

**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-000709**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0676**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> Segment 9DE Edge Panel
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b> Missed UT Indications by QC	

**Reference Description:** Missed UT indications by QC on Segment 9DE: Edge Plate to Deck Plate weld and Edge Plate Stiffener to FL3 weld

**Description of Non-Conformance:**

During the Quality Assurance (QA) Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Segment 9DE, this QA Inspector discovered the following issues:

- Two (2) longitudinal linear indications measuring approximately 310mm and 30mm in length.
- The indications dBs rating are +6 and +4.
- Material thickness is 18mm.
- The depth of the indications is approximately 11mm and 13mm.
- The welds are identified as SEG056\*-045 at Panel Point (PP) PP81.5 and EP148-022 at PP 81.
- The welds are designated as Seismic Performance Critical Material (SPCM).
- The indications are clearly marked on or near the weld.
- The Y distance for the indications are 50 mm from PP81.5 and 0 mm from EP148A.
- Weld SEG056\*-045 is a Complete Joint Penetration (CJP) Corner joint, joining the Edge Plate PL1336C (SPCM) to Deck Plate PL1314A (Non SPCM).
- Weld EP148-022 is a Complete Joint Penetration (CJP) "T" joint, joining the Edge Plate stiffener RS89F (Non SPCM) to FB24A plate PLX24D (SPCM).
- Segment 9DE is located outside of Paint shop.

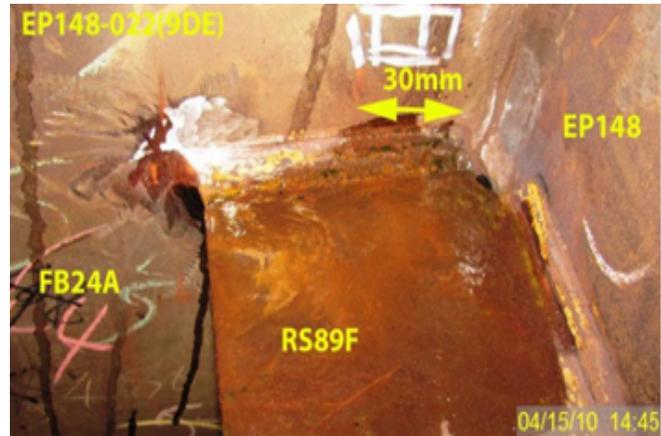
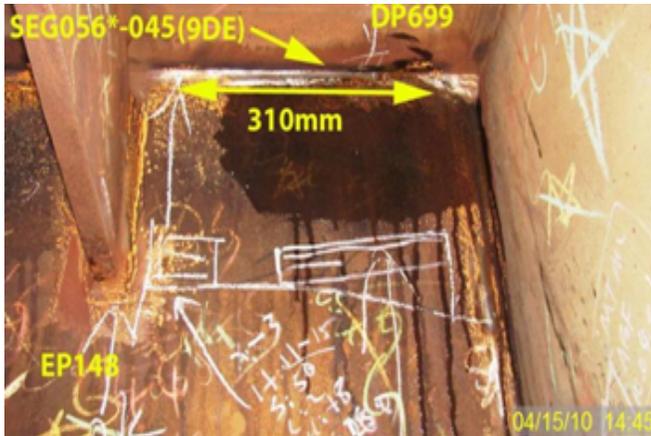
The Notice of Witness Inspection (NWIT) No. is 005523. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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### Applicable reference:

AWS D1.5-02 Section 6; Table 6.3 specifies a class “A” indication as having a rating of 10dBs and under for material thicknesses 8mm through 20mm.

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.”

**Who discovered the problem:** Subhasis Bera

**Name of individual from Contractor notified:** Wang Heng

**Time and method of notification:** 1500 hours, 04-15-10, Verbal

**Name of Caltrans Engineer notified:** Stanley Ku

**Time and method of notification:** 0830 hours, 04-16-10, Verbal

**QC Inspector's Name:** Wang Lu

**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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<b>Inspected By:</b>	Tsang, Eric	SMR
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<b>Reviewed By:</b>	Wahbeh, Mazen	SMR
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**DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge**  
 666 Feng Bin Road Room 708, Changxing Island  
 Shanghai 201913 PR China  
 Tel: 510-376-8234 Fax:

**NON-CONFORMANCE REPORT TRANSMITTAL**

<b>To:</b>	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	<b>Date:</b>	16-Apr-2010
<b>Dear:</b>	Mr. Charles Kanapicki	<b>Contract No:</b>	04-0120F4 04-SF-80-13.2 / 13.9
<b>Attention:</b>	Mr. Thomas Nilsson Project/Fabrication Manager	<b>Job Name:</b>	SAS Superstructure
<b>Subject:</b>	NCR No. ZPMC-0676	<b>Document No:</b>	05.03.06-000666

**Reference Description:** Missed UT indications by QC on Segment 9DE: Edge Plate to Deck Plate weld and Edge Plate Stiffener to FL3 weld

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:** 09

**Remarks:**

- During the Quality Assurance (QA) Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Segment 9DE, this QA Inspector discovered the following issues:
- Two (2) longitudinal linear indications measuring approximately 310mm and 30mm in length.
  - The indications dBs rating are +6 and +4.
  - Material thickness is 18mm.
  - The depth of the indications is approximately 11mm and 13mm.
  - The welds are identified as SEG056\*-045 at Panel Point (PP) PP81.5 and EP148-022 at PP 81.
  - The welds are designated as Seismic Performance Critical Material (SPCM).
  - The indications are clearly marked on or near the weld.
  - The Y distance for the indications are 50 mm from PP81.5 and 0 mm from EP148A.
  - Weld SEG056\*-045 is a Complete Joint Penetration (CJP) Corner joint, joining the Edge Plate PL1336C(SPCM) to Deck Plate PL1314A (Non SPCM).
  - Weld EP148-022 is a Complete Joint Penetration (CJP) "T" joint, joining the Edge Plate stiffener RS89F (Non SPCM) to FB24A plate PLX24D (SPCM).
  - Segment 9DE is located outside of Paint shop.

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

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

**Transmitted by:** Stanley Ku Sr. Bridge Engineer  
**Attachments:** ZPMC-0676

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# NCT

( *Continued Page 2 of 2* )

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**cc:** Rick Morrow, Gary Pursell, Peter Siegenthaler, Jason Tom, Bill Casey

**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000666

**Subject:** NCR No. ZPMC-0676

**Dated:** 21-May-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000671 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** ZPMC has repaired the missed indications and has performed the NDT after to show that the welds are acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC has repaired the missed indications and has performed the NDT after to show that the welds are acceptable. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000671R00;

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**Caltrans' comments:**

**Status:** CLO

**Date:** 25-May-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0676 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 25-May-2010



No. B-765

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-5-21**

**REGARDING: NCR-000709(ZPMC-0676)**

ZPMC is providing the NDT records show the indications have been removed and repaired and the welds are now acceptable. Based on this, ZPMC is requesting closure of this NCR.

**ATTACHMENT:**

NCR-000709(ZPMC-0676)

B787-UT-12343 R1

B787-UT-12342 R1

A handwritten signature in black ink, appearing to be "Ly" followed by a stylized flourish.

5/21/10



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge  
666 Fong Bin Road Room 700, Changxing Island  
Shanghai 201913 PR China  
Tel: 510-376-8234 Fax:

## NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV  
375 BURMA ROAD  
OAKLAND CA 95607

Date: 16-Apr-2010

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

Job Name: SAS Superstructure

Document No: 05.03.06-000666

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0676

Reference Description: Missed UT indications by QC on Segment 9DE: Edge Plate to Deck Plate weld and Edge Plate Stiffener to FL3 weld

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: 09

### Remarks:

During the Quality Assurance (QA) Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Segment 9DE, this QA Inspector discovered the following issues:

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- Segment 9DE is located outside of Paint shop.

### Action Required and/or Action Taken:

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

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0676

02.02.15.04  
NCT-05.03.06-000666,NCT

Received  
NCT-000666 19 Apr 10 Page 1 of 2

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NCT

*( Continued Page 2 of 2 )*

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cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Jason Tom, Bill Casey

File: 05.03.06

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

Bay Area Branch  
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(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4City: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. ChinaReport No: NCR-000709Prime Contractor: American Bridge/Fluor Enterprises, a JVDate: 15-Apr-2010Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing IslandNCR #: ZPMC-0676

### Type of problem:

Welding  Concrete  Other   
 Welding  Curing  Procedural  Bridge No: 34-0006  
 Joint fit-up  Coating  Other  Component: Segment 9DE Edge Panel  
 Procedural  Procedural  Description: Missed UT Indications by QC

Reference Description: Missed UT indications by QC on Segment 9DE: Edge Plate to Deck Plate weld and Edge Plate Stiffener to FL3 weld

### Description of Non-Conformance:

During the Quality Assurance (QA) Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Segment 9DE, this QA Inspector discovered the following issues:

- Two (2) longitudinal linear indications measuring approximately 310mm and 30mm in length.
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- Segment 9DE is located outside of Paint shop.

The Notice of Witness Inspection (NWIT) No. is 005523. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



**Applicable reference:**

AWS D1.5-02 Section 6; Table 6.3 specifies a class "A" indication as having a rating of 10dBs and under for material thicknesses 8mm through 20mm.

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."

Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Wang Heng

Time and method of notification: 1500 hours, 04-15-10, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 0830 hours, 04-16-10, Verbal

QC Inspector's Name: Wang Lu

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



# REPORT OF ULTRASONIC EXAMINATION

## UT探伤报告

REPORT NO. 报告编号 B787-UT-12343R1      DATE 2010.05.05      PAGE 1 OF 1      Revision No: 0

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

ITEMS NAME: 9DE WEB AND DECK PLATE SPLICE      DRAWING NO.: SEG056\*      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  
 SMAW      T-JOINT      Dec. 28<sup>ST</sup>, 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 IIV BLOCK TYPE II      C.M.C      A709M-345T2-X      14/20mm

### 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 探伤角度	FROM FACE 检测面	LEG (枚数)	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	Depth from Surface 埋藏深度	From X 距X	From Y 距Y			
SEG056*-045	1R1	70				32									ACC.	100%

AFTER B-WR12121

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EXAMINED BY 主探 WELCHAO 20/0.05.05      REVIEWED BY 审核 Huang jing 20/0.05.05  
 LEVEL-II SIGN / DATE      LEVEL-II SIGN / DATE

质量经理 / QCM      用户CUSTOMER

签字 SIGN / 日期 DATE      签字 SIGN / 日期 DATE



# REPORT OF ULTRASONIC EXAMINATION

## UT探伤报告

REPORT NO. 报告编号 B787-UT-12342R1      DATE 2010.05.15      PAGE 1 OF 1      Revision No: 0

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

ITEMS NAME: 9DE CORNER ASSEMBLY WEB PLATE      DRAWING NO.: EP148      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  
 SMAW      T-JOINT      Dec. 28<sup>ST</sup>, 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 IIV BLOCK TYPE II      C.M.C      A709M-345T2-X      18mm

### 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
EP148-001-022	1R1	70				32									ACC.	100%

AFTER B-WR12120

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EXAMINED BY 主探 <i>Wang Jing</i> 2010.05.15 LEVEL - I SIGN / DATE	REVIEWED BY 审核 <i>Wichao</i> 2010.05.15 LEVEL - II SIGN / DATE
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质量经理 / QCM  签字 SIGN / 日期 DATE	用户CUSTOMER  签字 SIGN / 日期 DATE
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**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


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**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**


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**Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000666**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0676**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:** 15-Apr-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) Segment 9DE, this QA Inspector discovered the following issues:

- Two (2) longitudinal linear indications measuring approximately 310mm and 30mm in length.
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- Segment 9DE is located outside of Paint shop.

The Notice of Witness Inspection (NWIT) No. is 005523. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform hundred (100%) percent UT inspection of this weld.

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

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

**Corrective action taken:**

Contractor submitted post repair NDT report verifying the weld is now in conformance with Contract weld quality requirements.

**Did corrective action require Engineer's approval?**

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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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 , who represents the Office of Structural Materials for your project.

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**Inspected By:**    Simonis,Jim

Quality Assurance Inspector

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**Reviewed By:**    Wahbeh,Mazen

QA Reviewer