

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-000645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0616**Type of problem:**

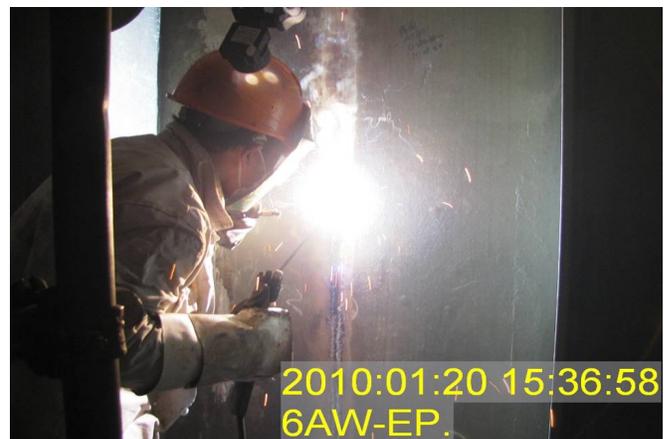
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 6AW Edge Panel
Procedural	Procedural	Description:	

Reference Description: ZPMC performed Base Metal Repair on 6AW Edge Panel (SPCM material) without prior Engineer's approval

Description of Non-Conformance:

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Base metal repairs (BMR) were being performed without Engineer's approval or Critical Weld Report (CWR) at a location where a T-Rib stiffener had been removed.
- These BMR's were located along the 6AW Edge Panel at panel point (PP) 40.75 Cross Beam side.
- Y location measured from PP 41 is: 1 meter
- The removed T-Rib stiffener is identified as: X106M(FS)
- The Edge Plate located at 6AW is identified as: EP30B
- The material is identified as: A709M Grade 345 Seismic Performance Critical Member (SPCM).
- The approved drawing sheet reference is: EP30

**Applicable reference:**

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

12.17.4 Approval: “All critical repairs to base metal and welds shall be approved by the Engineer prior to beginning the repair and shall be documented giving details of the type of discontinuity and extent of repair.”

12.17.3 Critical Weld Repairs: “All welding to correct errors in fabrication such as improper cutting, punching, drilling, machining, assembly, etc. ”

Special Provisions Section 8-3.01: “The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair.”

ZPMC Welding Quality Control Plan, Section 9.2.1.2: “Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks.”

AWS D1.5/2002, Section 3.7.4: “Prior approval of the Engineer shall be obtained for repairs to base metal.”

Who discovered the problem: M. Manikandan

Name of individual from Contractor notified: Ding Xing Chi

Time and method of notification: 1630 hours, 01-20-10, Verbal

Name of Caltrans Engineer notified: Bill Howe and Ching Chao

Time and method of notification: 1030 hours, 01-21-10, Email

QC Inspector's Name: Lay Tao

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Carreon,Albert

Lead Reviewer/Task Leader

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: 24-Jan-2010

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: 05.03.06-000607

Subject: NCR No. ZPMC-0616

Reference Description: ZPMC performed Base Metal Repair on 6AW Edge Panel (SPCM material) without prior Engineer's approval

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 the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Base metal repairs (BMR) were being performed without Engineer's approval or Critical Weld Report (CWR) at a location where a T-Rib stiffener had been removed.
- These BMR's were located along the 6AW Edge Panel at panel point (PP) 40.75 Cross Beam side.
- Y location measured from PP 41 is: 1 meter
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- The Edge Plate located at 6AW is identified as: EP30B
- The material is identified as: A709M Grade 345 Seismic Performance Critical Member (SPCM).
- The approved drawing sheet reference is: EP30

Please see attached NCR ZPMC-616 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0616

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao, Bill Howe
File: 05.03.06

NCR PROPOSED RESOLUTION

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

Dated: 08-Feb-2010

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000554 Rev: 00

Ref: 05.03.06-000607

Subject: NCR No. ZPMC-0616

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has held internal training with the CWIs and production regaining base metal repairs without Engineer approval. NDT of base metal repaired areas will be provided when available.

ZPMC has held internal training with the CWIs and production regaining base metal repairs without Engineer approval. Attached is the meeting minutes of the ZPMC meeting that was held on 1/28/2010. NDT of base metal repaired areas will be provided when available, based on this ZPMC requests this proposal be accepted with action pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000554R00;

Caltrans' comments:

Status: AAP

Date: 08-Feb-2010

In order to accept approved action pending status it is understood that the word "regaining" above should read "regarding".

Submitted by: Howe, Bill

Date: 08-Feb-2010

Attachment(s):

会议签到单

会议时间： 2010-1-28 12: 40

会议地点： OBG 拼装会议室

会议主题： 关于返修过程中无报告及人员问题

与会人员（签到）：

CWI:

朱忠海 耿伟 李勤华 李强

施工队 总焊带班:

刘立军
樊汉强
冯石强
李强

会议签到单

会议时间：2010.01.28.

会议地点：OBG 会议室

会议主题：关于OBG拼装返修和修补过程中无报告及人员问题.

与会人员（签到）：

武高 王河新 王科、钟国祥
李伟 郭伟 张强 袁伟 徐玲
陈军 王明 周亦 陈平 李平
莫春辉 李杰

会议记录

会议时间：2010.01.28 12: 40

会议地点：OBG 拼装会议室

会议主题：关于 OBG 拼装返修和修补过程中无报告及人员问题

会议内容纲要：

问题：

1. 返修过程中没有返修报告
2. 施工队焊接过程中没有 CWI 现场确认
3. 施工队焊接过程中没有 QC 人员在现场监控
4. 返修没有按照 WPS 上面要求预热和焊接
5. 焊工焊接位置不正确

对于上述问题我们的解决方案：

- 1、 返修过程中没有返修报告：如返修要进行焊接的都要开具返修报告，分一般返修和关键返修报告。一般返修报告先由探伤或 CWI 开具手写版，上面要写清楚是缺陷名称，缺陷的长度和大小，图号及焊缝编号都要写清楚，并签字。再由 CWI 人员签写所选用的 WPS，并签字。施工队工人拿到手写版的一般返修报告才能进行返修，在返修时必须有 CWI 或 QC 人员在现场才能进行工作，返修过程中所使用的 WPS 必须在现场，并且按照 WPS 上面所要求的预热及其他参数进行，现场 CWI 人员要对返修过程中预热、所选取的电流电压进行测量并记录数据，完全按照 WPS 上面的要求执行。同时按照手写的一般返修报告由文档人员开具正式的返修报告，生产工艺确认后由质检经理签字后下方施工队和质检。发现缺陷超出一般返修成为关键返修时，施工人员应停止次项工作，由探伤或 CWI 人员记录好缺陷位置、长度、大小、焊缝和钢板编号，开具关键返修报告提交文档室。文档人员拿到报

告后由生产部门写明缺陷产生的原因及以后的预防措施，再由工艺人员写清楚返修程序注意事项及所选用的 WPS，在由文档人员提交监理进行审批，审批结束后由文档人员下发到车间和现场质检。拿到关键返修报告后施工人员要在 CWI 和监控下进行返修，返修要严格按照返修报告上面及 WPS 上面的要求执行。施工队和质检要严格按照返修程序进行返修，禁止没有报告进行返修，对于没有报告返修者我们要对施工队及个人进行经济处罚。

2、 施工队焊接过程中没有 CWI 人员在现场：WQCP 上面要求 CWI 人员每半个小时在现场监控一次，以免在施工过程中能及时发现问题，并解决问题。但是我们近期出现长时间没有 CWI 人员在现场进行检查，这是我们 CWI 人员的失职。现在我们的 CWI 人员必须严格要求自己，按照质量控制计划上面的要求，至少每半个小时到一个焊接工位一次，并检查施工过程中是否存在违反要求的问题。施工队人员在施工之前必须通知质检人员，不允许存在没有 CWI 进行施工的存在，CWI 必须和施工人员协调和工作计划。施工人员在在通知 CWI 施工前必须做好准备工作，CWI 必须对施工前准备工作进行检查，施工过程中要进行检查，检查施工人员是否按照 WPS 上面及 WQCP 上面的要求执行，施工人员必须正确的接受 CWI 人员的检查，焊接结束后要对焊缝程序进行检查。要做到焊前、焊中及焊后 3 方面检查。

3、 施工队焊接过程中没有 QC 人员在现场监控：施工过程中 QC 人员必须在现场进行监控，QC 人员必须要对自己所监控的范围负责，不允许出现任何违反质量控制计划的事情出现。对于现场 QC 来说，应当随时监控现场的施工动态，对焊接过程中所使用的焊接参数进行记录、焊工进行核实编号、是否使用正确的 WPS、所处的环境是否适合焊接、焊机是否是经过鉴定过的、焊材是否是处于保温状态等很多方面进行监控的，所以说 QC 这个位置是非常重要的。对于发现问题能及时按照要求进行解决的要及时解决，对于不能解决的可以及时反馈 CWI 人员进行解决，施工人员必须配合 QC 的工作。加入没有 QC 在现场监控，施工过程中的问题就不

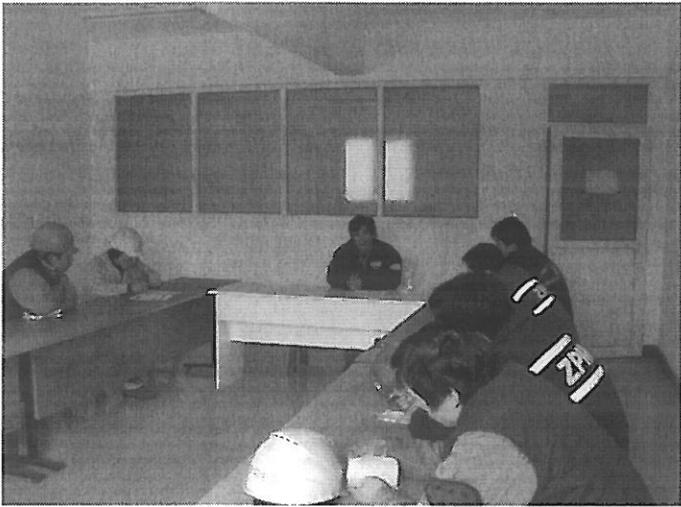
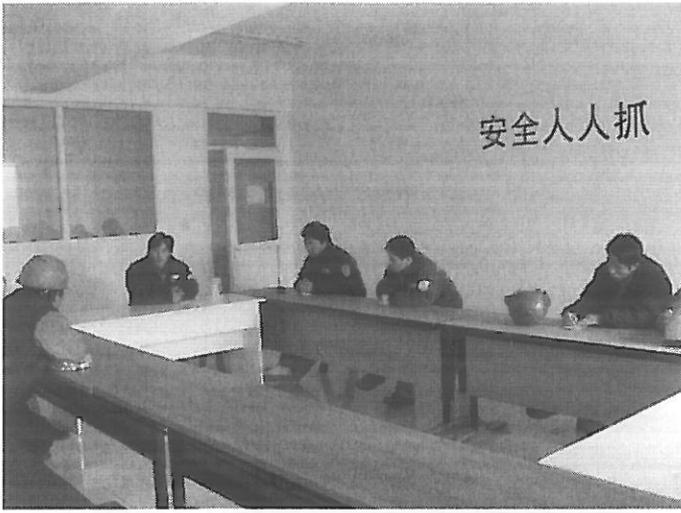
能及时解决和及时反馈，施工人员就会视问题而不见。施工人员有责任通知 QC 人员发现问题，对于开始焊接之前必须通知 QC 进行监控，QC 也要主动配合施工，QC 要时刻在现场监控，对于如特殊原因要求离开的需让别人代替，坚决不允许出现没有 QC 人员在现场监控。

4、返修没有按照 WPS 上面要求预热和焊接：WPS 上面的参数都是经过试验得出来的结论，所以要严格按照 WPS 上面的要求执行。就如预热：预热可以使焊接位置周围的水分消失，减少了影响焊接过程中的氢，氢在焊缝中容易造成裂纹的出现，为什么我们在焊接重要位置的时候经常采用低氢焊条，就是减少焊缝中的氢含量，减少裂纹和的出现，所以说焊前预热是很重要的，WPS 里面的参数是能够焊出合格焊缝的依据，没有 WPS 或没有按照 WPS 焊接的焊缝就是不合格的焊缝。WPS 必须贴到施工现场，以免及时查阅，以后对于没有按照 WPS 焊接的焊缝我们要求刨除焊缝，并对焊工进行处罚，严重的取消在美国钢桥上面工作的资格，没收焊工证。

5、焊工焊接位置不正确：焊工证都是经过权威机构认可的证明。对于焊接位置不正确的问题也视为没有焊工证，在施工前现场检验员要检查焊工的焊工证，检查焊工的发证机构、焊接的位置及焊工的编号，焊工只能焊接焊工证上面要求的位置，没有要求的位置焊工不能焊接，检验员要严格控制。焊工必须主动配合质检的检查，不允许能虚作假，如发现焊接与焊工证位置不同的焊工要进行经济处罚，严重的取消焊接资格。

OBG 拼装质检室

2010-1-28



NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000607

Subject: NCR No. ZPMC-0616

Dated: 29-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000554 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has completed the work associated with this non conformance and the work has been verified by the Department's inspectors and thus removed from the Shipment 2 punchlist

ZPMC has completed the work associated with this non conformance and the work has been verified by the Department's inspectors and thus removed from the Shipment 2 punchlist to show that the remediation is acceptable. In addition, ZPMC has written an internal NCR to document this and as a means to prevent future occurrences. Based on that ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000554R01;

Caltrans' comments:

Status: CLO

Date: 05-Apr-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0616 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 05-Apr-2010



No. B-710

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-29

REGARDING: NCR-000645 (ZPMC-0616)

ZPMC acknowledged this problem and has issued internal NCR. ZPMC QA has emphasized the requirement to site QC/CWI that there should be a copy of WRR/CWR before start welding for base metal repair. After grinding these repair areas was tested by MT and was found to be acceptable. T stiffeners have been rewelded and the fillet welds were tested to be acceptable. After NDT verification this issue has been removed from punchlist by CT's representative and green tag has been achieved by three parties. Based on this, ZPMC is requesting this NCR to be closed.

ATTACHMENT:

NCR-000645 (ZPMC-0616)

NCR-B-412 (ZPMC-0616)



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: 24-Jan-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0616

Document No: 05.03.06-000607

Reference Description: ZPMC performed Base Metal Repair on 6AW Edge Panel (SPCM material) without prior Engineer's approval

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 the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

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 - The approved drawing sheet reference is: EP30
- Please see attached NCR ZPMC-616 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0616

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao, Bill Howe

File: 05.03.06

05.03.06-000607,NCT

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-000645

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-Jan-2010

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

NCR #: ZPMC-0616

Type of problem:

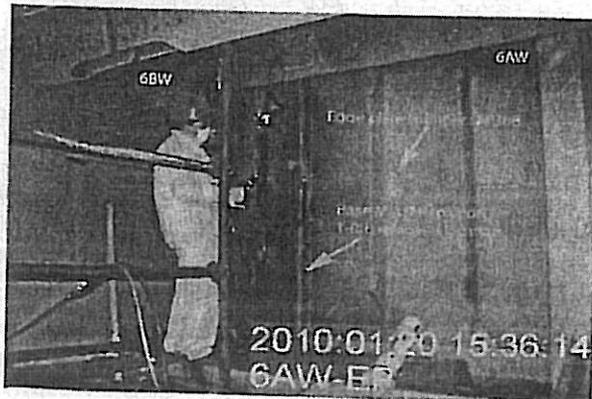
- Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: 6AW Edge Panel
 Procedural Procedural Description:

Reference Description: ZPMC performed Base Metal Repair on 6AW Edge Panel (SPCM material) without prior Engineer's approval

Description of Non-Conformance:

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Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

12.17.4 Approval: "All critical repairs to base metal and welds shall be approved by the Engineer prior to beginning the repair and shall be documented giving details of the type of discontinuity and extent of repair."

12.17.3 Critical Weld Repairs: "All welding to correct errors in fabrication such as improper cutting, punching, drilling, machining, assembly, etc."

Special Provisions Section 8-3.01: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair."

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: M. Manikandan

Name of individual from Contractor notified: Ding Xing Chi

Time and method of notification: 1630 hours, 01-20-10, Verbal

Name of Caltrans Engineer notified: Bill Howe and Ching Chao

Time and method of notification: 1030 hours, 01-21-10, Email

QC Inspector's Name: Lay Tao

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Carreon, Albert

Reviewed By: Wahbeh, Mazen

Lead Reviewer/Task Leader

SMR



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 编号: NCR-B-412(ZPMC-0616)
Item: Base Metal Repair without CWR 名称描述: 无报告的母材返修	Item Number: 件号:	Drawing: 图号: 6AW
Location: 位置: 6AW	Date: 日期: 2010-01-29	

Description of Nonconformance:

During random in-process visual inspection of OBG segments in Trial Assembly area, CT inspector discovered the following issue:

- Base metal repairs were being performed without Engineer's approval or CWR at a location where a T-rib stiffener had been removed.
 - These BMP's were located along the 6AW Edge Plate PP40.75 Crossbeam side.
 - Y location measured from PP41 is :1 Meter.
 - The removed T-rib is identified as: X106M(FS).
 - The Edge Plate located at 6AW is identified as: EP30B.
 - The material is identified as: SPCM
- 在加州的随机检查中发现如下问题:
- 正对 T 肋移除位置的母材返修没有得到批准也没有相应 CWR。
 - 返修位于 6AW 箱体, PP40.75 处, 靠近联系侧的腹板位置。
 - 从 PP41 处测得, 返修位于 1 米处;
 - 被移除的 T 肋件号未 X106M(FS)
 - 腹板为 EP30B。
 - 该处母材为 SPCM。

Work By: 施工方: <i>Xia Faling</i>	Prepared by: 准备: <i>1/29/10</i>	Reviewed by QCE: 质量工程师批准: <i>Lu Parker</i>
<input type="checkbox"/> Drawing Error 图纸错误	<input checked="" type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: 处理措施:	<input type="checkbox"/> Use as is 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
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Recommendation:
建议:

Prepared by: 准备	Approved by QCA: 质量经理批准
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Reason for Nonconformance:
不符合原因:

由于正对 T 肋移除位置的母材返修没有得到批准也没有相应 CWR.
Remove Trib and repair base metal without approved CWR.

Prevention of Re-occurrence:
预防措施:

加强现场监控与检查。
Enhance supervision and inspection on-site.

Approved by/批准: G40 Jun 2.2

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

按返修报告 WK-9848 进行处理。
Deal with this problem per disposition in WK-9848.

Reviewed /批准: He Xiao Lin

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

已按工艺要求完成

Zhu-zhong-hai

Verified by QCI/质检确认: 2010.03.09 Reviewed by QCA/质检主任审核: _____

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
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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-000599**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0616**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: 20-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Base metal repairs (BMR) were being performed without Engineer's approval or Critical Weld Report (CWR) at a location where a T-Rib stiffener had been removed.
- These BMR's were located along the 6AW Edge Panel at panel point (PP) 40.75 Cross Beam side.
- Y location measured from PP 41 is: 1 meter
- The removed T-Rib stiffener is identified as: X106M(FS)
- The Edge Plate located at 6AW is identified as: EP30B
- The material is identified as: A709M Grade 345 Seismic Performance Critical Member (SPCM).
- The approved drawing sheet reference is: EP30

Contractor's proposal to correct the problem:

Perform NDT required to verify weld quality.

Corrective action taken:

Contractor issued an internal NCR regarding this issue. NDT documentation was not submitted with the NPR. However, the department performed MT at this location before removing the item from the Voyage 2 Punchlist and confirmed that the repairs are in conformance with Contract specifications.

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.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer