

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



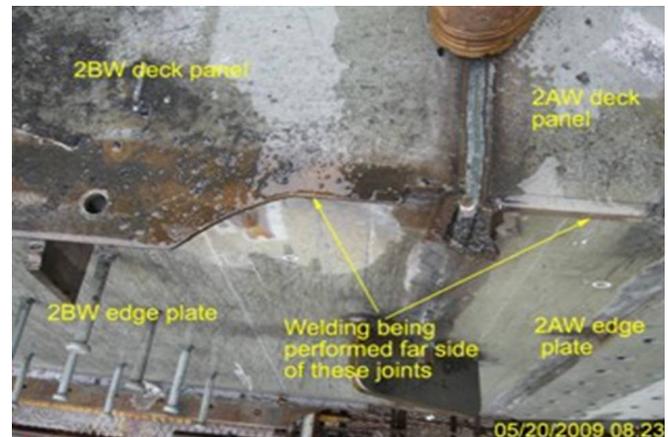
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000269**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-May-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0243**Type of problem:**

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

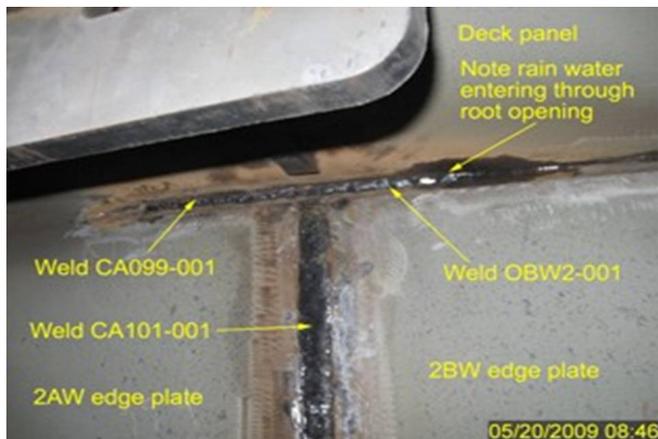
Bridge No: 34-0006**Component:** OBG Segments 2AW and 2BW**Reference Description:** Welding on Wet Material, Segments 2AW & 2BW**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed ZPMC welding personnel perform SMAW welding on SPCM material while the material was wet. The weld joints are identified as CA099-001(segment 2AW) and CA101-001 (segment 2BW).



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002 section 3, paragraph 3.1.3 "Welding shall not be done when the surfaces are wet or exposed to rain."

AWS D1.5 2002 section 3, paragraph 3.2.1 "Surfaces to be welded and surfaces adjacent to a weld shall also be free from moisture that would prevent proper welding."

Who discovered the problem: Steve Hall
Name of individual from Contractor notified: Peter Ferguson
Time and method of notification: 0930 hours, 05-20-09, Verbal
Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 1030 hours, 05-20-09, Verbal
QC Inspector's Name: Wu Zhi Cheng
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:	Guest, Skyler	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-May-2009

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: 05.03.06-000234

Subject: NCR No. ZPMC-0243

Reference Description: Welding on Wet Material, Segments 2AW & 2BW

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:**

Remarks:

Caltrans Quality Assurance (QA) Inspector observed ZPMC welding personnel perform SMAW welding on SPCM material while the material was wet. The weld joints are identified as CA099-001(segment 2AW) and CA101-001 (segment 2BW).

Action Required and/or Action Taken:

Please propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0243

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, Jason Tom, Ching Chao

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000234

Subject: NCR No. ZPMC-0243

Dated: 27-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000238 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has notified ZPMC QA/QC/Production to strictly comply with the AWS code and not weld during inclement weather conditions. ZPMC will submit inspection documents at a later date.

ABF has notified ZPMC QA/QC/Production to strictly comply with the AWS code and not weld during inclement weather conditions. ZPMC will submit inspection documents at a later date.

Submitted by:

Attachment(s): ABF-NPR-000238R00

Caltrans' comments:

Status: REJ

Date: 09-Jun-2009

The proposed resolution is not acceptable. Welding and/or gouging of welds while wet has been a recurring issue. In addition to NCR ZPMC-243, this issue has been documented in NCRs ZPMC-229, ZPMC-248, and ZPMC-266.

Please submit details describing what will be done to prevent future occurrences of this issue, and what testing will be done to ensure that the welds are sound. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0243 at that time.

Submitted by: Wright, Doug

Date: 09-Jun-2009

Attachment(s): NPR CT Comments

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000234

Subject: NCR No. ZPMC-0243

Dated: 03-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000238 Rev: 01

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-000238R01;

Caltrans' comments:

Status: CLO

Date: 24-Aug-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0243 is closed.

Submitted by: Wright, Doug

Date: 24-Aug-2009

Attachment(s):



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B
 项目名称: 美国加州海湾大桥
 NCR Number: NCR-B-161 (NCR-00269)
 NCR 编号:

Item: Welding on Wet Material
 名称描述: 潮湿母材上焊接
 Item Number: CA099-001
 件号: CA101-001
 Drawing: CA099, CA101
 图号:

Location: Trail Assembly Yard 2AW & 2BW
 位置: 总拼外场 2AW 和 2BW
 Date: 2009-06-02
 日期:

Description of Nonconformance:
 不符合项状态描述:
 Caltrans Inspector observed ZPMC welding personnel perform SMAW welding on SPCM material while the material was wet. The weld joint are identified as CA099-001 (SEGMENT 2AW) and CA101-001 (SENGMET 2BW)
 加州检验员发现焊工在对 SPCM 母材进行 SMAW 焊接, 而母材是潮湿的。相关焊缝为 CA099-001 (2AW), 以及 CA101-001(2BW)。
 AWS D1.5 2002 版, 章节 3.1.3 “严禁在表面潮湿或者暴露于雨、雪之中进行焊接”
 Work By: Prepared by: Reviewed by QCE:
 施工方: Xiaofan Jin 准备: Li Lu 质量工程师批准: zhuishuangbao
 Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因 6.2

Disposition: Use as is Repair Reject
 处理措施: 回用 返修 拒收

Recommendation:
 建议: 加强对现场的监控, 焊接前必须先检查母材的状态
 Enhance supervision on-site. Check base metal condition before welding.
 Prepared by: Du Wenling Approved by QCA: _____
 准备 质量经理批准

Reason for Nonconformance:
 不符合原因: 母材是湿的情况下对 SPCM 母材进行 SMAW 焊接。
 预防措施: 加强对现场监控, 检查, 并对焊工进行教育。
 Approved by/批准: Gao Jun 09.05.12

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
 回用或返修的技术依据: 对焊缝作 NDT 检测, 加强焊工培训, perform NDT and training.
 Reviewed /批准: Li Lu 06/02/09
 perform NDT inspection and train workers.

Verification: Acceptable Unacceptable
 确认: 可接受 不可接受

Verified by QCI/质检确认: _____ Reviewed by QCA/质检主任审核: _____



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 Date: 22-May-2009
 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: 05.03.06-000234
 Subject: NCR No. ZPMC-0243

Reference Description: Welding on Wet Material, Segments 2AW & 2BW

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Material Location: OBG Lift:

Remarks:

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Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0243

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, Jason Tom, Ching Chao

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
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Vallejo, CA 94592-1133
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(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-000269

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-May-2009

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

NCR #: ZPMC-0243

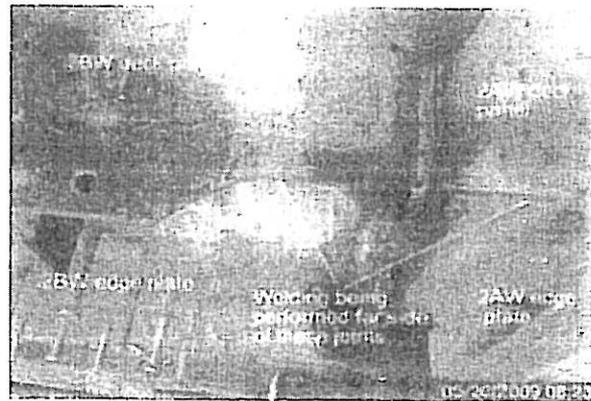
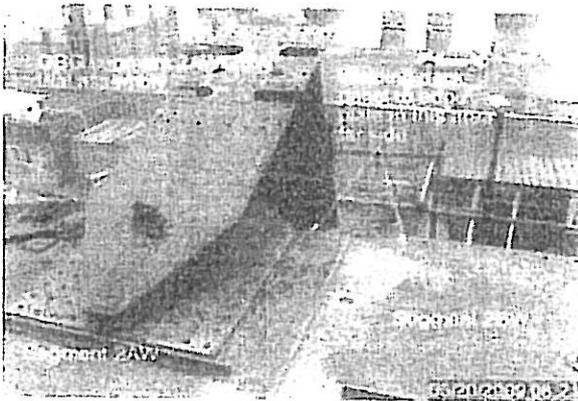
Type of problem:

Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: OBG Segments 2AW and 2BWProcedural Procedural Description:

Reference Description: Welding on Wet Material, Segments 2AW & 2BW

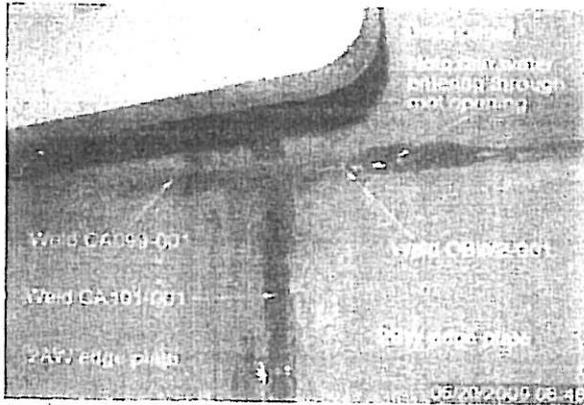
Description of Non-Conformance:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 0930 hours, 05-20-09, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 1030 hours, 05-20-09, Verbal

QC Inspector's Name: Wu Zhi Cheng

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

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Inspected By: Guest,Skylar

SMR

Reviewed By: Wahbeh,Mazen

SMR



Visual Weld Inspection Report
焊缝目视检查报告

周数 82

日期 2009.05.28

Caltrans Contract No. 加州合同编号		04-0120F4		Girder/ 梁: Tower/ 塔:		OBG Plate Panel Splice	
Project No.: 项目名称		San Francisco Oakland Bay Bridge 旧金山海湾大桥		Quality Control Representative: 质检代表:		N/A	
Project No.: 项目编号:		ZP06-787		CWI: 检验员:		Wang Lu Wu Shicheng	
Weld No. 焊缝编号		Welder I.D.# 焊工识别号		Quality Assurance Manager ~Approval 质量控制经理:		L. J. Ramirez	
CA099-001-006	4G	THJ506Fe-1(Φ4.0)	√	Undercut 咬边	√	Porosity 气孔	√
CA099-001-005	2G+4G	supercore71H(Φ1.4)THJ506Fe-1(Φ4.0)	√	Crater 弧坑	√	Arc strike 电弧擦伤	√
SEG007A-001-028	4G	THJ506Fe-1(Φ4.0)	√	Over lap 焊瘤	√	Spatters 飞溅	√
SEG007A-001-027	2G+4G	supercore71H(Φ1.4)THJ506Fe-1(Φ4.0)	√	Crack 裂纹	√	Crater 弧坑	√
				Accept or Reject 接受或拒收	ACC	Repair 返修	NA
				Accept or Reject 接受或拒收	ACC	Repair 返修	NA
				Accept or Reject 接受或拒收	ACC	Repair 返修	NA
				Accept or Reject 接受或拒收	ACC	Repair 返修	NA
				Accept or Reject 接受或拒收	ACC	Repair 返修	NA
				Accept or Reject 接受或拒收	ACC	Repair 返修	NA

After root weld

After CWR or WRR No.:

#R787-QCP-603

After cover pass

After HSR No.:

Others

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



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-7509 DATE 2009.07.11 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 2AW CORNER ASSEMBLY DRAWING NO.: OBW2 CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 SMAW FCAW CORNER-JOINT Dec. 28ST, 2009

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345 20/25/18/16mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	Reference Level 参考灵敏度			20dB

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)							
									a	b	c	d	Length 长度			Sound Path 声程
CA099-001-006		70						34							ACC.	100%
CA099-001-005		70						34							ACC.	100%
SEG007A-001-028		70						34							ACC.	100%
SEG007A-001-027		70						34							ACC.	100%

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EXAMINED BY 主探 REVIEWED BY 审核
Han Feng 07.7.11 Huang Jin 07.7.11
 LEVEL - II SIGN / DATE LEVEL - II SIGN / DATE

质量经理 / QCM 用户CUSTOMER
Liu Panhua 7/1/09 _____
 签字 SIGN / 日期 DATE 签字 SIGN / 日期 DATE



Visual Weld Inspection Report
焊缝目视检查报告

Caltrans Contract No. 加州合同编号		04-0120F4		Girder/梁:		OBG Plate Panel Splice						
Project No.: 项目名称		San Francisco Oakland Bay Bridge 国海湾大桥		Tower/塔:		N/A						
Project No.: 项目编号:		ZP06-787		Quality Control Representative: 质检代表:		Wang Lu Wu Zhicheng 08021751						
Welder I.D.# 焊工识别号		Location 位置		Quality Assurance Manager ~Approval 质量控制经理:		Lin Zhenhua						
Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 修后接受或拒
CA099-001-006	048617	THJ506Fe-1(Φ4.0)	√	√	√	√	√	√	√	ACC	NA	NA
CA099-001-005	202841 048617	supercore71H(Φ1.4)THJ506Fe-1(Φ1.4)	√	√	√	√	√	√	√	ACC	NA	NA
<input type="checkbox"/> After root weld <input type="checkbox"/> After CWR or WRR No.:												
<input type="checkbox"/> After cover pass <input type="checkbox"/> After HSR No.:												

#R787-QCP-603 Others *NR-B-161*

"√" 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-12132		DATE日期 2009.06.29		PAGE OF页码 1/1	Revision No: 0	
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: OBW2 OBG PLATE PANEL SPLICE			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-345 18/20/25			
WELDING PROCESS 焊接方法	SMAW/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			
CA099-001-005				ACC.		100%MT
CA099-001-006				ACC.		100%MT
CA101-001-001				ACC.		100%MT
CA101-001-002				ACC.		100%MT
BLANK						
EXAMINED BY主探 Jin Jianting Jin Jianting 09.06.29 LEVEL - II SIGN 签名 / DATE日期			REVIEWED BY 审核 Gai Xinxin 09.06.29 LEVEL-II SIGN / DATE日期			
质量经理 / QCM Liu Jianting 6/29/09 签字 SIGN / 日期 DATE			用户CUSTOMER _____ 签字 SIGN / 日期 DATE			



Visual Weld Inspection Report
焊缝目视检查报告

Caltrans Contract No. 加州合同编号		04-0120F4		Girder/梁:		OBG Plate Panel Splice		周数	86														
Project No.: 项目名称		San Francisco Oakland Bay Bridge 国海湾大桥		Tower/塔:		N/A		日期	2009.06.26														
Project No.: 项目编号:		ZP06-787		Quality Control Representative: 质检代表:		Wang, Lu Wu Zhicheng 08021751																	
Weld No. 焊缝编号		Welder I.D.# 焊工识别号		Quality Assurance Manager ~Approval 质量控制经理:		Lu Jiansheng																	
CA101-001-002	4G	THJ506Fe-1(Φ4.0)	√	Undercut 咬边	√	Porosity 气孔	√	Over lap 焊瘤	√	Crater 弧坑	√	Arc strike 电弧擦伤	√	Spatters 飞溅	√	Crack 裂纹	√	Accept or Reject 接受或拒收	ACC	Repair 返修	NA	Accept or Reject after repair 修后接受或拒	NA
CA101-001-001	2G+4G	supercore71H(Φ1.4)THJ506Fe-1(Φ1.4)	√	Undercut 咬边	√	Porosity 气孔	√	Over lap 焊瘤	√	Crater 弧坑	√	Arc strike 电弧擦伤	√	Spatters 飞溅	√	Crack 裂纹	√	Accept or Reject 接受或拒收	ACC	Repair 返修	NA	Accept or Reject after repair 修后接受或拒	NA

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000248**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0243**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: 20-May-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed ZPMC welding personnel perform SMAW welding on SPCM material while the material was wet. The weld joints are identified as CA099-001(segment 2AW) and CA101-001 (segment 2BW).

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 is being tracked on the 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:**

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