

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:** Bay 7 of Fabrication Facility, Shanghai, China**Report No:** NCR-000017**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Nov-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0016**Type of problem:**

| | | | |
|---------------------|-------------------|--|---|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: Floor Beam Components |
| Procedural | Procedural | Descriptor: Heat straightening without Engineer's approval. | |

Description of Non-Conformance:

The Caltrans Quality Assurance (QA) inspectors Scott Croff and Alfredo Acuna observed ZPMC personnel using unapproved methods for straightening complete penetration butt joint welded parts. The QA inspector observed a 5.5 ton block being used to hold down one end of plate and an electromagnet on the overhead gantry crane to pull up on the opposite end of the plate while using a torch to apply localized heat to the welded area. The QA inspectors observed these listed parts being straightened using the unapproved described procedure: FB015-003-026, FB007-W028-026, FB007-03-026, FB008-01-026, FB007-02-026, FB007-01-026.

Applicable reference:

ZPMC WQCP Section 11 and AWS D1.5 (2002) Section 3.7.3

Who discovered the problem: Caltrans QA inspector Scott Croff, later observed by QA inspector Alfredo Acuna.**Name of individual from Contractor notified:** David Williams**Time and method of notification:** 1300 hours, 11-27-2007**Name of Caltrans Engineer notified:** Stanley Ku verbally notified by SMR Ryan Smith**Time and method of notification:** 1245 hours, 11-27-2007**QC Inspector's Name:** Li Zhi Jiang, Fu Yu Hong**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Unknown 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 Patrick Lowry, 916-227-5719, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer



DEPARTMENT OF TRANSPORTATION
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 10-Dec-2007

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

Attention: Michael Flowers Project Executive

Job Name: SAS Superstructure

Document No: 05.03.06-000003

Subject: NCR No. ZPMC-0016

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 items:

NCR No: ZPMC-0016

Remarks:

ZPMC personnel was observed using unapproved method for straightening complete penetration joint welded parts. For details, please see attached NCR No. ZPMC-0016.

Transmitted by: Stanley Ku Sr. Bridge Engineer

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Stanley Ku, Brian Boal, Michael Flowers, Keith Devonport, Jason Tom

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000003

Subject: NCR No. ZPMC-0016

Dated: 05-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000050 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: Additional inspectors and training have been provided to aid in proper heat straightening techniques.
Please see attached.

Submitted by: Kanapicki, Charles
Attachment(s): ABF-NPR-000050R00;

Caltrans' comments:

Status: CLO
Date: 06-Aug-2008

The Contractor's response is acceptable. The Department concurs that Non-Conformance ZPMC-0016 is closed.

Submitted by: Wright, Doug
Attachment(s):

Date: 06-Aug-2008

17 July 2008

Reply to: SL-ABF-08-0xxx

Attention: Gary Pursell

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

Subject: NCR# ZPMC-0016

Mr. Pursell:

This letter is issued to provide formal response addressing the proposed resolution to the following nonconformance reports:

NCR # ZPMC-0016

The CT QA observed unapproved methods for straightening complete penetration butt joint welded parts.

ZPMC understand the contact requirements for submitting heat straightening records for approval when required. Additional QC inspectors have been added to help insure proper approval is obtained prior to performing heat straightening. Additionally, training has been provided on proper straightening techniques.

If further clarifications are needed, please contact me.

Nate S. Lindell
Quality Assurance Manager
American Bridge Fluor Joint Venture

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Bay 7 of Fabrication Facility, Shanghai, China**Report No:** NCS-000018**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 10-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0016**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: 26-Nov-2007**Description of Non-Conformance:**

The Caltrans Quality Assurance (QA) inspectors Scott Croff and Alfredo Acuna observed ZPMC personnel using unapproved methods for straightening complete penetration butt joint welded parts. The QA inspector observed a 5.5 ton block being used to hold down one end of plate and an electromagnet on the overhead gantry crane to pull up on the opposite end of the plate while using a torch to apply localized heat to the welded area. The QA inspectors observed these listed parts being straightened using the unapproved described procedure: FB015-003-026, FB007-W028-026, FB007-03-026, FB008-01-026, FB007-02-026, FB007-01-026.

Contractor's proposal to correct the problem:

METS-OSM will track this issue as a Quality Management Issue and does not request a response from the Contractor at this time. If this issue becomes systemic, METS will elevate this issue to second-tier and request a response from the Contractor.

Corrective action taken:

N/A

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: Liu, Chengwen

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer