

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-000021**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0020**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor: Improper TL-508 Electrode Baking and Storage	

Description of Non-Conformance:

1) ABF has allowed ZPMC to utilize TL-508 (E-7018) electrodes that do not appear to have been dried prior to storage. There is no evidence, documented or otherwise, that indicates that the electrodes have been properly dried prior to being stored within the holding oven.

2) It has been observed numerous times in the last two weeks that the storage ovens are below the required temperature range per AWS D1.5-2002 and/or the manufacturer's written drying instructions of 100-150 degrees Centigrade.

Applicable reference:

TL-508 Manufacturer's Written Drying Instructions, AWS D1.5-2002 and the Welding Quality Control Plan (WQCP), Section 8, Revision 0-July 2007.

Who discovered the problem: John Tracy**Name of individual from Contractor notified:** Steve Lawton**Time and method of notification:** 1300 1/8/08, Verbal**Name of Caltrans Engineer notified:** Ching Chao**Time and method of notification:** 1300 1/8/08, Verbal**QC Inspector's Name:** Xu Jun**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 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



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: 22-Jan-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000006

Subject: NCR No. ZPMC-0020

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-0020

Remarks:

Please see attached NCR # ZPMC-0020.

Transmitted by: Ching Chao

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods, Jason Tom, Dave Williams, Ching Chao, Ching Chao

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000006

Subject: NCR No. ZPMC-0020

Dated: 19-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000079 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: At this time the welds in question are being investigated for contract conformance. Inspection recodes shall be submitted for approval and closure of this NCR once identified.

Please see attached letter.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000079R00;

Caltrans' comments:

Status: REJ

Date: 09-Sep-2008

The Department understands that the Contractor is investigating the welds in question and will provide further documentation in a subsequent submittal. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0020 at that time.

Submitted by: Wright, Doug

Attachment(s):

Date: 09-Sep-2008



American
Bridge

FLUOR

A JOINT VENTURE

August 19, 2008

Reply to: SL-ABF-08-0174

Attention: Gary Pursell

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

Subject: NCR# ZPMC-0020

Mr. Pursell:

This letter is issue to provide formal response addressing the proposed resolution to NCR# ZPMC-0020.

ZPMC understands the requirements of AWS D1.5-02 in regards to electrode storage. All electrodes shall be stored in conformance with Code and Contract. At this time the welds in question are being investigated for contract conformance. Inspection recodes shall be submitted for approval and closure of this NCR once identified.

Please feel free to contact me directly if you require assistance or further clarification.

Sincerely,

Nate Lindell
Quality Assurance Manager
AMERICAN BRIDGE / FLUOR JV

cc: file

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000006

Subject: NCR No. ZPMC-0020

Dated: 15-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000079 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: APPROVED, ACTION PENDING should be an option for those NCRs where Caltrans agrees with our proposed resolution but where the actual corrective action and/or supporting documentation is forthcoming.

When setting up this NCR system on PMIV we specifically requested that a status of APPROVED, ACTION PENDING be an option for those NCRs where Caltrans agrees with our proposed resolution but where the actual corrective action and/or supporting documentation is forthcoming.

For the NCRs noted above, Caltrans agrees with our proposals. A status of REJECTED sends the message that the proposal is rejected when in fact what (I think) they are saying is "we agree and we'll close when the proper paperwork comes in."

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000079R01

Caltrans' comments:

Status: AAP

Date: 23-Sep-2008

The Contractor's understanding of the "Approved Action Pending" status is correct.

The Department understands that the Contractor is investigating the welds in question and will provide further documentation in a subsequent submittal. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0020 at that time.

Submitted by: Prchlik, Aaron

Attachment(s):

Date: 23-Sep-2008

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000006

Subject: NCR No. ZPMC-0020

Dated: 03-Dec-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000079 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has attached the welding consumable storage record as evidence of filler metal control. ZPMC requests closure of this NCR.

Please see attached welding consumable storage record.

Submitted by:

Attachment(s): ABF-NPR-000079R02; Welding consumable storage record

Caltrans' comments:

Status: CLO

Date: 21-Dec-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0020 is closed.

Submitted by: Wright, Doug

Date: 22-Dec-2008

Attachment(s):



WELDING CONSUMABLES STORAGE RECORD

焊接材料保温记录表

No.	Welding Consumables 材料名称	Type 型号	Batch No. 批号	Oven No. 箱号	Drying Start Time 开始烘焙时间	Oven Temp. (°C) 温度	Preservation Drying Time 保温时间	Preservation Drying Temp. (°C) 保温温度	Accept (Yes/No) 是/否	Confirm by Controller 确认人	Remarks 备注
1	焊条 4.0	THL 506	38823	3#	9:30	380°C	11:30	130°C	YES	LYX1991	8月13号 140
2	焊条 4.50	THL 506	36523	3#	9:30	380°C	11:30	130°C	YES	LYX1991	8月13号 140
3	焊条 4.3	TL 508	80610102	5#	10:00	350°C	12:00	130°C	YES	LYX1991	8月13号 300
4	焊条 4.0	TL 508	80620106	4#	10:00	350°C	12:00	130°C	YES	LYX1991	8月13号 400
5	焊条 4.0	TL 508	70919106	6# 7#	20:30	350°C	22:30	130°C	YES	LYX1991	8月13号 900
6	焊条 4.3	TL 508	80610102	5#	15:20	350°C	17:20	130°C	YES	LYX1991	8月13号 300
7	焊条 4.50	TL 508	80702101	4#	15:20	350°C	17:20	130°C	YES	LYX1991	8月13号 400
8	焊条 4.0	TL 508	70919106	6# 7#	10:30	350°C	12:30	130°C	YES	LYX1991	8月13号 480
9	焊条 4.4	THL 506	38823	3#	19:00	380°C	21:00	130°C	YES	LYX1991	8月27号 1000
10	焊条 4.3	THL 506	36523	3#	19:00	380°C	21:00	130°C	YES	LYX1991	8月27号 3200
11	焊条 4.3	TL 508	80610102	5#	11:00	350°C	13:00	130°C	YES	LYX1991	8月27号 600
12	焊条 4.50	TL 508	86702101	4#	11:00	350°C	13:00	130°C	YES	LYX1991	8月27号 300
13	焊条 4.4	TL 508	80702101	6# 7#	17:00	350°C	19:00	130°C	YES	LYX1991	8月27号 3800
14	焊条 4.4	THL 506	38823	3#	14:30	380°C	16:30	130°C	YES	LYX1991	8月27号 800
15	焊条 4.50	THL 506	36523	3#	14:30	380°C	16:30	130°C	YES	LYX1991	8月27号 2400
16	焊条 4.4	TL 508	80702101	6# 7#	8:00	350°C	10:00	130°C	YES	LYX1991	8月27号 600
17	焊条 4.50	THL 506	38823	3#	15:30	380°C	17:30	130°C	YES	LYX1991	8月27号 2400
18	焊条 4.4	THL 506	36523	3#	14:20	380°C	16:20	130°C	YES	LYX1991	8月27号 2400
19	焊条 4.3	TL 508	80610102	5#	11:00	350°C	13:00	130°C	YES	LYX1991	8月27号 1600
20	焊条 4.4	TL 508	80702101	4#	11:00	350°C	13:00	130°C	YES	LYX1991	8月27号 1600
21	焊条 4.4	TL 508	80702101	6# 7#	15:00	380°C	17:00	130°C	YES	LYX1991	8月27号 300
22	焊条 4.4	THL 506	38823	3#	14:00	380°C	16:00	130°C	YES	LYX1991	8月27号 300

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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-000133**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0020**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: 13-Dec-2007**Description of Non-Conformance:**

ABF has allowed ZPMC to utilize TL-508 (E-7018) electrodes that do not appear to have been dried prior to storage. There is no evidence, documented or otherwise, that indicates that the electrodes have been properly dried prior to being stored within the holding oven. In addition, it has been observed that the storage ovens are below the required temperature range per AWS D1.5-2002 and/or the manufacturer's written drying instructions of 100-150 degrees Centigrade.

Contractor's proposal to correct the problem:

ZPMC will provide a welding consumable storage record as evidence of filler metal control.

Corrective action taken:

ZPMC has submitted a welding consumable storage record as evidence of filler metal control. This record indicates that the electrodes have a preservation drying temperature of 130 degrees Centigrade, which is in compliance with AWS D1.5-2002, Section 4.5.2 and the manufacturer's written drying instructions.

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 Serge Sinevod, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge

Quality Assurance Inspector

Reviewed By: Sinevod, Serge

QA Reviewer