

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-000678**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0645**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Lifts 6E and 6W Deck Panel
Procedural	Procedural	Description:	

Reference Description: A few issues were noted for the weld build up on Lifts 6E and 6W Deck Panel Edges at bolted splice connection

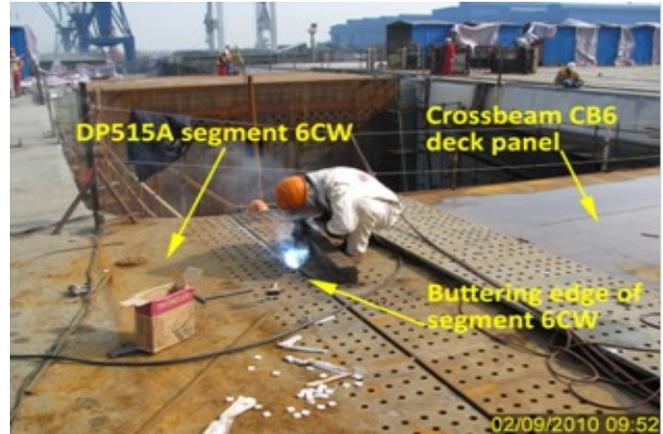
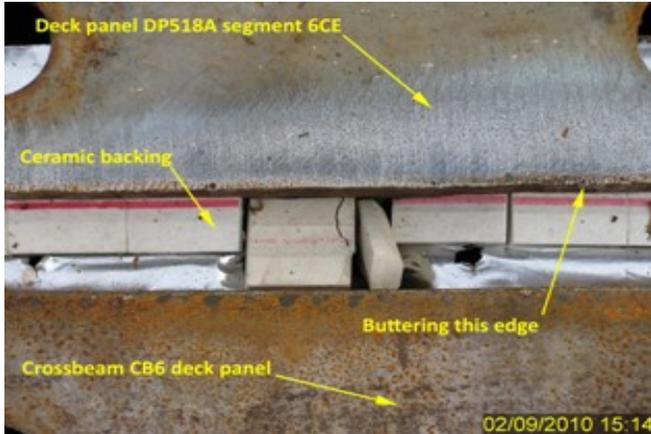
Description of Non-Conformance:

During random in process observation of the trial assembly of OBG Lifts 6E and 6W, this Quality Assurance Inspector discovered the following issues:

- ZPMC personnel are performing weld build up of the deck panel edge (DP515A and DP518A) by buttering. These edges are to be aligned adjacent to the CrossBeam6 deck panel for the bolted splice connection. The welding procedure was being performed without the prior Engineer's approval. Furthermore, ZPMC personnel did not follow the repair procedures noted in their internal documentation, weld repair report (B-WR 10561).
- Bevel angle noted in "drawing 1" in the disposition of the B-WR 10561 was not observed during the welding operation.
- The type and percentage of NDT inspection to be performed is not known as it is not specified clearly in note 6 of the disposition in B-WR 10561. Furthermore, it is noted that the working drawings do not have a specified weld detail or NDT requirement at this location.
- ZPMC welder performed FCAW of this edge with many times of stop and restart passes without cleaning the "crater area" of the weld prior to resuming the welding process.
- The segments are identified as 6CE and 6CW.
- The deck panels are identified as DP518A on the east line and DP515A on the west line.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

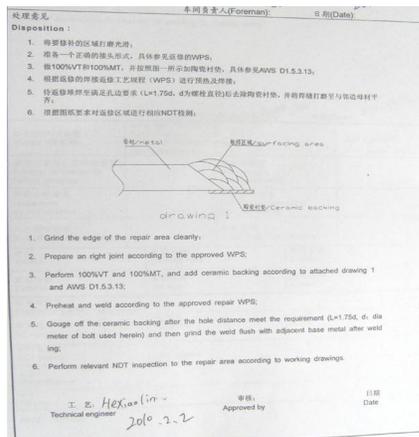
(Continued Page 2 of 3)



Applicable reference:

AWS D1.5 2002 section 3.7.4 specifies “Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies.”

AWS D1.5 2002 section 3.11.1 “Before welding over previously deposited metal, all slag shall be removed and adjacent base metal shall be brushed clean. This requirement shall apply not only to successive layers but also to successive beads and to the crater area when welding is resumed after any interruption. ”



Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 02-09-10_18:30_Email

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 02-10-10_14:00_Verbal

QC Inspector's Name: Zhang Wei

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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

NCT

(Continued Page 2 of 2)

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000635

Subject: NCR No. ZPMC-0645

Dated: 23-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000631 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the WRR used at the time and the NDT records to show that the repair is acceptable. Based on this ZPMC requests that this NCR be closed.

ZPMC is providing the WRR used at the time and the NDT records to show that the repair is acceptable. Based on this ZPMC requests that this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000631R00;

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-0645 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 05-Apr-2010



No. B-705

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-21

REGARDING: NCR-000678 (ZPMC-0645)

ZPMC acknowledged this problem and has issued internal NCR. ZPMC is providing the WRR & NDT records what show ZPMC's repair procedure and the repair is now acceptable. Please be noticed that this issue has been confirmed and removed from punchlist by CT's representative. Based on this, ZPMC is requesting this NCR to be closed.

ATTACHMENT:

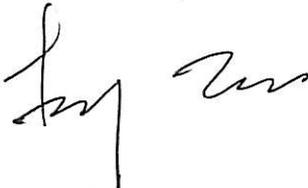
NCR-000678 (ZPMC-0645)

B-WR10672

B787-UT-11544

B787-MT-19945

B787-MT-19946


2/21/10



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: 10-Feb-2010

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

Dear: Mr. Charles Kanapicki
 Attention: Mr. Thomas Nilsson Project/Fabrication Manager
 Subject: NCR No. ZPMC-0645

Job Name: SAS Superstructure
 Document No: 05.03.06-000635

Reference Description: A few issues were noted for the weld build up on Lifts 6E and 6W Deck Panel Edges at bolted splice connection

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 random in process observation of the trial assembly of OBG Lifts 6E and 6W, this Quality Assurance Inspector discovered the following issues:

- ZPMC personnel are performing weld build up of the deck panel edge (DP515A and DP518A) by buttering. These edges are to be aligned adjacent to the CrossBeam6 deck panel for the bolted splice connection. The welding procedure was being performed without the prior Engineer's approval. Furthermore, ZPMC personnel did not follow the repair procedures noted in their internal documentation, weld repair report (B-WR 10561).
- Bevel angle noted in "drawing 1" in the disposition of the B-WR 10561 was not observed during the welding operation.
- The type and percentage of NDT inspection to be performed is not known as it is not specified clearly in note 6 of the disposition in B-WR 10561. Furthermore, it is noted that the working drawings do not have a specified weld detail or NDT requirement at this location.
- ZPMC welder performed FCAW of this edge with many times of stop and restart passes without cleaning the "crater area" of the weld prior to resuming the welding process.
- The segments are identified as 6CE and 6CW.
- The deck panels are identified as DP518A on the east line and DP515A on the west line.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

RECEIVED

FEB 11 2010

AMERICAN BRIDGE/FLUOR

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0645

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

NCT

(Continued Page 2 of 2)

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-000678

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 09-Feb-2010

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

NCR #: ZPMC-0645

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: OBG Lifts 6E and 6W Deck Panel

Reference Description: A few issues were noted for the weld build up on Lifts 6E and 6W Deck Panel Edges at bolted splice connection

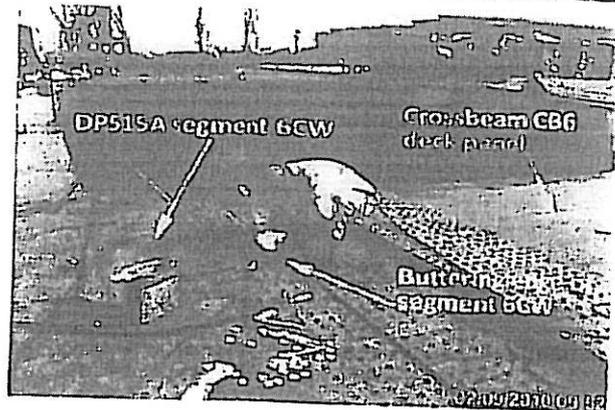
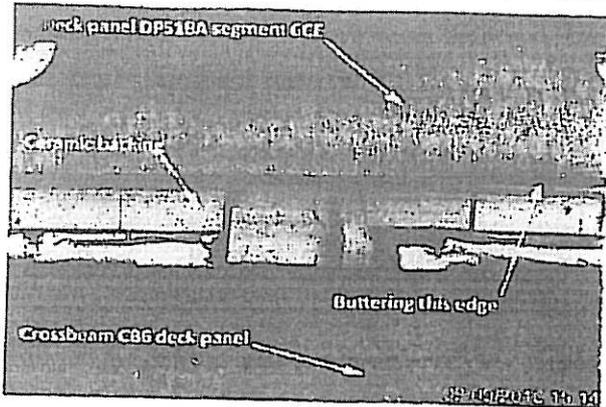
Description of Non-Conformance:

During random in process observation of the trial assembly of OBG Lifts 6E and 6W, this Quality Assurance Inspector discovered the following issues:

- ZPMC personnel are performing weld build up of the deck panel edge (DP515A and DP518A) by buttering. These edges are to be aligned adjacent to the CrossBeam6 deck panel for the bolted splice connection. The welding procedure was being performed without the prior Engineer's approval. Furthermore, ZPMC personnel did not follow the repair procedures noted in their internal documentation, weld repair report (B-WR 10561).
- Bevel angle noted in "drawing 1" in the disposition of the B-WR 10561 was not observed during the welding operation.
- The type and percentage of NDT inspection to be performed is not known as it is not specified clearly in note 6 of the disposition in B-WR 10561. Furthermore, it is noted that the working drawings do not have a specified weld detail or NDT requirement at this location.
- ZPMC welder performed FCAW of this edge with many times of stop and restart passes without cleaning the "crater area" of the weld prior to resuming the welding process.
- The segments are identified as 6CE and 6CW.
- The deck panels are identified as DP518A on the east line and DP515A on the west line.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

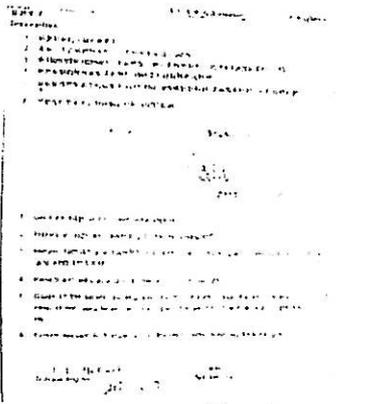
(Continued Page 2 of 3)



Applicable reference:

AWS D1.5 2002 section 3.7.4 specifies "Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies."

AWS D1.5 2002 section 3.11.1 "Before welding over previously deposited metal, all slag shall be removed and adjacent base metal shall be brushed clean. This requirement shall apply not only to successive layers but also to successive beads and to the crater area when welding is resumed after any interruption."



Who discovered the problem: Steve Hall
Name of individual from Contractor notified: Steve Lawton
Time and method of notification: 02-09-10_18:30_Email
Name of Caltrans Engineer notified: Bill Howe
Time and method of notification: 02-10-10_14:00_Verbal
QC Inspector's Name: Zhang Wei
Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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

修改后MT
返修后MT



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-456(ZPMC-0645)
Item: Deck Panel building up 名称描述: 顶板堆焊	Item Number: 件号:	Drawing: 图号: DP515 DP518
Location: Outside Yard 位置: 外场		Date: 日期: 2010-02-25

Description of Nonconformance:

During CT random visual inspection of OBG 6E & 6W, CT inspector observe the following issues:

- ZPMC personnel are performing weld build up of the deck panel edge (DP515A & DP518A) by buttering. These edges are to be aligned adjacent to the CB6 deck panel for the bolted splice connection. The welding procedure was being performed without the prior Engineer's approval. Furthermore, ZPMC personnel did not follow the repair procedure noted in B-WR10561.
- Bevel angle noted in "Drawing 1" in the disposition of the WR10561 was not observed during the welding.
- The type and percentage of NDT inspection to be performed is not known as it is not specified clearly in note 6 of the disposition in WR10561. Furthermore, it is noted that the drawing do not have a specified weld detail or NDT requirement at this location.
- ZPMC welder performed FCAW of this edge with many times of stop and restart passes without cleaning the "crater area" of the weld prior to resuming the welding process.
- The segment are identified as 6CE & 6CW

加州在对 6E 和 6W 的随机检查中发现如下问题:

- ZPMC 在对顶板 (DP515A & DP518A) 边缘进行堆焊。这些位置位于 CB6 与顶板的螺栓连接位置。该焊接工艺未得到工程师批准。另外, ZPMC 的返修工艺也没有按照 B-WR10561 的要求操作。
- B-WR10561 "图 1" 中的坡口在焊接过程中没有得到执行
- NDT 种类和抽检率没有详细规定出。另外, 这种位置的 NDT 细节也没有相关规定。
- ZPMC 焊工在焊接过程中, 多次停顿并重新起焊, 而且在焊口位置没有进行清理旧继续施焊。
- 这些板用于 6CE 和 6CW。

Work By:	Prepared by:	Reviewed by QCE:
施工方:	准备: 2/25/10	质量工程师批准: 02/25/10
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input checked="" type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

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

Recommendation:
建议:

Prepared by: _____	Approved by QCA: _____
准备	质量经理批准

Reason for Nonconformance:

不符合原因:

由于堆焊时该焊接工艺未得到工程部门批准
weld technology didn't approved by engineer and repair without
经过修时未按照要求操作。
according to requirement.

Prevention of Re-occurrence:

预防措施:

加强现场监控和检查
Enhance supervision and inspection on-site.

Approved by/批准: Gao Jun 2.27

Technical Justification for Use-As-Is/Repair:

回用或返修的技术依据:

Attachment

附件

Non-attachment

无附件

Reviewed /批准: _____

Verification:

确认:

Acceptable

可接受

Unacceptable

不可接受

Gu rong jian

07120671

2010.3.21

Verified by QCI/质检确认: _____

Reviewed by QCA/质检主任审核: _____



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	6CE, 6CW	报告编号 Report No.	B-WR10672
合同号 Contract No.:	04-0120F4	部件名称 Items Name	箱梁6CE、6CW与联系梁 对接处端口顶板Box 6C E、6CW and strut plate butt weld	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

检查发现箱梁6CE、6CW与联系梁对接处,其顶板端口因孔边距不足,需堆焊处理。见附图:

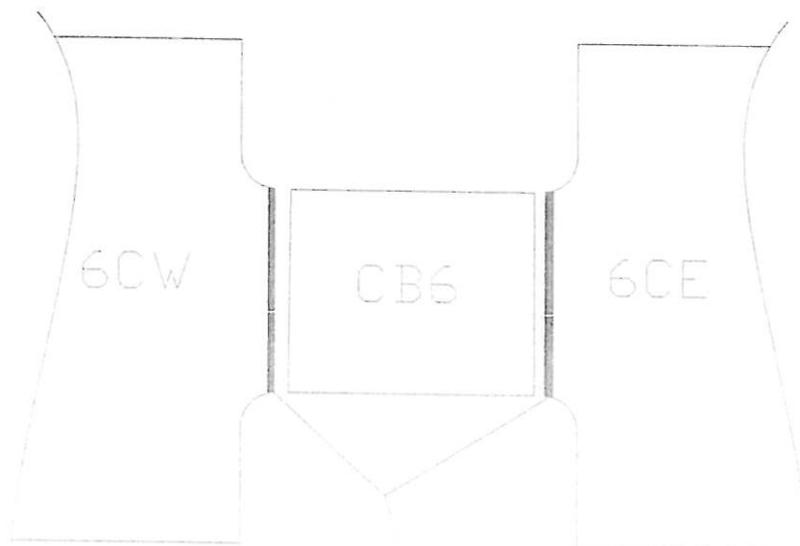
After inspection box 6CE and 6CW and strut plate butt weld, the hole distance size wasn't enough and needed to build up. The detail sees following draft.

cheng jinling 10.02.02

检验员 (Inspector): cheng jinling 日期(Date): 10.02.02

焊缝返修位置示意图:

Draft of welding discontinuity:



此两处需要堆焊

产生原因:

Caused:

焊接变形和制造误差。

Weld distortion and fabricate error.

车间负责人(Foreman):

Gas Jun 日期(Date) 2015.02.02

处理意见

Disposition:

1. 将要修补的区域打磨光滑;
2. 准备一个正确的接头形式, 具体参见返修的WPS;
3. 做100%VT和100%MT, 并贴陶瓷衬垫, 具体参见AWS D1.5.3.13;
4. 根据返修的焊接返修工艺规程(WPS)进行预热及焊接;
5. 待返修堆焊至满足孔边要求 ($L=1.75d$, d 为螺栓直径)后去除陶瓷衬垫, 并将焊缝打磨至与邻边母材平齐;
6. 根据图纸要求对返修区域进行相应NDT检测;

1. Grind the edge of the repair area cleanly;
2. Prepare an right joint according to the approved WPS;
3. Perform 100%VT and 100%MT, and add ceramic backing according to AWS D1.5.3.13;
4. Preheat and weld according to the approved repair WPS;
5. Gouge off the ceramic backing after the hole distance meet the requirement ($L=1.75d$, d : dia meter of bolt used herein) and then grind the weld flush with adjacent base metal after welding;
6. Perform relevant NDT inspection to the repair area according to working drawings.

工艺:
Technical engineer

He Xiaolin
2015.02.02

审核:
Approved by

日期
Date



焊缝返修报告

Welding Repair Report

版本 Rev. No.

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	6CE、6CW	报告编号 Report No.	B-WR10672
合同号 Contract No.:	04-0120F4	部件名称 Items Name	箱梁6CE、6CW与联系 梁对接处端口顶板Box 6CE、6CW and strut plate butt weld	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

加强焊接过程中的监控, 减少误差。

Enhance supervision in process of welding to reduce error.

车间负责人(Foreman)

Gao Jun

日期(Date):

2010.02.02

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-Repair WPS-345-FCAW-1 G(1F)-Repair-1	工艺员 technologist	He Xiadin 2010.02.02
返修(碳刨)前预热温度 Preheat temperature before gouging	87°C	返修的缺陷 Description of discontinuity	36道超尺寸
焊前处理检查 Inspection before welding	OK	焊前预热温度 Preheat temperature before welding	149°C
最大碳刨深度 Max. depth of gouging	NA	碳刨总长 Total length of gouging	NA
焊工 welder	220066	焊接类型 welding type	FCAW
焊接电流 Current	330	焊接电压 Voltage	30
		焊接位置 position	1G
		焊接速度 Speed	300

返修后检查
Inspection After repairing:

外观检查 VT result	A	检验员 Inspector	日期 Date
			2010.02.15
NDT复检 NDT result	MT 17 Apr	探伤员 NDT person	日期 Date
		Wang Wen Tang Jinghua	2010.03.13 2010.03.13

见证:
Witness/Review:备注:
Remark:

#R787-QCP-900



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-11544 DATE 2010.03.14 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: DECK PLATE DRAWING NO.: DP515A/518A CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 NA NA Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345T2 -X 20mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	Reference Level 参考灵敏度		20dB	

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

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									a	b	c	d	Length 长度			Sound Path 声程
PL838A		70				32									ACC.	100%
		0				22									ACC.	100%
PL843A		70				32									ACC.	100%
		0				22									ACC.	100%
BLANK																

EXAMINED BY 主探
Tauf Ding Shun / 10.3.14
 LEVEL - II SIGN / DATE

REVIEWED BY 审核
Pat Greysky / 10.3.14
 LEVEL - II SIGN / DATE

质量经理 / QCM

 签字 SIGN / 日期 DATE

用户CUSTOMER

 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-000593**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0645**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: 09-Feb-2010**Description of Non-Conformance:**

During random in process observation of the trial assembly of OBG Lifts 6E and 6W, this Quality Assurance Inspector discovered the following issues:

- ZPMC personnel are performing weld build up of the deck panel edge (DP515A and DP518A) by buttering. These edges are to be aligned adjacent to the CrossBeam6 deck panel for the bolted splice connection. The welding procedure was being performed without the prior Engineer's approval. Furthermore, ZPMC personnel did not follow the repair procedures noted in their internal documentation, weld repair report (B-WR 10561).
- Bevel angle noted in "drawing 1" in the disposition of the B-WR 10561 was not observed during the welding operation.
- The type and percentage of NDT inspection to be performed is not known as it is not specified clearly in note 6 of the disposition in B-WR 10561. Furthermore, it is noted that the working drawings do not have a specified weld detail or NDT requirement at this location.
- ZPMC welder performed FCAW of this edge with many times of stop and restart passes without cleaning the "crater area" of the weld prior to resuming the welding process.
- The segments are identified as 6CE and 6CW.
- The deck panels are identified as DP518A on the east line and DP515A on the west line.

Contractor's proposal to correct the problem:

Perform NDT required to verify quality of additional base metal.

Corrective action taken:

Contractor supplied NDT documentation verifying additional base metal conforms with Contract weld quality specifications. An internal NCR was issued by the Contractor in regards to this issue.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?**

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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.

Inspected By:	Simonis,Jim	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer
