

**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:** Working Drawing Campus (WDC)**Report No:** NCR-000002**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 19-Mar-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0002**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Welding Quality Control Plan (WQCP)
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	Missing minimum required data in WQCP.

**Description of Non-Conformance:**

ABF's Quality Control Manager submitted ABF-SUB-000054: Draft Welding Quality Control Plan (WQCP) for ZPMC before correcting deficiencies. Items that ABF's QCM failed to identify included:

1. Missing information (NDT and welder certifications, filer metal documentation, etc.
2. Various sections that do not comply with AS D1.5, 2002, ASNT, SNT-TC-1A, or the Special Provisions.
3. Discrepancies with submitted WPS and PQR documentation.

Please see State Letter 05.03.01-000158 for a complete list of deficient items.

**Applicable reference:**

pecial Provisions, section 8-3.01, The QCM shall be the sole individual responsible to the Contractor for submitting, receiving, reviewing, and approving all correspondence, required submittals, and reports to and from the Engineer. (Also reference RFI 70)

**Who discovered the problem:** Patrick Lowry**Name of individual from Contractor notified:** Contractor not notified.**Time and method of notification:** N/A**Name of Caltrans Engineer notified:** Stanly Ku**Time and method of notification:** Monday, 03-19-07, verbal**QC Inspector's Name:** Jim Bowers**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Revise and resubmit the minimum required documentation.

**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:** Mertz, Robert

Quality Assurance Inspector

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Reviewed By:** Lowry,Patrick

QA Reviewer



**DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge**  
 333 Burma Road  
 Oakland CA 94607  
 Tel: 510-622-5158 Fax:

**NON-CONFORMANCE REPORT TRANSMITTAL**

**To:** American Bridge/Fluor Enterprises, a JV  
 375 BURMA ROAD  
 OAKLAND CA 95607

**Date:** 27-Apr-2007

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

**Dear:** Mr. Charles Kanapicki  
**Attention:** Mr. Michael Flowers Project Executive  
**Subject:** NCR No. ZPMC-0002

**Job Name:** SAS Superstructure  
**Document No:** 05.03.06-000066

**Reference Description:** The Weld quality of several welds could not be determined due to the lack of weld preparation prior to radiography and an adequate

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 - No Response Required.

**Material Location:** **Lift:**

**Remarks:**  
 Originally Sent by State Letter 05.03.01-000220

**Action Required and/or Action Taken:**

**Transmitted by:** Keith Osantowski Sr. Engineer  
**Attachments:** ZPMC-0002

**cc:**  
**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000066

**Subject:** NCR No. ZPMC-0002

**Dated:** 28-Nov-2007

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000001 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** No future incomplete, partial and/or deficient WQCP submittals will be provided for initial review by the State.

The original submittal of the ZPMC WQCP was provided to the State, for initial review, with the understanding that the document contained omissions and deficiencies. It is agreed that no further "correspondence, required submittals, and reports", as detailed in Section 8-3 of the Contract Special Provisions, shall be submitted to the State prior to the completion of said review and approval by the ABFJV Welding Quality Control Manager (WQCM), and that no future incomplete, partial and/or deficient WQCP submittals will be provided for initial review by the State.

The ABFJV WQCM reviewed, revised and corrected all of the deficiencies as noted in the State Letter 05.03.01-000158 regarding this submittal. The WQCP for ZPMC was subsequently approved by the State Letter No. 05.03.01-000718, dated October, 2007.

The ABFJV considers this NCR status as closed.

**Submitted by:** Flowers, Michael

**Attachment(s):** ABF-NPR-000001R00; ABF-CAL-LTR-000374

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### Caltrans' comments:

**Status:** CLO

**Date:** 11-Mar-2008

See State Letter 05.03.01-001503

**Submitted by:** Pursell, Gary

**Date:** 11-Mar-2008

**Attachment(s):** State Letter 05.03.01-001503w/signature

**DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program**

333 Burma Rd.

Oakland, CA 94607

(510) 622-5660, (510) 286-0550 fax



*Flex your power  
Be energy efficient!*

March 11, 2008

Contract No. 04-0120F4

04-SF-80-13.2 / 13.9

Self-Anchored Suspension Bridge

Letter No. 05.03.01-001503

Michael Flowers  
Project Executive  
American Bridge /Fluor Enterprises, a JV  
375 Burma Road  
Oakland, CA 94607

Dear Michael Flowers,

**ZPMC NCRs 2, 3 & 15**

This letter is issued as a response to ABF-CAL-LTR-000374, dated November 28, 2007, ABF-CAL-LTR-000447, dated February 15, 2008, and ABF-CAL-LTR-000448, dated February 18, 2008, requesting written confirmation from the Engineer that the referenced Non-Conformance Reports (NCRs) at Zhenhua Port Machinery Company, Ltd (ZPMC) have been closed. In addition to those closed previously, the Department considers the following ZPMC NCRs closed:

<b>NCR No.</b>	<b>State Letter</b>	<b>ABF Letter</b>	<b>Description</b>
2	05.03.01-000220	ABF-CAL-LTR-000374	Draft Welding Quality Control Plan submitted before deficiencies corrected
3	05.03.01-000229	ABF-CAL-LTR-000448	QCM did not review & approve RT film before requesting Department's approval
ZPMC 15 Report #16	NCT - 0001	ABF-CAL-LTR-000447	SPCM material fabricated prior to Check Samples being removed and delivered to the Engineer

If you have any questions, please contact Rick Morrow at 510-286-0501.

Sincerely,

GARY PURSELL  
Resident Engineer

cc: Rick Morrow, Mark Woods, Brian Boal, Gary Lai  
file: 05.03.01

28-Nov-2007

ABF-CAL-LTR-000374

Mr. Gary Pursell  
Resident Engineer  
**California Department of Transportation**  
333 Burma Road,  
Oakland, CA 94607, USA

**PROJECT: San Francisco Oakland Bay SAS Bridge Superstructure**  
**Caltrans Contract No. 04-0120F4**  
**ABF Job No. 660110**

**SUBJECT: RESPONSE TO NCR-000002**

Gentlemen:

American Bridge / Fluor Enterprises Inc. a Joint Venture (ABFJV) acknowledges receipt of the Department's Letter No.05.03.01-000220 dated April 27, 2007 forwarding the Department's Non-Compliance Report NCR-000002

For the Department's consideration in closure of NCR-000002, ABFJV offers the following:

The original submittal of the ZPMC WQCP was provided to the State, for initial review, with the understanding that the document contained omissions and deficiencies. It is agreed that no further "correspondence, required submittals, and reports", as detailed in Section 8-3 of the Contract Special Provisions, shall be submitted to the State prior to the completion of said review and approval by the ABFJV Welding Quality Control Manager (WQCM), and that no future incomplete, partial and /or deficient WQCP submittals will be provided for initial review by the State.

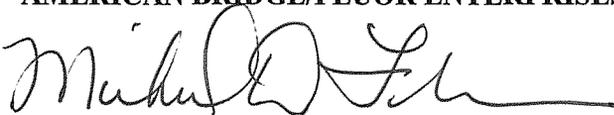
The ABFJV WQCM reviewed, revised and corrected all of the deficiencies as noted in the State Letter 05.03.01-000158 regarding this submittal. The WQCP for ZPMC was subsequently approved by the State Letter No.05.03.01-000718, dated October, 2007.

The ABFJV considers this NCR status as closed.

If you need any more information, please call Jim Bowers at +1 (510) 808-4600.

Sincerely,

**AMERICAN BRIDGE/FLUOR ENTERPRISES, INC. A JOINT VENTURE**



Michael Flowers  
Project Director  
MF/JB/km

File: 02.01, 15.04

**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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Working Drawing Campus (WDC)**Report No:** NCS-000001**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Jul-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0002**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 19-Mar-2007**Description of Non-Conformance:**

ABF's Quality Control Manager submitted ABF-SUB-000054: Draft Welding Quality Control Plan (WQCP) for ZPMC before correcting deficiencies. Items that ABF's QCM failed to identify included:

1. Missing information (NDT and welder certifications, filler metal documentation, etc.
2. Various sections that do not comply with AS D1.5, 2002, ASNT, SNT-TC-1A, or the Special Provisions.
3. Discrepancies with submitted WPS and PQR documentation.

Please see State Letter 05.03.01-000158 for a complete list of deficient items.

**Contractor's proposal to correct the problem:**

Revise and resubmit the minimum required documentation.

**Corrective action taken:**

The WQCP was revised and resubmitted and was AAN on 7-26-07 by METS.

**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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

**Inspected By:** Mertz, Robert

Quality Assurance Inspector

**Reviewed By:** Lowry, Patrick

QA Reviewer