

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-000853**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0815**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Skin E, Fit lug- 119m. elevation
Procedural	Procedural	Description:	

Reference Description: Skin E, Fit lug-119m have been cut without Engineer's approval**Description of Non-Conformance:**

During the Quality Assurance Dimensional verification measurements at Tower Trial assembly Heavy Dock area, the following discovered:

- Approximately 85mm in length, (25mm wide) of Fit Lug that was welded to the top diaphragm. Skin Plate E was removed without engineer approval.

For further information, please see the attached pictures below.

- The Fit lug found in top diaphragm, skin E, Lift 4- 119 mtr, West Tower,
- The Weld removed has the following Weld ID: WSTL4-2 C/L-86.

**Applicable reference:**

AWS D1.5 Section 3.7.5- "The Engineer shall be notified before improperly fitted and welded members are cut apart."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Who discovered the problem: Baskar Govindarajan
Name of individual from Contractor notified: Mr. Bi De wei
Time and method of notification: 15.25 hours, 09/29/10, Verbal
Name of Caltrans Engineer notified: Sean Eagen
Time and method of notification: 1030Hours, 10/01/10, Verbal
QC Inspector's Name: Mr. Zhao Chen Sun
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, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Ng,Michael	QA Inspector
Reviewed By:	Devey,Jim	SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: 510-286-0539 Fax: 510-286-0550

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 04-Oct-2010

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-0815

Job Name: SAS Superstructure
Document No: 05.03.06-000810

Reference Description: Tower/ Lift 4/West /Skin E/ Fit lug-119m have been cut without Enginner '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: Tower **Lift:** 04

Remarks:

While taking the Quality Assurance dimensional verification measurements at the Tower vertical trial assembly area on the Heavy Dock, the following was discovered:

- Approximately 85mm long by 25mm wide of fit lug was removed without the Engineer's approval. The fit lug was welded to the top diaphragm at Skin Plate E.

For further information, please see the attached pictures.

- The fit lug was found in the top diaphragm of Lift 4 West, Skin E at 119m.
- The weld removed has the following Weld ID: WSTL4-2 C/L-86.

Reference:

AWS D1.5 Section 3.7.5- "The Engineer shall be notified before improperly fitted and welded members are cut apart."

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance item and document that the various deficiencies have been brought into compliance with contract requirements. Also propose a resolution that addresses the apparent failure of Quality Control to identify the non-conformance with the appropriate Welding Procedure Specification (WPS). Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

Transmitted by: Gina Rizzardo Transportation Engineer

NCT

(Continued Page 2 of 2)

Attachments: ZPMC-0815

cc: Rick Morrow, Peter Siegenthaler, Mark Woods

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000810

Subject: NCR No. ZPMC-0815

Dated: 23-Nov-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000840 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

ZPMC-0815

Please see ZPMC's comments

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000840R00;

Caltrans' comments:

Status: CLO

Date: 25-Nov-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0815 is closed.

Submitted by: Eagen, Sean

Date: 25-Nov-2010

Attachment(s):



No. T-178

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-11-23

REGARDING: NCR-000853(ZPMC-0815),
NCR-000855(ZPMC-0817),
NCR-000856(ZPMC-0818)

ZPMC received NCR-000853(ZPMC-0815), NCR-000855(ZPMC-0817), NCR-000856(ZPMC-0818), it mentioned that CT inspectors found Skin E fit lugs have been cut without Engineer's approval.

When CT inspector found this problem, ZPMC took positive action and performed NDT work, finally these fit lug issue have been resolved and rechecked by CT site inspector. ZPMC also realized this issue and emphasized to related people it should strictly perform according to approved procedure and criteria during work, once issue appears, it's required to report to site QC immediately, and not permit to treat it privately.

Here attached related NDT reports and inspection notification, hope CT take a review and close these NCRs.

ATTACHMENT:

NCR-000853(ZPMC-0815)

NCR-000855(ZPMC-0817)

NCR-000856(ZPMC-0818)

T787-MT-11471

Notification: 07446/07448

Zhang Tao
2010.11.23



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-11471 DATE日期 2010.11.21 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: ESTL4-2C/L WSTL4-2C/L SSSL3-1C/L NSTL4-3C/L THE FOURTH LIFTING TOWER		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 , 2010
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 DA-400S	SERIAL NO. 连续编号 17371
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-HPS-485T2-Z 75/40mm
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			
SSTL4-1C/L-41	.			ACC.		AFTER GRINDING
NSTL4-3C/L-41				ACC.		AFTER GRINDING
ESTL4-2C/L-118				ACC.		AFTER GRINDING
ESTL4-2C/L-49				ACC.		AFTER GRINDING
WSTL4-2C/L-118				ACC.		AFTER GRINDING
WSTL4-2C/L-49				ACC.		AFTER GRINDING

BLANK

EXAMINED BY主探 Fu Zhiqiang <i>Fuzhiqiang</i>	REVIEWED BY审核 <i>Wangmei</i>
LEVEL - II SIGN 签名 / DATE日期 2010.11.21	LEVEL-II SIGN / DATE日期 2010.11.21
质量经理 / QCM <i>Wangmei</i> 2010.11.21	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

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 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000853

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 29-Sep-2010

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

NCR #: ZPMC-0815

Type of problem:

Welding **Concrete** **Other**

Welding **Curing** **Procedural**

Bridge No: 34-0006

Joint fit-up **Coating** **Other**

Component: Skin E, Fit lug- 119m. elevation

Procedural **Procedural** **Description:**

Reference Description: Skin E, Fit lug-119m have been cut without Engineer's approval

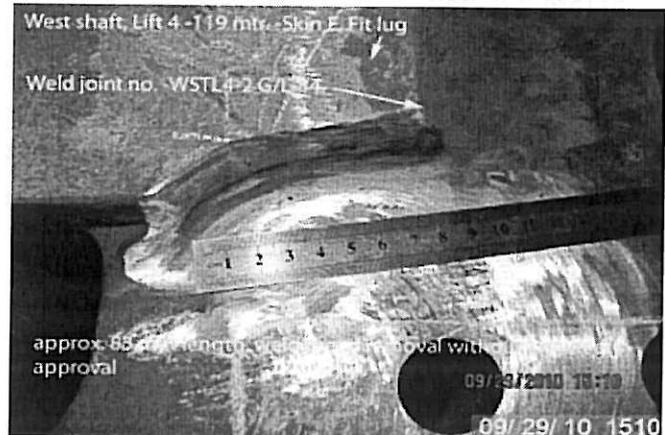
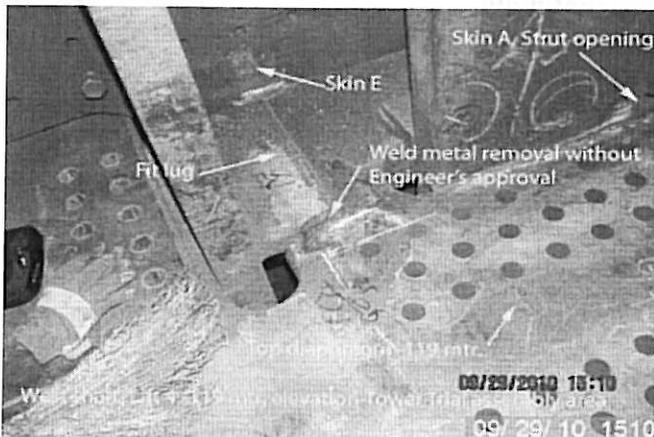
Description of Non-Conformance:

During the Quality Assurance Dimensional verification measurements at Tower Trial assembly Heavy Dock area, the following discovered:

- Approximately 85mm in length, (25mm wide) of Fit Lug that was welded to the top diaphragm. Skin Plate E was removed without engineer approval.

For further information, please see the attached pictures below.

- The Fit lug found in top diaphragm, skin E, Lift 4- 119 mtr, West Tower,
- The Weld removed has the following Weld ID: WSTL4-2 C/L-86.



Applicable reference:

AWS D1.5 Section 3.7.5- "The Engineer shall be notified before improperly fitted and welded members are cut apart."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Who discovered the problem: Baskar Govindarajan
Name of individual from Contractor notified: Mr. Bi De wei
Time and method of notification: 15.25 hours, 09/29/10, Verbal
Name of Caltrans Engineer notified: Sean Eagen
Time and method of notification: 1030Hours, 10/01/10, Verbal
QC Inspector's Name: Mr. Zhao Chen Sun
Was QC Inspector aware of the problem: Yes No
Contractor's proposal to correct the problem:

N/A

Comments:

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Inspected By: Ng,Michael	QA Inspector
Reviewed By: Devey,Jim	SMR

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 File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shasnghai, P.R. China

Report No: NCR-000855

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Oct-2010

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

NCR #: ZPMC-0817

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: 119m Fit Lug

Reference Description: East and North Shaft at 119m: Skin E - Fit Lug removal without Engineer's approval

Description of Non-Conformance:

During the Quality Assurance Inspection of dimension measurements at tower trial assembly area, heavy dock, this Quality Assurance Inspector (QA) discovered the following issues:

-Approx. 55 mm length, 25 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without Engineer's approval.

-The fit lug found in East Tower, Lift 4- 119m top diaphragm.

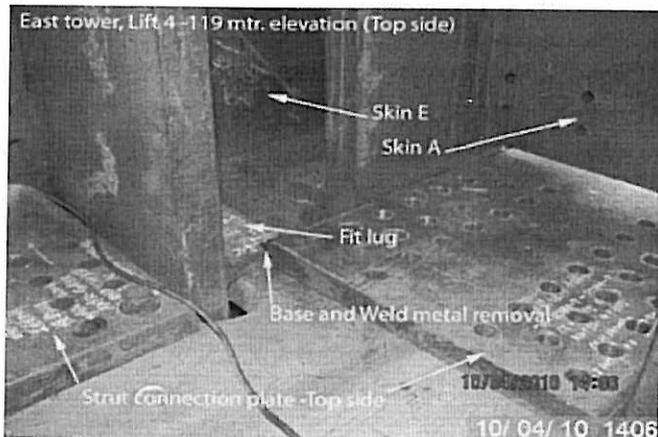
-The weld joint no. of the fit lug weld found to be ESTL4-2 C/L-115.

-Approx. 50 mm length, 35 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without engineer's approval.

-The fit lug found in North Tower, Lift 4- 119m top diaphragm.

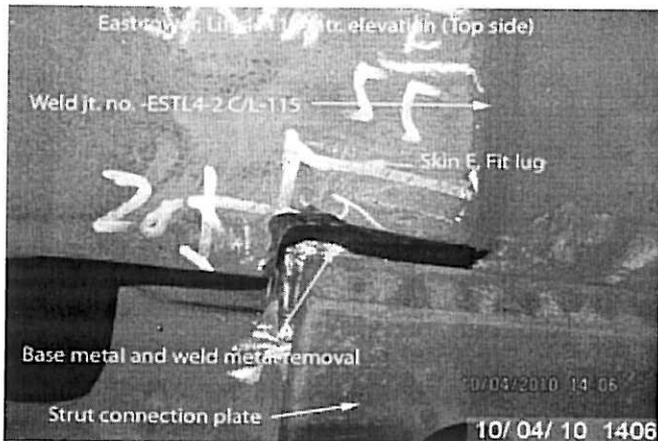
-The weld joint no. of the fit lug weld found to be NSTL4-1 C/L-98.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D 1.5 Section 3.7.4 – “Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies.”

AWS D1.5 Section 3.7.5- “The Engineer shall be notified before improperly fitted and welded members are cut apart.”

Who discovered the problem: Baskar Govindarajan

Name of individual from Contractor notified: Mr. Kim

Time and method of notification: 1425 hours, 10/04/10, Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 1330 hours, 10/05/10, Verbal

QC Inspector's Name: Mr. Zhu Feng

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

Inspected By: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR

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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-000856

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Oct-2010

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

NCR #: ZPMC-0818

Type of problem:

Welding Concrete Other

Welding Curing Procedural **Bridge No:** 34-0006

Joint fit-up Coating Other **Component:** Fit Lug- West Tower

Procedural Procedural **Description:**

Reference Description: Fit Lug Removal without Engineer's approval located at West Shaft (109m) and South Shaft (119m)

Description of Non-Conformance:

During the Quality Assurance Inspection of Dimension measurements at Tower trial assembly area, Heavy Dock, this Quality Assurance Inspector (QA) discovered the following issue:

- Approx. 50mm length, weld metal removal observed in Skin E, fit lug weld, without Engineer's approval.
- The fit lug found in West Tower, Lift 3- 109m top diaphragm.
- The weld joint no. of the fit lug weld found to be WSTL3-4 I / K-128.

- Approx. 55mm length, weld metal removal observed in Skin E, fit lug weld, without Engineer's approval.
- The fit lug found in South Tower, Lift 4- 119m top diaphragm.
- The weld joint no. of the fit lug weld found to be SSTL4-1 C/L-98.

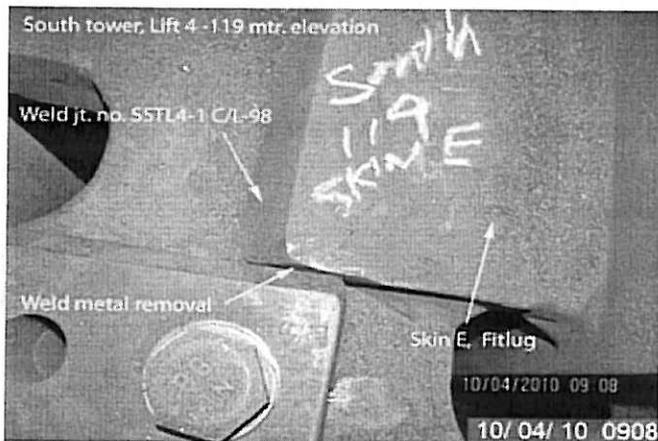
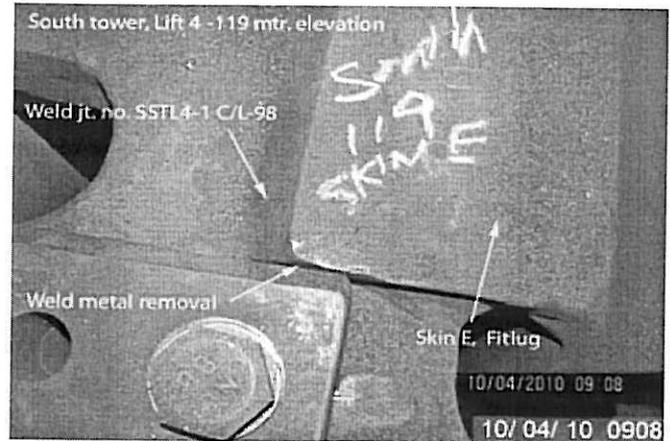
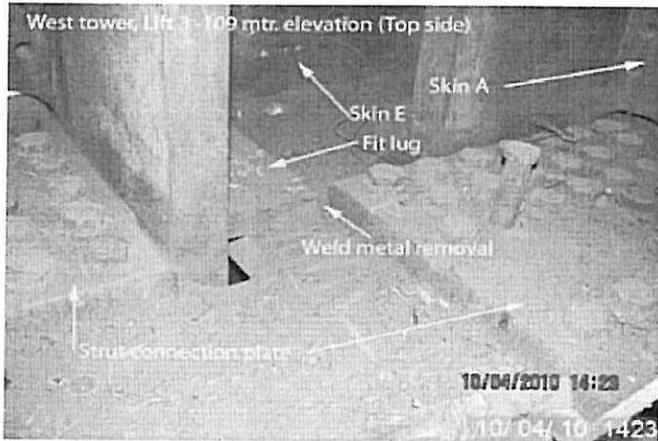
For further information, please see the attached pictures below.

Applicable reference:

AWS D1.5 Section 3.7.5- "The Engineer shall be notified before improperly fitted and welded members are cut apart."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Who discovered the problem: Baskar Govindarajan
Name of individual from Contractor notified: Mr. Kim
Time and method of notification: 1425 hours, 10/04/10, Verbal
Name of Caltrans Engineer notified: Jim Reid
Time and method of notification: 1330 Hours, 10/5/10, Verbal
QC Inspector's Name: Mr. Zhu Feng
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 , who represents the Office of Structural Materials for your project.

Inspected By: Ng, Michael	QA Inspector
Reviewed By: Devey, Jim	SMR



CT客户检验通知单

NDT Inspection Notification Sheet

文件编号: 07448 Document No.		申请递交时间: Submit time: 2010-11-22 09:30		CT 计划赴检时间 CT Estimated Inspection Time	
序号 No	检验内容 Inspection	待检验构件 Inspection part	产品分类 Section	检验场地 Inspection Place	计划检验时间 Inspection Time
1	MT FOR WELDS	SSTL4-1C/L-41 NSTL4-3C/L-41 (FOR CLOSE ZPMC-0817)	TOWER LIFT 4 119M FIT LUG	TOWER JETTY	2010-11-22 10:00 FOR GREEN TAG
2					

1、见证通知发出后，现场等待时间通常不超过30分钟；如有变动，现场通知。

1、When ZPMC give this table to AB/F, ZPMC will do the inspection in 30

2、ZPMC根据自己的检验控制点 (HOLD POINT) 进行日常检验。

2、ZPMC will do any inspection according to the HOLD POINT.

3、此单为临时试用单，仅适用于完工焊缝的NDT检验见证通知。

3、This table is a temporary one, just for final NDT inspection notification.

4、QC检验完成后，QA是否需要复验，由QA自行决定，QC不再另行通知。复验等待时间通常为1小时。

4、When ZPMC QC finish NDT inspection, Caltrans QA can decide if they want to

retest it. ZPMC QC will not inform Caltrans again. The waiting time is 1 hour

ordinarily.

5、AB/F预约CT后会在同班时间内通知ZPMC具体CT现场报验时间

5、AB/F to notify ZPMC in the same shift that CT will attend and at what time.

6、加州现场检验完成后会告知AB/F检验结果，AB/F会在1小时内告知ZPMC加州复检结果。

6、CT to notify AB/F that the work has been completed and the result. AB/ to

notify ZPMC that the work has been completed and the result within 1 hour.

ZPMC 联系人:

Requested By: Zhang Jindao

AB/F 签收人:

AB/F Receiver: Anne Zhang

签收时间:

Time:

11/22/2010 9:42

签收时间:

Time:



NDT客户检验通知单

NDT Inspection Notification Sheet

文件编号: 07446 Document No.	申请递交时间: Submit time: 2010-11-21 15:15	CT 计划赴检时间 CT Estimated Inspection Time	
待检验构件 Inspection part	产品类别 Section	检验场地 Inspection Place	计划检验时间 Inspection Time
1 MT FOR WELDS WSD1-FASA4-2A/E-45~48, 55, 56 WSD1-FESA4-4A/F-24~27, 32~35 ESTL4-2C/L-118, 49 WSTL4-2C/L-118, 49 (FOR CLOSE NCR ZPMC/817)	TOWER LIFT 4, PADEYE OF SKIN A&E TOWER LIFT 4, 119M FIT LUG	TOWER JETTY TOWER JETTY	2010/11/21 15:45:00 FOR GREEN TAG 2010/11/21 15:45:00 FOR GREEN TAG

ZPMC 联系人: *Qian*
Requested Rv:

AB/F 签收人: *Annie Zhang*
AB/F Receiver:

签收时间: *11/21/2010 15:24*
Time:

签收时间:
Time:

- 1、见证通知发出后，现场等待时间通常不超过30分钟；如有变动，现场通知。
- 1、When ZPMC give this table to AB/F, Zpmc will do the inspection in 30 minutes. If we
- 2、ZPMC根据自己的检验控制点 (HOLD POINT) 进行日常检验。
- 2、ZPMC will do any inspection according to the HOLD POINT.
- 3、此单为临时试用单，仅适用于完工焊缝的NDT检验见证通知。
- 3、This table is a temporary one, just for final NDT inspection notification.
- 4、QC检验完成后，QA是否需要复验，由QA自行决定，QC不再另行通知。复验等待时间通常为1小时。
- 4、When ZPMC QC finish NDT inspection, Caltrans QA can decide if they want to retest it. ZPMC QC will not inform Caltrans again. The waiting time is 1 hour ordinarily.
- 5、AB/F预约CT后会在同班时间内通知ZPMC具体CT现场报验时间
- 5、AB/F to notify ZPMC in the same shift that CT will attend and at what time.
- 6、加州现场检验完成后会告知AB/F检验结果，AB/F会在1小时内告知ZPMC加州复检结果。
- 6、CT to notify AB/F that the work has been completed and the result. AB/ to notify ZPMC that the work has been completed and the result within 1 hour.

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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-000796**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0815**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: 29-Sep-2010**Description of Non-Conformance:**

During the Quality Assurance Dimensional verification measurements at Tower Trial assembly Heavy Dock area, the following discovered:

- Approximately 85mm in length, (25mm wide) of Fit Lug that was welded to the top diaphragm. Skin Plate E was removed without Engineer's approval.
- The Fit lug found in top diaphragm, skin E, Lift 4- 119 mtr, West Tower,
- The Weld removed has the following Weld ID: WSTL4-2 C/L-86.

Contractor's proposal to correct the problem:

Contractor submitted TC-RFI-0166 expressing there's an interference between the Tower flange splice plate and a fit lug at the 119M elevation. Conflict required coping the fit lug (55mmX35mm) to allow full contact with the splice plate's faying surface. For future constructability issues, ZPMC will instruct the workers to report to QC first, obtain prior approval from Engineer, and then proceed ahead with the agreed upon resolution.

Corrective action taken:

TC-RFI-0166 response accepted to leave the fit-lug plate cut-out (maximum depth of 35mm as shown) to clear the diaphragm splice plate, provided that the trim was tapered in a 2:1 transition and MT was performed to ensure no cracks after grinding smooth. Work was performed in conformance with TC-RFI-0166, NDT reports received. ZPMC instructed their workers to notify QC immediately whenever there are questions regarding constructability, and can only perform remedial work with prior Engineer's approval.

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 Thomas Ho, (86) 150.0204.8250, who represents the

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Office of Structural Materials for your project.

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer
