

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 #: 73.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Unyang, Korea**Report No:** NCR-000211**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Oct-2008**Submitting Contractor:** HoChang, Korea**NCR #:** HMI-0001**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: PIER E2 BEARING
Procedural	Procedural	Description: Forging E-2 bearing housing, Solid Shaft and Spher	

Reference Description: Forging**Description of Non-Conformance:**

Forging was started without any advance notification to the Engineer on pier E2 bearing and shear key components. Also, latest fabrication procedure for shear key and bearings were not approved in accordance with requirements of "working drawings" section in special provision, prior to start of work.

Applicable reference:

Standards spec section 55-1.03 Inspection

Special provision Section 10-1.59 Steel structures

Who discovered the problem: Dong J, Shin**Name of individual from Contractor notified:** Project Engineer, Chan I. Park**Time and method of notification:** 10-30-2008, 10:00 By Verbal**Name of Caltrans Engineer notified:** Ajay Sahegal**Time and method of notification:** 10-29-08, verbal 11:00 am**QC Inspector's Name:** Mr Sang Ho, Kwak**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

None at this time.

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

Inspected By: Shin, DJ

QA Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Reviewed By: Lanz,Joe

QA Inspector

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:	11-Nov-2008
Dear:	Mr. Charles Kanapicki	Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Attention:	Mr. James Bowers	Job Name:	SAS Superstructure
Subject:	NCR No. HMI-0001	Document No:	05.03.06-000180
Reference Description:	Forging		

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: Other **Lift:** N/A

The Contractor did not provide the required notification to the Department prior to commencing fabrication in accordance with Section 5-1.018 "Foreign Fabrication," of the Contract Special Provisions and Section 55-1.03, "Inspection" of the Standard Specifications.

Furthermore, the Contractor commenced this work without approved working drawings in violation of Section 5-1.02 "Plans and Working Drawings" of the Standard Specifications.

See NCR #HMI-0001

Action Required and/or Action Taken:

Perform testing in accordance with the Contract requirements to verify the acceptability of the forgings. The Department's representative must witness all testing. Until such time that testing confirms the forgings comply with the Contract requirements, the material is considered rejected in accordance with Section 6-1.04 "Defective Materials" of the Standard Specifications.

Provide notification to the Department prior to commencing any operations - a minimum of 14 days notice is required.

Transmitted By: Warren Collins Assistant Structural Rep

Attachments: HMI-0001

cc: Rick Morrow, Brian Boal, Ajay Sehgal

File: 05.03.06, 09.073.0005.2

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000180

Subject: NCR No. HMI-0001

Dated: 07-Jan-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000195 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: This is HMI's first job with Caltrans and there was a misunderstanding about the TL-38 filing procedure.

This is HMI's first job with Caltrans and there was a misunderstanding about the TL-38 filing procedure. HMI now has that procedure (attached) and Griffin Associates are now in constant communication with Mr. Shin of HMI in Korea and HMI is now following the proper procedures. It is true that the Fabrication Plans we not complete in some areas not related to the work at Doosan, however we believe that the 5th revision, now being reviewed, covers these issues

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000195R00;

Caltrans' comments:

Status: CLO

Date: 29-Sep-2009

The NCR is resolved

Submitted by: Collins, Warren

Attachment(s):

Date: 29-Sep-2009



Hochang Machinery Industries Co., Ltd.

743-65, Yangdeung-Ri, Sangbuk-Myeon, Ulju-Gun, Ulsan, Korea
Phone +82 52 240 3328 / Fax +82 52 237 5255

Letter of Transmittal

Transmittal No.: TRANS-HMIC-ABF-00007 Rev.0

Project : SFOBB / Pier E2 Bearing & Shearkey

Project Contract No 04-0120F4

Supply Agreement #SA-006

Issue Date: Jan. 06, 2009

To: Mr. Charles J. Kanapicki / QCM
American Bridge/Flour JV.
375 Burma Road
Oakland, CA94607

We are sending the following attached items : Attached Via Fedex

Doc No	Rev	Description/Title	DWG No	Status	Rev. Date
HMIC-QM-0901-001	0	Response to NCR Letter HMI-0001			

Total Number of Documents : 1 with 3pages

Remarks:

C.C : HMIC Barry Griffin, T.R Lee, C.I(Charles) Park, S.H Kwak, K.C Shin

Yours faithfully,

Tony Kang / Project Manager

Thanks to acknowledge receipt of this transmittal and to confirm by return that this is transmitted complete to you without any fails.

Acknowledgement of Receipt

Date :

Signature :



HOCHANG MACHINERY INDUSTRIES CO., LTD.

743-65, Yangdeung-Ri, Sangbuk-Myeon, Ulju-Gun, Ulsan, Korea
Tel. +82 52 255 2015, Fax. +82 52 255 2135, E-mail : hocqm@hoc21.com

Jan. 06, 2009

American Bridge/FLUOR

375 Burma Road Oakland CA 94607, USA

Phone 510-808-4600 / Fax 510-808-4601

Our Ref. No. HMIC-QM-0901-001

Total page(s) including this letter : 3

ATTENTION : Mr. Charles J. Kanapicki / QCM

C.C : Mr. Robert G. Kick / Project Manager - Tower

Mr. Sean Wichman / Project Engineer

SUBJECT : Response to NCR Letter HMI-0001

Dear Sirs,

With many thanks for your continuous support given to us so far.

Further to Caltrans NCR No. HMI-0001 dated Oct. 29, 2008, we'd like to express our explanation.

This is HMI's first job with Caltrans and there was a misunderstanding about the TL-38 filing procedure. HMI now has that procedure (refet to Attachment 1) and Griffin Associates are now in constant communication with Mr. Shin (Caltrans Inspector) of HMI in Korea and HMI is now following the proper procedures. It is true that the Fabrication Plans not complete in some areas not related to the work at Doosan, however we believe that the 5th revision, now being reviewed, covers these issues.

For the future, we will try to follow the right procedures and do not occur this nonconformance again.

If you have any questions regarding above mentioned, please let us know.

With best regards,

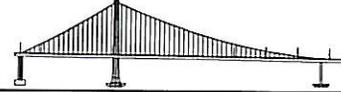
Attachment :

1. TL38 Filing Procedure - 2 Sheets

J.H. Choi

Senior Vice President

HOCHANG Machinery Industries Co., Ltd.



Project: SFOBB Self-Anchored Suspension Bridge

Contract No.: 04-0120F4

Revision: 0

Date: August 13, 2007

Page 1 of 2

As a supplier or subcontractor to ABFJV, you and your subcontractors need to complete a TL38 (This form can be downloaded off the web at: <http://www.dot.ca.gov/hq/esc/Translab/smbforms.htm>) and Fax it to the number shown on the top of the form. Let ABFJV (Area Project Manager and QC Manager) know when this is done by emailing a scan of the form to them. It is important that we use this form and procedure. If you use this form and give proper notification (at least 2 business days if in California, at least one week advance notice otherwise) and CalTrans doesn't show up you can proceed. Any other form of communication runs a risk.

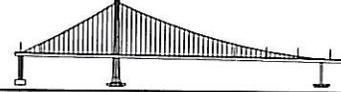
Attached is a scan of a TL38 that was filled out recently. The Bid Item and Item Codes can be found in the front of the Special Provisions (Engineer's Estimate). PLEASE NOTE: The ABFJV Area Project Manager or Jim Bowers (for welding) need to be shown as the person requesting inspection. The person to contact should be from your or your subcontractor's organization.

Concerning the notice, CalTrans would like us to be as exact as can be in scheduling but understand that things happen and dates might slip. As long as they feel we are making a good faith effort they probably won't have a problem. Starting an activity earlier than scheduled however would be a big problem. Late = OK. Early = NOT OK.

At a minimum the following would trigger filing a TL 38:

- Start of fabrication
- Restarting fabrication (if fabrication is not continuous)
- Transfer of work from one facility to another (i.e., heat treater, galvanizer, painter, etc.) and visa versa
- Final inspection and shipping

Please keep ABFJV in the loop.



Project: SFOBB Self-Anchored Suspension Bridge	Contract No.: 04-0120F4
Revision: 0	Date: August 13, 2007
Page 2 of 2	

California Department of Transportation
OFFICE OF STRUCTURAL MATERIALS
 690 Walnut Avenue, Suite 150
 Vallejo, California 94592-1133
 PHONE: (707) 649-5453 FAX: (707) 649-5493

SCHEDULED DATE: _____ **INSPECTOR ASSIGNED:** _____

OR **MATERIAL WILL NOT BE INSPECTED AT THE SOURCE AT THIS TIME**

This section is for METS LAB use only

INSPECTION REQUEST

NUMBER OF PAGES INCLUDING COVER PAGE: (1)

CONTRACT NO: 04-0120F4 **INSPECTION DATE REQUESTED:** 08/10/07
 (EA - XX-XXXXXX) *Requests must be received at least 2 business days prior to the inspection date requested. One week notice is required locations outside the State of California.*

MATERIALS OR ACTIVITIES TO BE INSPECTED:

BID ITEM #	ITEM CODE*	MATERIAL DESCRIPTION	QUANTITY TO BE INSPECTED
48	520102	Rebar Couplers	See Below

* 6-digit code can be found at the beginning of each contract's special provisions

WELDING (Shop / Field) **PROCEDURE/QUALIFICATION TEST** **CONCRETE**
Please circle.

OTHER _____

COMMENTS: Rebar Coupler (HRC 500 & 510) Pre-Job and Operator qualification testing
 Friday, August 10 at 10:00 AM for three operators

COMPANY NAME: American Bridge / FLUOR **E-MAIL:** ckanapicki@abfjv.com
 JV

PHONE: (510) 808-4609 **FAX:** (510) 808-4601

ADDRESS / CITY / ZIP CODE: 375 Burma Rd., Oakland, CA 94607

PERSON REQUESTING INSPECTION: Charles J. Kanapicki

PERSON TO CONTACT ON SITE: Charles J. Kanapicki **PHONE:** (510) 774-2296

Note: Inspection will only be done at the location where the material is located. All appropriate documents should be readily available for our inspector to verify. Be aware that any other material not listed on the inspection form will not be inspected without prior confirmation. We expect to be able to confirm your inspection date on the next business day following receipt of this form. Please notify this office of all changes to your schedule at least 24 hours prior to the scheduled inspection date. Incomplete or incorrectly filled out forms will delay the inspection process. Be advised that due to the unpredictable nature of inspections, OSM staff will not schedule appointments for a specific time of day. Inspections of material in production may occur at any time. Please remember to provide safe access to all material requiring inspection. This form can be downloaded off the web at:
<http://www.dot.ca.gov/hq/esc/Translab/smbforms.htm>

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Unyang, Korea**Report No:** NCS-000196**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** HoChang, Korea**NCR #:** HMI-0001**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: 29-Oct-2008**Description of Non-Conformance:**

Forging was started without any advance notification to the Engineer on pier E2 bearing and shear key components. Also, latest fabrication procedure for shear key and bearings were not approved in accordance with requirements of "working drawings" section in special provision, prior to start of work.

Contractor's proposal to correct the problem:

Notify Engineer in advance of forging and casting operations. Ensure fabrication procedures and other contract requirements are approved prior to start of work.

Corrective action taken:

Same as Contractors proposed resolution.

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

Inspected By: Choy, Nina

Quality Assurance Inspector

Reviewed By: Choy, Nina

QA Reviewer