

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:** Changxing Island, Shanghai, China**Report No:** NCR-000005**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Sep-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0004**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 77m Mock-Up Long Stiffener to Skin Plate welds
Procedural	Procedural	Descriptor:	

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

The Contractor has allowed the fabricator to proceed with making repairs to rejectable indications found in the complete joint penetration (CJP) welds which connect the longitudinal stiffeners to Skin Plates A and E of the 77m mock-up. These indications were found using Ultrasonic Testing (UT) at lengths greater than 10% of the cumulative length of the welds. These repairs are considered unsatisfactory to the Department regarding mock-up fabrication requirements. In addition, these repairs were made in manner that does not demonstrate a procedure that is repeatable in actual production.

Applicable reference:

Special Provisions, Section 10-1.59, "Fabrication/Erection Procedure and Mock-Ups", Page 313, paragraph B.2 and B.4.

Who discovered the problem: Ryan Smith, SMR and Alistair Melville, Assistant SR**Name of individual from Contractor notified:** Steve Lawton, ABF Quality Assurance Manager**Time and method of notification:** 12-SEP-07 at approximately 1330 hours via verbal notification**Name of Caltrans Engineer notified:** Jason Tom, Structure Representative**Time and method of notification:** 12-SEP-07 at approximately 0900 hours via verbal notification**QC Inspector's Name:** N/A**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

None proposed 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 Mazen Wahbeh, 818-292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Smith, Ryan

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Reviewed By: Lowry,Patrick

QA Reviewer

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:** Changxing Island, Shanghai, China**Report No:** NCS-000011**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0004**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: 11-Sep-2007**Description of Non-Conformance:**

The Contractor has allowed the fabricator to proceed with making repairs to rejectable indications found in the complete joint penetration (CJP) welds which connect the longitudinal stiffeners to Skin Plates A and E of the 77m mock-up. These indications were found using Ultrasonic Testing (UT) at lengths greater than 10% of the cumulative length of the welds. These repairs are considered unsatisfactory to the Department regarding mock-up fabrication requirements. In addition, these repairs were made in manner that does not demonstrate a procedure that is repeatable in actual production.

Contractor's proposal to correct the problem:

None at the time of the NCR.

Corrective action taken:

ABFJV has reviewed the mock-up section of the Special Provision with ZPMC to gain understanding of this requirement which is different from the requirements for production. Both ABFJV and ZPMC now understand this requirement. ZPMC initiated an internal NCR to address this nonconformance. ZPMC also conducted internal tests and has submitted a plan to improved weld quality.

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: Ishibashi, Josh

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer