

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
 Vallejo, CA 94592-1133
 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China**Report No:** NCR-000974**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0933**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 12BW to 12CW Deck Panel
Procedural	Procedural	Description:	

Reference Description: The weld repair was performed without following the approved repair WPS and WRR

Description of Non-Conformance:

ZPMC personnel performed overhead position weld repair on Segment 12BW to 12CW deck plate splice joint by using the ZPMC internally approved welding repair report (WRR) B-WR19621. While Quality Assurance (QA) Inspector was performing random in-process visual inspection, the following issues were noted.

- 1.) The weld repair was not performed in accordance with an approved repair WPS (Welding Procedure Specification); rather, the WRR indicated a WPS identified as WPS-B-P-2214-B-U2-FCM-1.
- 2.) This WPS indicated a joint configuration/preparation that was not being used in this weld repair.
- 3.) The ZPMC internally approved WRR prescribed a WPS that is not applicable to this repair.
- 4.) The weld was performed without following an approved WPS.
- 5.) The weld was performed without following the WRR disposition, which says "preheat and weld according to the approved repair WPS."

-The weld is identified as OBW12A-001.

-The Weld is Complete Joint Penetration (CJP) butt joint.

-The Y distance for the exposed area was 13150 mm to 13620mm as measured from edge plate (on the counterweight side).

-The segments are located at the trial assembly area.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

ZPMC		Welding Repair Report			0
项目名称 Project Name	美国海西大桥 SFOBB	部件图号 Drawing No.	12BW+12CW	报告编号 Report No.	B-WR19621
合同号 Contract No.	04-0120F4	部件名称 Items Name	箱梁顶板	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.	ZP05-787				
纠正措施: Correction action to prevent re occurrence: 加强焊接过程中的监控, 减少误差。 Enhance supervision in process of welding to reduce error.					
车间负责人(Foreman) <i>Ma Ruiqun</i> 日期(Date): 2011.01.16					
参照的WPS编号 Repair WPS No.	WPS-B-P-2214-B- U2-FCM-1 WPS-B-P-2211-B- U2-FCM-1	工艺员 technologist	<i>Xu Dongyi</i> 2011.01.16		
或焊(探伤) 前预热温度 Preheat temperature before gouging		返修的缺陷 Description of discontinuity			
焊前处理检查 Inspection before welding		焊前预热温度 Preheat temperature before welding			

Applicable reference:

-Welding Repair Report B-WR19621: "preheat and weld according to the approved repair WPS."

-Welding Quality Control Plan Section 9.2.2.3: "The weld repair shall be in accordance with the approved repair WPS."

Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Ding

Time and method of notification: 1345 hours, 01-21-11, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1400 hours, 01-21-11, Verbal

QC Inspector's Name: Zhou Zhong Hai

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

Inspected By: Tsang, Eric SMR

Reviewed By: Wahbeh, Mazen 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: 22-Jan-2011

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: 05.03.06-000931

Subject: NCR No. ZPMC-0933

Reference Description: The weld repair was performed without following the approved repair WPS and WRR

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:** 12

Remarks:

ZPMC personnel performed overhead position weld repair on Segment 12BW to 12CW deck plate splice joint by using the ZPMC internally approved welding repair report (WRR) B-WR19621. While Quality Assurance (QA) Inspector was performing random in-process visual inspection, the following issues were noted.

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- The Weld is Complete Joint Penetration (CJP) butt joint.
- The Y distance for the exposed area was 13150 mm to 13620mm as measured from edge plate (on the counterweight side).
- The segments are located at the trial assembly area.

Action Required and/or Action Taken:

Propose resolutions for the identified non-conformance items and document that the various deficiencies have been brought in compliance with contract requirements. Also propose a resolution that addresses the apparent failure of Quality Control to identify the non-conformance with the appropriate Welding Procedure Specification (WPS). Provide documentation of the steps taken by the Quality Control Manager 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: Sean Eagen Transportation Engineer

Attachments: ZPMC-0933

cc: Rick Morrow, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000931

Subject: NCR No. ZPMC-0933

Dated: 14-Mar-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000936 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The site QC has been reminded that correct repair documents need to be on had before repairs begin to prevent this from occurring in the future.

In addition to ZPMC's comments, the site QC has been reminded that correct repair documents need to be on had before repairs begin to prevent this from occurring in the future.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000936R00;

Caltrans' comments:

Status: CLO

Date: 17-Mar-2011

The welds in question were repaired with subsequent NDT documentation.

Submitted by: Chao, Ching

Attachment(s):

Date: 17-Mar-2011



TRANSMITTAL LETTER

PROJECT: S.F.O.B.B.

DATE:2011-03-14

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: OBG NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

(01) LR: No. B-980

(02) NCR-000974(ZPMC-0933)

B-WR19621

B787-MT-36814

UT-12W-035R2

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

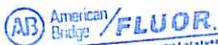
ACKNOWLEDGEMENT

PLAN HOLDER:

Rosemary

15:50
RECEIVED 14 MAR 2011

COMPANY:



PHONE NO.

PLAN NUMBER:N/A

#R787-QCP-102



No. B-980

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-03-14

REGARDING: NCR-000974 (ZPMC-0933)

ZPMC has issued an internal NCR to address this problem. To show the actual welding repair method what was used, ZPMC has made the corrected WRR, B-WR19621 R-. And ZPMC is providing the NDT record to show the acceptance of this weld after repair. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000974 (ZPMC-0933)

B-WR19621

B787-MT-36814

UT-12W-035 R2

zhongwei

3/14/11



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: 22-Jan-2011

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: 05.03.06-000931

Subject: NCR No. ZPMC-0933

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15.04
05.03.06-000931,NCT

Received
NCT-000931 21 Jan 11 Page 1 of 2

NCT

(Continued Page 2 of 2)

Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0933

cc: Rick Morrow, Peter Siegenthaler, Stanley Ku, Brian Boal, Contract Files, Ching Chao, Bill Casey

File: 05.03.06



DEPARTMENT OF TRANSPORTATION

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Contract #: 04-0120F4City: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000974**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0933**Type of problem:**Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:**Bridge No:** 34-0006**Component:** OBG Segment 12BW to 12CW Deck Panel

Reference Description: The weld repair was performed without following the approved repair WPS and WRR

Description of Non-Conformance:

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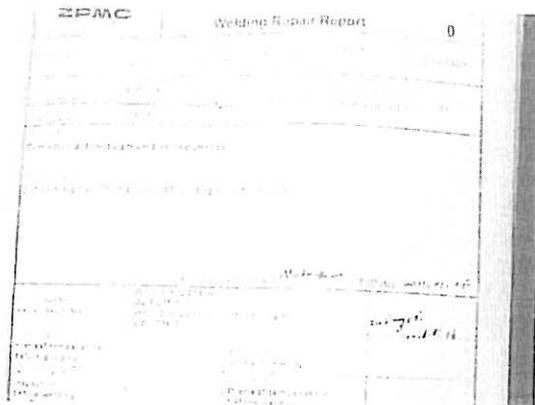
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Name of individual from Contractor notified: Ding

Time and method of notification: 1345 hours, 01-21-11, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1400 hours, 01-21-11, Verbal

QC Inspector's Name: Zhou Zhong Hai

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

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR

复-议章



焊缝返修报告

版本 Rev. No.

Welding Repair Report

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No	12BW+12CW	报告编号 Report No.	B-WR19621
合同号 Contract No.:	04-0120F4	部件名称 Items Name	箱梁顶板	NDT报告编号 Report No.of NDT	NA
项目编号 Project No.:	ZP06-787				

焊缝缺陷描述:

Description of welding discontinuity:

检查发现12BW+12CW顶板对接焊缝焊接过程中发现有3处错边, 最大错边量是3mm, 位置是1070~1670、6570~7070、13150~13620, 需要进行开刀调整。焊缝编号是OBW12A-001

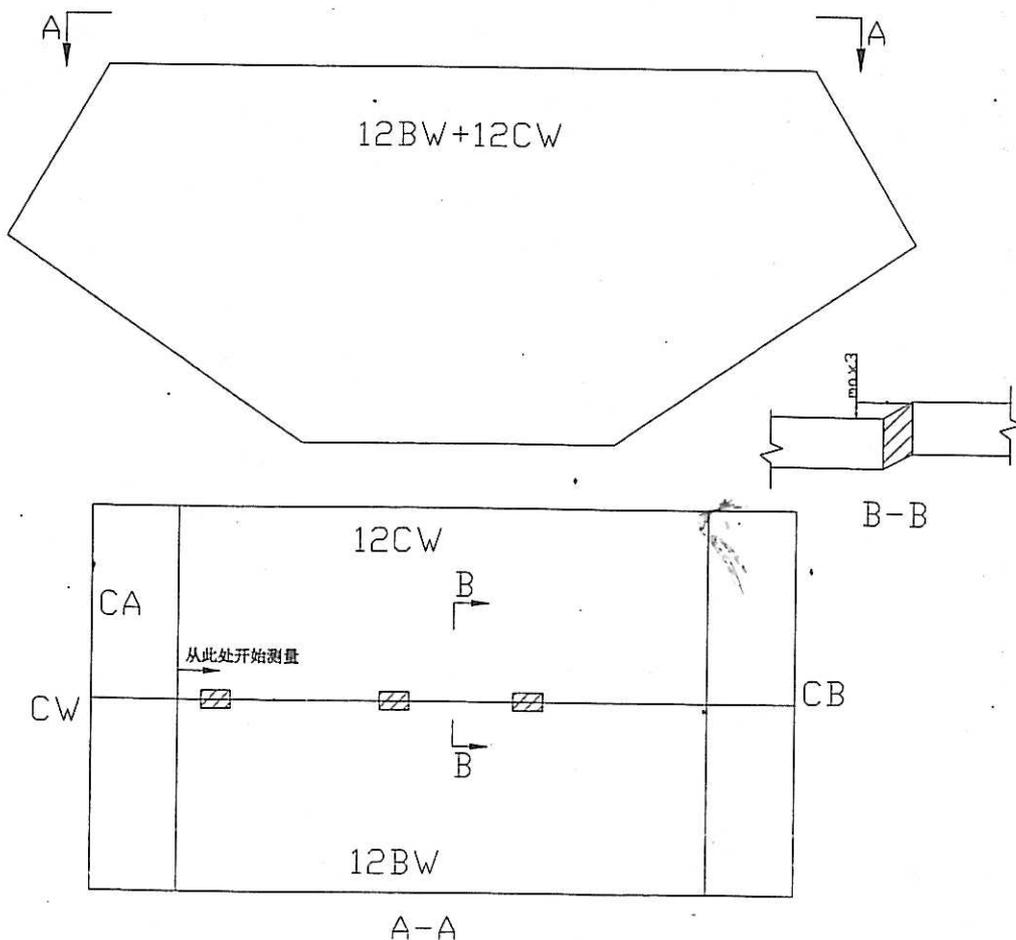
After inspection 12BW and 12CW deck plate butt weld, it was maximum 3mm misalignment at weld OBW12A-001, the position is 1070~1670、6570~7070、13150~13620 from the weld, and needs to cut to adjust.

Zhu Zhong Hai

检验员 (Inspector): ZHUZHONGHAI 日期(Date): 2011.01.16

焊缝返修位置示意图:

Draft of welding discontinuity



产生原因:

Caused:

焊接变形和制造误差。

Weld distortion and fabricate error.

车间负责人(Foreman): GaoJun 日期(Date): 2011.01.16

处理意见

Disposition :

1. 采用火焰切割或碳刨的方法割除上述焊缝, 碳刨前应根据相应的WPS进行预热;
2. 对母材刨除区域进行VT和MT检测确认无缺陷存在;
3. 采用外力调整筋板的对接错边量, 使其满足公差要求, 然后进行点焊固定;
4. 根据批准返修的WPS预热并焊接, 并随时检测直线度;
5. 将修补焊缝打磨与周边焊缝或与母材平齐;
6. 根据图纸要求进行相应的NDT检测。

1. Remove the welds by the way of gouging or Oxygen Preheat according to the WPS prior to gouging.
2. Perform 100%VT and 100%MT inspection to the metal cutting area to ensure no defects exist.
3. Adjust the misalignment and the straightness to meet the tolerance by extra force and ensure the stiff ener to meet the tolerance, and then perform tack weld.
4. Preheat and weld according to the approved repair WPS with check the line degree sometime.
5. Grind the weld flush to the adjacent weld or base metal.
6. Perform NDT inspection of the weld according to the working drawings.

工艺: Niu Tie feng
Technical engineer

审核: W Jianhua
Approved by

日期 01.16.
Date



焊缝返修报告

Welding Repair Report

版本 Rev. No.

0

项目名称 Project Name	美国海湾大桥 SFOBB	部件图号 Drawing No.	12BW+12CW	报告编号 Report No.	B-WR19621
合同号 Contract No.:	04-0120F4	部件名称 Items Name	箱梁顶板	NDT报告编号 Report No. of NDT	NA
项目编号 Project No.:	ZP06-787				

纠正措施:

Correction action to prevent re occurrence:

加强焊接过程中的监控, 减少误差。

Enhance supervision in process of welding to reduce error.

车间负责人(Foreman): Gao Jun 日期(Date): 2011.01.16

参照的WPS编号 Repair WPS No.	WPS-345-SMAW-1 G(1F)-FCM-Repair -1 WPS-345-SMAW-4 G(4F)-FCM-Repair -1	工艺员 technologist	Niu Tiejun
返修(碳刨)前预热温度 Preheat temperature before gouging	160	返修的缺陷 Description of discontinuity	C 裂纹
焊前处理检查 Inspection before welding	All	焊前预热温度 Preheat temperature before welding	160
最大碳刨深度 Max. depth of gouging	16	碳刨总长 Total length of gouging	1000
焊工 welder	044551	焊接类型 welding type	SMAW
焊接电流 Current	152	焊接电压 Voltage	25
		焊接位置 position	16/46
		焊接速度 Speed	1.00

返修后检查

Inspection After repairing:

外观检查 VT result	检验员 Inspector	日期 Date
All	zhuzhonghai	2011.02.25
NDT复检 NDT result	探伤员 NDT person	日期 Date
All	MT Acc Wang Long D. Bushme	2011.02.12 2011.3.8

见证:

Witness/Review:

备注:

Remark:



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-36814 DATE日期 2011.03.12 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. OBW12 CALTRANS CONTRACT NO.:
 图号: 12BW+12CW 加州工程编号 04-0120F4

REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2011
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EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 USA	MODEL NO. 样式编号 #ES-X	SERIAL NO. 连续编号 14243
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MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
----------------------------	------------------------------------	---------------	----

PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
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MATERIAL TO BE EXAMINED 检测材料	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2 20mm
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WELDING PROCESS 焊接方法	FCAW/SAW/SMAW	TYPE OF JOINT 焊缝类型	BUTT
-------------------------	---------------	-----------------------	------

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			
CA3012-012				ACC.		100%MT
OBW12A-001				ACC.		100%MT
OBW12A-002				ACC.		100%MT
CA3012-010				ACC.		100%MT
OBW12A-003				ACC.		100%MT

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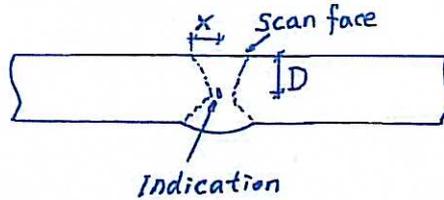
EXAMINED BY 主探 Wang Long <u>Wang Long</u> LEVEL - II SIGN 签名 / DATE日期 2011.03.12 质量经理 / QCM <u>[Signature]</u> 签字 SIGN / 日期 DATE	REVIEWED BY 审核 <u>Huang zheng chao</u> LEVEL-II SIGN / DATE日期 2011.03.12 用户CUSTOMER 签字 SIGN / 日期 DATE
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UT Report

Project Name: SFOBB SAS Bridge **Date:** 2011.3.8
Lift / Segment No.: 12BW/12CW **Report Number:** UT-12W-035 R2
Drawing Number: CA3012/OBW12A **Page Number:** 1 of 2
Component: A1, A2, A10 (R2) **Tower / OBG:** OBG

Refer to the attached sketch.



Material: A709 **Thickness:** 20/20 **Examination Specification:** AWS D1.5
Surface Condition: As Welded Dressed **Acceptance Criteria:** AWS D1.5 Table 6.3 / 6.4
Type of Instrument: HS610e/USN58L **Test Procedure Number:** ZPQC-UT-01
Serial Number: 612216 / 612540 / 01P8HW
Type of Transducer: 2.5P20 ; 2.25 / .75 X .625 **Reference Block:** IIW
Transducer Angle: 0° ; 70° **Couplant:** CMC Paste
Welding Process: FCAW SMAW GMAW SAW

Weld Number.	Indication No.	Scan Face	Leg	Decibels				Discontinuity Dimensions (mm)				Evaluation	Inspector	Inspection %	
				Indication Level	Reference Level	Attenuation Factor	Indication Rating	Length	Sound Path	Depth	Distance				
											From "X"				From "Y"
a	b	c	d												
OBW12A-001 (A1)	/	outside	/	/	/	/	/	/	/	/	/	ACC.	S022 S020	100%	
OBW12A-002 (A10)	/	outside	/	/	/	/	/	/	/	/	/	ACC.	S002	100%	
CA3012-012 (A2)	/	outside	/	/	/	/	/	/	/	/	/	ACC.	S034	100%	

Observation: Scanning Pattern:- A / B / C / D / E **Time of Inspection**
 Pattern D conducted inline with Transverse Segment Assembly Splice Ultrasonic Testing Procedure. **Start:-** 2011.3.8 13:40
Completed:- 2011.3.8 17:00
Legend: ACC--Accept, REJ--Reject, TLI--Transverse Linear Indication, LLI--Longitudinal Linear Indication, RI--Rounded Indication, LF--Lack of Fusion.

Prepared By:		Reviewed By:	
Name	Wang Zhenhua	Name	PETER FERGUSON
Sign	WangZH (S001)	Sign	<i>[Signature]</i>
Position		Position	FABRICATION SUPERINTENDENT
Date	2011.3.8	Date	09 MAR 2011

12BW/12CW

A1.A2.A10

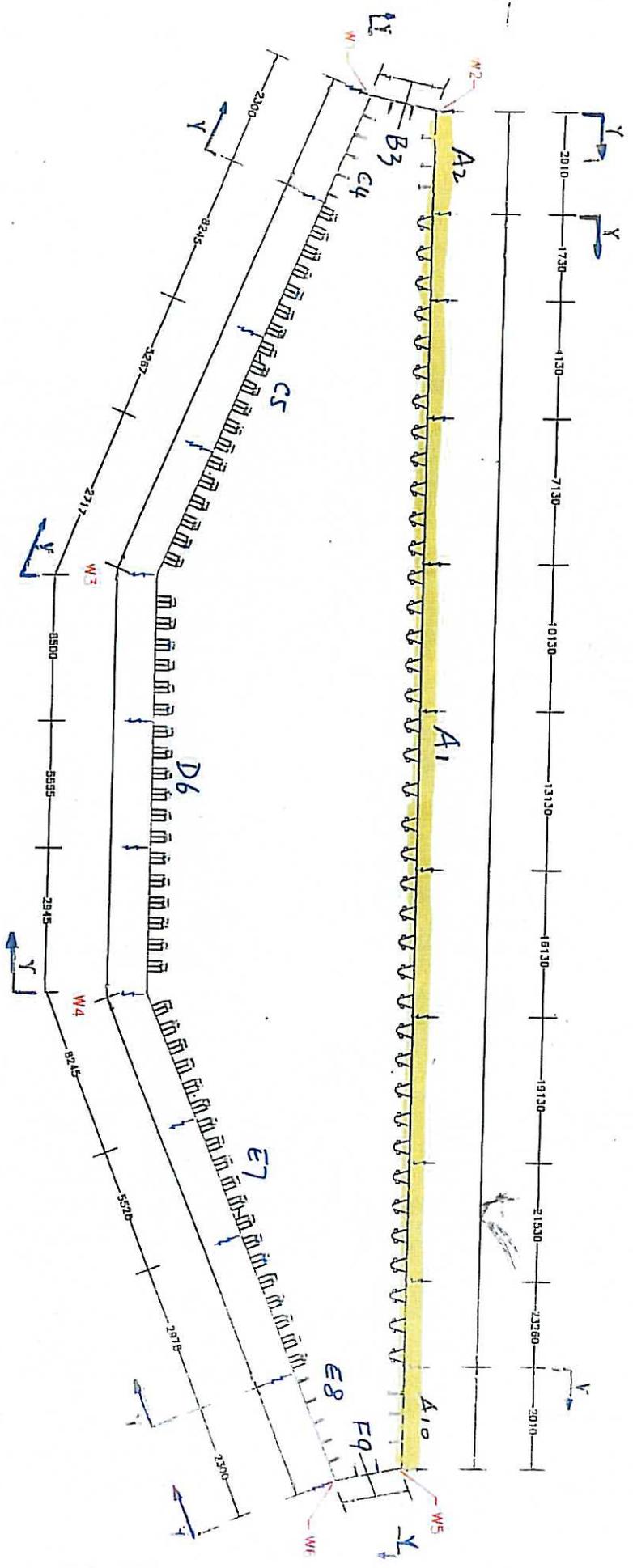
UT-12W-035R2 12/20

COUNTER WEIGHT

OBW

SPLICE

CROSSBEAM



SEGMENT:	SPLICE	
DESIGNED BY:	R.P.	
DATE:	04-01-2004	
DESCRIPTION:	SEGMENT SPLICE INDICATION TRACKING OBG OUTER SKIN SEAMS (LUG EASTBND)	
DATE:	SEPTEMBER 2009	

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
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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-000951**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Mar-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0933**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: 21-Jan-2011**Description of Non-Conformance:**

ZPMC personnel performed overhead position weld repair on Segment 12BW to 12CW deck plate splice joint by using the ZPMC internally approved welding repair report (WRR) B-WR19621. While Quality Assurance (QA) Inspector was performing random in-process visual inspection, the following issues were noted.

- 1.) The weld repair was not performed in accordance with an approved repair WPS (Welding Procedure Specification); rather, the WRR indicated a WPS identified as WPS-B-P-2214-B-U2-FCM-1.
- 2.) This WPS indicated a joint configuration/preparation that was not being used in this weld repair.
- 3.) The ZPMC internally approved WRR prescribed a WPS that is not applicable to this repair.
- 4.) The weld was performed without following an approved WPS.
- 5.) The weld was performed without following the WRR disposition, which says "preheat and weld according to the approved repair WPS."

-The weld is identified as OBW12A-001.

-The Weld is Complete Joint Penetration (CJP) butt joint.

-The Y distance for the exposed area was 13150 mm to 13620mm as measured from edge plate (on the counterweight side).

-The segments are located at the trial assembly area.

Contractor's proposal to correct the problem:

Contractor will repair the weld, and provide the NDT report to prove the weld is acceptable. Contractor will remind the personnel involved to use and follow the correct Repair and Weld Procedures.

Corrective action taken:

Contractor repaired the weld. NDT report provided shows the weld is acceptable. Contractor issued an internal NCR to the QA personnel.

Did corrective action require Engineer's approval?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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: Wahbeh,Mazen

QA Reviewer