

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:** Shanghai, China**Report No:** NCR-000008**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Sep-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0006**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 114 Meter Mock-Up
Procedural	Procedural	Descriptor:	

Description of Non-Conformance:

A number of welds for Skin Plates A MA-106 and B MA-101 have defects as defined by AWS D1.5, that were found by Ultrasonic Testing with cumulative lengths in excess of 10% of the weld lengths. Cumulative length of indication for the welds in question were found to range of 11% to 45.4% on welds 5 & 7 of A MA-106 and welds 5, 5 R1 and 8 on b MA-101. American Bridge/Flour allowed repairs to be carried out without notifying Caltrans Quality Assurance.

Applicable reference:

Special Provisions Contract Number 04-0120F4, Fabrication/Erection Procedure and Mock-Ups, Item B.2 page 313.

Who discovered the problem:**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:****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:****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: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Shanghai, China**Report No:** NCS-000012**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0006**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: 24-Sep-2007**Description of Non-Conformance:**

A number of welds for Skin Plates A MA-106 and B MA-101 have defects as defined by AWS D1.5, that were found by Ultrasonic Testing with cumulative lengths in excess of 10% of the weld lengths. Cumulative length of indication for the welds in question were found to range of 11% to 45.4% on welds 5 & 7 of A MA-106 and welds 5, 5 R1 and 8 on b MA-101. American Bridge/Fluor allowed repairs to be carried out without notifying Caltrans Quality Assurance.

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 improve 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:**

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Inspected By: Ishibashi, Josh

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer