:** NCR No. ZPMC-0605

**Reference Description:** ZPMC welder was observed welding outside of his qualified position on 6CW to 7AW Side Panel temporary attachments

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:** 07

### Remarks:

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Welder Xiao Di #203204 (2F) welding in the 4F position which he is not qualified.
- Welding was performed on temporary fit up plates SP150A (6CW) to SP151A (7AW) at the Side Plate Segment field splice, Counter Weight side.
- Fit up plate was welded approximately 2410mm from the Side Plate to Bottom plate splice weld.
- The material for 6CW SP150A (PL524A) is designated as Seismic Performance Critical Member (SPCM).
- The material for 7AW SP151A (PL527A) is designated as Non-Seismic Performance Critical Member (Non-SPCM).
- Segment 6CW/7AW is located outside in the Trial Assembly area.

### Action Required and/or Action Taken:

Ensure the welder Xiao Di welds in the positions for which he is approved. A response for the resolution of this issue is expected within 7 days.

**Transmitted by:** Bill Howe Sr. Transportation Engineer

**Attachments:** ZPMC-0605

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

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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-000632  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV **Date:** 14-Jan-2010  
**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0605

**Type of problem:**

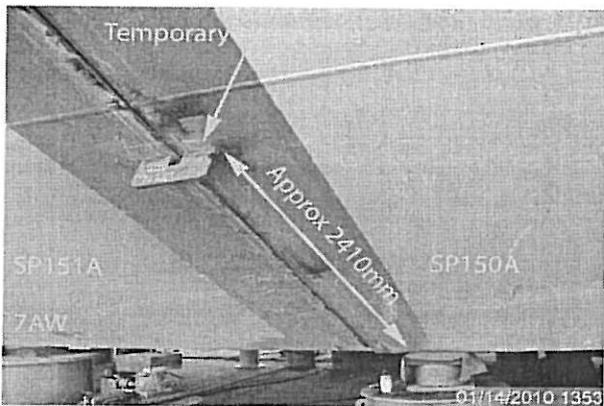
- Welding  Concrete  Other
- Welding  Curing  Procedural  **Bridge No:** 34-0006
- Joint fit-up  Coating  Other  **Component:** Segment 6CW/7AW Side Panel
- Procedural  Procedural  Description:

**Reference Description:** ZPMC welder was observed welding outside of his qualified position on 6CW to 7AW Side Panel temporary attachments

**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Welder Xiao Di #203204 (2F) welding in the 4F position which he is not qualified.
- Welding was performed on temporary fit up plates SP150A (6CW) to SP151A (7AW) at the Side Plate Segment field splice, Counter Weight side.
- Fit up plate was welded approximately 2410mm from the Side Plate to Bottom plate splice weld.
- The material for 6CW SP150A (PL524A) is designated as Seismic Performance Critical Member (SPCM).
- The material for 7AW SP151A (PL527A) is designated as Non-Seismic Performance Critical Member (Non-SPCM).
- Segment 6CW/7AW is located outside in the Trial Assembly area.



**Applicable reference:**

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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AWS D1.5 (2002) Section 5.22.2.2 2F (horizontal) – “Qualification in the 2F (horizontal) position shall qualify for flat and horizontal position fillet welding of plate and structural shapes”.

**Who discovered the problem:** Dan Hernandez

**Name of individual from Contractor notified:** He Yong

**Time and method of notification:** 1400 hours, 01-14-10, Verbal

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

**Time and method of notification:** 1830 hours, 01-14-10, Email

**QC Inspector's Name:** Wu Zhi Cheng

**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

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**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:** 29-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:** 05.03.06-000618

**Subject:** NCR No. ZPMC-0629

**Reference Description:** Welder was not qualified to weld in 4F position for 6CW counterweight connection plate

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 the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- ZPMC welder Xiao Di # 066401 was observed welding in the 4F overhead welding position, which he is only qualified in 3F vertical position.
- Welding was performed on the Connection Plate to Deck Plate.
- The Deck Plate is identified as CA29A.
- The weld is identified as OBW6F-009.
- This weld is a Complete Joint Penetration (CJP).
- A total of eight (8) repairs were performed on the bottom side of weld joint OBW6F-009.
- These repairs are located on the Counter Weight side of segment 6CW at the W3 line.
- Lift 6W is located in the OGB Trial Assembly Area.

Please attached NCR ZPMC-629 for details.

### Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences and also provide documentation to show that the weld quality conforms to contract requirements.

**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0629

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

02.02.15.04  
05.03.06-000618.NCT

Received  
NCT-000618 01 Feb 10 Page 1 of 1

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  
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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-000658

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-Jan-2010

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

NCR #: ZPMC-0629

### Type of problem:

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

Bridge No: 34-0006

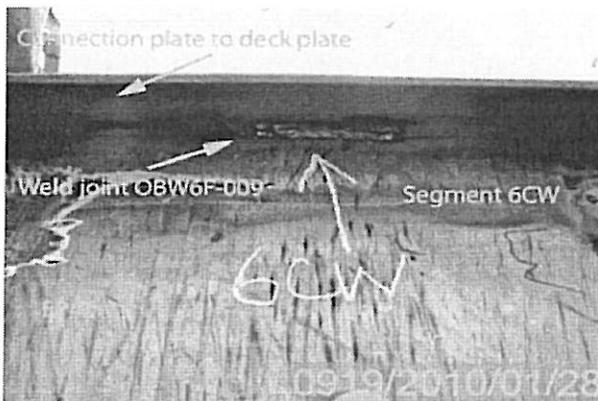
Component: 6CW counterweight connection plate

Reference Description: Welder was not qualified to weld in 4F position for 6CW counterweight connection plate

### Description of Non-Conformance:

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- ZPMC welder Xiao Di # 066401 was observed welding in the 4F overhead welding position, which he is only qualified in 3F vertical position.
- Welding was performed on the Connection Plate to Deck Plate.
- The Deck Plate is identified as CA29A.
- The weld is identified as OBW6F-009.
- This weld is a Complete Joint Penetration (CJP).
- A total of eight (8) repairs were performed on the bottom side of weld joint OBW6F-009.
- These repairs are located on the Counter Weight side of segment 6CW at the W3 line.
- Lift 6W is located in the OGB Trial Assembly Area.



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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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(Continued Page 2 of 2)

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### Applicable reference:

Caltrans Special Provision 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) 5.22.2.3; 3F (Vertical). Qualification in the 3F (vertical) position shall qualify for flat, horizontal, and vertical position fillet welding of plate and structural shapes.

ZPMC Welding Repair Report B-WR9929; "QC or CWI shall be present to witness repair, direct and supervise all repair operation during this repair to ensure the repair is per the disposition requirements, and AWS D1.5 code requirements."

**Who discovered the problem:** Joe Alaniz

**Name of individual from Contractor notified:** CK Chan

**Time and method of notification:** 0945 hours, 01/28/10, Verbal

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

**Time and method of notification:** 0930 hours, 01/29/10, 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.

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**Inspected By:** Tsang, Eric

SMR

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**Reviewed By:** Wahbeh, Mazen

SMR

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## 美国海湾大桥焊工考试试板试验记录 Test Record of Welder Qualification

试验委托单号 Consigning list of testing: WT-LX-20100309-6      检测依据 Test Standard: AWS D1.5:2002

样品接收日期 Date of receiving the Spe.: 2010.3.9      送样人 Sender: 赵佳能      接收人 Receiver: 谢建

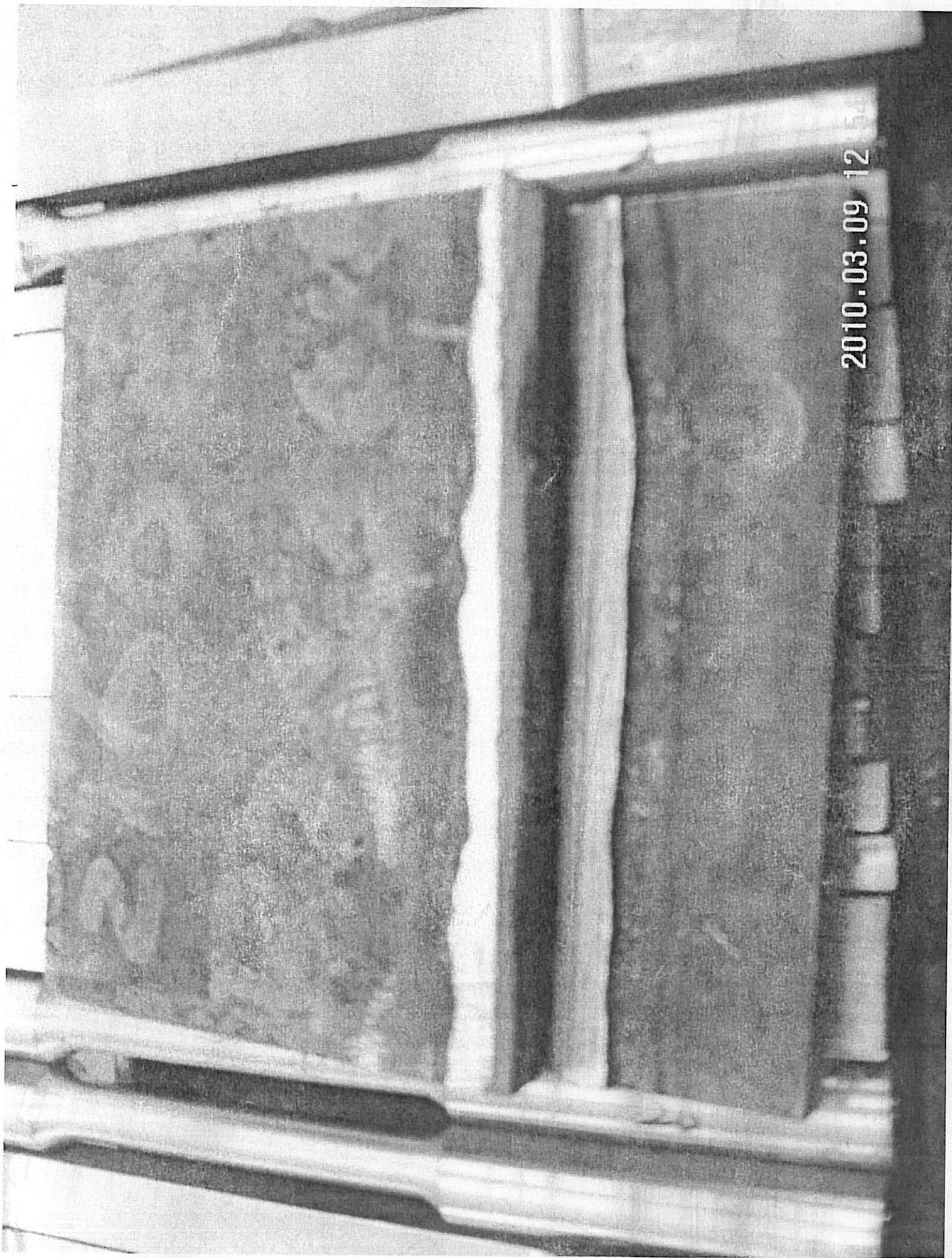
试验设备名称 Testing equipment: WE-600

试验设备编号 Equipment No.: ZTC-L-002

试验员 Operator: 顾文彬 审核 Reviewed by: 王明      见证 Witnessed by: B240.      环境温度 Surround temp.: 18°C

样品号 Specimen No.	焊工姓名 Welder	试板编号 No.	焊接位置 Welding Position	焊接方法 Welding Process	试样尺寸 Width*Thickness*Length mm	弯曲类型 Type of Bend	宏观腐蚀试验 Macro-etching test	试验结果 Test Result	试验日期 Test Date.
肖迪 (Xiao Di)	肖迪 (Xiao Di)	203204	-	-	-	折面 Break test	样品经10%硝酸酒精溶液腐蚀。 After Macro-etching by alcohol with 10% nitric acid. <input checked="" type="checkbox"/> 未见缺陷 No defects. <input type="checkbox"/> 缺陷描述 Defects description: CT B240-016-10	OK	2010.3.9
王斌斌 (Wang Binbin)	王斌斌 (Wang Binbin)	216086	-	-	-	折面 Break test	样品经10%硝酸酒精溶液腐蚀。 After Macro-etching by alcohol with 10% nitric acid. <input checked="" type="checkbox"/> 未见缺陷 No defects. <input type="checkbox"/> 缺陷描述 Defects description: CT B240-D15-10	OK	2010.3.9
王中伟 (Wang Zhongwei)	王中伟 (Wang Zhongwei)	053753	-	-	-	折面 Break test	样品经10%硝酸酒精溶液腐蚀。 After Macro-etching by alcohol with 10% nitric acid. <input checked="" type="checkbox"/> 未见缺陷 No defects. <input type="checkbox"/> 缺陷描述 Defects description: CT B240-017-10	OK	2010.3.9

2010.03.09 12:54









## 美国海湾大桥焊工考试试板试验记录 Test Record of Welder Qualification

试验委托单号 Consigning list of testing: WT-LX-20100329-7      检测依据 Test Standard: AWS D1.5:2002

样品接收日期 Date of receiving the Spe.: 2010.3.29      送样人 Sender: 赵佳能      接收人 Reciever: 谢萍

试验设备名称 Testing equipment: WE-600

试验设备编号 Equipment No.: ZTC-L-002

试验员 Operator: 顾之华 段国华      审核 Reviewed by: 袁江平      环境温度 Surround temp.: 16°C

样品号 Specimen No.	焊工姓名 Welder	试板编号 No.	焊接位置 Welding Position	焊接方法 Welding Process	试样尺寸 Size of Specimen <small>宽度*厚度*长度 Width*Thickness*Length mm</small>	弯曲类型 Type of Bend	宏观腐蚀试验 Macro-etching test	试验结果 Test Result	试验日期 Test Date.
-	Li Daizhen	066401	4F	SMAW	200 x 100 x 12mm	折断 Break test	样品经10%硝酸酒精溶液腐蚀。 After Macro-etching by alcohol weith 10% nitric acid. 未见缺陷 No defects. <input checked="" type="checkbox"/> 缺陷描述 Defects description. <input type="checkbox"/>	OK	2010.3.29



**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

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Bay Area Branch  
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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-000580**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0629**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>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 28-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- ZPMC welder Xiao Di # 066401 was observed welding in the 4F overhead welding position, which he is only qualified in 3F vertical position.
- Welding was performed on the Connection Plate to Deck Plate.
- The Deck Plate is identified as CA29A.
- The weld is identified as OBW6F-009.
- This weld is a Complete Joint Penetration (CJP).
- A total of eight (8) repairs were performed on the bottom side of weld joint OBW6F-009.
- These repairs are located on the Counter Weight side of segment 6CW at the W3 line.
- Lift 6W is located in the OGB Trial Assembly Area.

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

Qualify welder for welding in the 4G position.

**Corrective action taken:**

Welder Liu Dai Quan, ID 066401, was qualified to weld in said position on March 29, 2010. NOTE: Incorrect welder name mentioned in the NCR, however, the correct welder ID was provided.

**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