

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-000786

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 05-Jul-2010

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

NCR #: ZPMC-0748

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: A325 High Strength Bolts (M24x65)
Procedural	Procedural	Description:	

Reference Description: The Contractor used a Skidmore calibrator with an expired calibration date in verifying M24x65 bolts

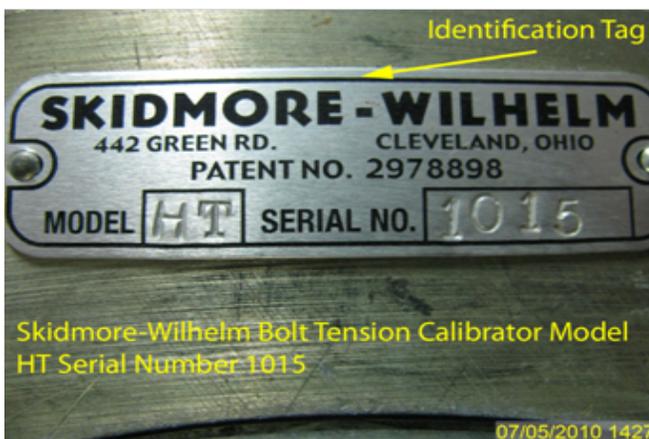
Description of Non-Conformance:

During the Quality Assurance (QA) Pre-Installation Verification of Required Tension for M24x65 high strength bolts, this QA Inspector discovered the following issues:

-The Skidmore-Wilhelm Bolt Tension Calibrator Model HT Serial Number (SN) 1015 calibration date had expired, and was being used by the Contractor in verifying M24x65 bolts (Lot number DHGM240013 and DHGM240002).

-Valid period of calibration are from June 4, 2009 through June 4, 2010.

-Calibration dates are displayed on the Bolt Tension Calibrator.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Standard Specification Section 55-3.14 Bolted Connections – “Bolt tension measuring devices and calibrated wrenches shall be calibrated within one year prior to first being used on the job, and a minimum of once each year thereafter. This calibration shall be done by a qualified independent laboratory or authorized warranty repair and calibration center recognized by the tool manufacturer.”

Who discovered the problem: Dan Hernandez

Name of individual from Contractor notified: David Wu

Time and method of notification: 1530 hours, 07-05-10, verbal

Name of Caltrans Engineer notified: Aaron Prchlik

Time and method of notification: 0700 hours, 07-06-10, verbal

QC Inspector's Name: Lay Tao

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric SMR

Reviewed By: Devey, Jim SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 06-Jul-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: 05.03.06-000744

Subject: NCR No. ZPMC-0748

Reference Description: The Contractor used a Skidmore calibrator with an expired calibration date in verifying M24x65 bolts

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:**

Remarks:

- During the Quality Assurance (QA) Pre-Installation Verification of Required Tension for M24x65 high strength bolts, this QA Inspector discovered the following issues:
- The Skidmore-Wilhelm Bolt Tension Calibrator Model HT Serial Number (SN) 1015 calibration date had expired, and was being used by the Contractor in verifying M24x65 bolts (Lot number DHGM240013 and DHGM240002).
 - Valid period of calibration are from June 4, 2009 through June 4, 2010.
 - Calibration dates are displayed on the Bolt Tension Calibrator.

See attached NCR No. ZPMC-748 for details.

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.

Transmitted by: Ching Chao

Attachments: ZPMC-0748

cc: Gary Pursell, Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000744

Subject: NCR No. ZPMC-0748

Dated: 23-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000790 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will send the Skidmore to a nationally accredited laboratory for calibration certification and provide the certification to the Department when available to close this NCR.

ZPMC will send the Skidmore to a nationally accredited laboratory for calibration certification and provide the certification to the Department when available to close this NCR. Based on this proposed course of action, ZPMC requests that this NCR be approved with action pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000790R00

Caltrans' comments:

Status: AAP

Date: 12-Oct-2010

ZPMC needs to provide certification to skidmore after calibration.

Submitted by: Woo, Laraine

Date: 12-Oct-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000744

Subject: NCR No. ZPMC-0748

Dated: 25-Oct-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000790 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has performed tension verification again of the bolts identified in the NCR with a Skidmore with a calibration date within tolerance and found the results to be acceptable

ZPMC has performed tension verification again of the bolts identified in the NCR with a Skidmore with a calibration date within tolerance and found the results to be acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000790R01;

Caltrans' comments:

Status: CLO

Date: 27-Oct-2010

The proposed resolution is acceptable. This NCR is closed.

Submitted by: Woo, Laraine

Date: 27-Oct-2010

Attachment(s):



No. B-914

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-10-20

REGARDING: NCR-000786(ZPMC-0748)

ZPMC has re-done the Minimum tension tests with a new arriving calibrated SKIDMORE. The tested results show the tension ZPMC used to verify the bolting installation is satisfying the minimum tension requirement. ZPMC is providing the tests' report for engineer's review. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000786(ZPMC-0748)

MINIMUM TENSION TEST REPORTS

Len W

10/20/2010



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 06-Jul-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: 05.03.06-000744

Subject: NCR No. ZPMC-0748

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- Non-Conformance Resolved.

Material Location: OBG

Lift:

Remarks:

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- Calibration dates are displayed on the Bolt Tension Calibrator.

See attached NCR No. ZPMC-748 for details.

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.

Transmitted by: Ching Chao

Attachments: ZPMC-0748

cc: Gary Pursell, Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000786

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 05-Jul-2010

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

NCR #: ZPMC-0748

Type of problem:

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

Bridge No: 34-0006

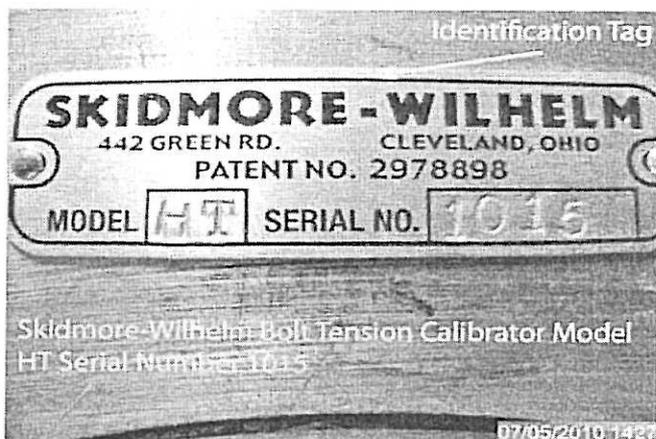
Component: A325 High Strength Bolts (M24x65)

Reference Description: The Contractor used a Skidmore calibrator with an expired calibration date in verifying M24x65 bolts

Description of Non-Conformance:

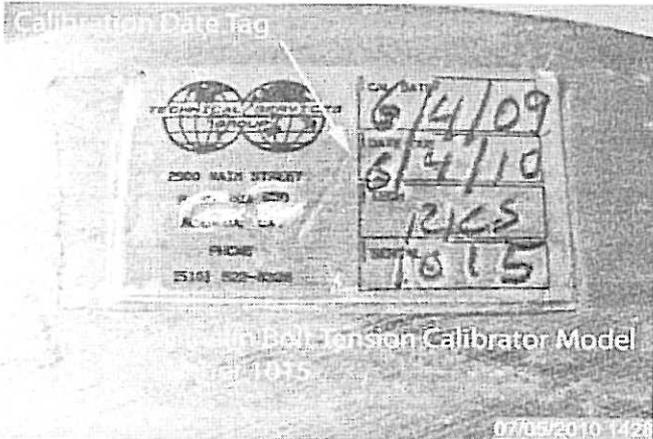
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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QC Inspector's Name: Lay Tao

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

SMR



高强度螺栓扭矩试验报告 报告编号: 240

REPORT OF HIGH STRENGTH BOLT
MINIMUM TENSION TORQUE TESTING

REPORT No.

产品名称: 美国圆塔大钻
Project

产品工号: 2006-787
Project No.

试验时间: 2010.10.19
Testing Date

试验地点: ZPMC
Testing Place

螺栓规格: M24*65 DH6M24003
Bolt Size

SKIDMORE编号: 1064
Skidmore No.

扭力扳手编号: 2#
Torque Wrench No.

试验环境: 温度: 23 °C 湿度: 56 %
Test Condition: Temperature Humidity

Rotate from bolt head

试验结果:	最小拉力扭矩		再拧紧5度扭矩	
	Minimum Tension Torque		Torque after 5 degree more	
Test Result	最小拉力	实际扭矩 (N. m)	螺栓拉力	实际扭矩 (N. m)
	Required Minimum Tension	Actual Torque	Actual tension	Torque value
试验螺栓一	KIP: <u>46</u>		KIP: <u>48</u>	<u>1200</u>
No. 1	N:		N:	
试验螺栓二	KIP: <u>46</u>		KIP: <u>47</u>	<u>960</u>
No. 2	N:		N:	
试验螺栓三	KIP: <u>46</u>		KIP: <u>51</u>	<u>800</u>
No. 3	N:		N:	
试验螺栓四	KIP: <u>46</u>		KIP: <u>50</u>	<u>1020</u>
No. 4	N:		N:	
试验螺栓五	KIP: <u>46</u>		KIP: <u>52</u>	<u>920</u>
No. 5	N:		N:	

结果
RESULT

平均扭矩:
Average torque: 965.7 N.m

试验人员: Zhang Haijun 日期: 2010.10.19 见证: B279 日期: 10/19/2010
Operator Date Witnessed by: Date



高强度螺栓扭矩试验报告 报告编号: 242

REPORT OF HIGH STRENGTH BOLT
MINIMUM TENSION TORQUE TESTING

REPORT No.

产品名称: 美国海湾大桥

产品工号: 2p06-787

Project

Project No.

试验时间: 2010.10.19

试验地点: ZPMC

Testing Date

Testing Place

螺栓规格: M24x65 DH6M 240002

SKIDMORE编号: 1014

Bolt Size

Skidmore No.

扭力扳手编号: 24

试验环境: 温度: 23 °C 湿度: 56 %

Torque Wrench No.

Test Condition: Temperature Humidity

试验结果:	最小拉力扭矩		再拧紧5度扭矩	
	Minimum Tension Torque		Torque after 5 degree more	
Test Result	最小拉力	实际扭矩 (N.m)	螺栓拉力	实际扭矩 (N.m)
	Required Minimum Tension	Actual Torque	Actual tension	Torque value
试验螺栓一	KIP: <u>46</u>		KIP: <u>52</u>	<u>1320</u>
No. 1	N:		N:	
试验螺栓二	KIP: <u>46</u>		KIP: <u>50</u>	<u>1400</u>
No. 2	N:		N:	
试验螺栓三	KIP: <u>46</u>		KIP: <u>49</u>	<u>1200</u>
No. 3	N:		N:	
试验螺栓四	KIP: <u>46</u>		KIP: <u>50</u>	<u>1250</u>
No. 4	N:		N:	
试验螺栓五	KIP: <u>46</u>		KIP: <u>52</u>	<u>1240</u>
No. 5	N:		N:	

结果

RESULT

平均扭矩:

Average torque: 1270 N.m

试验人员: Shang Haijun 日期: 2010.10.19

见证: B279 日期: 10/19/2010

Operator

Date

Witnessed by:

Date



高强度螺栓扭矩试验报告 报告编号: 241

REPORT OF HIGH STRENGTH BOLT
MINIMUM TENSION TORQUE TESTING

REPORT No.

产品名称: 美国海湾大桥
Project

产品工号: 2206-787
Project No.

试验时间: 2010.10.19
Testing Date

试验地点: ZPMC
Testing Place

螺栓规格: M24x70 DH6M240075
Bolt Size

SKIDMORE编号: 1014
Skidmore No.

扭力扳手编号: 2A
Torque Wrench No.

试验环境: 温度: 23 °C 湿度: 56 %
Test Condition: Temperature Humidity

试验结果:	最小拉力扭矩		再拧紧5度扭矩	
	Minimum Tension Torque		Torque after 5 degree more	
Test Result	最小拉力	实际扭矩 (N.m)	螺栓拉力	实际扭矩 (N.m)
	Required Minimum Tension	Actual Torque	Actual tension	Torque value
试验螺栓一	KIP: <u>46</u>		KIP: <u>48</u>	<u>880</u>
No. 1	N:		N:	
试验螺栓二	KIP: <u>46</u>		KIP: <u>51</u>	<u>1050</u>
No. 2	N:		N:	
试验螺栓三	KIP: <u>46</u>		KIP: <u>50</u>	<u>7080</u>
No. 3	N:		N:	
试验螺栓四	KIP: <u>46</u>		KIP: <u>52</u>	<u>1250</u>
No. 4	N:		N:	
试验螺栓五	KIP: <u>46</u>		KIP: <u>52</u>	<u>1200</u>
No. 5	N:		N:	

结果
RESULT

平均扭矩: 1110 N.M.
Average torque:

试验人员: hang huijun
Operator

日期: 2010.10.19
Date

见证: B279
Witnessed by:

日期: 10/19/2010
Date



高强度螺栓扭拒试验报告 报告编号: 230

REPORT OF HIGH STRENGTH BOLT
MINIMUM TENSION TORQUE TESTING

REPORT No.

产品名称: SFOBB

产品工号: 2P06-787

Project

Project No.

试验时间: 2010.6.22 15:00

试验地点: ZPMC

Testing Date

Testing Place

螺栓规格: M24X70 DH6M240075

SKIDMORE编号: 1015

Bolt Size

Skidmore No.

扭力扳手编号: 2#

试验环境: 温度: 25 °C 湿度: 56 %

Torque Wrench No.

Test Condition: Temperature Humidity

试验结果:	最小拉力扭矩		再拧紧5度扭矩 (Rotated from bolt head)	
	Minimum Tension Torque		Torque after 5 degree more	
Test Result	最小拉力	实际扭矩 (N.m)	螺栓拉力	实际扭矩 (N.m)
	Required Minimum Tension	Actual Torque	Actual tension	Torque value
试验螺栓一	KIP: <u>48.3</u>		KIP: <u>52</u>	<u>1160</u>
No. 1	N:		N:	
试验螺栓二	KIP: <u>48.3</u>		KIP: <u>53</u>	<u>1540</u>
No. 2	N:		N:	
试验螺栓三	KIP: <u>48.3</u>		KIP: <u>50</u>	<u>1500</u>
No. 3	N:		N:	
试验螺栓四	KIP: <u>48.3</u>		KIP: <u>53</u>	<u>1600</u>
No. 4	N:		N:	
试验螺栓五	KIP: <u>48.3</u>		KIP: <u>51</u>	<u>1400</u>
No. 5	N:		N:	

结果

RESULT

平均扭矩:

Average torque: 1480 N.M (SKIDMORE 1015 is calibrated on 6/4/09 to 6/4/10.)

试验人员: Zhang Haijun

日期: 2010.06.22

见证: 8222

日期: 6/22/10

Operator

Date

Witnessed by:

Date



高强度螺栓扭矩试验报告 报告编号: 232

REPORT OF HIGH STRENGTH BOLT
MINIMUM TENSION TORQUE TESTING

REPORT No.

产品名称: 美国海湾大桥

产品工号: 2906-787

Project

Project No.

试验时间: 14:55

试验地点: ZPMC

Testing Date

Testing Place

螺栓规格: M24x65 DHGM240013

SKIDMORE编号: 1015

Bolt Size

Skidmore No.

扭力扳手编号: 2#

试验环境: 温度: 28°C 湿度: 60%

Torque Wrench No.

Test Condition: Temperature Humidity

试验结果:	最小拉力扭矩		再拧紧5度扭矩 (Turn bolt head)	
	Minimum Tension Torque		Torque after 5 degree more	
Test Result	最小拉力	实际扭矩 (N. m)	螺栓拉力	实际扭矩 (N. m)
	Required Minimum Tension	Actual Torque	Actual tension	Torque value
试验螺栓一	KIP: <u>46</u>		KIP: <u>52</u>	<u>1220</u>
No. 1	N:		N:	
试验螺栓二	KIP: <u>46</u>		KIP: <u>50</u>	<u>1100</u>
No. 2	N:		N:	
试验螺栓三	KIP: <u>46</u>		KIP: <u>50</u>	<u>1240</u>
No. 3	N:		N:	
试验螺栓四	KIP: <u>46</u>		KIP: <u>54</u>	<u>980</u>
No. 4	N:		N:	
试验螺栓五	KIP: <u>46</u>		KIP: <u>52</u>	<u>960</u>
No. 5	N:		N:	

结果
RESULT

平均扭矩: 1100 N.m

Average torque: 1100 N.m

试验人员: Shang Haijun 日期: 07.05.10 见证: B222 日期: 7-5-10

Operator Date Witnessed by: Date

Skidmore Calibration date: 6/4/09 - 6/4/10



高强度螺栓扭矩试验报告 报告编号: 231

REPORT OF HIGH STRENGTH BOLT
MINIMUM TENSION TORQUE TESTING

REPORT No.

产品名称: 美国标准大六角

产品工号: 2906-787

Project

Project No.

试验时间: 14:30

试验地点: ZPMC

Testing Date

Testing Place

螺栓规格: M24x65 DHGM240002

SKIDMORE编号: 1015

Bolt Size

Skidmore No.

扭力扳手编号: 2#

试验环境: 温度: 28 °C 湿度: 60 %

Torque Wrench No.

Test Condition: Temperature Humidity

试验结果:	最小拉力扭矩		再拧紧5度扭矩 (Turn bolt head)	
	Minimum Tension Torque		Torque after 5 degree more	
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	Required Minimum Tension	Actual Torque	Actual tension	Torque value
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No. 1	N:		N:	
试验螺栓二	KIP: <u>46</u>		KIP: <u>51</u>	<u>1260</u>
No. 2	N:		N:	
试验螺栓三	KIP: <u>46</u>		KIP: <u>54</u>	<u>1100</u>
No. 3	N:		N:	
试验螺栓四	KIP: <u>46</u>		KIP: <u>56</u>	<u>1500</u>
No. 4	N:		N:	
试验螺栓五	KIP: <u>46</u>		KIP: <u>52</u>	<u>1380</u>
No. 5	N:		N:	

结果

RESULT

平均扭矩:

Average torque: 1300 N.m

Skidmore Calibration date.

6/4/09 - 6/4/10

试验人员: Yang Haijun

日期: 07.05.10 见证: BZZZ 日期: 7-5-10

Operator

Date

Witnessed by:

Date

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000852**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0748**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: 05-Jul-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Pre-Installation Verification of Required Tension for M24x65 high strength bolts, this QA Inspector discovered the following issues:

-The Skidmore-Wilhelm Bolt Tension Calibrator Model HT Serial Number (SN) 1015 calibration date had expired, and was being used by the Contractor in verifying M24x65 bolts (Lot number DHGM240013 and DHGM240002).

-Valid period of calibration are from June 4, 2009 through June 4, 2010.

-Calibration dates are displayed on the Bolt Tension Calibrator.

Contractor's proposal to correct the problem:

Contractor will perform the tension verification of the bolts to prove the bolts with Skidmore with calibration date is within tolerance and acceptable.

Corrective action taken:

Contractor resolved the issue by using another calibrated skidmore and provided acceptable testing result.

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 Wahbeh, Mazen 818-292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Ng, Michael

Quality Assurance Inspector

Reviewed By: Devey, Jim

QA Reviewer