

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-000795
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 12-Jul-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0757

Type of problem:

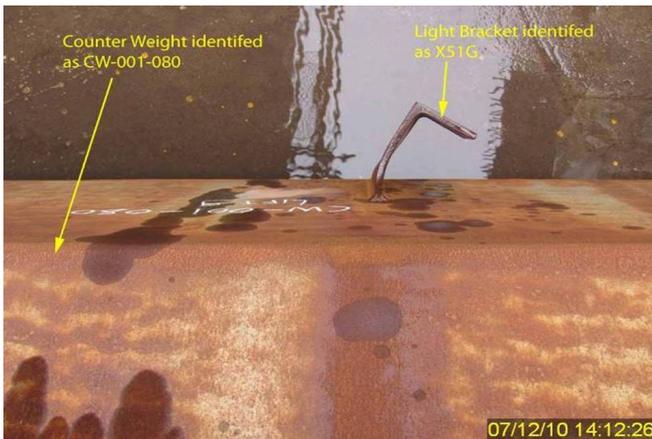
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Counterweight Light Mounting Bracket (Seg. 9DW)
Procedural	Procedural	Description: Bent/Damage Component	

Reference Description: A Light Mounting Bracket on a 9DW Counterweight was damaged and bent

Description of Non-Conformance:

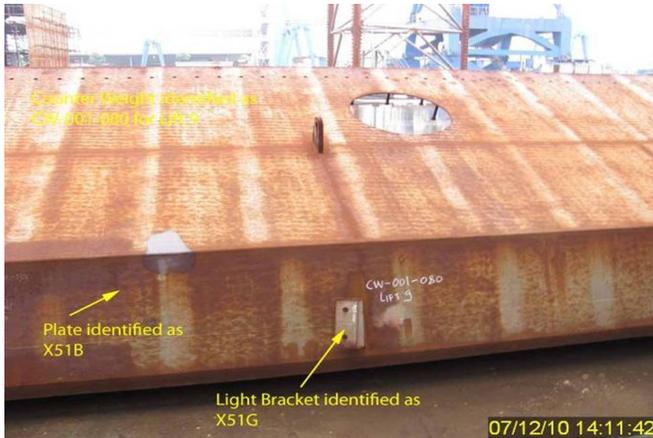
During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues.

- The Counterweight Light Mounting Bracket was damaged and bent.
- The maximum displacement of the Light Mounting Bracket is 80mm.
- Counterweight of concern is CW-001-080 (Segment 9DW).
- Light Mounting Bracket identified as X51G.
- Counterweight Plate identified as X51B to which Light Mounting Bracket is welded.
- Counterweight CW-001-080 is located in the outside yard, behind bay 13.
- The area has previously tested and accepted by ZPMC prior to this damage.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Standard Specifications July, 1999 Section 55-1.04 Shipping, Handling and Storing Materials; "In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.

Who discovered the problem: S. Manjunath. Math.

Name of individual from Contractor notified: Ding Xing Chi

Time and method of notification: 14:15 hours, 07/12/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 10:00 hours, 07/13/10, 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 Jim Devey, (86) 150-0002-6784, 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

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: 13-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: 05.03.06-000753

Subject: NCR No. ZPMC-0757

Reference Description: A Light Mounting Bracket on a 9DW Counterweight was damaged and bent

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 Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues.
- The Counterweight Light Mounting Bracket was damaged and bent.
 - The maximum displacement of the Light Mounting Bracket is 80mm.
 - Counterweight of concern is CW-001-080 (Segment 9DW).
 - Light Mounting Bracket identified as X51G.

Action Required and/or Action Taken:

Proposed 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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0757

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, 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: 05.03.06-000753

Subject: NCR No. ZPMC-0757

Dated: 21-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000784 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the heat straightening record used when they performed the work and the NDT done after to show the affected weld is acceptable.

ZPMC acknowledges that this heat straightening requires Engineer approval before being performed. In the future, work requiring heat straightening will be approved prior to commencing. ZPMC is providing the heat straightening record used when they performed the work and the NDT done after to show the affected weld is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000784R00;

Caltrans' comments:

Status: AAP

Date: 26-Sep-2010

The proposed resolution is acceptable for the heat straightening without the Engineer's approval. However, the issue of improper storage and handling which the NCR was issued for, still needs to be addressed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 26-Sep-2010



No. B-880

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-9-18

REGARDING: NCR-000795(ZPMC-0757)

ZPMC QA personnel have talked with the production department to address this issue. ZPMC is providing the heat straightening report and the NDT record to show the soundness of the affect weld and is requesting closure of this NCR.

ATTACHMENT:

NCR-000795(ZPMC-0757)

HSR1(B)-8655 R0

B787-MT-28087

Log W

9/18/10



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 Date: 13-Jul-2010
375 BURMA ROAD
OAKLAND CA 95607 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: 05.03.06-000753
Subject: NCR No. ZPMC-0757

Reference Description: A Light Mounting Bracket on a 9DW Counterweight was damaged and bent

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Material Location: OBG Lift: 09

Remarks:

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Proposed 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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0757

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao, Bill Casey
File: 05.03.06

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 DIVISION OF ENGINEERING SERVICES
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 12-Jul-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0757

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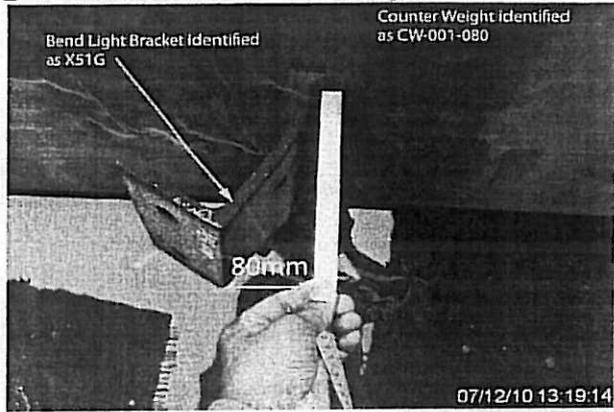
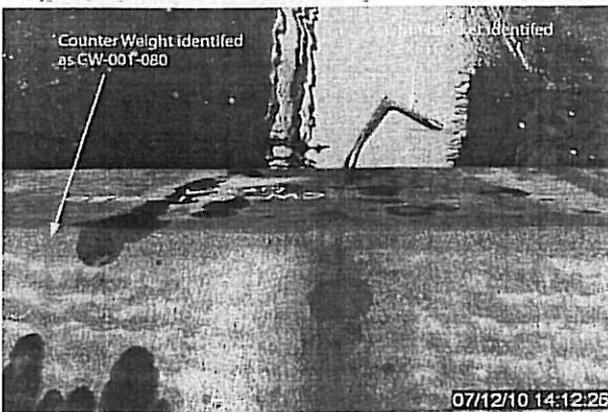
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 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Counterweight Light Mounting Bracket (Seg. 9DW)
 Procedural Procedural Description: Bent/Damage Component

Reference Description: A Light Mounting Bracket on a 9DW Counterweight was damaged and bent

Description of Non-Conformance:

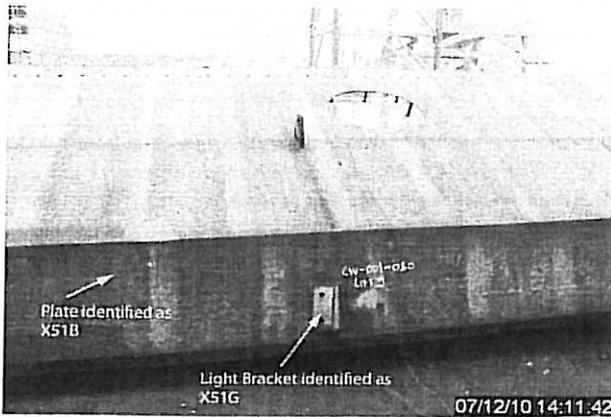
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Time and method of notification: 14:15 hours, 07/12/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 10:00 hours, 07/13/10, 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 Jim Devey, (86) 150-0002-6784, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric SMR

Reviewed By: Devey, Jim SMR

B-488

 <h2 style="margin: 0;">火工校正记录</h2> <h3 style="margin: 0;">Heat Straightening Record (HSR1)</h3>	报告号 Record #	HSR1(B)-8655 -
	版本号 Revision #	0
日期 Date		2010.08.17

美国海湾大桥 San Francisco Oakland Bay Bridge	
CALTRANS #04-0120F4	工程编号 JOB#: ZP06-787
装配 Assembly:	质检代表/Quality Control Representative
部装 Sub-Assembly:	
梁段 Gird: 配重块 CW1	质检经理/Quality Assurance Manager-Approval <i>dujianhua 8/17/10</i>
塔段 Tower:	N/A
焊缝号 Weld No:	130
焊缝地图号 Weld Map No:	CW001-PP080

情况描述 Description of Condition	
Cause 原因	Welding distortion 焊接变形
Type of Defect 缺陷类型	Welding distortion 焊接变形
Inspection Method 检查方法	Visual 目检

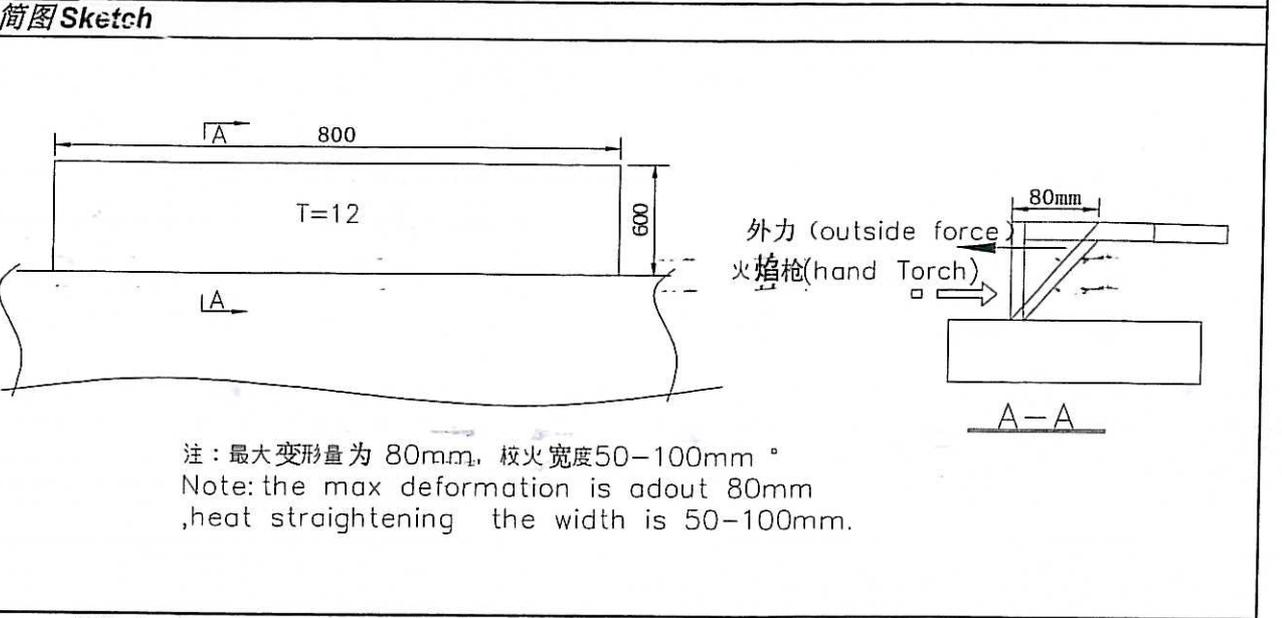
处置方法 Disposition

缺陷去除方法(Defect Removal Method): 1、Flame Straightening by oxygen acetylene 运用氧乙炔进行校火 2、QC is responsible for monitoring temperature during heat straightening. QC必须持有校火报告批准件, 全程监控, 并控制好校火温度。

后续NDE(Post-Removal NDE): Jack shall be used in a manner such that all forces are applied passively. After finishing heat straightening, the weld of the heated area shall perform NDT according to approved shop drawing. 正确使用千斤顶, 避免因千斤顶使用不当造成构件塑性变形; 校火后, 根据图纸要求对校火区和热影响区域进行100%VT, 100%MT, 检测。

纠正措施(Corrective Action(s)): Fasten subcomponent to transportation trailer securely prior to transport. 转运之前将构件安全地紧固在转运拖车上。

实施次数(Number of application): 1~3
最高温度(Maximum temprature): <650°C



To be signed when Closing HSR~Verify compliance and all necessary reports are ready to attach

检验员 Inspector:	<i>Wang Jinyu</i>	签字 Signature:	<i>李志记</i>
II 级探伤 NDE Certification:	Level II	Closing Date:	2010.9.1
质检经理 QC Manager		审核日期 Review Date:	

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787-QCP-1101 艾伟

Approved by *dujianhua* 8/17/10



REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 B787-MT-28087 DATE日期 2010.09.01 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. CW001 CALTRANS CONTRACT NO.:
图号: counterweight boxes 加州工程编号 04-0120F4

REFERENCING CODE ACCEPTANCE STANDARD PROCEDURE NO. CALIBRATION DUE DATE
参考规范编码 接受标准 程序编号 仪器校正有效期
AWS D1.5-2002 AWS D1.5-2002 ZPQC-MT-01 Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 连续编号
MT YOKE PARKER B310S 4149

MAGNETIZING METHOD Continuous magnetic yoke CURRENT
磁化方法 磁轭式连续法 电流 AC

PARTICLE TYPE Dry magnet powder YOKE SPACING
磁粉类型 干磁粉 磁轭间距 70~150mm

MATERIAL TO BE EXAMINED WELDING 焊接件 Material & thickness A709M-345T2-X
检测材料 CASTING 铸件 母材, 厚度 10/9.5mm
 FORGING 锻造

WELDING PROCESS SMAW TYPE OF JOINT T-JOINT
焊接方法 焊缝类型

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
CW001-PP080-130				ACC.		100%MT

AFTER HSR1(B)-8655

BLANK

EXAMINED BY主探 LI Liming *Li Liming* 2010.9.1 REVIEWED BY 审核 Wang Mei *Wang Mei* 2010.9.1

LEVEL - II SIGN 签名 / DATE日期 LEVEL-II SIGN / DATE日期

质量经理 / QCM 用户CUSTOMER

签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000753

Subject: NCR No. ZPMC-0757

Dated: 27-Oct-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000784 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing training documents to show the steps taking to prevent further damage from improper handling and storage.

ZPMC is providing training documents to show the steps taking to prevent further damage from improper handling and storage. Based on this training and previously submitted documents. ZPCM requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000784R01;

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-919

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-10-27

REGARDING: NCR-000795(ZPMC-0757)

Internal refresh training was taken to address the requirement of transportation. ZPMC is providing the training record and is requesting closure of this NCR.

ATTACHMENT:

NCR-000795(ZPMC-0757)

MEETING MEMO

A handwritten signature in black ink, appearing to be "L. W.", is written over the printed text.

copy/ra-

NCR PROPOSED RESOLUTION

To: California Department of Transportation
333 Burma Road
Oakland, CA 94607
Attention: Siegenthaler, Peter
Resident Engineer
Ref: 05.03.06-000753
Subject: NCR No. ZPMC-0757

Dated: 21-Sep-2010
Contract No.: 04-0120F4
04-SF-80-13.2/13.9
Job Name: Self-Anchored Suspension Bridge
Document No: ABF-NPR-000784 **Rev:** 0

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the heat straightening record used when they performed the work and the NDT done
ZPMC acknowledges that this heat straightening requires Engineer approval before being performed. In the future, work requiring heat straightening will be approved prior to commencing. ZPMC is providing the heat straightening record used when they performed the work and the NDT done after to show the affected weld is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted By: Ishibashi, Joshua
Attachment(s): ; ABF-NPR-000784R00

Status: AAP

Caltrans' comments:

Date: 26-Sep-2010

The proposed resolution is acceptable for the heat straightening without the Engineer's approval. However, the issue of improper storage and handling which the NCR was issued for, still needs to be addressed.

Submitted By: **Date:** 26-Sep-2010
Attachment(s): ABF-NPR-000784



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: 13-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: 05.03.06-000753

Subject: NCR No. ZPMC-0757

Reference Description: A Light Mounting Bracket on a 9DW Counterweight was damaged and bent

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- 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:

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Action Required and/or Action Taken:

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Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0757

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao, 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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Vallejo, CA 94592-1133

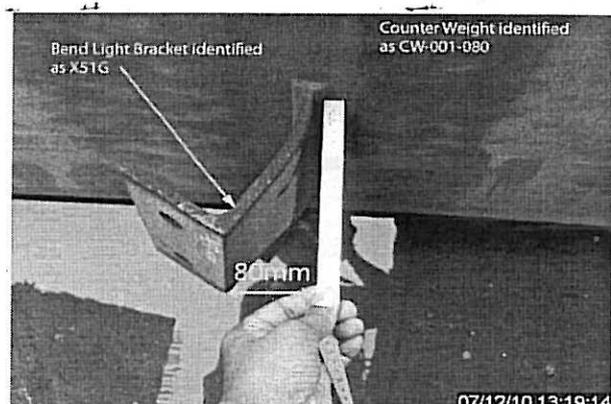
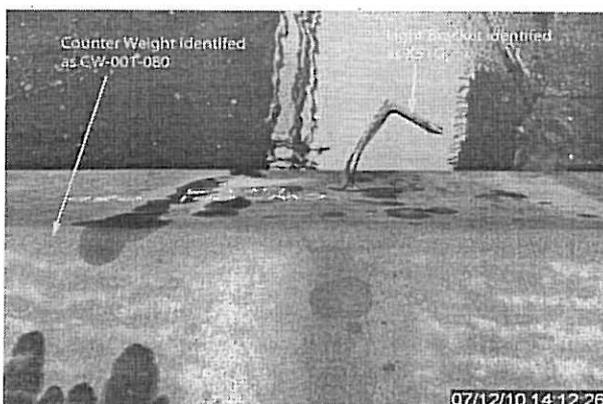
(707) 649-5453

(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-000795**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Jul-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0757**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Counterweight Light Mounting Bracket (Seg. 9DW)Procedural Procedural Description: Bent/Damage Component**Reference Description:** A Light Mounting Bracket on a 9DW Counterweight was damaged and bent**Description of Non-Conformance:**

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

SMR

会议纪要

会议时间：2010- 10 - 12

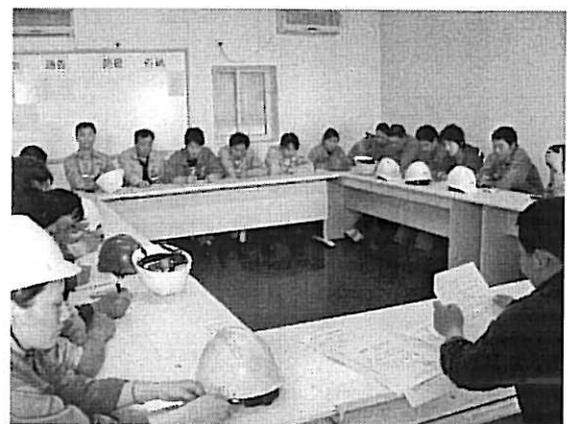
会议地点： 钢构八车间现场办会议室

会议主题： 美国钢桥构件转运、摆放专项会议

会议主持： 吕广斌（主任）

参加人员： 张桂铭、龚海兵、胡玉璋、张浩、杨杰、韦龙友、戴春、徐其辉、陈建华、陆叶飞、刘恒成、刘井飞（施建刚队）、金建（胡玉队）、吉华（王郡莲队）、李自涛（郑喜芝队）、崔国志（李政界队）

会议内容纲要：



各调度在转运美国钢桥构件时必须注意以下几点：

- 1.构件装车时垫好枕木，平稳，绑扎牢固。
- 2.在卸车时也要垫好枕木，观察周围环境是否会被其它油漆喷到。
- 3.如堆放时间太长，平时要巡查，看看是否移位、损坏。
- 4.以后构件堆放在制定地点，专人负责。

钢构八车间

2010- 10 -12

Meeting Memo

Pay attentions to the following requirements during the transportation:

- 1、 During transportation components shall be stacked with wood block and with good strapping.
- 2、 When unload components from lorry, wood block is still need when component is going to stack on ground. The storage area shall not nearby the painting working area.
- 3、 If components will be stacked long time. Inspect the storage state from time to time, to make sure no damage or sliding occurred.
- 4、 All the component shall be stacked in designated yard, and arrange the personnel responsible in charge.

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-000861**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0757**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-Jul-2010**Description of Non-Conformance:**

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues.

- The Counterweight Light Mounting Bracket was damaged and bent.
- The maximum displacement of the Light Mounting Bracket is 80mm.
- Counterweight of concern is CW-001-080 (Segment 9DW).
- Light Mounting Bracket identified as X51G.
- Counterweight Plate identified as X51B to which Light Mounting Bracket is welded.
- Counterweight CW-001-080 is located in the outside yard, behind bay 13.
- The area has previously tested and accepted by ZPMC prior to this damage.

Contractor's proposal to correct the problem:

Contractor will provide a training course to show the steps taking to prevent further damage from improper handling and storage.

Corrective action taken:

ZPMC is providing the heat straightening record used when they performed the work and the NDT done after to show the affected weld is acceptable.

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.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer