

**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, China

**Report No:** NCR-000837

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 10-Sep-2010

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

**NCR #:** ZPMC-0799

### Type of problem:

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

**Bridge No:** 34-0006

**Component:** Bike Path BK004A7

**Reference Description:** Missed MT Indication

### Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021 this Quality Assurance Inspector (QA) discovered the following issues:

- One linear crack indication in the weld measuring approximately 10mm in length.
- One area of overlap of the fillet weld measuring approximately 20mm in length.
- The weld is identified as 9C-BK004A7-021-187.
- The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.
- The indications are clearly marked on the material near the weld.
- The Bike Path 021 Stringer Plate is located in Bay# 11.

The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.



### Applicable reference:

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

---

---

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

---

---

welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.

AWS D1.5 (02) Section 3.6.5 Welds shall be free from overlap.

**Who discovered the problem:** Nagalingam Pandaram Pillai

**Name of individual from Contractor notified:** Zhao Xian Be

**Time and method of notification:** 1000 hours, 09/11/10, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 1500 hours, 09/12/10, Email

**QC Inspector's Name:** Wang Chuang Xin

**Was QC Inspector aware of the problem:** Yes No

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

NA

**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,(818) 292-0659, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Devey,Jim	SMR
----------------------	-----------	-----

---

<b>Reviewed By:</b>	Wahbeh,Mazen	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-Sep-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-0799

**Job Name:** SAS Superstructure  
**Document No:** 05.03.06-000794

**Reference Description:** Missed MT Indication

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:** Bike Path **Lift:**

**Remarks:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021, Caltrans Quality Assurance Inspector (QA) discovered the following issues:

- One linear crack indication in the weld measuring approximately 10mm in length.
- One area of overlap of the fillet weld measuring approximately 20mm in length.
- The weld is identified as 9C-BK004A7-021-187.
- The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.
- The indications are clearly marked on the material near the weld.
- The Bike Path 021 Stringer Plate is located in Bay# 11.

The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

**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:** Laraine Woo Transportation Engineer  
**Attachments:** ZPMC-0799

**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:** 05.03.06-000794

**Subject:** NCR No. ZPMC-0799

**Dated:** 23-Sep-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000792 Rev: 00

---

### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC has repaired the missed indications and is providing the WWR used at the time to repair the weld and the MT report performed after to show that the weld is acceptable.

ZPMC has repaired the missed indications and is providing the WWR used at the time to repair the weld and the MT report performed after to show that the weld is acceptable. To prevent future occurrences ZPCM has written an internal NCR and the inspector who missed the indications has been identified and his performance will be monitored to ensure that he does not continue a pattern of missed indications. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000792R00;

---

### Caltrans' comments:

**Status:** AAP

**Date:** 07-Oct-2010

The proposed resolution for the quality management is acceptable. However, the documentation of the overlap repair is required to close this issue.

**Submitted by:** Woo, Laraine

**Date:** 07-Oct-2010

**Attachment(s):**



No. B-892

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-9-23**

**REGARDING: NCR-000837(ZPMC-0799)**

For this case, ZPMC has issue an internal NCR to address this issue. The missed indications now have been repaired and were tested to be acceptable. The CWR number is B-CWR1918. ZPMC is providing NDT record for review. Based on this, please consider closure of this NCR.

**ATTACHMENT:**

NCR-000837(ZPMC-0799)

B787-MT-27968R1

*Zhangjiagang*  
*2010-9-23*



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-Sep-2010

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

**Dear:** Mr. Charles Kanapicki  
**Attention:** Mr. Thomas Nilsson Project/Fabrication Manager  
**Job Name:** SAS Superstructure

**Subject:** NCR No. ZPMC-0799  
**Document No:** 05.03.06-000794

**Reference Description:** Missed MT Indication

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:** Bike Path

**Lift:**

### Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021, Caltrans Quality Assurance Inspector (QA) discovered the following issues:

- One linear crack indication in the weld measuring approximately 10mm in length.
- One area of overlap of the fillet weld measuring approximately 20mm in length.
- The weld is identified as 9C-BK004A7-021-187.
- The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.
- The indications are clearly marked on the material near the weld.
- The Bike Path 021 Stringer Plate is located in Bay# 11.

The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

### 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:** Laraine Woo Transportation Engineer

**Attachments:** ZPMC-0799

**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

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

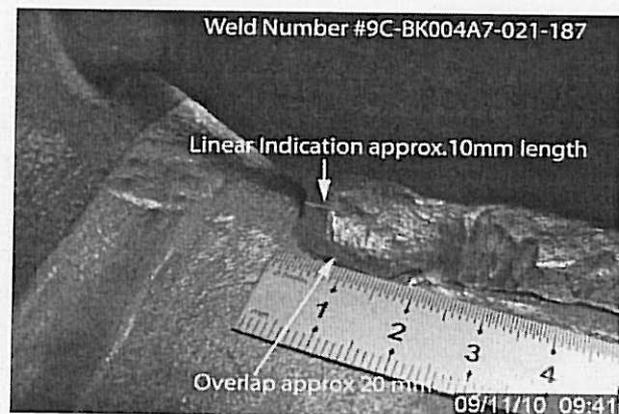
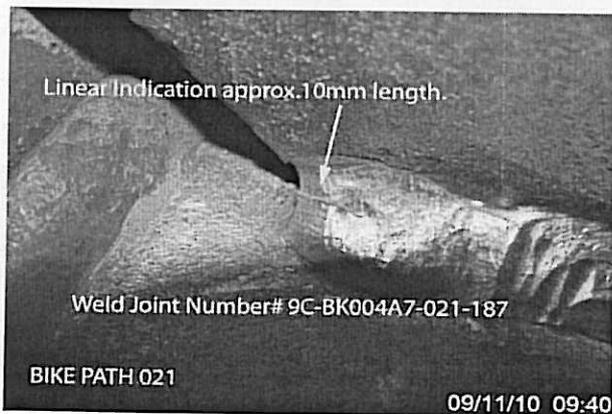
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, China**Report No:** NCR-000837**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 10-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0799**Type of problem:**Welding  Concrete  Other Welding  Curing  Procedural Joint fit-up  Coating  Other Procedural  Procedural  Description:**Bridge No:** 34-0006**Component:** Bike Path BK004A7**Reference Description:** Missed MT Indication**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021 this Quality Assurance Inspector (QA) discovered the following issues:

- One linear crack indication in the weld measuring approximately 10mm in length.
- One area of overlap of the fillet weld measuring approximately 20mm in length.
- The weld is identified as 9C-BK004A7-021-187.
- The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.
- The indications are clearly marked on the material near the weld.
- The Bike Path 021 Stringer Plate is located in Bay# 11.

The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

**Applicable reference:**

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

---

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

---

welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.

AWS D1.5 (02) Section 3.6.5 Welds shall be free from overlap.

**Who discovered the problem:** Nagalingam Pandaram Pillai

**Name of individual from Contractor notified:** Zhao Xian Be

**Time and method of notification:** 1000 hours, 09/11/10, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 1500 hours, 09/12/10, Email

**QC Inspector's Name:** Wang Chuang Xin

**Was QC Inspector aware of the problem:**  Yes  No

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

NA

**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,(818) 292-0659, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Devey,Jim SMR

**Reviewed By:** Wahbeh,Mazen SMR

---

2PML-0799



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-27968R1      DATE日期 2010.09.16      PAGE OF页码 1/1      Revision No: 0

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

DRAWING NO.      BK4A-021-9C      CALTRANS CONTRACT NO.:  
 图号:      cantilever box bracket      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. 28<sup>ST</sup>, 2010

EQUIPMENT 设备      MANUFACTURER 制造商      MODEL NO. 样式编号      SERIAL NO. 连续编号  
 MT YOKE      PARKER      DA-400S      17368

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

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

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

WELDING PROCESS      FCAW      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			
BK004A7-021-187	1R1			ACC.		100%MT

AFTER B-CWR1918rev0

BLANK

EXAMINED BY主探      REVIEWED BY 审核  
 Cai Xinxin      Cai Xinxin      Su Wei  
 LEVEL-II SIGN 签名 / DATE日期      20/0.09.16      LEVEL-II SIGN 签名 / DATE日期      20/0.09.16  
 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:** 05.03.06-000794

**Subject:** NCR No. ZPMC-0799

**Dated:** 12-Oct-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000792 Rev: 01

---

**Contractor's Proposed Resolution:**

**Reference Resolution:** The visual defects noted in the NCR were corrected at the time the crack was repaired and verified to be visually acceptable.

The visual defects noted in the NCR were corrected at the time the crack was repaired and verified to be visually acceptable. Based on this clarification and previous submitted acceptable NDT documents ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000792R01;

---

**Caltrans' comments:**

**Status:** CLO

**Date:** 13-Oct-2010

The issue has been addressed with weld repair with subsequent NDT verification. This NCR is considered closed.

**Submitted by:** Woo, Laraine

**Date:** 13-Oct-2010

**Attachment(s):**



No. B-904

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-10-12**

**REGARDING: NCR-000837(ZPMC-0799)**

The VT deflection of overlap was located at the same Y location of the MT indication. It was removed and repaired together with the MT indication. Based on this clarification and with the previously submitted documentations, ZPMC is request closure of this NCR.

**ATTACHMENT:**

NCR-000837(ZPMC-0799)

A handwritten signature in black ink, appearing to be "J. W.", is located below the attachment information. The signature is written in a cursive style.

10/12/2010



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-Sep-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:** 05.03.06-000794

**Subject:** NCR No. ZPMC-0799

**Reference Description:** Missed MT Indication

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:** Bike Path

**Lift:**

### Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021, Caltrans Quality Assurance Inspector (QA) discovered the following issues:

- One linear crack indication in the weld measuring approximately 10mm in length.
- One area of overlap of the fillet weld measuring approximately 20mm in length.
- The weld is identified as 9C-BK004A7-021-187.
- The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.
- The indications are clearly marked on the material near the weld.
- The Bike Path 021 Stringer Plate is located in Bay# 11.

The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

### 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:** Laraine Woo Transportation Engineer

**Attachments:** ZPMC-0799

**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  
 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, China

**Report No:** NCR-000837

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 10-Sep-2010

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

**NCR #:** ZPMC-0799

**Type of problem:**

**Welding**  **Concrete**  **Other**

**Welding**  **Curing**  **Procedural**

**Joint fit-up**  **Coating**  **Other**

**Procedural**  **Procedural**  **Description:**

**Reference Description:** Missed MT Indication

**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021 this Quality Assurance Inspector (QA) discovered the following issues:

-One linear crack indication in the weld measuring approximately 10mm in length.

-One area of overlap of the fillet weld measuring approximately 20mm in length.

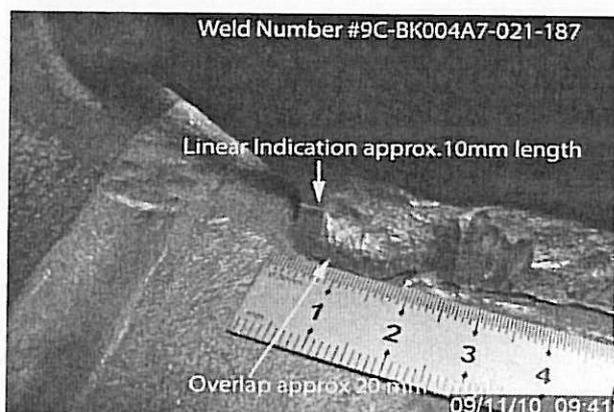
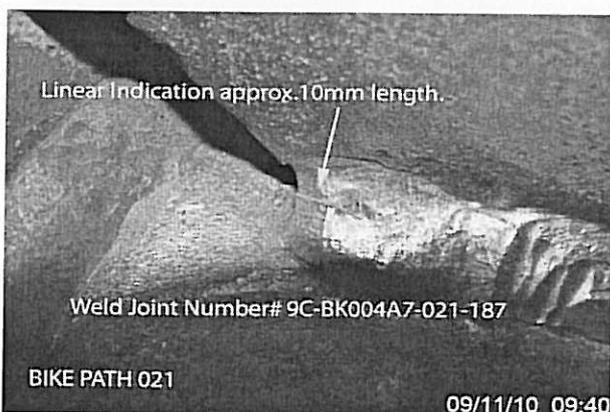
-The weld is identified as 9C-BK004A7-021-187.

-The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.

-The indications are clearly marked on the material near the weld.

-The Bike Path 021 Stringer Plate is located in Bay# 11.

The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.



**Applicable reference:**

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

---

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

---

welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.

AWS D1.5 (02) Section 3.6.5 Welds shall be free from overlap.

**Who discovered the problem:** Nagalingam Pandaram Pillai

**Name of individual from Contractor notified:** Zhao Xian Be

**Time and method of notification:** 1000 hours, 09/11/10, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 1500 hours, 09/12/10, Email

**QC Inspector's Name:** Wang Chuang Xin

**Was QC Inspector aware of the problem:**  Yes  No

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

NA

**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,(818) 292-0659, who represents the Office of Structural Materials for your project.

---

**Inspected By:** Devey,Jim

SMR

---

**Reviewed By:** Wahbeh,Mazen

SMR

**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, China**Report No:** NCS-000775**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0799**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>Description:</b>	

**Date the Non-Conformance Report was written:** 10-Sep-2010**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Bike Path 021 this Quality Assurance Inspector (QA) discovered the following issues:

- One linear crack indication in the weld measuring approximately 10mm in length.
- One area of overlap of the fillet weld measuring approximately 20mm in length.
- The weld is identified as 9C-BK004A7-021-187.
- The weld is a fillet T-joint, joining stiffener identified as BKX7L to stringer plate identified as BKX9C.
- The indications are clearly marked on the material near the weld.
- The Bike Path 021 Stringer Plate is located in Bay# 11.

The Notice of Witness Inspection Number (NWIT) is 006640. The indication is located Within an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

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

"ZPMC has repaired the missed indications and is providing the WWR used at the time to repair the weld and the MT report performed after to show that the weld is acceptable. To prevent future occurrences ZPCM has written an internal NCR and the inspector who missed the indications has been identified and his performance will be monitored to ensure that he does not continue a pattern of missed indications."

**Corrective action taken:**

The issue has been addressed with weld repair with subsequent NDT verification.

**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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

---

---

# QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

---

---

---

**Inspected By:** Tsang, Eric

Quality Assurance Inspector

---

**Reviewed By:** Wahbeh, Mazen

QA Reviewer