

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-000316

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Jun-2009

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

NCR #: ZPMC-0290

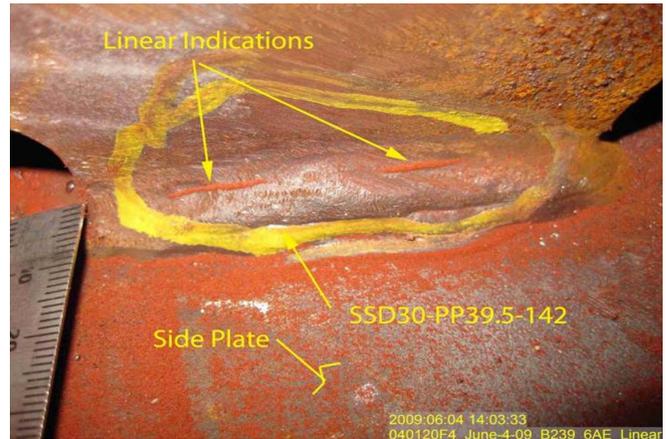
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 6AE
Procedural	Procedural	Description:	

Reference Description: Missed MT Indications by QC, Segment 6AE

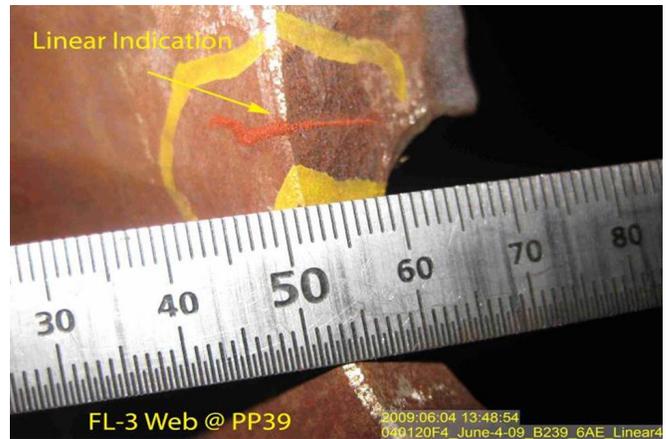
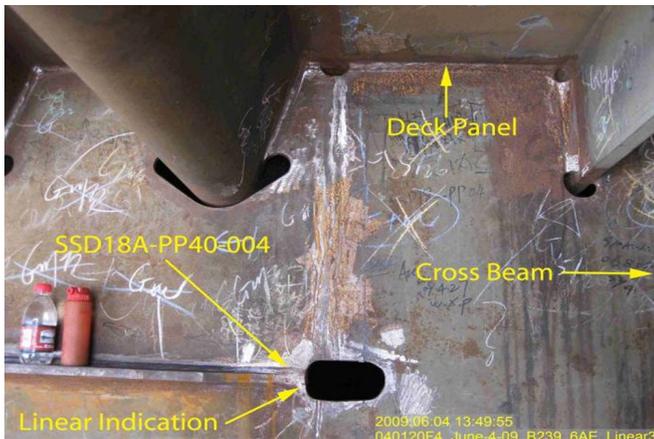
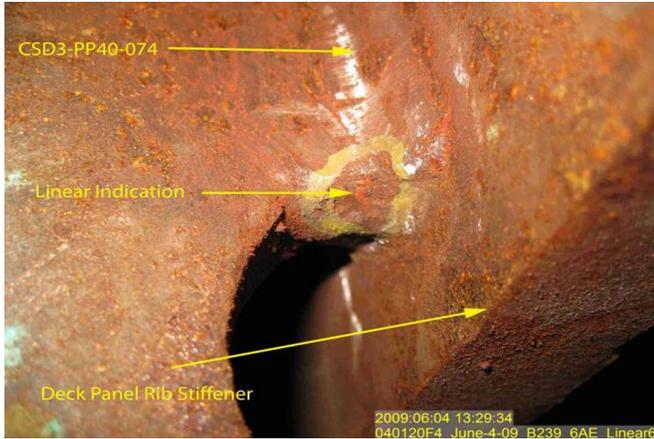
Description of Non-Conformance:

During random verification magnetic particle testing (MT) of the internal components of OBG Segment 6AE, Caltrans Quality Assurance (QA) Inspector discovered a total of five (5) linear indications ranging from 10 to 40mm in length in the following welds: SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 and SSD30-PP39.5-142. These welds have been previously tested and accepted by ZPMC Quality Control (QC) MT technicians.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



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 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.”

Who discovered the problem: Rodney Patterson
Name of individual from Contractor notified: Peter Shaw
Time and method of notification: 06/04/09, 16:00, Verbal
Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 06/08/09, 8:00, Verbal
QC Inspector's Name: Wang Lu
Was QC Inspector aware of the problem: Yes No
Contractor's proposal to correct the problem:

Comments:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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 Skyler Guest, (86) 1500.042.2360, 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: 14-Jun-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: 05.03.06-000278

Subject: NCR No. ZPMC-0290

Reference Description: Missed MT Indications by QC, Segment 6AE

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:** 06

Remarks:

During random verification magnetic particle testing (MT) of the internal components of OBG Segment 6AE, Caltrans Quality Assurance (QA) Inspector discovered a total of five (5) linear indications ranging from 10 to 40mm in length in the following welds: SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 and SSD30-PP39.5-142. These welds have been previously tested and accepted by ZPMC Quality Control (QC) MT technicians.
See NCR report No. ZPMC-290 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem in quality control with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0290

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, 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: 05.03.06-000278

Subject: NCR No. ZPMC-0290

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000311 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has notified ZPMC of the missed MT indications and ZPMC has completed the necessary repairs. ABF is also conducting an investigation of why ZPMC is experiencing cracking of welds.

ABF has notified ZPMC of the missed MT indications and ZPMC has completed the necessary repairs. ABF has taken action by hiring several MT technicians to perform overchecks of several types of welds due to the amount of missed indications. ABF is also conducting an investigation of why ZPMC is experiencing cracking of welds. This investigation is being performed by both onsite ABF personnel as well as welding experts hired by ABF for this purpose. Recently CT has brought in their own welding consultant to discuss ABF findings and preventive actions. Preventive actions such as increased preheats have been discussed with ZPMC. When the investigation is completed, ABF will submit the findings to ZPMC and CT. ABF will continue to perform overchecks until we are sure this issue is corrected and preventive actions are implemented. ZPMC will submit the repair documents at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000311R00

Caltrans' comments:

Status: AAP

Date: 09-Sep-2009

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

Please provide documentation of the weld repairs that were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0290 at that time.

Submitted by: Wright, Doug

Date: 09-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000278

Subject: NCR No. ZPMC-0290

Dated: 15-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000311 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired these indication using grinding and is attaching NDT reports to show that the welds are acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC has repaired these indication using grinding and is attaching NDT reports to show that the welds are acceptable. ZPMC has conducted training with its inspectors to decrease occurrences of missed indications. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000311R01;

Caltrans' comments:

Status: CLO

Date: 17-Mar-2010

The assertion that these indications were removed by slight grinding (as mentioned in the NPR response) is not correct. Some indications were very deep and could not be removed by light grinding. However, the NDT information supplied indicates these locations have been repaired. Therefore this NCR can be closed.

Submitted by: Howe, Bill

Attachment(s):

Date: 17-Mar-2010



No. B-675

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-15

REGARDING: NCR-000316(ZPMC-0290)

ZPMC acknowledged this problem and has issued internal NCR. After slight grinding these MT linear indications were removed and are now accepted by CT and have been removed from punchlist. ZPMC is providing the NDT records show the welds are acceptable after grinding. Based on this, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-000316(ZPMC-0290)

B787-MT-19882

B787-MT-19880

B787-MT-19879

B787-MT-20701

fy

3/15/10



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-189
NCR 编号: (NCR-000316) ZPMC-290

Item: Missed MT Indications
名称描述: MT 漏检

Item Number: N/A
件号: N/A

Drawing: 6AE
图号: 6AE

Location: OBG Trail Assembly Yard
位置: OBG 外场

Date: 2009-06-19
日期: 2009-06-19

Description of Nonconformance:

不符合项状态描述:

During random magnetic particle testing of the internal component of OBG 6AE, Caltrans inspector discovered a total of five linear indications ranging from 10 to 40mm in length in the following welds: SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 and SSD30-PP39.5-142. These welds have been previously tested and accepted by ZPMC MT technicians.

在对 6AE 箱体内部的随机 MT 抽查中发现 5 处线状缺陷长度 10mm~40mm。焊缝如下: SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 和 SSD30-PP39.5-142。这些焊缝已经由 ZPMC MT 人员检测并接受,

参考标准: 参考标准: 标书章节 8.3 "QC 应承担承包商的职责。最少对每个焊缝焊前、焊中、焊后进行检查和检测并确保母材以及施工满足标准要求"。

Work By: Li Li Prepared by: Loi To Reviewed by QCE: Zhao Shuangbao
施工方: Li Li 准备: 6.19.09 质量工程师批准: Zhao Shuangbao
 Drawing Error Material Defect Fabrication Error Other
图纸错误 材料缺陷 制作错误 其他原因 6-19

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

Recommendation:

建议: 重新检测, 返修 Re-inspection and repair.

Prepared by: Li Li Approved by QCA: _____
准备 2010.03.12 质量经理批准

Reason for Nonconformance:

不符合原因: Discover
线状缺陷漏检, Linear defects
Enhance technology and reinspection

预防措施: 加强技术提升, 加强复检
Approved by/批准: Li Li 2010.03.12

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
回用或返修的技术依据:

附件 无附件

Reviewed /批准: _____

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
 375 BURMA ROAD
 OAKLAND CA 95607

Date: 14-Jun-2009

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-0290

Job Name: SAS Superstructure
 Document No: 05.03.06-000278

Reference Description: Missed MT Indications by QC, Segment 6AE

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: 06

Remarks:

During random verification magnetic particle testing (MT) of the internal components of OBG Segment 6AE, Caltrans Quality Assurance (QA) Inspector discovered a total of five (5) linear indications ranging from 10 to 40mm in length in the following welds: SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 and SSD30-PP39.5-142. These welds have been previously tested and accepted by ZPMC Quality Control (QC) MT technicians.
 See NCR report No. ZPMC-290 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem in quality control with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0290

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao
 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, P.R. China

Report No: NCR-000316

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Jun-2009

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

NCR #: ZPMC-0290

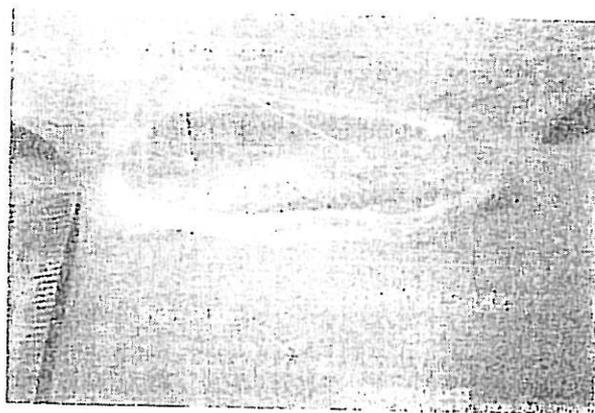
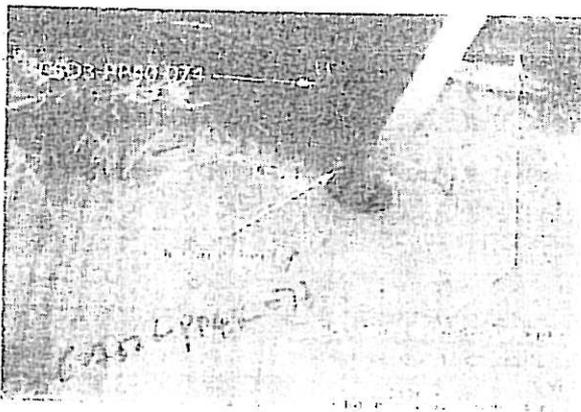
Type of problem:

- Welding Concrete Other
- Welding Curing Procedural Bridge No: 34-0006
- Joint fit-up Coating Other Component: OBG Segment 6AE
- Procedural Procedural Description:

Reference Description: Missed MT Indications by QC, Segment 6AE

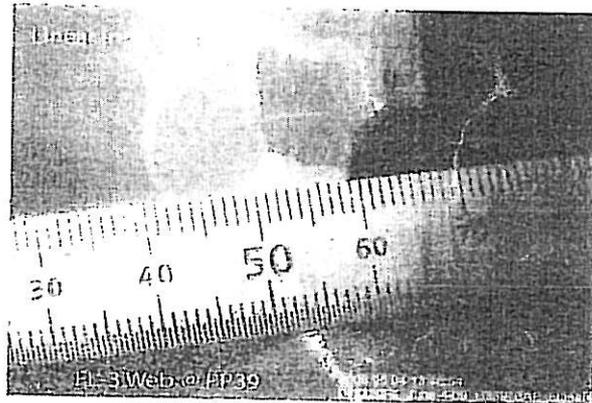
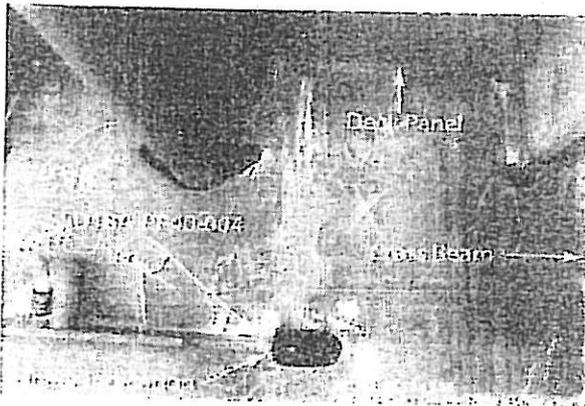
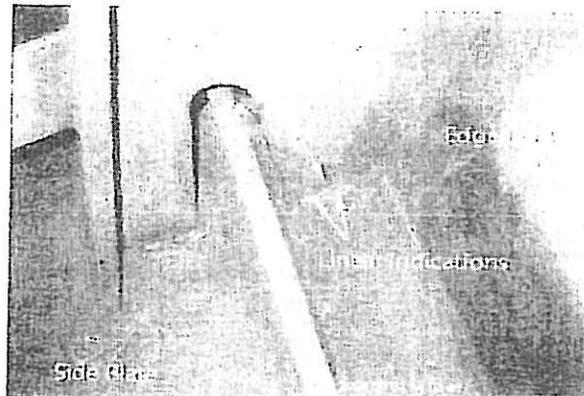
Description of Non-Conformance:

During random verification magnetic particle testing (MT) of the internal components of OBG Segment 6AE, Caltrans Quality Assurance (QA) Inspector discovered a total of five (5) linear indications ranging from 10 to 40mm in length in the following welds: SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 and SSD30-PP39.5-142. These welds have been previously tested and accepted by ZPMC Quality Control (QC) MT technicians.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



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 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.”

Who discovered the problem: Rodney Patterson
Name of individual from Contractor notified: Peter Shaw
Time and method of notification: 06/04/09, 16:00, Verbal
Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 06/08/09, 8:00, Verbal
QC Inspector's Name: Wang Lu
Was QC Inspector aware of the problem: Yes No
Contractor's proposal to correct the problem:

Comments:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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 Skyler Guest, (86) 1500.042.2360, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

SMR

Reviewed By: Wahbeh, Mazen

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-19882 DATE日期 2010.03.04 PAGE OF 页码 1/1 Revision No: 0

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

DRAWING NO. SSD30 CALTRANS CONTRACT NO.:
 图号: 6AW CORNER STEEL 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. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 连续编号
 MT YOKE PARKER B310S 5395 5617 5620

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

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

MATERIAL TO BE EXAMINED √ WELDING 焊接件 Material & thickness A709M-345T2-X
 检测材料 CASTING 铸件 母材, 厚度 10/18 mm
 FORGING 锻造

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			
SSD30-PP39.5-142				ACC.		100%MT

BLANK

EXAMINED BY 主探 _Sun Gongchang	REVIEWED BY 审核
LEVEL - II SIGN 签名 / DATE 日期	LEVEL-II SIGN / DATE 日期
质量经理 / QCM	用户 CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-19880 DATE日期 2010.03.04 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. CSD3 CALTRANS CONTRACT NO.: 04-0120F4
 图号: 6AW CORNER ASSEMBLY 加州工程编号

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 , 2010
---	--	-------------------------------------	---

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 30/22 mm	A709M-345T2/F2-X
---------------------------------	---	---	------------------

WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	CORNER 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			
CSD3-PP40-074				ACC.		100%MT

BLANK

EXAMINED BY 主探 Sun Gongchang	REVIEWED BY 审核
LEVEL - II SIGN 签名 / DATE 日期 质量经理 / QCM	LEVEL-II SIGN / DATE 日期 用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-20701 DATE日期 2010.03.04 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. SSD18A CALTRANS CONTRACT NO.:
 图号: 6AE FLOOR BEAM SPLICE 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 , 2010
---	--	-------------------------------------	---

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-345T2-X 12/14 mm
---------------------------------	---	--------------------------------	-------------------------------

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			
SSD18A-PP40-004				ACC.		100%MT

BLANK

EXAMINED BY 主探 Sun Gongchang <i>SUN Gongchang</i> 2010.03.04 LEVEL-II SIGN 签名 / DATE日期 质量经理 / QCM	REVIEWED BY 审核 <i>SU Wei</i> 2010.03.04 LEVEL-II SIGN / DATE日期 用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

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-000545**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0290**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: 04-Jun-2009**Description of Non-Conformance:**

During random verification magnetic particle testing (MT) of the internal components of OBG Segment 6AE, Caltrans Quality Assurance (QA) Inspector discovered a total of five (5) linear indications ranging from 10 to 40mm in length in the following welds: SSD18A-PP40-004, SSD17A-PP39-003, CSD3-PP40-074 and SSD30-PP39.5-142. These welds have been previously tested and accepted by ZPMC Quality Control (QC) MT technicians.

Contractor's proposal to correct the problem:

Repair indications and perform NDT required to verify weld quality.

Corrective action taken:

Contractor submitted NDT reports verifying the welds are now in conformance with Contract specifications. An internal NCR was issued by the Contractor and additional training was provided for NDT Technicians in regards to this issue.

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 152. 1675.3703, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer