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-000826
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 17-Aug-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0788

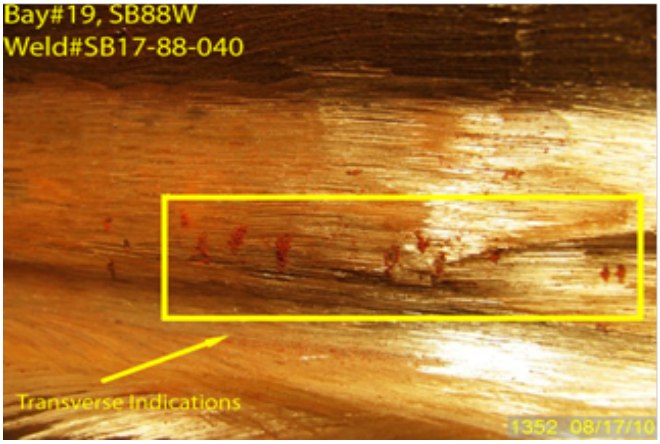
Type of problem:

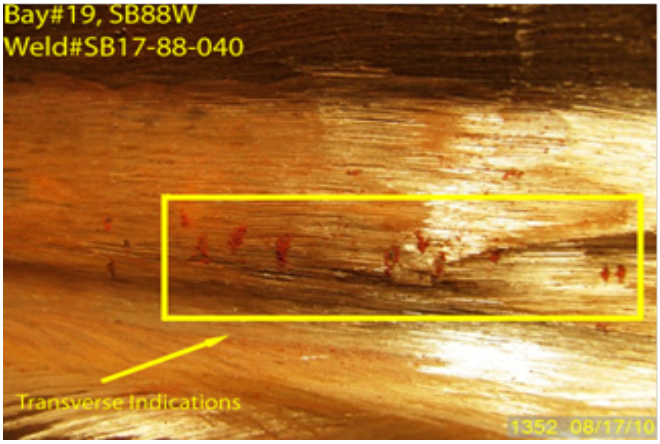
Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:** Suspender Bracket 88W for Segment 10AW
Procedural	☐	**Procedural**	☐	**Description:** Found MT longitudinal & transverse cracks by QC		

Reference Description: QA found some longitudinal and transverse cracks in SB88W (Segment 10AW) after ZPMC's had tested and accepted the weld

Description of Non-Conformance:

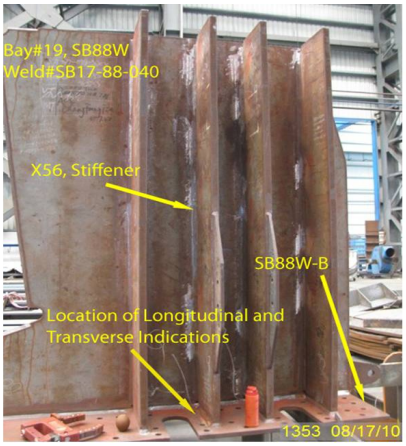
During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Suspender Bracket (SB) 88W for Segment 10AW, this QA Inspector discovered the following issues:
-QA found two (2) longitudinal cracks measuring approximately 25mm and 45mm.
-ZPMC removed the 2 longitudinal cracks by grinding down 2-3mm.
-Subsequently, QA completed QA verification with MT of the weld and found a total of twelve (12) transverse cracks measuring approximately 5 mm~8mm in length.
-The weld is identified as: SB017-088-040.
-The weld is a fillet weld type joining the Top Plate SB88W-B to vertical stiffener X56.
-The SB88W is located in OBG fabrication bay#19.
-The Notice of Witness Inspection Number (NWIT) is 006417. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.





QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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: Hiranch Patel

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1500 hours, 08/17/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0830 hours, 8/18/10, Email

QC Inspector's Name: Xu Tao

Was QC Inspector aware of the problem: ☐ **Yes** ☑ **No**

Contractor's proposal to correct the problem:

Provide CWR and perform weld repair with subsequent NDT

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

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To:	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	**Date:**	18-Aug-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:**	05.03.06-000783
Subject:	NCR No. ZPMC-0788		

Reference Description: QA found some longitudinal and transverse cracks in SB88W (Segment 10AW) after ZPMC's had tested and accepted the weld

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:** 10

Remarks:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Suspender Bracket (SB) 88W for Segment 10AW, Caltrans QA Inspector discovered the following issues:

-QA found two (2) longitudinal cracks measuring approximately 25mm and 45mm.

-ZPMC removed the 2 longitudinal cracks by grinding down 2-3mm.

-Subsequently, QA completed QA verification with MT of the weld and found a total of twelve (12)transverse cracks measuring approximately 5 mm~8mm in length.

-The weld is identified as: SB017-088-040.

-The weld is a fillet weld type joining the Top Plate SB88W-B to vertical stiffener X56.

-The SB88W is located in OBG fabrication bay#19.

-The Notice of Witness Inspection Number (NWIT) is 006417. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0788

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

File: 05.03.06

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 23223 Oakland, CA 94623

Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000783

Subject: NCR No. ZPMC-0788

Dated: **21-Sep-2010**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000783 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the areas noted in the NCR and is submitting the MT documents to show that the repair was successful.

ZPMC has repaired the areas noted in the NCR and is submitting the MT documents to show that the repair was successful. The CWR for repair was not submitted to the Department prior to work commencing, but this issues has be clarified to the work site personnel to ensure that they clearly understand that the Department's approval for onsite CWRs is still required prior to work beginning. To prevent future occurrences of this ZPMC has reprimanded the inspector who accepted these welds and he is being held accountable for his actions. Future occurrences will decrease based on these actions. ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000783R00;

Caltrans' comments:

Status: AAP

Date: 26-Sep-2010

This NCR was issued for 12 missed transverse cracks in suspender bracket welds. However, the submitted NDT report only verifies one indication that was repaired and found to be acceptable. Please submit NDT report for the rest of the indications.

Submitted by: Woo, Laraine

Date: 26-Sep-2010

Attachment(s):

No. B-884

LETTER OF RESPONSE

TO: American Bridge/Flour
DATE: 2010-9-18
REGARDING: NCR-000826(ZPMC-0788)

These indications have been removed, repaired and retested to be acceptable. ZPMC is providing both the NDT records to show the soundness of these welds. The indications were repaired prior to the related templete CWR be confirmed by department's representative, due to the misunderstanding from ZPMC site personnel. ZPMC QA personnel have instruct the site personnel to follow the procedure of templete CWR which requirs all the templete CWR shall be confirmed by department's representative prior to using. And the unverified CWR has been submitted to department's engineer to review. Based on this, ZPMC is request closure of this NCR.

ATTACHMENT:
NCR-000826(ZPMC-0788)
B787-MT-26475 R1

9/18/10

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To:	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	**Date:**	18-Aug-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:**	05.03.06-000783
Subject:	NCR No. ZPMC-0788		

Reference Description: QA found some longitudinal and transverse cracks in SB88W (Segment 10AW) after ZPMC's had tested and accepted the weld

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:** 10

Remarks:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Suspender Bracket (SB) 88W for Segment 10AW, Caltrans QA Inspector discovered the following issues:

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-The Notice of Witness Inspection Number (NWIT) is 006417. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0788

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

File: 05.03.06

02.02:15.04 *05.03.06-000783.NCT*

Received
NCT-000783 18 Aug 10

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY Arnold Schwarzenegger, Governor

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 #: 04-0120F4
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
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

Report No: NCR-000826
Date: 17-Aug-2010
NCR #: ZPMC-0788

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑
Welding	☐	**Curing**	☐	**Procedural**	☐
Joint fit-up	☐	**Coating**	☐	**Other**	☑
Procedural	☐	**Procedural**	☐		

Bridge No: 34-0006
Component: Suspender Bracket 88W for Segment 10AW
Description: Found MT longitudinal & transverse cracks by QC

Reference Description: QA found some longitudinal and transverse cracks in SB88W (Segment 10AW) after ZPMC's had tested and accepted the weld

Description of Non-Conformance:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Suspender Bracket (SB) 88W for Segment 10AW, this QA Inspector discovered the following issues:

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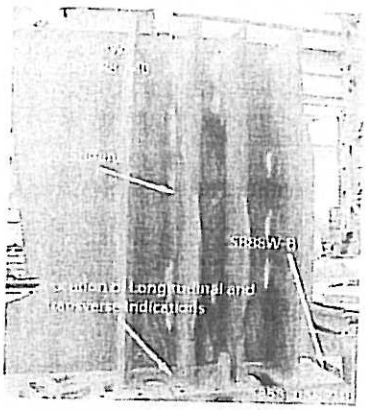
QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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: Hiranch Patel

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1500 hours, 08/17/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0830 hours, 8/18/10, Email

QC Inspector's Name: Xu Tao

Was QC Inspector aware of the problem: ☐ Yes ☑ No

Contractor's proposal to correct the problem:

Provide CWR and perform weld repair with subsequent NDT

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

ZPMC-0788

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 B787-MT-26475R1	DATE日期 2010.09.08	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: SB88W SUPPORT BEAM	CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4

REFERENCING CODE 参考规范编码	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号	CALIBRATION DUE DATE 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	KOREA	MP-A2L	MP1690

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	√ WELDING 焊接件 ☐ CASTING 铸件 ☐ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2 30mm
WELDING PROCESS 焊接方法	SMAW	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			
SB017-088-040	1R1			ACC.		100%MT
AFTER B-CWR1848rev0						
BLANK						

EXAMINED BY主探	REVIEWED BY 审核
Chang Fangjie Chang Fangjie	Li Liming
LEVEL - II SIGN 签名 / DATE日期 2010-09-08	LEVEL-II SIGN / DATE日期 2010-09-08
质量经理 / QCM	用户CUSTOMER
Lu Jianhua	
签字 SIGN / 日期 DATE 2010-09-08	签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 23223 Oakland, CA 94623

Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000783

Subject: NCR No. ZPMC-0788

Dated: **14-Oct-2010**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000783 Rev: 01**

Contractor's Proposed Resolution:

Reference Resolution: To clarify ZPMC's previous response, the twelve indications were located in close proximity of each other within the weld so when the weld was repaired the gouging encompassed all indications.

To clarify ZPMC's previous response, the twelve indications were located in close proximity of each other within the weld so when the weld was repaired the gouging encompassed all indications. The subsequent weld repair was in one location. Based on the clarification of the situation and the attached NDT, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000783R01;

Caltrans' comments:

Status: CLO

Date: 15-Oct-2010

The proposed resolution is acceptable. This NCR is considered closed.

Submitted by: Woo, Laraine

Date: 15-Oct-2010

Attachment(s):

No. B-~~09~~ 10

LETTER OF RESPONSE

TO: American Bridge/Flour
DATE: 2010-10-14
REGARDING: NCR-000826(ZPMC-0788)

These indications were located at close quarters. After gouging these indications were in same excavation and were repaired together. So the previously submitted MT record is reflecting to this situation and has covered all the indications recorded in NCR. Based on this, please consider closure of this NCR.

ATTACHMENT:
NCR-000826(ZPMC-0788)
B787-MT-26475 R1

10/14/2010

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 18-Aug-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: 05.03.06-000783

Subject: NCR No. ZPMC-0788

Reference Description: QA found some longitudinal and transverse cracks in SB88W (Segment 10AW) after ZPMC's had tested and accepted the we

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:** 10

Remarks:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Suspender Bracket (SB) 88W for Segment 10AW, Caltrans QA Inspector discovered the following issues:

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-The Notice of Witness Inspection Number (NWIT) is 006417. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0788

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

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
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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-000826
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 17-Aug-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0788

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:** Suspender Bracket 88W for Segment 10AW
Procedural	☐	**Procedural**	☐			**Description:** Found MT longitudinal & transverse cracks by QC

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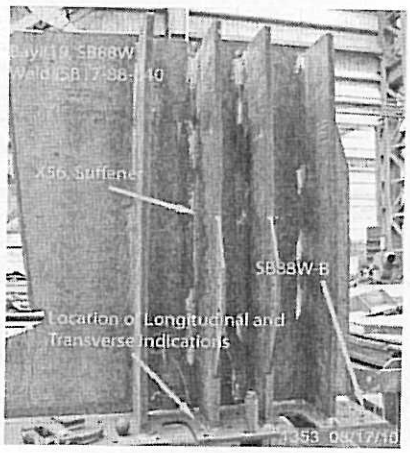
QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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."

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Who discovered the problem: Hiranch Patel

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1500 hours, 08/17/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0830 hours, 8/18/10, Email

QC Inspector's Name: Xu Tao

Was QC Inspector aware of the problem: ☐ **Yes** ☑ **No**

Contractor's proposal to correct the problem:

Provide CWR and perform weld repair with subsequent NDT

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

ZPMC

REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 B787-MT-26475R1	DATE日期 2010.09.08	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:	SB88W SUPPORT BEAM	CALTRANS CONTRACT NO.: 加州工程编号	04-0120F4

REFERENCING CODE 参考规范编码	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号	CALIBRATION DUE DATE 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	KOREA	MP-A2L	MP1690

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	√ WELDING 焊接件 ☐ CASTING 铸件 ☐ FORGING 锻造	Material & thickness 母材,厚度	A709M-345T2 30mm
WELDING PROCESS 焊接方法	SMAW	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			
SB017-088-040	1R1			ACC.		100%MT
AFTER B-CWR1848rev0						
BLANK						

EXAMINED BY主探 Chang Fangjie Chang Fangjie 2010.09.08 LEVEL - II SIGN 签名 / DATE日期	REVIEWED BY 审核 Dong Hechang 2010.09.08 LEVEL-II √ SIGN / DATE日期
质量经理 / QCM Liu Jianhua 2010.09.08 签字 SIGN / 日期 DATE	用户CUSTOMER 签字 SIGN / 日期 DATE

(FORM# ZPQC-MT01)

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 #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCS-000823
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 15-Oct-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0788

Type of problem:

Welding	☐	**Concrete**	☐	**Other**	☑	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☑	**Component:**
Procedural	☐	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 17-Aug-2010

Description of Non-Conformance:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Suspender Bracket (SB) 88W for Segment 10AW, this QA Inspector discovered the following issues:
-QA found two (2) longitudinal cracks measuring approximately 25mm and 45mm.
-ZPMC removed the 2 longitudinal cracks by grinding down 2-3mm.
-Subsequently, QA completed QA verification with MT of the weld and found a total of twelve (12) transverse cracks measuring approximately 5 mm~8mm in length.
-The weld is identified as: SB017-088-040.
-The weld is a fillet weld type joining the Top Plate SB88W-B to vertical stiffener X56.
-The SB88W is located in OBG fabrication bay#19.
-The Notice of Witness Inspection Number (NWIT) is 006417. The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Contractor's proposal to correct the problem:

Contractor will gouge and repair the twelve indications area. Contractor will submit NDT report to prove the weld is free of indications.

Corrective action taken:

Contractor gouged the area, and repaired it. Contractor provided the NDT report to prove the weld is acceptable.

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 Wahbeh, Mazen 818-292-0659, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By:	Ng,Michael	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer