

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 #: 1x.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Job Site**Report No:** NCR-000719**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 19-Apr-2010**Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0007**Type of problem:**

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

Reference Description: Planar Misalignment**Description of Non-Conformance:**

This NCR addresses planar misalignments between the adjoining OBG skin plates at the transverse field splices. The planar misalignments were identified by QA during in-process and completed splices.

The magnitude and length of the planar misalignment observed by QA Inspectors varied for each field splice.

The range of the magnitude of the planar misalignments and overall length of misalignment exceeding the AWS tolerance (as a percentage of overall length) is listed below:

FS 1E-2E: Varies between approximately 4-7 mm for almost 5% of the overall weld length.

FS 2E-3E: Varies between approximately 2-8 mm for almost 2% of the overall weld length.

FS 3E-4E: Varies between approximately 4-13 mm for almost 4% of the overall weld length.

FS 1W-2W: Varies between approximately 3-6 mm for almost 6% of the overall weld length.

FS 2W-3W: Varies between approximately 3-8 mm for almost 1% of the overall weld length.

Additional details, measurements, and locations are available upon request.

Applicable reference:

AWS D1.5, Section 3.3.3, states:

“Parts to be joined by groove welds shall be carefully aligned. Where the parts are effectively restrained against bending due to eccentricity in alignment, the offset from theoretical alignment shall not exceed 10 percent of the thickness of the thinner part joined, but in no case shall be more than 3mm [1/8 in.]”

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Who discovered the problem: QA Inspectors
Name of individual from Contractor notified: WQCM- Jim Bowers
Time and method of notification: Various
Name of Caltrans Engineer notified:
Time and method of notification:
QC Inspector's Name: Jim Bowers
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 Mohammad Fatemi, 916-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bozorgnia,Behrouz	QA Inspector
Reviewed By:	Lowry,Patrick	SMR



DEPARTMENT OF TRANSPORTATION

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: 28-Apr-2010
Contract No: 04-0120F4
Dear: Mr. Charles Kanapicki
04-SF-80-13.2 / 13.9
Attention: Mr. James Bowers
Job Name: SAS Superstructure
Subject: NCR No. ABF-0007
Document No: 05.03.06-000676
Reference Description: Planar Misalignment

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.

Remarks:

Material Location: OBG Field Splice Locations **Lift:** 1E, 2E, 3E, 4E,1W, 2W, 3W

This NCR addresses planar misalignments between the adjoining OBG skin plates at the transverse field splices. The planar misalignments were identified by QA during in-process and completed splices.

The magnitude and length of the planar misalignment observed by QA Inspectors varied for each field splice.

The range of the magnitude of the planar misalignments and overall length of misalignment exceeding the AWS tolerance (as a percentage of overall length) is listed below:

- FS 1E-2E: Varies between approximately 4-7 mm for almost 5% of the overall weld length.
- FS 2E-3E: Varies between approximately 2-8 mm for almost 2% of the overall weld length.
- FS 3E-4E: Varies between approximately 4-13 mm for almost 4% of the overall weld length.
- FS 1W-2W: Varies between approximately 3-6 mm for almost 6% of the overall weld length.
- FS 2W-3W: Varies between approximately 3-8 mm for almost 1% of the overall weld length.

Additional details, measurements, and locations are available upon request.

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: Tai-Lin Liu Transportation Engineer

Attachments: ABF-0007

cc: Gary Pursell, Peter Siegenthaler, Stanley Ku, Jason Tom, Bill Casey

File: 05.03.06, 09.001.0015

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Job Site**Report No:** NCS-000799**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0007**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: 19-Apr-2010**Description of Non-Conformance:**

This NCR addresses planar misalignments between the adjoining OBG skin plates at the transverse field splices. The planar misalignments were identified by QA during in-process and completed splices.

The magnitude and length of the planar misalignment observed by QA Inspectors varied for each field splice.

The range of the magnitude of the planar misalignments and overall length of misalignment exceeding the AWS tolerance (as a percentage of overall length) can be found on ABF-007.

Contractor's proposal to correct the problem:

Please refer to Department letter 05.03.01-008592 dated December 2nd, 2010.

Corrective action taken:

Please refer to Department letter 05.03.01-008592 dated December 2nd, 2010.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** William S Casey**Date:** 02-Dec-2010**Is Engineer's approval attached?** Yes No Reference State Letter 05.03.01-008592.**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: Mahjoub, Nina

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer