

**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-000663

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

**Date:** 29-Jan-2010

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

**NCR #:** ZPMC-0633

### 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> SA3-438 Longitudinal Stiffener Splice Plate
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Base Metal Repair (Buttering) without Engineer's Approval, SA3-438 Longitudinal Stiffener Splice Plate, North Tower Lift 2-3

### Description of Non-Conformance:

During random in-process visual inspection of North Tower lift 2 ~ lift 3, skin B & skin D splice plate, Caltrans Quality Assurance (QA) discovered the following:

- The deposition of weld metal (buttering/build-up) by Shielded Metal Arc Welding (SMAW) process on the base metal of SA3-438 splice plates.
- This build-up is measured to be approximately 15mm in width and approximately 370mm long.
- The plate thickness is 60mm.
- The material grade is A709M HPS 485 T2-Z, non-SPCM.
- This base metal repair was performed without the Engineer's approval.
- The welder is identified as 066236.
- The members are located in Bay 10.



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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Applicable reference:**

AWS D1.5 Section: 3.7.4 "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), or for a revised design to compensate for deficiencies."

Special Provisions 8-3: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them."

**Who discovered the problem:** Umesh D. Gaikwad

**Name of individual from Contractor notified:** Steve Lawton

**Time and method of notification:** 1630 Hrs, 01/29/10, Verbal

**Name of Caltrans Engineer notified:** Scott Kennedy

**Time and method of notification:** 1645 Hrs, 01/29/10, Verbal

**QC Inspector's Name:** Gao Zhi Chun

**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.

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<b>Inspected By:</b>	Guest,Skyler	SMR
<b>Reviewed By:</b>	Wahbeh,Mazen	SMR

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**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:** 31-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:** 05.03.06-000623

**Subject:** NCR No. ZPMC-0633

**Reference Description:** Base Metal Repair (Buttering) without Engineer's Approval / North Shaft Lift 2-3 Splice 2 Skin B & D / Longitudinal Stiffener Spli

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:** 02

**Remarks:**

During random in-process visual inspection of North Tower lift2 ~ lift 3, skin B & skin D splice plate, Caltrans Quality Assurance (QA) discovered the following:

- The deposition of weld metal (buttering/build-up) by Shielded Metal Arc Welding (SMAW) process on the base metal of SA3-438 splice plates.
- This build-up is measured to be approximately 15mm in width and approximately 370mm long.
- The plate thickness is 60mm.
- The material grade is A709M HPS 485 T2-Z, non-SPCM.
- This base metal repair was performed without the Engineer's approval.
- The welder is identified as 066236.
- The members are located in Bay 10.

AWS D1.5 Section: 3.7.4 "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), or for a revised design to compensate for deficiencies."

Special Provisions 8-3: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them."

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

Propose a resolution for the identified non-conformance, documenting that the repaired base metal / welding repairs are in compliance with the contract requirements. Documentation provided for the Engineer's review of the acceptability of the weld repairs 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.

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( *Continued Page 2 of 2* )

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

**Transmitted by:** Scott Kennedy      Sr. Bridge Engineer

**Attachments:**    ZPMC-0633

**cc:**    Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods

**File:**    05.03.06

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000623

**Subject:** NCR No. ZPMC-0633

**Dated:** 11-Feb-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000591 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC requests that this NCR be closed because the repairs were performed using the same procedure that was later approved.

After discussions with Caltrans and ABFJV, the weld built up witnessed in the report is acceptable if there is a weld repair report present and there is representative of Caltrans present. In this case, there was a WRR and a Caltrans representative on site to witness the work. Although agreed upon after the incident occurred, ZPMC requests that this NCR be closed because the repairs were performed using the same procedure that was later approved. In addition, ZPMC has issued internal instructions to their work crews so they understand the process in future cases.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000591R00;

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### Caltrans' comments:

**Status:** CLO

**Date:** 11-Feb-2010

Based on the interpretation of SMR/METS, it is acceptable for ABF/ZPMC to proceed with protocol for the OBG temporary attachment base metal repair and to utilize the maximum build up limits for weld joint correction from AWS D1.5 Section 3.3.4.1 (the lesser of 20mm or 2t) for these elements.

The proposed resolution is acceptable. The Department concurs that Non-conformance ZPMC-0633 is closed.

**Submitted by:** Lee, Ken

**Attachment(s):**

**Date:** 11-Feb-2010



No. T-128

## LETTER OF RESPONSE

**TO: American Bridge/Flour JV**

**DATE: 2010-2-09**

**REGARDING: NCR-000663(ZPMC-0633)**

**NCR-000666(ZPMC-0636)**

ZPMC recently received NCR-000663(ZPMC-0633) and NCR-000666(ZPMC-0636), they all mentioned that ZPMC performed buttering work without the approval of the Engineer. The thickness of buttering is respectively 15mm and 12mm.

For this case, ZPMC especially discussed with ABF and CT and made the decision finally. It included as following "For base metal buttering, if the thickness is less than 20mm, WRR should be needed and CT inspector in site should be informed before that; if the thickness is more than 20mm, CWR should be needed." In order to make a good use of this decision, ZPMC issued INTERNAL WORK REPORT to emphasize to the involved departments as well, see attachment.

So, we hope CT can take a review and close these two NCR ASAP.

**ATTACHMENT:**

**NCR-000663(ZPMC-0633)**

**NCR-000666(ZPMC-0636)**

**Internal Work Report (ZP06-787-133)**

*zhao jia neng*  
*2010-2-9*



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: 31-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: 05.03.06-000624

Subject: NCR No. ZPMC-0636

Reference Description: Base Metal Repair (Buttering) without Engineer's Approval / North Shaft Lift 2-3 Splice 2 Skin B & D / Longitudinal Splice Plate S

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: 02

### Remarks:

During random in-process observations of the fabrication of North Tower lift2 ~ lift 3, skin B & skin D splice plates, Caltrans Quality Assurance (QA) observed the following issues:

- ZPMC performed deposition of weld metal (buttering/build up) by Shielded Metal Arc Welding (SMAW) process on the base metal edge of splice plates for skin B and skin D of North Tower lift2~lift3.
- This base metal repair was performed without the approval of the Engineer.
- This build up was performed across the entire width of the edge and measured approximately 12mm thick and approximately 410mm in length.
- The material thickness is 50mm.
- The members are both identified as SA3-433.
- The plate material is designated as A709 grade 485 Non-Seismic Performance Critical Members (Non-SPCM).
- These members are located inside of Tower Bay 10.

AWS D1.5 Section: 3.7.4; "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), or for a revised design to compensate for deficiencies."

Special Provisions 8-3; "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them."

### Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance, documenting that the repaired base metal / welding repairs are in compliance with the contract requirements. Documentation provided for the Engineer's review of the acceptability of the weld repairs 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

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**NCT**

*(Continued Page 2 of 2)*

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Quality Control to prevent future occurrences.

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

**Transmitted by:** Scott Kennedy      Sr. Bridge Engineer

**Attachments:** ZPMC-0636

**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods

**File:** 05.03.06

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



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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

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

**Report No:** NCR-000666

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

**Date:** 30-Jan-2010

**NCR #:** ZPMC-0636

**Type of problem:**

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

**Bridge No:** 34-0006

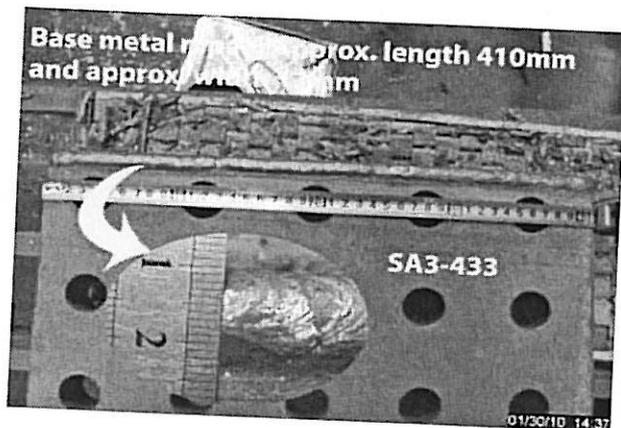
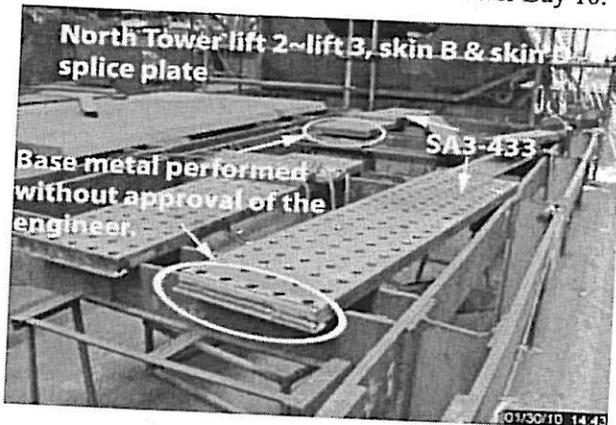
**Component:** Longitudinal Splice Plate SA3-433

**Reference Description:** Base Metal Repair (buttering) without the Engineer's Approval, Longitudinal Splice Plate SA3-433

**Description of Non-Conformance:**

During random in-process observations of the fabrication of North Tower lift 2 ~ lift 3, skin B & skin D splice plates, Caltrans Quality Assurance (QA) observed the following issues:

- ZPMC performed deposition of weld metal (buttering/build up) by Shielded Metal Arc Welding (SMAW) process on the base metal edge of splice plates for skin B and skin D of North Tower lift 2 ~ lift 3.
- This base metal repair was performed without the approval of the Engineer.
- This build up was performed across the entire width of the edge and measured approximately 12mm thick and approximately 410mm in length.
- The material thickness is 50mm.
- The members are both identified as SA3-433.
- The plate material is designated as A709 grade 485 Non-Seismic Performance Critical Members (Non-SPCM).
- These members are located inside of Tower Bay 10.



## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

**Applicable reference:**

AWS D1.5 Section: 3.7.4; "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), or for a revised design to compensate for deficiencies."

Special Provisions 8-3; "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them."

**Who discovered the problem:** Umesh D. Gaikwad

**Name of individual from Contractor notified:** Steve Lawton

**Time and method of notification:** 1600 Hrs, 01/30/10, Verbal

**Name of Caltrans Engineer notified:** Scott Kennedy

**Time and method of notification:** 1630 hours, 01-30-10, Verbal

**QC Inspector's Name:** Yu Zhi Lai

**Was QC Inspector aware of the problem:**  Yes  No

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

**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

**Reviewed By:** Wahbeh, Mazen

SMR



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:** 31-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:** 05.03.06-000623

**Subject:** NCR No. ZPMC-0633

**Reference Description:** Base Metal Repair (Buttering) without Engineer's Approval / North Shaft Lift 2-3 Splice 2 Skin B & D / Longitudinal Stiffener Spli

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:** 02

### Remarks:

During random in-process visual inspection of North Tower lift 2 ~ lift 3, skin B & skin D splice plate, Caltrans Quality Assurance (QA) discovered the following:

- The deposition of weld metal (buttering/build-up) by Shielded Metal Arc Welding (SMAW) process on the base metal of SA3-438 splice plates.
- This build-up is measured to be approximately 15mm in width and approximately 370mm long.
- The plate thickness is 60mm.
- The material grade is A709M HPS 485 T2-Z, non-SPCM.
- This base metal repair was performed without the Engineer's approval.
- The welder is identified as 066236.
- The members are located in Bay 10.

AWS D1.5 Section: 3.7.4 "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), or for a revised design to compensate for deficiencies."

Special Provisions 8-3: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them."

### Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance, documenting that the repaired base metal / welding repairs are in compliance with the contract requirements. Documentation provided for the Engineer's review of the acceptability of the weld repairs 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.

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**NCT**

*( Continued Page 2 of 2 )*

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

**Transmitted by:** Scott Kennedy      Sr. Bridge Engineer

**Attachments:**    ZPMC-0633

**cc:**    Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods

**File:**    05.03.06

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

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690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
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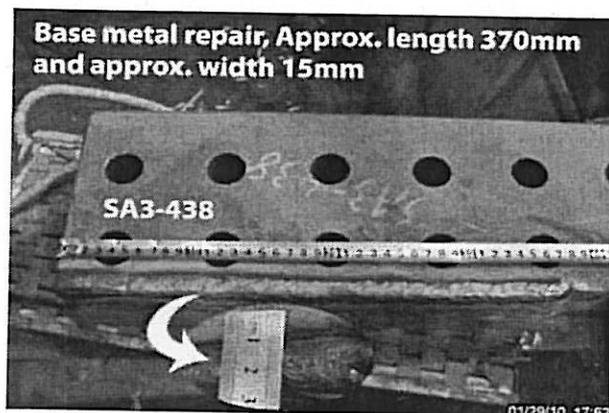
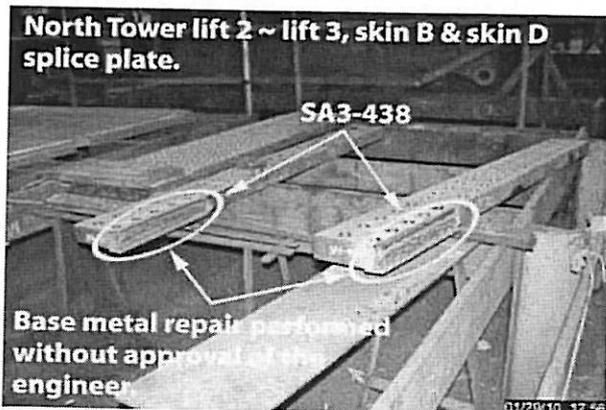
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000663**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0633**Type of problem:**Welding  Concrete  Other Welding  Curing  Procedural Joint fit-up  Coating  Other Procedural  Procedural  Description:**Bridge No:** 34-0006**Component:** SA3-438 Longitudinal Stiffener Splice Plate

**Reference Description:** Base Metal Repair (Buttering) without Engineer's Approval, SA3-438 Longitudinal Stiffener Splice Plate, North Tower Lift 2-3

**Description of Non-Conformance:**

During random in-process visual inspection of North Tower lift 2 ~ lift 3, skin B & skin D splice plate, Caltrans Quality Assurance (QA) discovered the following:

- The deposition of weld metal (buttering/build-up) by Shielded Metal Arc Welding (SMAW) process on the base metal of SA3-438 splice plates.
- This build-up is measured to be approximately 15mm in width and approximately 370mm long.
- The plate thickness is 60mm.
- The material grade is A709M HPS 485 T2-Z, non-SPCM.
- This base metal repair was performed without the Engineer's approval.
- The welder is identified as 066236.
- The members are located in Bay 10.



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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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( Continued Page 2 of 2 )

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**Applicable reference:**

AWS D1.5 Section: 3.7.4 "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), or for a revised design to compensate for deficiencies."

Special Provisions 8-3: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them."

**Who discovered the problem:** Umesh D. Gaikwad

**Name of individual from Contractor notified:** Steve Lawton

**Time and method of notification:** 1630 Hrs, 01/29/10, Verbal

**Name of Caltrans Engineer notified:** Scott Kennedy

**Time and method of notification:** 1645 Hrs, 01/29/10, Verbal

**QC Inspector's Name:** Gao Zhi Chun

**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.

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**Inspected By:** Guest, Skyler

SMR

**Reviewed By:** Wahbeh, Mazen

SMR

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# 工作联系单

第 1 页 共 1 页

INTERNAL WORK REPORT

编号: ZP06-787-133

产品名称: 美国加州海湾大桥

总图号: ZP06-787

内容提要: 钢塔母材返修要求

内容:

经过 ZPMC、ABF 及 CT 讨论, 现明确针对钢塔现场制作过程中母材返修要求:

1、母材热切割边缘的返修 (除堆焊方式) 参照 AWS D1.5 第 3 章 3.2 中相关要求。

2、母材的堆焊要求:

*Base metal buttering:*

A- 非 SPCM 构件的需堆焊厚度不超过 20mm 可开 WRR, 且 WRR 上处理措施按 CWR 执行, 施焊前通知 CT 现场检验员; 超出 20mm 须开 CWR。  
*Non-SPCM material, if less than 20mm, need WRR (Inform CT Inspector); more than 20mm, need CWR.*

B- SPCM 构件参照 D1.5 第 12 章相关要求, 需堆焊厚度不超过 10mm 可开 WRR, 且 WRR 上处理措施按 CWR 执行; 超出 10mm 须开 CWR。

3、母材临时构件移除后的表面缺陷返修:

A- 非 SPCM 板临时构件移除后的表面缺陷返修只须 WRR 即可, 返修点处需打磨干净, 且磨出 2: 1 斜势, 严禁直接在碳刨点上补焊。

B- SPCM 板临时构件移除后的表面缺陷返修须开 CWR。

凡是以上未提及的母材返修均须要 CWR, 且之前凡与此单相抵触之要求皆以此单为准, 烦请各部门能积极配合落实此项工作。

(注: 此联系单中所有 SPCM 构件的区分均以图纸标注为准。)

原发	质检公司:	分发	顾新寨 部长	分发	耿爱军 部长
审核		分发	杨学辉 部长	抄送	丁志水 总

**DEPARTMENT OF TRANSPORTATION**

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Quality Assurance and Source Inspection



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(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000519**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0633**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>Description:</b>	

**Date the Non-Conformance Report was written:** 29-Jan-2010**Description of Non-Conformance:**

During random in-process visual inspection of North Tower lift 2 ~ lift 3, skin B & skin D splice plate, Caltrans Quality Assurance (QA) discovered the following:

- The deposition of weld metal (buttering/build-up) by Shielded Metal Arc Welding (SMAW) process on the base metal of SA3-438 splice plates.
- This build-up is measured to be approximately 15mm in width and approximately 370mm long.
- The plate thickness is 60mm.
- The material grade is A709M HPS 485 T2-Z, non-SPCM.
- This base metal repair was performed without the Engineer's approval.
- The welder is identified as 066236.
- The members are located in Bay 10.

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

Accept buttering based on the presence of WRR and CT inspector witnessing repair.

**Corrective action taken:**

The maximum build up limits for weld joint correction from AWS D1.5 Section 3.3.4.1 (the lesser of 20mm or 2t) was applied to these elements, which makes the work performed in conformance to the 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 Skyler Guest, 15000422360, who represents the Office of

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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Structural Materials for your project.

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**Inspected By:** Guest,Skylar

Quality Assurance Inspector

**Reviewed By:** Wahbeh,Mazen

QA Reviewer

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