

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, PRC**Report No:** NCR-000137**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0131**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP-594-001
Procedural	Procedural	Description:	OBG Deck Panel

Reference Description: Unapproved repair of cracked tack welds**Description of Non-Conformance:**

The Contractor did not properly evaluate the extent of a crack prior to repair and welding over the crack. The Contractor attempted to repair numerous cracked tack welds by grinding without performing MT, PT or other equally positive means to ascertain the extent of the cracks. The Contractor did not remove 50 millimeters on either side of the crack before commencing the closed rib GMAW root pass. This occurred on tack welds in weld joint #s -001 through -010 on deck panel DP-594-001. The cracks were initially observed on Tuesday 05-20-2008 as indicated in the time and date stamp in the digital photograph below.

**Applicable reference:**

AWS D1.5, Section 3.7.2.4: "Cracks in Weld or Base Metal. The extent of the crack shall be ascertained by use of MT, PT, or other equally positive means; the metal shall be removed for the full length of the crack plus 50 mm [2 in.] beyond each end of the crack, and rewelded."

Who discovered the problem: QA Inspector Greg Bertlesman**Name of individual from Contractor notified:** ABFJV QC Inspector Mr. Steve Lawton

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 1100 Verbal notification.

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 5/22/08 1230 Verbal

QC Inspector's Name: ZPMC QC Inspector Sun Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By:	Lowry,Patrick	SMR
----------------------	---------------	-----

Reviewed By:	Lowry,Patrick	SMR
---------------------	---------------	-----
