

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-000732

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 12-May-2010

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

NCR #: ZPMC-0695

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: West Tower Lift 3
Procedural	Procedural	Description:	

Reference Description: Removal of Improperly Fit Members Without Notifying Engineer

Description of Non-Conformance:

During random in process verification of West Tower lift 3, Catltrans Quality Assurance (QA) discovered the following issues:

- The welded end cap plate of B/C and C/D corner diagonal stiffener of West Tower lift 3 (top) has been removed by thermal cutting without notifying the engineer.
- As per AWS D1.5, section 3.7.5; The Engineer shall be notified before improperly fitted and welded members are cut apart.
- The green tag has been previously issued for this member.
- The members are located in Bay 11.



Applicable reference:

AWS D1.5 (02) Section 3.7.4: "The Engineer shall be notified before improperly fitted and welded members are cut apart."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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: You Yuan Mao
Time and method of notification: 1330, 05/12/10, Verbal
Name of Caltrans Engineer notified: Ken Lee
Time and method of notification: 800, 05/13/10, Verbal
QC Inspector's Name: Zhang Jiadi
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: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 14-May-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-0695

Job Name: SAS Superstructure
Document No: 05.03.06-000690

Reference Description: Removal of Improperly Fit Members Without Notifying Engineer/ Tower/ West Lift 3

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:** 03

Remarks:

During random in process verification of West Tower lift 3, Caltrans Quality Assurance (QA) discovered the following issues:

- The welded end cap plate of B/C and C/D corner diagonal stiffener of West Tower lift 3 (top) has been removed by thermal cutting without notifying the engineer.
- As per AWS D1.5, section 3.7.5; The Engineer shall be notified before improperly fitted and welded members are cut apart.
- The green tag has been previously issued for this member.
- The members are located in Bay 11.

AWS D1.5 (02) Section 3.7.5: "The Engineer shall be notified before improperly fitted and welded members are cut apart." (Please note that the applicable spec was mistakenly quoted as Section 3.7.4. The correct section in AWS D1.5 should be Section 3.7.5)

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 welds 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 and the NDT results.

In addition to the material/workmanship non-conformance, address the failure by Quality Control in proceeding with work without prior notification to the Engineer. Provide documentation of the steps/actions taken by Production and Quality Control to prevent future occurrences.

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

NCT

(Continued Page 2 of 2)

Transmitted by: Ken Lee Transportation Engineer

Attachments: ZPMC-0695

cc: Rick Morrow, Gary Pursell, 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: 05.03.06-000690

Subject: NCR No. ZPMC-0695

Dated: 11-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000695 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will provide NDT to show that after the member was rewelded it was acceptable. This issue has been addressed by ZPMC's QA and Production crews to prevent this issue.

ZPMC will provide NDT to show that after the member was rewelded it was acceptable. This issue has been addressed by ZPMC's QA and Production crews to prevent this issue. As this does not appear to be a consistent issue, ZPMC believes that these steps will correct the issue. Based on this proposal ZPMC requests that this NCR be approved, with actions pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000695R00

Caltrans' comments:

Status: AAP

Date: 13-Jun-2010

This proposed resolution is accepted with action pending. However in addition to submitting the NDT results for review and approval, also provide the welding repair procedure utilized.

Submitted by: Rizzardo, Gina

Attachment(s):

Date: 13-Jun-2010

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000690

Subject: NCR No. ZPMC-0695

Dated: 30-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000695 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the documents of the repair documented in the NCR and subsequent NDT to show the areas are acceptable.

ZPMC is providing the documents of the repair documented in the NCR and subsequent NDT to show the areas are acceptable. ZPMC understand that Engineer approval is required in this situation and has educated the production team in question to reinforce this. As this is not a consistent issue in the Tower, ZPMC QA is confident that this action will stop this issue from recurring. Based in this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000695R01;

Caltrans' comments:

Status: CLO

Date: 01-Jul-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0695 is closed.

Submitted by: Rizzardo, Gina

Date: 01-Jul-2010

Attachment(s):



No. T-147

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-6-29

REGARDING: NCR-000732(ZPMC-0695)

ZPMC received NCR-000732(ZPMC-0695), it mentioned that CT inspector discovered ZPMC remove cap plate of B/C and C/D corner diagonal stiffener of West Tower Lift 3 without notifying engineer.

ZPMC acknowledged this problem and already inculcated related work team and charger also will enhance their management, in the future, they come to an agreement, it must be informed to the engineer before any component removal and this won't appear to be a consistent issue. Per ABF-NPR-000695 Rev. 00, here ZPMC attached NDT and WPS utilized documents proving the welds sound at last.

So ZPMC hope CT could take a review and close this NCR.

ATTACHMENT:

NCR-000747(ZPMC-0710)

T787-MT-9763

WPS-B-T-2132

WPS-B-T-2133

Zhang Hado
2010. 6. 29



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 14-May-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: 05.03.06-000690

Subject: NCR No. ZPMC-0695

Reference Description: Removal of Improperly Fit Members Without Notifying Engineer/ Tower/ West Lift 3

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:** 03

Remarks:

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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 welds 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 and the NDT results.

In addition to the material/workmanship non-conformance, address the failure by Quality Control in proceeding with work without prior notification to the Engineer. Provide documentation of the steps/actions taken by Production and Quality Control to prevent future occurrences.

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

02.02:15.04
NCT 05.03.06-000690,NCT

Received
NCT-000690 21 Jan 10 Page 1 of 2

NCT

(Continued Page 2 of 2)

Transmitted by: Ken Lee Transportation Engineer

Attachments: ZPMC-0695

cc: Rick Morrow, Gary Pursell, Mark Woods

File: 05.03.06

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

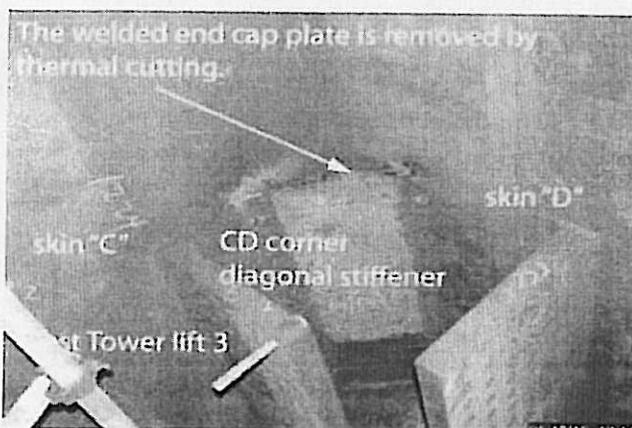


Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000732**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0695**Type of problem:**Welding Concrete Other Welding Curing Procedural **Bridge No:** 34-0006Joint fit-up Coating Other **Component:** West Tower Lift 3Procedural Procedural Description:**Reference Description:** Removal of Improperly Fit Members Without Notifying Engineer**Description of Non-Conformance:**

During random in process verification of West Tower lift 3, Catltrans Quality Assurance (QA) discovered the following issues:

- The welded end cap plate of B/C and C/D corner diagonal stiffener of West Tower lift 3 (top) has been removed by thermal cutting without notifying the engineer.
- As per AWS D1.5, section 3.7.5; The Engineer shall be notified before improperly fitted and welded members are cut apart.
- The green tag has been previously issued for this member.
- The members are located in Bay 11.

**Applicable reference:**

AWS D1.5 (02) Section 3.7.4: "The Engineer shall be notified before improperly fitted and welded members are cut apart."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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: You Yuan Mao
Time and method of notification: 1330, 05/12/10, Verbal
Name of Caltrans Engineer notified: Ken Lee
Time and method of notification: 800, 05/13/10, Verbal
QC Inspector's Name: Zhang Jiadi
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



焊接工艺规程 B*
WELDING PROCEDURE SPECIFICATION

编号 No. WPS-B-T-2132
有效期 Period of validity
FCM :2007.1~2010.1
NON-FCM :2007.1~2012.1

母材技术条件 (Material specification) ASTM A.709M Gr.345F2
 焊接方法 (Welding process) 药芯焊丝 CO2 气体保护焊(FCAW)
 手工或机械 (Manual or machine or semi-auto) 半自动(Semi-auto)
 焊接位置 (Position of welding) 横角焊(2F)
 填充金属技术条件 (Filler metal specification)- AWS A5.20 填充金属级别 (Filler metal classification) E71T-1
 填充金属牌号 (Filler metal brand) Supercored 71H (Φ1.4)
 焊剂 (Flux) N/A
 保护气体 (Shielding gas) 100%CO2 流率 (Flow rate) 18~25L/min
 单焊道或多焊道 (Single or multiple pass) 多道(Multiple Pass)
 单弧或多弧 (Single or multiple arc) 单弧(Single arc)
 焊接电流 (Welding current) 直流(DC) 极性 (Polarity) 反接(EP)
 焊丝伸出长度 (Electrode extension) 20mm
 焊接方向 (Welding progression) N/A
 根部处理 (Root treatment) N/A
 最低预热和道间温度 (Preheat and interpass temperature Min)
 非断裂危险(NON-FCM) 10°C [T≤20mm] 20°C [20mm<T≤40mm] 65°C [40mm<T≤60mm] 110°C [60mm<T]
 断裂危险(FCM) 60°C [T≤20mm] 100°C [20mm<T≤40mm] 120°C [40mm<T≤60mm] 160°C [60mm<T]
 最高预热和道间温度 (Preheat and interpass temperature Max) 230°C
 后热温度(Postheat temperature) N/A
 热输入 (线能量) (Heat input) 最小(Min) 1.54KJ/mm
 最大单道角焊缝尺寸 (Maximum size of single pass) 7mm
 最小多道角焊缝尺寸 (Minimum size of multiple pass) 10.5mm

APPROVED
 APPROVED AS NOTED
 NOT APPROVED

Pursuant to Section 5-1.02 of the Standard Specifications of the State of California
 DEPARTMENT OF TRANSPORTATION

Signed Sean Eason for Rick Murren
 Structure Representative

Date 10/25/2007

焊接工艺
(Welding procedure)

焊道序号 Pass No.	焊条(丝)规格 Electrode Size (mm)	焊接电流 Welding Current		焊接速度 Travel Speed (mm/min)	接头详图 Joint Detail
		安培 Amp(s)	伏特 Volts		
1~n	1.4	280~350	28~32.5	182.6~442.4	T1=T2=3~∞mm R=0~2mm

选定适用的电流、电压后在 WPS 焊接参数选用表中查到焊接速度范围。
 Refer to WPS parameters table to determine operating parameter to stay within the heat input limit.

该工艺可以因制造工序、装配、焊道尺寸等而变化,但应在 AASHTO/AWS D1.5 第 5 章给出的变量限值之内。
 (This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variable given in Section 5.)

修订号 (Revision No.) 2
 工艺评定记录编号 (PQR No.) HP2006107-10/HP2006111
 * 本 WPS 符合 AASHTO/AWS D1.5 2002, 用于桥梁结构。
 (This WPS is conformable with the current edition of AASHTO/AWS D1.5 2002. used for BRIDGE structure.)

批准 (Authorized by) [Signature]
 日期 (Date) 2007-8-10



焊接参数选用表 B*
SELECTED LIST OF WELDING
PARAMETER

编号 No.
WPS-B-T-2132

PQR 编号: HP2006107-10
PQR No.

根据 5.12 最大热输入评定的 WPS
For WPS qualified to 5.12 For Maximum Heat Input

	电流 Amps	电压 Volts	焊接速度 Travel Speed (mm/min)	热输入 Heat Input (KJ/mm)						
平均值 Average	345.0	32.3	260.2	2.57						
最大值 Maximum	350.0	32.5								
范围 Range										
最大值 Maximum	350.0	32.5		2.57						
最小值 Minimum	280.0	28.0		1.54						

经过评定合格的 WPS 焊接参数选用表
WPS Parameters Table

电压 Volts	电流 Amps									
	280.0		290.5		315.0		332.5		350.0	
28.0	182.6	304.4	194.1	323.4	205.5	342.4	216.9	361.5	228.3	380.5
29.1	190.1	316.8	202.0	336.6	213.8	356.4	225.7	376.2	237.6	396.0
29.5	192.6	320.9	204.6	341.0	216.6	361.0	228.7	381.1	240.7	401.1
31.4	204.9	341.6	217.7	362.9	230.6	384.3	243.4	405.6	256.2	427.0
32.5	212.4	354.0	225.6	376.1	238.9	398.2	252.2	420.3	265.5	442.4

焊接速度 Travel Speed in mm/min

选用示例: 如选用 315A 和 29.1V, 在表中纵横相交查到的焊接速度范围为 213.8~356.4mm/min.
EX.: 315A X 29.1V X Travel speed Range 213.8~356.4mm/min.

- APPROVED
- APPROVED AS NOTED
- NOT APPROVED

Pursuant to Section 5-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION

Signed Sean Egan for Rick Harman
Structure Representative

批准(Authorized By):

日期(Date):

2007-8-10

Date 10/25/2007



焊接工艺规程 B*
WELDING PROCEDURE SPECIFICATION

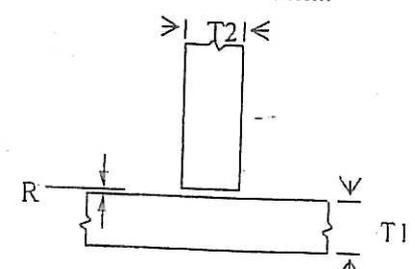
编号 No.
WPS-B-T-2133
有效期 Period of validity
FCM :2007.1~2010.1
NON-FCM :2007.1~2012.1

母材技术条件 (Material specification) ASTM A.709M Gr.345F2
 焊接方法 (Welding process) 药芯焊丝 CO2 气体保护焊(FCAW)
 手工或机械 (Manual or machine or semi-auto) 半自动(Semi-auto)
 焊接位置 (Position of welding) 立角焊(3F)
 填充金属技术条件 (Filler metal specification) AWS A5.20 填充金属级别 (Filler metal classification) E71T-1
 填充金属牌号 (Filler metal brand) Supercored 71H (Φ1.4)
 焊剂 (Flux) N/A
 保护气体 (Shielding gas) 100%CO2 流率 (Flow rate) 18~25L/min
 单焊道或多焊道 (Single or multiple pass) 多道(Multiple Pass)
 单弧或多弧 (Single or multiple arc) 单弧(Single arc)
 焊接电流 (Welding current) 直流(DC) 极性 (Polarity) 反接(EP)
 焊丝伸出长度 (Electrode extension) 20mm
 焊接方向 (Welding progression) 向上立焊 (Vertical-up direction)
 根部处理 (Root treatment) N/A
 最低预热和道间温度 (Preheat and interpass temperature Min)
 非断裂危险(NON-FCM) 10°C [T≤20mm] 20°C [20mm<T≤40mm] 65°C [40mm<T≤60mm] 110°C [60mm<T]
 断裂危险(FCM) 40°C [T≤20mm] 65°C [20mm<T≤40mm] 100°C [40mm<T≤60mm] 140°C [60mm<T]
 最高预热和道间温度 (Preheat and interpass temperature Max) 230°C
 后热温度(Postheat temperature) N/A
 热输入 (线能量) (Heat input) 最小(Min) 1.94KJ/mm
 最大单道角焊缝尺寸 (Maximum size of single pass) 9mm
 最小多道角焊缝尺寸 (Minimum size of multiple pass) 11mm

焊接工艺
(Welding procedure)

NOT APPROVED
 Pursuant to Section 5-1.02
 of the Standard Specifications
 State of California
 DEPARTMENT OF TRANSPORTATION
 Signed Sam Ecker Sr. Rick Morrison
 Structure Representative

Date 10/25/2007

焊道序号 Pass No.	焊条(丝)规格 Electrode Size (mm)	焊接电流 Welding Current		焊接速度 Travel Speed (mm/min)	接头详图 Joint Detail
		安培 Amp(s)	伏 特 Volts		
1~n	1.4	182.6~223.2	23.9~27.5	101.6~124.2	T1=T2=3~∞ mm R=0~2mm 

选定适用的电流、电压后在 WPS 焊接参数选用表中查到焊接速度范围。
 Refer to WPS parameters table to determine operating parameter to stay within the heat input limit.

该工艺可以因制造工序、装配、焊道尺寸等而变化, 但应在 AASHTO/AWS D1.5 第 5 章给出的变量限值之内。
 (This procedure may vary due to fabrication sequence, fit-up, pass size, etc., within the limitation of variable given in section 5.)
 修订号(Revision No.) 2
 工艺评定记录编号(PQR No.) HP2006118/HP2006112
 * 本 WPS 符合 AASHTO/AWS D1.5 2002, 用于桥梁结构。
 (This WPS is conformable with the current edition of AASHTO/AWS D1.5 2002 used for BRIDGE...)
 批准(Authorized by) [Signature]
 日期(Date) 2007.8.10



焊接参数选用表 B*
SELECTED LIST OF WELDING
PARAMETER

编号 No.
WPS-B-T-2133

PQR 编号: HP2006118
PQR No.

根据 5.13 评定的关于 FCAW 的 WPS
For WPS qualified to 5.13 For FCAW

	电流 Amps	电压 Volts	焊接速度	热输入						
			Travel Speed (mm/min)	Heat Input (KJ/mm)						
平均值 Average	202.9	25.7	112.9	2.77						
范围 Range										
最大值 Maximum	223.2	27.5	124.2	3.05						
最小值 Minimum	182.6	23.9	101.6	1.94						

经过评定合格的 WPS 焊接参数选用表
WPS Parameters Table

电压 Volts	电流 Amps									
	182.6		192.7		202.9		213.0		223.2	
23.9	101.6	124.2	101.6	124.2	101.6	124.2	101.6	124.2	105.0	124.2
24.8	101.6	124.2	101.6	124.2	101.6	124.2	104.0	124.2	109.0	124.2
25.1	101.6	124.2	101.6	124.2	101.6	124.2	105.3	124.2	110.3	124.2
26.6	101.6	124.2	101.6	124.2	106.3	124.2	111.6	124.2	116.9	124.2
27.5	101.6	124.2	104.4	124.2	109.9	124.2	115.3	124.2	120.8	124.2

焊接速度 Travel Speed in mm/min

*用示例: 如选用 202.9A 和 26.6V, 在表中纵横相交查到的焊接速度范围为 106.3~124.2mm/min.
EX.: 202.9A X 26.6V X Travel speed Range 106.3~124.2mm/min.

- APPROVED
- APPROVED AS NOTED
- NOT APPROVED

Pursuant to Section 5-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION

Signed Sean Egan for Rick
Structure Representative

Date 10/25/2007

批准(Authorized By):

日期(Date): 2007-8-10

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-000739**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0695**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: 12-May-2010**Description of Non-Conformance:**

During random in process verification of West Tower lift 3, Catltrans Quality Assurance (QA) discovered the following issues:

- The welded end cap plate of B/C and C/D corner diagonal stiffener of West Tower lift 3 (top) has been removed by thermal cutting without notifying the engineer.
- As per AWS D1.5, section 3.7.5; The Engineer shall be notified before improperly fitted and welded members are cut apart.
- The green tag has been previously issued for this member.
- The members are located in Bay 11.

Contractor's proposal to correct the problem:

ZPMC to provide the documents of the repair required in the NCR and subsequent NDT reports to show the areas affected comply with Contract requirements. As this is not a consistent issue in the Tower, ZPMC QA is confident that this non-conformance will not happen in future.

Corrective action taken:

ZPMC provided the NDT reports confirming the re-welded areas are acceptable. The production team and QC personnel have been educated not to allow similar incidents to happen in future.

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer