

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-000661
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 29-Jan-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0632

Type of problem:

Welding **Concrete** **Other**
Welding **Curing** **Procedural** **Bridge No:** 34-0006
Joint fit-up **Coating** **Other** **Component:** DP weld for Segment 12AE
Procedural **Procedural** **Description:** Missed MT indication by QC

Reference Description: Missed MT Indication by QC on DP weld for Segment 12AE

Description of Non-Conformance:

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3006-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 90mm.
- The weld is identified as: DP 3056-001-015
- The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate (PL3119A).
- The member is located in Bay 9
- The Notice of Witness Inspection Number (NWIT) is #005148. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25%) 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 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks

Who discovered the problem: Daniel Barrentine

Name of individual from Contractor notified: Lv Yun

Time and method of notification: 01/29/10, 10:00, Verbal

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 01/29/10, 15:30, Verbal

QC Inspector's Name: Sun Bo

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: 05.03.06-000621

Subject: NCR No. ZPMC-0632

Reference Description: Missed MT Indication by QC on DP weld for Segment 12AE

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:** 12

Remarks:

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3006-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 90mm.
- The weld is identified as: DP 3056-001-015
- The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate (PL3119A).
- The member is located in Bay 9
- The Notice of Witness Inspection Number (NWIT) is #005148. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25%) percent MT inspection of this weld.

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3006-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 90mm.
- The weld is identified as: DP 3056-001-015
- The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate (PL3119A).
- The member is located in Bay 9
- The Notice of Witness Inspection Number (NWIT) is #005148. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25%) percent MT inspection of this weld.

Please see attached NCR ZPMC-632 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences and provide documentation to show that the missed indication has been properly repaired to meet contract requirements. 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-0632

cc: Rick Morrow, Gary Pursell, 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: 05.03.06-000621

Subject: NCR No. ZPMC-0632

Dated: 08-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000563 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-000563R00;

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
孙功强 Sun Gongqiang	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 Chenggong	钢桥
黄瑞 Huang Rui	钢桥	孙工 Sun Gong	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: 05.03.06-000621

Subject: NCR No. ZPMC-0632

Dated: 23-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000563 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indications in accordance with B-CWR1192 and is providing NDT documentation to show that the weld is acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC has repaired the indications in accordance with B-CWR1192 and is providing NDT documentation to show that the weld is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000563R01;

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-0632 is closed.

Submitted by: Eagen, Sean

Date: 05-Apr-2010

Attachment(s): NPR CT Comments



No. B-702

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-21

REGARDING: NCR-000661(ZPMC-0632)

ZPMC is providing NDT record shows this weld is now acceptable after repair and requesting this NCR to be closed. Please refer to B-CWR1192.

ATTACHMENT:

NCR-000661(ZPMC-0632)

B787-MT-19770 R1

A handwritten signature in black ink, appearing to read 'L. J. [unclear]'.

3/21/10



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

Job Name: SAS Superstructure

Document No: 05.03.06-000621

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0632

Reference Description: Missed MT Indication by QC on DP weld for Segment 12AE

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: 12

Remarks:

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3006-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 90mm.
 - The weld is identified as: DP 3056-001-015
 - The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate (PL3119A).
 - The member is located in Bay 9
 - The Notice of Witness Inspection Number (NWIT) is #005148. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25%) percent MT inspection of this weld.
- During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3006-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 90mm.
- The weld is identified as: DP 3056-001-015 *(should be DP3006-001-015, refer to photos)*
- The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate (PL3119A).
- The member is located in Bay 9
- The Notice of Witness Inspection Number (NWIT) is #005148. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25%) percent MT inspection of this weld.

Please see attached NCR ZPMC-632 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences and provide documentation to show that the missed indication has been properly repaired to meet contract requirements. 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-0632

cc: Rick Morrow, Gary Pursell, 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
 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-000661

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 29-Jan-2010

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

NCR #: ZPMC-0632

Type of problem:

Welding Concrete Other

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

Joint fit-up Coating Other **Component:** DP weld for Segment 12AE

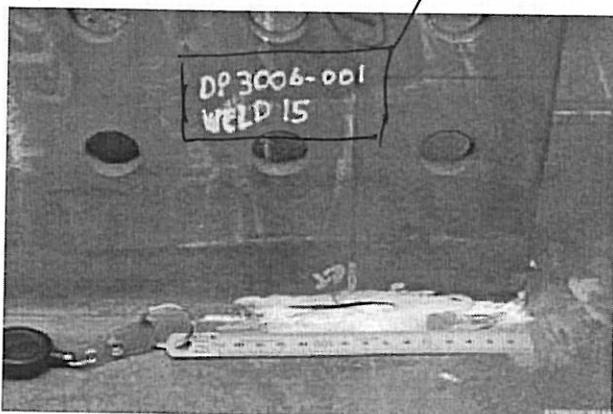
Procedural Procedural **Description:** Missed MT indication by QC

Reference Description: Missed MT Indication by QC on DP weld for Segment 12AE

Description of Non-Conformance:

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3006-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 90mm.
- The weld is identified as: DP 3056-001-015
- The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate (PL3119A).
- The member is located in Bay 9
- The Notice of Witness Inspection Number (NWIT) is #005148. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25%) percent MT inspection of this weld.



SFOBB QA VERIFICATION TAG
 IN-PROCESS

Tag No. 011483

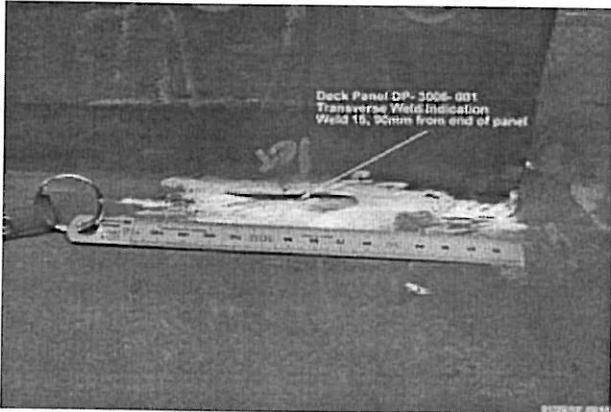
SUBASSEMBLY DP3006-001
12AE

INSPECTIONS				REPAIRS			
	ZPMC	ABE	CI		ZPMC	ABE	CI
CVT				CWR			
VT				DRW			
MT				NCR			
DRW							

Notes: Instead of VT: Sub E. / Log # 13.2.9

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 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks

Who discovered the problem: Daniel Barrentine

Name of individual from Contractor notified: Lv Yun

Time and method of notification: 01/29/10, 10:00, Verbal

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

Time and method of notification: 01/29/10, 15:30, Verbal

QC Inspector's Name: Sun Bo

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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-19770R1 DATE日期 2010.03.19 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: DP3006 U RIB 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 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	<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-345T2-X-S 12/14mm
---------------------------------	---	--------------------------------	----------------------------

WELDING PROCESS 焊接方法	NA	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			
DP3006-001-015	1R1			ACC.		100%MT

AFTER B-CWR1192 rev2

BLANK

EXAMINED BY 主操 <i>Jm Terry</i> / 1003.19 LEVEL-II SIGN 签名 / DATE 日期 质量经理 / QCM	REVIEWED BY 审核 <i>Sme</i> / 1003.19 LEVEL-II SIGN / DATE 日期 用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

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-000596**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0632**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: 29-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Deck Panel (DP 3006-001), this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) transverse indication measuring approximately 8mm in length at Y location 90mm.
- The weld is identified as: DP 3056-001-015
- The Weld is a Partial Joint Penetration (PJP) Tee weld joining the Rib stiffener (RS3032C) to the deck plate (PL3119A).
- The member is located in Bay 9
- The Notice of Witness Inspection Number (NWIT) is #005148. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform twenty-five (25%) percent MT inspection of this weld.

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 documentation verifying the weld number listed in the NCR 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?** 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.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer