

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 #: 70.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Murooran, Japan**Report No:** NCR-000058**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Feb-2008**Submitting Contractor:** Japan Steel Works**NCR #:** JSW-0001**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: West Deviation Saddle Segment W2E1
Procedural	Procedural	Descriptor:	Failure to provide adequate notification for NDT

Description of Non-Conformance:

Japan Steel Works (JSW) conducted magnetically particle and ultrasonic testing to identify casting repair locations on the interior portion of West Deviation Saddle segment W2E1 without providing the required notification to METS. The TL-38 for starting of NDT activities was submitted on February 9, 2008 and JSW stated that the previous NDT efforts were to identify casting repair locations. However, in progress NDT efforts, originally identified by JSW as in-house testing, were observed by Mr. Wai Pau on January 8, 2008. In addition, JSW indicate that Nikko Inspection Services, currently under contract by ABF to provide third party NDT services, has not anticipated conducting the previously completed NDT services a second time.

Applicable reference:

Special Provisions, Section 10 1.59 STEEL STRUCTURES, CASTINGS: "The Contractor shall provide the Engineer with work schedules, and expected readiness of work for quality assurance (QA) inspection by the Engineer."

Special Provisions, Section 5-1.018 FOREIGN FABRICATION: "When Department audit, inspection, or test witnessing is requested for facilities outside the United States, the Contractor shall provide 14 days notice to the Department, except when Department representatives are already on site."

Who discovered the problem: Mr. Wai Pau**Name of individual from Contractor notified:** Kazunori Sato with JSW**Time and method of notification:** 1658 on February 13, 2008**Name of Caltrans Engineer notified:** Warren Collins**Time and method of notification:****QC Inspector's Name:****Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

JSW has not provided a corrective scheduling notification solution to METS at this time. A TL-38 for the ongoing work was submitted on February 9, 2008.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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 Venkatesh Iyer,(510) 808-4542, who represents the Office of Structural Materials for your project.

Inspected By: Brasel,Ron

Quality Assurance Inspector

Reviewed By: Iyer,Venkatesh

QA Reviewer



DEPARTMENT OF TRANSPORTATION

333 Burma Road

Oakland CA 94607

Tel: 510-622-5661 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge/Fluor Enterprises, a JV
375 Burma Road
Oakland CA 94607

Date: 14-Feb-2008

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

Attention: Michael Flowers Project Executive

Job Name: SAS Superstructure

Subject: NCR No. JSW-0001

Document No: 05.03.06-000029

The Attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Non-Conformance with quality control procedures. Please take appropriate corrective action. Recurrence may require further administrative action.
- Non-Conformance with quality control. Records indicate that this is a recurring issue and constitutes a systematic problem in quality control. Within fourteen (14) days, please submit a plan to correct the deficiency.
- Material or workmanship is not in compliance with contract requirements.

Enclosed please find the following item:

NCR No. JSW-0001

Remarks:

JSW failed to provide notification of NDE operations and thus denied the Department the opportunity to witness the procedure - See attached NCR #JSW-0001 for further details.

Transmitted By: Warren Collins Assistant Structural Rep

cc: Rick Morrow, Brian Boal, Venkatesh Iyer

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000029

Subject: NCR No. JSW-0001

Dated: 30-Jul-2008

Contract No.: 04-0120F 4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000048 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: A teleconference was held on Feb. 14, 2008 where we discussed this non-conformance and corrective action. ABF JV considers this NCR closed. A teleconference was held on Feb. 14, 2008 where we discussed this non-conformance and corrective action. Please see attached for additional information as to the items discussed at the teleconference.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000048R00;

Caltrans' comments:

Status: CLO
Date: 13-Oct-2008

The Department considers NCR #JSW-0001 (ABF-NPR-000048R00) closed.

Please note that the use of a meeting agenda will not be considered acceptable for the resolution of any further NCR's.

Submitted by: Collins, Warren

Attachment(s):

Date: 16-Oct-2008

Charles Kanapicki

From: jim bowers [jbowers@abfjv.com]
Sent: Thursday, February 14, 2008 10:23 AM
To: Brian Petersen; Charles Kanapicki
Subject: JSW Conference Call

Gents:

Here is rough agenda for items of discussion with JSW. Please add anything you feel is pertinent.

Thanks

Jim Bowers
American Bridge / Fluor - a Joint Venture
Welding Quality Control Manager
375 Burma Road
Oakland, CA 94607
Office Phone: 510 808 4608
Cell Phone: 510 774 0821
jbowers@abfjv.com

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This message has been scanned for viruses
and dangerous content by [MailScanner](#).

February 14, 2008

Japan Steel Works Teleconference

CALTRANS ITEMS of CONCERN:

- 1) The Caltrans METS Inspector reported that they observed JSW performing PT (dye penetrant) testing during inter-pass welding of a PQR Plate. They also reported that subsequent repairs were being performed as a result of that testing. .
- 2) Caltrans reported that JSW stated that they were performing the test due to problems with the welder/welding operator and suspected porosity in the weld.
- 3) Caltrans contends that JSW requested that a portion of the PQR be disregarded for testing, and that the remaining length be accepted.
- 4) Caltrans is concerned that the Nikko CWI Inspector allowed the PT testing to be performed when the process and procedure was not clearly stated and defined on the PQR documentation.

QUESTIONS for JSW RE: ITEMS of CONCERN:

- 1) What were the specific details of the PQR Plate being tested:
 - a) Plate type
 - b) Plate thickness
 - c) Plate length
 - d) Weld Process and Electrode
- 2) Was JSW performing PT on intermediate passes within the PQR Plate??
- 3) What specific defects was JSW seeking to find with the PT??
- 4) What specific defects were found with the testing??
- 5) Were any repairs made subsequent to, and as a result of, the PT testing??

- 6) Was the PT matrix (dye and developer) suited for the temperature range of the in-process plate?? Was the specified inter-pass temperature maintained during the PT testing and any subsequent repairs??
- 7) Is the use of the in-process PT testing on this type of material standard practice in the JSW shop??
- 8) Has any further welding been performed on the PQR plate?? Is the plate complete??
- 9) Has JSW asked Caltrans to disregard portions of the plate and accept other portions??
- 10) Does JSW still intend to use any portion of this particular plate, as welded, to present for testing and approval.

RECOMMENDATIONS:

- 1) JSW may not be prohibited from using means to enhance the visual inspection of intermediate weld passes during testing. However, if the testing is to be performed on the qualification test, it must be clearly defined and stated on the procedure qualification welding procedure and the method must be approved for the welding conditions, both for the test plate and for the actual production conditions.
- 2) Anything other than corrections to the topmost weld layer, such as grinding to remove unacceptable portions of a weld, during the PQR test is considered a repair and is expressly prohibited by the AWS D1.5 Welding Code.
- 3) JSW should refrain from asking Caltrans for "considerations" of any kind, either verbally, or otherwise. JSW is obligated to provide a visually acceptable qualification plate that meets the requirements of the AWS Code (or ASME as applicable) and the Contract Special Provisions. The test plate should be of the minimum size as required and should not contain any unacceptable or non-conforming sections.

ADDITIONAL ITEM:

The ABFJV has been informed, by Caltrans, that a Non-Conformance Report has been issued against JSW for failure to provide adequate notification prior to performing UT testing on the West Deviation Saddle. JSW is reminded that a TL-38 Form must be filed with the State of California, at least one week in advance, of any and all welding and NDE operations. This requirement was discussed extensively during the pre-weld meeting. Copies of the submitted



QUALITY CONTROL DEPARTMENT
375 Burma Road
Oakland, CA 94067
Office Tel: 510 808 4600
Office Fax: 510 808 4601

TL-38 Form must also be sent to ABFJV, and should include Mr. Robert Kick, Project Manager and Mr. Jim Bowers, Welding Quality Control Manager.

JSW is also reminded that they must provide unlimited access to any Caltrans personnel to the components in process in the JSW shop.

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Murooran, Japan**Report No:** NCS-000071**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Aug-2008**Submitting Contractor:** Japan Steel Works**NCR #:** JSW-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: 09-Feb-2008**Description of Non-Conformance:**

Japan Steel Works (JSW) conducted magnetically particle and ultrasonic testing to identify casting repair locations on the interior portion of West Deviation Saddle segment W2E1 without providing the required notification to METS. The TL-38 for starting of NDT activities was submitted on February 9, 2008 and JSW stated that the previous NDT efforts were to identify casting repair locations. However, in progress NDT efforts, originally identified by JSW as in-house testing, were observed by Mr. Wai Pau on January 8, 2008. In addition, JSW indicate that Nikko Inspection Services, currently under contract by ABF to provide third party NDT services, has not anticipated conducting the previously completed NDT services a second time.

Contractor's proposal to correct the problem:

JSW has not provided a corrective scheduling notification solution to METS at this time. A TL-38 for the ongoing work was submitted on February 9, 2008.

Corrective action taken:

JSW and NIS started and has consistently maintained a daily notification program that includes both NDT (from NIS) and fabrication (from JSW) schedules for the following day's activities.

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 Ryan Smith, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By: Brasel, Ron

Quality Assurance Inspector

Reviewed By: Iyer, Venkatesh

QA Reviewer