

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 #: 74.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Goodwin International, Trentham, UK

Report No: NCR-000930

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 30-Nov-2010

Submitting Contractor: Goodwin Steel, UK

NCR #: GSC-0002

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 5540-B16-CBPA plate assemblies
Procedural	Procedural	Description:	

Reference Description: During QA Monitoring of activities in progress, It was observed that:

Description of Non-Conformance:

1. No mill order was supplied to the engineers representative per ABF-RFI-2014R3.
2. No mill Test Report was supplied after receipt of material to the engineers representative per ABF-RFI-2014R3
3. Material was not inspected by engineers representative prior to cutting per ABF-RFI 2014R3 and California Department of Transportation Standard Specifications section 55-1.03 "Inspection".
4. Material was not released by engineers representative from Simaron to Goodwin International per RFI 2014R3 and Standard Specs section 55-1.03 "Inspection".



Applicable reference:

ABF-RFI-2014R3: In accordance with Section 55-1.03 "Inspection" of the California Department of Transportation Standard Specifications, provide a copy of the mill order specifying that the material at 10mm

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

and 50mm thickness must meet the same (minimum) mechanical properties required by ASTM A709M Grade 345. After receipt of the material, provide a copy of the certified Material Test Report stating that the material has met these properties. The proposed material substitution will not be permitted and the material cannot be incorporated into the work without these verifying documentation.

-Standard Specs section 55-1.03 “ Inspection”.

Who discovered the problem: Randy Riegler

Name of individual from Contractor notified: Kieth Salt

Time and method of notification: 1500 11-30-10

Name of Caltrans Engineer notified: Kittric Guest

Time and method of notification: 1530 Verbal

QC Inspector's Name: A. Cashmore

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 Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Riegler,Randy

NDT Technician

Reviewed By: Guest,Kittric

SMR



DEPARTMENT OF TRANSPORTATION

333 Burma Road
Oakland CA 94607
Tel: 510-622-5661 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607
Date: 06-Dec-2010
Contract No: 04-0120F4
04-SF-80-13.2/ 13.9
Dear: Mr. Charles Kanapicki
Attention: Mr. Karsten Baltzer
Job Name: SAS Superstructure
Subject: NCR No. GSC-0002
Document No: 05.03.06-000886

Reference Description: Non Compliance with Material Inspection requirements

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: Cable **Lift:** N/A

Plate material was not subject to inspection as required by Section 55-1.03 "Inspection" of the Standard Specifications and as informed in ABF-RFI-002014R03.

See NCR GSC-0002 for further details.

Action Required and/or Action Taken:

As no MTR has been provided as required by the Specifications and by ABF-RFI-002014R03 for acceptance of an alternate material, the plate material is hereby rejected in accordance with Section 6-1.04 "Defective Materials" of the Standard Specifications.

The material may be accepted for incorporation into the permanent work if the MTR demonstrates the material meets the same (minimum) mechanical properties required by ASTM A707M Grade 345 with traceability to the MTR.

Transmitted By: Warren Collins Assistant Structural Rep

Attachments: GSC-0002

cc: Brian Boal

File: 05.03.06, 09.074.0015, 56.2014

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000886

Subject: NCR No. GSC-0002

Dated: 23-Feb-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000928 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

"Please see the attached response from Goodwin Steel."

Submitted by: Kanapicki, Charles

Attachment(s): ; ABF-NPR-000928R00

Caltrans' comments:

Status: CLO

Date: 23-Mar-2011

The NCR is resolved.

Submitted by: Collins, Warren

Date: 23-Mar-2011

Attachment(s):

Non-Conformance Report

SUPPLIER IN HOUSE		GOODWINS ORDER NUMBER 00154789 - KS	NCR No. 27
GOODWINS JOB NUMBER AG09113	DATE 25/01/2011	QUANTITY RECEIVED 9	NCR QUANTITY 9

DESCRIPTION OF ITEMS
B16 Cable Band Plate assembly's

MANUFACTURING STATUS FINISHED <input checked="" type="checkbox"/> PART FINISHED <input type="checkbox"/>	DRAWING NUMBER 5540-B16-CBPA
	ITEM / IDENT NUMBER AH6821

NCR DETAILS - ATTACHMENTS (YES / NO) - INCLUDE ROOT CAUSES

The raw plate material was moved to the subcontract machine shop without informing the onsite Caltrans inspector or giving him the option to review the mill certs and green tag the items for release.

This mistake took place as the person sending the plates out for machining was unaware of the contract requirement for the green tag release between sites.

DISPOSITION		CONCESSION (YES / NO)
SCRAP <input type="checkbox"/>	USE AS IS <input checked="" type="checkbox"/> <small>(Design evaluation required)</small>	CONCESSION No: _____
RETURN TO SUPPLIER <input type="checkbox"/> <small>(See note at bottom of page)</small>	REWORK <input type="checkbox"/>	NOT GRANTED <input type="checkbox"/>
RECTIFY <input type="checkbox"/>		GRANTED <input type="checkbox"/>

RECTIFICATION DETAILS (if applicable)
The purchase order and the relevant mill certification were presented for review to the onsite Caltrans inspector, and the plates presented for visual inspection. (ALL DOCUMENTS ARE ATTACHED).

CORRECTIVE ACTION IMPLEMENTED BY SUPPLIER ATTACHMENT (YES / NO)
The purchasing department have been made aware of the contract requirement for green tag release between sites.

Raised By: C.Ryder Authorised By: A.Bentley
(QA / QC Department Only)

NCR Complete (Signed): C.Ryder Date: 25/01/2011

On delivery of replacement or rectified goods, the supplier delivery note must reference the NCR No. (See top of page). Failure carry this out may result in delayed or non payment of invoices

Goodwin International Ltd

REG No. 468115 ENGLAND
 TELEPHONE: 01782 654000
 FAX 01782 208060

Supplier: MALTHOUSE ENGINEERING LTD.
 3 HAINGE ROAD
 TIVIDALE
 WARLEY.
 WEST MIDLANDS.
 B69 2NL
 GB
 GREAT BRITAIN

Deliver to: GOODWIN INTERNATIONAL LTD.

NEWSTEAD INDUSTRIAL ESTATE
 PLANTATION ROAD, TRENTHAM
 STOKE-ON-TRENT, UNITED KINGDOM
 ST4 8HU

Purchase Order Date : 03-NOV-10
 Order no : 00154789 - KS

Please supply the undermentioned goods and debit to our account (Subject to our conditions of purchase GI-Rev-001)

Line No	Job Number	Int Ref	Quantity	Description	Del.Date	Price	Cost / £
1	AG09113	T113BA	9	B16 CABLE BAND PLATE ASSEMBLY OAKLAND BAY BRIDGE B16 PRO-FILE TO DRAWING + MACHINING ALLOWANCE AROUND EACH EDGE. DRAWING NUMBER: -5540-B16-CBPA MATERIAL: -S355J2+N SIZE: -966 X 341 X 50 SEE FOOT NOTE FOR MATERIAL DETAILS.	09 Nov 10		
ORDER TOTAL							

(End of Lines)

CONFIRMATION OF ORDER PLACED WITH MORRIS.04.10.2010

MATERIAL MUST BE S355J2+N WITH:-
 MINIMUM ELONGATION OF 21%
 MINIMUM YIELD STRENGTH OF 345
 TENSILE STRENGTH OF 470 - 630 RM(N/mm2)

- I) DELIVERY DATE IS THE ESSENCE OF THIS CONTRACT.
- II) ENSURE OUR PURCHASE ORDER NUMBER IS CLEARLY STATED ON THE INVOICE/DELIVERY NOTE
- III) PLEASE ENSURE BAR/PLATE IS MARKED/TAGGED WITH HEAT NUMBER, BARS WILL BE REJECTED IF THIS DOES NOT HAPPEN
- IV) ALL MATERIAL CERTIFICATION IS TO BE E-MAILED TO SEardley@goodwingroup.com

Goodwin International Ltd

NEWSTEAD TRENTHAM STOKE-ON-TRENT ST4 8HU ENGLAND
 REG No. 468715 ENGLAND
 TELEPHONE: 01782 654000
 FAX: 01782 208060
 VAT REGISTRATION No. GB 278 9237 05
 e mail: gipurchasing@goodwingroup.com
 web site: www.goodwin.co.uk

Supplier: MALHOUSE ENGINEERING LTD.
 3 HAINGE ROAD
 TIVIDALE
 WARLEY.
 WEST MIDLANDS.
 B69 2NL
 GB
 GREAT BRITAIN

Deliver to: GOODWIN INTERNATIONAL LTD.
 NEWSTEAD INDUSTRIAL ESTATE
 PLANTATION ROAD, TRENTHAM
 STOKE-ON-TRENT, UNITED KINGDOM
 ST4 8HU

Purchase Order Date : 03-NOV-10
 Order no : 00154789 - KS

Please supply the undermentioned goods and debit to our account (Subject to our conditions of purchase GI-Rev-001)

Line No	Job Number	Int Ref	Quantity	Description	Del.Date	Price	Cost / £
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linglis@goodwingroup.com

- a. EACH ITEM/BAR/PIECE TO BE LOW STRESS STAMPED WITH THE MATERIAL HEAT NUMBER.
 - b. SUPPLY PHOTOCOPIES OF ORIGINAL MILL MATERIAL CERTIFICATES TO EN10204.3.1B.
 - c. CERTIFICATES MUST ACCOMPANY GOODS
 - d. MATERIAL CERTS AND DELIVERY NOTES MUST REFERENCE THE GOODWIN JOB NUMBER, THE PRODUCT CODE, DRAWING NUMBER AND HEAT NUMBERS. PRICES ARE FIXED AND FIRM FOR YOUR DELIVERY PERIOD, CARRIAGE PAID TO OUR WORKS - TRENTHAM, STOKE ON TRENT.
- NOTE: DELIVERY MUST BE EFFECTED DURING THE 7 DAYS COMMENCING ON THE DATE STATED (NO EARLIER - NO LATER) SHOULD YOU DELIVER EARLIER, TAX POINT/ INVOICE DATE WILL BE CONSIDERED TO BE DURING THE STATED 7 DAY PERIOD.
- *****
 DO NOT PROCEED WITH THIS ORDER IF YOU DO NOT AGREE WITH THE STATED NETT PRICE, OR IF YOU INTEND TO CHARGE FOR PACKING/ CARRIAGE/CERTIFICATION ETC. (FAX/E-MAIL DETAILS FOR APPROVAL).

K.S. Salt
 K Salt

For and on behalf of **GOODWIN INTERNATIONAL LTD**
 (End of Purchase Order)

minmax

SPI4620

00154789

407553/40754

METINVEST™

Spartan UK

SPARTAN WORKS
KOPERY ROAD TEANUS, NE3 2RD
TEL 0191 4604265 • FAX 0191 460557
REGISTERED NO 4149353 ENGLAND
VAT REG NO 7334605 19

Inspection Certificate BS EN 10204 3.1

Customer: Plates
 Certificate: 73456
 Data: 29/03/2010
 Deal Note: 31002704
 Date: 29/03/2010
 Order: J1000691
 Vs: TPI-003705
 Treatment: SR
 Rs: Rm: A5%
 Brand: Impact test Temp: Impact test Z% Rp02 Temp

MIN MAX
 C Mn Si P S Cu Ni Cr Mo Al V Nb Ti C.Eq.
 AR = as Rolled
 NR = Normalised Temperature
 N = Normalised

Chemical Analysis (heat)

Heat: AH6821
 C: 0.16
 Mn: 1.45
 Si: 0.22
 P: 0.013
 S: 0.003
 Cu: 0.02
 Ni: 0.01
 Cr: 0.02
 Mo: 0.01
 Al: 0.033
 V: 0.005
 Nb: 0.028
 Ti: 0.005
 N: 0.004
 C.Eq.: 0.411

Chemical Analysis (product)

Cu Ni Cr Mo Al V Nb Ti C.Eq.

No	Plates	Block	Test	Dimensions	(2)	(4)	(5)	Tamp	ReH	Rm	A	Temp	Rp 02	Z%	Bend Type	(3)	Temp	Impact test	Plate Number		
AH6821	102/RSB	54935	✓	050x2000x04000	2	P	CC	+20	379	563	26		KV	L	-20	P	139	J	150	122	226525
AH6821	102/05C	54935	✓	050x2000x04000	2	P	CC	+20	379	563	28		KV	L	-20	P	139	J	150	122	226525

(2) Position: T = Top 2 = Bottom
 (3) Direction: L = Longitudinal T = Transverse S = Thickness
 WE CONFIRM that the listed plates conform to the prescribed order, that the checks for paint markings, superficial and dimensional aspect have given a positive result
 INSPECTION
 CHIEF INSPECTION

CE
 0045
 CERT No: 0045-CPD-099D

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(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Goodwin International, Trentham, UK**Report No:** NCS-000944**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Mar-2011**Submitting Contractor:** Goodwin Steel, UK**NCR #:** GSC-0002**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: 30-Nov-2010**Description of Non-Conformance:**

1. No mill order was supplied to the engineers representative per ABF-RFI-2014R3.
2. No mill Test Report was supplied after receipt of material to the engineers representative per ABF-RFI-2014R3
3. Material was not inspected by engineers representative prior to cutting per ABF-RFI 2014R3 and California Department of Transportation Standard Specifications section 55-1.03 "Inspection".
4. Material was not released by engineers representative from Simaron to Goodwin International per RFI 2014R3 and Standard Specs section 55-1.03 "Inspection".

Contractor's proposal to correct the problem:

Notify purchasing department of requirement to green tag material prior to cutting and providing mill certs.

Corrective action taken:

Goodwin obtained and provided mill certs for QA inspector review, and notified appropriate personnel of requirement of green tagging material prior to fabrication.

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 Kit Guest 510-295-5393, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Guest, Kittric

Quality Assurance Inspector

Reviewed By: Choy, Nina

QA Reviewer