

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-000236**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Mar-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0210**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segments 3AW, 3BW
Procedural	Procedural	Description:	

Reference Description: Welding was performed not in accordance with the approved WPS.**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed the flux-cored arc welding of segment 3AW/3BW weld joint (OBW-3A-003). During the inspection, it was found that the welding parameters did not comply with the approved WPS. The welding parameters recorded by the QA Inspector are "345 Amps and 38 Volts." According to the approved WPS, the allowable parameter ranges are "280~313.3 Amps and 28~30 Volts". Therefore, the welding of this joint (OBW-3A-003) was not done in conformance with the approved WPS.

Applicable reference:

Approved WPS-B-2231-T

Who discovered the problem: Hiranch Patel**Name of individual from Contractor notified:** Li Man Kit**Time and method of notification:** 0800 hours, Verbal**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** 1300 hours, Verbal**QC Inspector's Name:** Zang Hai, Wang Zhu**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 Eric Tsang, +(86) 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric SMR**Reviewed By:** Wahbeh, Mazen SMR

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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-000281**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0210**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: 28-Mar-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed the flux-cored arc welding of segment 3AW/3BW weld joint (OBW-3A-003). During the inspection, it was found that the welding parameters did not comply with the approved WPS. The welding parameters recorded by the QA Inspector are "345 Amps and 38 Volts." According to the approved WPS, the allowable parameter ranges are "280~313.3 Amps and 28~30 Volts". Therefore, the welding of this joint (OBW-3A-003) was not done in conformance with the approved WPS.

Contractor's proposal to correct the problem:

Contractor has acknowledged that this item must be addressed, and the item was added to the Master Punchlist.

Corrective action taken:

Completion of work being tracked on Master Punchlist. Submittal of documentation by Contractor being tracked on Documentation Punchlist.

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:**

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Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer