

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-000246

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 29-Mar-2009

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

NCR #: ZPMC-0220

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Crossbeam 4
Procedural	Procedural	Description:	

Reference Description: Welder was welding in an unqualified position

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed welder Mao Shuai (217294) welding in the 4G position on weld joint CB201G-148/166 in OBG Assembly Bay 5. QA Inspector asked for welder's qualification card for verification. It was noted that the welder was not qualified to weld in the 4G position. Therefore, this welder was welding in an unqualified position.



Applicable reference:

AWS D1.5 (2002) - Sec. 5.24.2.2: "A change in the position of welding to one for which the welder is not already qualified shall require requalification."

Who discovered the problem: Joe Alaniz

Name of individual from Contractor notified: Kelvin Cheung

Time and method of notification: 1600 hours, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 1300 hours, Verbal

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: Shen Xue Jun

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
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Reviewed By:	Wahbeh, Mazen	SMR
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NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000212

Subject: NCR No. ZPMC-0220

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000219 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will test this welder in the 4G position and submit the documentation at a later date.
ZPMC will test this welder in the 4G position and submit the documentation at a later date.

Submitted by:

Attachment(s): ABF-NPR-000219R00

Caltrans' comments:

Status: AAP

Date: 04-Jun-2009

The response is acceptable, but the Non-Conformance is not closed.

Provide the welder qualification record documenting that the welder has completed the qualification testing. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0220 at that time.

The qualification record must be submitted and approved before this weld can be accepted.

Submitted by: Wright, Doug

Date: 04-Jun-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000212

Subject: NCR No. ZPMC-0220

Dated: 15-Jun-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000219 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has provided the inspection documentation of this weld, the welder will be re-tested in the near future.
ZPMC has provided the inspection documentation of this weld, the welder will be re-tested in the near future.

Submitted by:

Attachment(s): ABF-NPR-000219R01;

Caltrans' comments:

Status: AAP

Date: 17-Jun-2009

The response is acceptable, but the Non-Conformance is not closed.

Provide the welder qualification record documenting that the welder has completed the qualification testing. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0220 at that time.

The qualification record must be submitted and approved before this weld can be accepted.

Submitted by: Wright, Doug

Date: 17-Jun-2009

Attachment(s):



Visual Weld Inspection Report

焊缝目视检查报告

Caltrans Contract No. 04-0120F4
加州合同编号

Project No.: San Francisco Oakland Bay Bridge 美
项目名称 国海湾大桥

Project No.: ZP06-787
项目编号:

Quality Assurance Manager
~Approval
质量控制经理:

2Pine - 0220
Final VY/AT
Reports

周数 70 #
日期 2009.04.30

OBG Corner Assembly

NA

Wong 07120711

Weld No. 缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Overlap 焊瘤	Crater 弧坑	Arc 电弧	Spatter 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair
CB201G-001-147	215085	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-001-165	215085	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-001-148	215085	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-001-166	215085	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-002-147	217294	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-002-165	217294	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-002-148	217294	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-002-166	217294	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-003-147	68864	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-003-165	68864	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-003-148	68864	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-003-166	68864	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-004-147	69682	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-004-165	69682	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-004-148	69682	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA
CB201G-004-166	69682	2F	Supercored71H(1.4)	✓	✓	✓	✓	✓	✓	✓	Acc	NA	NA

After root weld

After CWR or WRR No.:

After cover pass

After HSR No.: HSR(18) - 6038

Others

"✓" is no defects. "X" is defects. "NA" is not applicable.



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-10949		DATE日期 2009.05.16	PAGE OF页码 7/17	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: CB4 OBG CORNER ASSEMBLY		CALTRANS CONTRACT NO.: 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 , 2009	
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620	
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	
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-345F2-X/A709M-345T2-X 14/12/22/20/16mm	
WELDING PROCESS 焊接方法	FCAW	TYPE OF JOINT 焊缝类型	T-JOINT	

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			
CB201G-004-147				ACC.		100%MT
CB201G-004-165				ACC.		100%MT
CB201G-004-148				ACC.		100%MT
CB201G-004-166				ACC.		100%MT
CB201G-004-036				ACC.		100%MT
CB201G-004-038				ACC.		100%MT
CB201G-004-040				ACC.		100%MT
CB201G-004-042				ACC.		100%MT
CB201G-004-044				ACC.		100%MT
CB201G-004-062				ACC.		100%MT
CB201G-004-066				ACC.		100%MT
CB201G-004-068				ACC.		100%MT

EXAMINED BY主探 <u>Ding's cheng</u>	REVIEWED BY 审核 <u>Yuan tao</u>
LEVEL - II SIGN 签名 / DATE日期 <u>09.05.16</u>	LEVEL-II SIGN / DATE日期 <u>09.05.16</u>
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: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000212

Subject: NCR No. ZPMC-0220

Dated: 27-Jul-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000219 **Rev:** 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000219R02;

Caltrans' comments:

Status: REJ

Date: 20-Aug-2009

The proposed resolution is not acceptable. The attached welder qualification documentation is not complete.

Please submit the Welder Performance Qualification Test Report and the RT report for welder ID# 217294 indicating the 4G position qualified.

The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0220 that time.

Submitted by: Wright, Doug

Date: 20-Aug-2009

Attachment(s):



No. B-404

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-7-20

REGARDING: NCR-00246/241 (ZPMC-0220/215)

With this letter of response, ZPMC requests closure for Caltrans **NCR-00246/241 (ZPMC-0220/215)**. According to the NPR comments that "provide the welder qualification record documenting that the welder has completed the qualification testing", therefore we have made the qualification for that two welder, and notify the caltrans inspector to witness all of the process. And as the specification of the AWS ,we have make the RT inspection for the bevel joint test piece and break test for the tack weld piece. Basically as the acceptable report we consider that the welder have complete the test.

So base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report **NCR-00246/241 (ZPMC-0220/215)**.

Please reference attached documentation for acceptance and closure the **NCR-00246/241 (ZPMC-0220/215)**.

ATTACHMENT:

NCR-00246/241 (ZPMC-0220/215)

The welder qualified detail pictures

The RT report for the bevel joint test piece

The break test report for the tack weld piece

Zhao Shuangbao

2009. 7. 20

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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-000246

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 29-Mar-2009

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

NCR #: ZPMC-0220

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

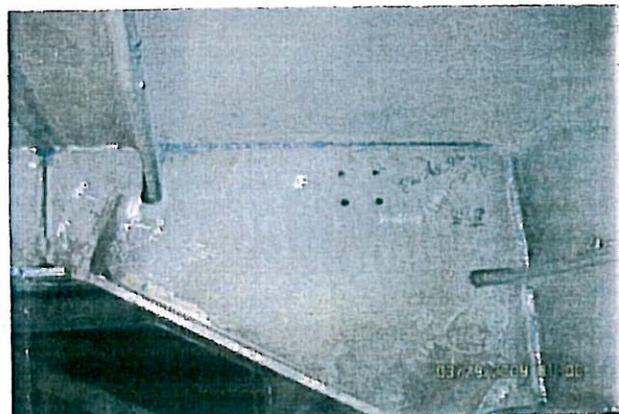
Bridge No: 34-0006

Component: OBG Crossbeam 4

Reference Description: Welder was welding in an unqualified position

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed welder Mao Shuai (217294) welding in the 4G position on weld joint CB201G-148/166 in OBG Assembly Bay 5. QA Inspector asked for welder's qualification card for verification. It was noted that the welder was not qualified to weld in the 4G position. Therefore, this welder was welding in an unqualified position.

**Applicable reference:**

AWS D1.5 (2002) - Sec. 5.24.2.2: "A change in the position of welding to one for which the welder is not already qualified shall require requalification."

Who discovered the problem: Joe Alaniz

Name of individual from Contractor notified: Kelvin Cheung

Time and method of notification: 1600 hours, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 1300 hours, Verbal

The welder qualification detail pictures

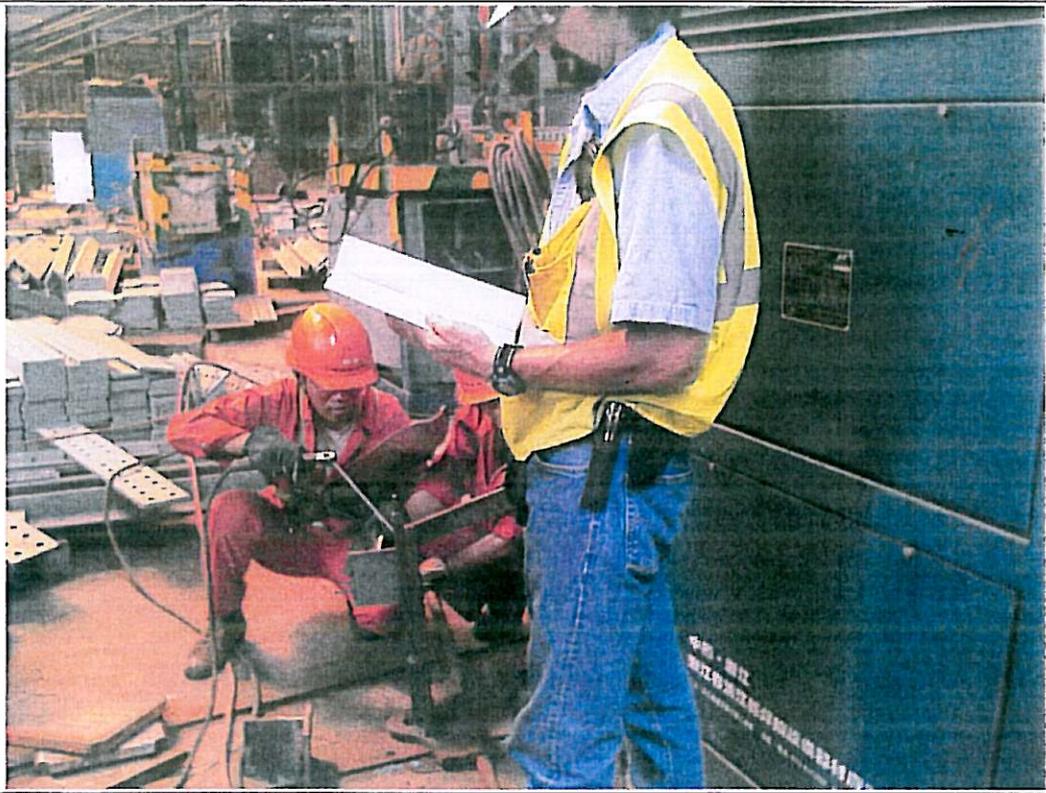
1



2



3



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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-000241

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Mar-2009

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

NCR #: ZPMC-0215

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: X8E Plate/Stiffener - Segment 4BE

Reference Description: Unapproved/non-certified welder was performing base metal repairs

Description of Non-Conformance:

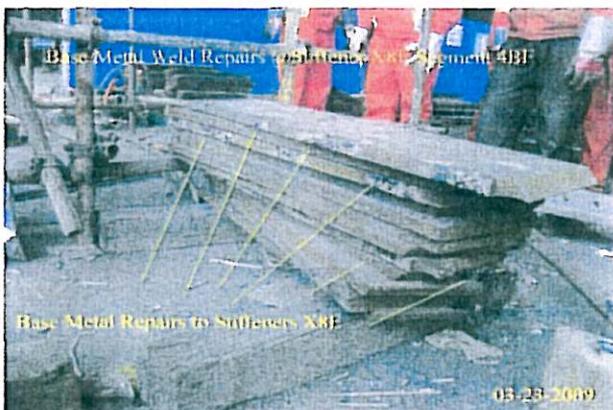
Quality Assurance (QA) Inspector observed a ZPMC personnel performing the base metal repairs on an X8E (stiffener plate) for Segment 4BE. The following issues were found by the QA Inspector:

-Unapproved and non-certified welder was performing the SMAW base metal repairs. The name of this person is **Hu Zhan Ling** (worker's ID# 208493).

-No welding repair was done without a welding repair report.

-Quality Control (QC) did not find that the person welding is a non-certified and unapproved welder.

Therefore, the welding of the X8E Plate/Stiffener was done not according to the project requirement.



Applicable reference:

2009年焊工考试试板点焊试验记录

Bending Retest Record of Welder Qualification

试验委托单号 Consigning list of testing: WT-LX-20090717-4		检测依据 Test Standard: AWS D1.5						
样品接收日期 Date of receiving the Spe.: July 17, 2009		送样人 Sender: 赵双宝						
试验设备名称 Testing equipment: WE-600								
试验设备编号 Equipment No.: ZTC-L-002								
试验员 Operator: 殷国华、邵飞飞		审核 Reviewed by: <i>[Signature]</i> 见证 Witnessed by: <i>[Signature]</i> 310709						
接收人 <i>[Signature]</i> 上海振华重工(集团)股份有限公司 检测中心 报告专用章(力学) 环境温度 Surround temp.: 26°C								
样品号 Specimen No.	试板编号 No.	焊接位置 Welding Position	焊接方法 Welding Process	焊工姓名	弯曲类型 Type of Bend	弯曲条件 Bending Condition	试验结果 Test Result	试验日期 Test Date.
208493	-	-	1F	Hu Zhan Ling	-	-	OK	July 17, 2009
209664	-	-	3F	Zhang Cheng	-	-	OK	July 17, 2009

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000212

Subject: NCR No. ZPMC-0220

Dated: 27-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000219 **Rev:** 03

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has attached the additional documents as requested for closure of this NCR.
ZPMC has attached the additional documents as requested for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000219R03;

Caltrans' comments:

Status: CLO

Date: 10-Sep-2009

The proposed resolution is acceptable. All of the required documents have been provided showing that the welder is qualified. The Department concurs that Non-Conformance ZPMC-0220 is closed.

Submitted by: Wright, Doug

Date: 10-Sep-2009

Attachment(s):



No. B-464

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-26

REGARDING: NCR-000246/241 (ZPMC-220/215)

With this letter of response, ZPMC requests closure for Caltrans NCR-000246/241 (ZPMC-220/215). Per the comments of the NCR proposed resolution we submit the welder performance qualification test reports for the two welders, and apply to close out the NCR in current.

so base on the above explanation, ZPMC applies to close the caltrans's report NCR-000246/241 (ZPMC-220/215).

Please reference attached document for acceptance and closure the NCR-000246/241(ZPMC-220/215).

ATTACHMENT:

NCR-000246/241 (ZPMC-220/215)

The welder performance qualification test reports

Zhao Shuang Bao

2009. 8. 26



SHANGHAI ZHENHUA HEAVY INDUSTRY CO., LTD

WELDER PERFORMANCE QUALIFICATION TEST REPORT

Welder's Name: Hu Zhan ling	WPS No.: WPS-B-P-2111	Test Date: 14 July 2009
I.D. No.: 208493	Application No.: NA	Test/Stamp No.: 208493
VARIABLE	ACTUAL QUAL VALUE	QUALIFICATION RANGE
Process	SMAW	SMAW
Process Type	Manual	Manual
Backing	NA	NA
Base Metal Spec/P or M-Number	ASTM A709 Grade 345	ASTM A709 Grades 250 & 345
Thickness - Groove	NA	NA
Thickness - Fillet	12mm	3mm ~ Unlimited
Diameter - Groove	N/A	N/A
Diameter - Fillet	N/A	N/A
Filler Metal		
Specification No.	AWS A5.1	N/A
Classification No.	E7018	N/A
F No.	NA	NA
Trade Name	TL-508	N/A
Diameter	4.0mm	N/A
Flux	NA	N/A
Deposited Weld Metal Thickness	N/A	N/A
Position	1F	1F
Vertical Progression	N/A	N/A
Shielding Gas	NA	NA
Root Shielding Gas	N/A	N/A
Current/Polarity	DCEP	DCEP
Transfer Mode	NA	N/A
Welding Witnessed by: Li Yanhua	CWI No.: 07120701	
Name of the Welding Test Center: Shanghai Zhenhua Heavy Industry Co., Ltd.		

TEST RESULTS

Type and Figure No.	Results	Type and Figure No.	Results
Split test	OK	Charpy V-Notch Impact	N/A
All Weld Metal Tension	N/A	Side Bend	N/A

Mechanical Test Conducted by (Name of the Testing Lab): Shanghai Zhenhua Port Machinery Co., Ltd.

NONDESTRUCTIVE EXAMINATION RESULTS

Visual Inspection Results: Acceptable	Visual Inspected by: Li Yanhua	Date: 2009-07-14
Ultrasonic Inspection Results: Acceptable	UT Report No.: NA	Date: NA
Macro Examination Results: Acceptable	ME Report No.: N/A	Date: NA

Radiographic Testing Conducted by (Name of the test lab): Shanghai Zhenhua Heavy Industry Co., Ltd.

We certify that the statements in this record are correct and the test weld was welded in compliance with the AWS D1.5M/D1.5:2002 Bridge Welding Code.

Date Qualified: 17 July 2009 By: ABE QCM Date: 17 July 2009

2009年焊工考试试板点焊试验记录

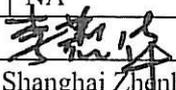
Bending Retest Record of Welder Qualification

试验委托单号 Consigning list of testing: WT-LX-20090717-4		检测依据 Test Standard: AWS D1.5						
样品接收日期 Date of receiving the Spe.: July 17, 2009		送样人 Sender: 赵双宝						
试验设备名称 Testing equipment: WE-600		<div style="border: 1px solid black; padding: 5px; display: inline-block;"> 接收人 邵飞飞 (集团) 上海振华重工 (集团) 股份有限公司 检测中心 报告专用章 (力学) </div>						
试验设备编号 Equipment No.: ZTC-L-002		审核 Reviewed by: <i>[Signature]</i>						
试验员 Operator: 殷国华、邵飞飞		见证 Witnessed by: <i>[Signature]</i> 环境温度 Surround temp.: 26°C						
样品号 Specimen No.	试板编号 No.	焊接位置 Welding Position	焊接方法 Welding Process	焊工姓名	弯曲类型 Type of Bend	弯曲条件 Bending Condition	试验结果 Test Result	试验日期 Test Date.
208493	-	-	1F	Hu Zhan Ling	-	-	OK	July 17, 2009
209664	-	-	3F	Zhang Cheng	-	-	OK	July 17, 2009



SHANGHAI ZHENHUA HEAVY INDUSTRY CO., LTD

WELDER PERFORMANCE QUALIFICATION TEST REPORT

Welder's Name: Mao Shuai	WPS No.: WPS-B-T-2234-B-U2a-F	Test Date: 14 July 2009
I.D. No.: 217294	Application No.: NA	Test/Stamp No.: 217294
VARIABLE	ACTUAL QUAL VALUE	QUALIFICATION RANGE
Process	FCAW	FCAW
Process Type	Manual	Manual
Backing	Steel backing	Steel backing
Base Metal Spec/P or M-Number	ASTM A709 Grade 345	ASTM A709 Grades 250 & 345
Thickness – Groove	25mm	3mm ~ Unlimited
Thickness – Fillet	NA	NA
Diameter - Groove	NA	NA
Diameter - Fillet	N/A	N/A
Filler Metal		
Specification No.	AWS A5.20	N/A
Classification No.	E71T-1	N/A
F No.	NA	NA
Trade Name	Supercored 71H	N/A
Diameter	Φ1.4mm	N/A
Flux	NA	N/A
Deposited Weld Metal Thickness	N/A	N/A
Position	4G	1G,2G,4G
Vertical Progression	N/A	N/A
Shielding Gas	100%CO2	N/A
Root Shielding Gas	N/A	N/A
Current/Polarity	DCEP	DCEP
Transfer Mode	NA	N/A
Welding Witnessed by: Li Yanhua 	CWI No.: 07120701	
Name of the Welding Test Center: Shanghai Zhenhua Heavy Industry Co., Ltd.		

TEST RESULTS

Type and Figure No.	Results	Type and Figure No.	Results
Split test	N/A	Charpy V-Notch Impact	N/A
All Weld Metal Tension	N/A	Side Bend	N/A

Mechanical Test Conducted by (Name of the Testing Lab): Shanghai Zhenhua Heavy Industry Co., Ltd.

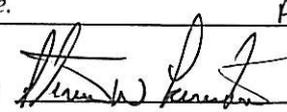
NONDESTRUCTIVE EXAMINATION RESULTS

Visual Inspection Results: Acceptable	Visual Inspected by: Li Yanhua	Date: 2009-07-14
Radiographic Inspection Results: Acceptable	RT Report No.: HK-LB-001	Date: 2009-07-17
Macro Examination Results: N/A	ME Report No.: N/A	Date: NA

Radiographic Testing Conducted by (Name of the test lab): Shanghai Zhenhua Heavy Industry Co., Ltd.

We certify that the statements in this record are correct and the test weld was welded in compliance with the AWS D1.5M/D1.5:2002 Bridge Welding Code.

ABF QCM

Date Qualified: 17 July 2009	By: 	Date: 17 July 2009
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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, P.R. China**Report No:** NCS-000294**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0220**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 29-Mar-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed welder Mao Shuai (217294) welding in the 4G position on weld joint CB201G-148/166 in OBG Assembly Bay 5. QA Inspector asked for welder's qualification card for verification. It was noted that the welder was not qualified to weld in the 4G position. Therefore, this welder was welding in an unqualified position.

Contractor's proposal to correct the problem:

Contractor has acknowledged that this issue must be addressed, and it has been added to the Master Punchlist.

Corrective action taken:

Documentation of welder's qualifications is being tracked on the Documentation Punchlist. Item was removed from the Master Punchlist on June 2, 2009.

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 Jim Simonis, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**