

**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-000023**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0022**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> Tower Strut-Shear Links MA-26-1 and MA-26-2
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Description of Non-Conformance:**

ABF has allowed ZPMC to receive and weld with SMAW TL-508 (E-7018) electrodes that were not issued from hermetically sealed containers, per section 4.5.2, nor is there any documented evidence that the electrodes were dried in accordance with AWS D1.5-2002, Section 4.5.2.

**Applicable reference:**

AWS D1.5 (2002) section 4.5.2 and WQCP section 8.1.

**Who discovered the problem:** John Tracy

**Name of individual from Contractor notified:** Nate Lindell

**Time and method of notification:** 1430 12/03/07, Verbally

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 0900 1/11/08, Verbally

**QC Inspector's Name:** Ye Yongjun

**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:** 05.03.06-000007

**Subject:** NCR No. ZPMC-0022

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-0022

**Remarks:**

Please see attached NCR # ZPMC-0022.

**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:** 05.03.06-000007

**Subject:** NCR No. ZPMC-0022

**Dated:** 19-Aug-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000080 Rev: 00

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**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-000080R00;

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**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-0022 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-08-0175

**Attention:** Gary Pursell

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

**Subject:** NCR# ZPMC-0022

Mr. Pursell:

This letter is issue to provide formal response addressing the proposed resolution to NCR# ZPMC-0022.

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:** 05.03.06-000007

**Subject:** NCR No. ZPMC-0022

**Dated:** 15-Sep-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000080 **Rev:** 01

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### Contractor's Proposed Resolution:

**Reference Resolution:** 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.

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-000080R01

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### 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-0022 at that time.

**Submitted by:** Prchlik, Aaron

**Date:** 23-Sep-2008

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000007

**Subject:** NCR No. ZPMC-0022

**Dated:** 03-Dec-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000080 Rev: 02

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**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-000080R02; Welding consumable storage record

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**Caltrans' comments:**

**Status:** CLO

**Date:** 22-Dec-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0022 is closed.

**Submitted by:** Wright, Doug

**Date:** 23-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 φ40	JHJ 506	36423	1#	7:30	380°C	9:30	130°C	YES	11/10/19 9:30	地量 120g
2	焊条 φ50	JHJ 506	36523	1#	7:30	380°C	9:30	130°C	YES	11/10/19 9:30	地量 60g
3	焊条 φ40	JHJ 506	36423	1#	8:50	380°C	10:50	130°C	YES	11/10/19 9:30	地量 100g
4	焊条 φ50	JHJ 506	36523	1#	8:50	380°C	10:50	130°C	YES	11/10/19 9:30	地量 100g
5	焊条 φ2.2 TL	508	7099102	2#	10:10	350°C	12:10	130°C	YES	11/10/19 9:30	地量 100g
6	焊条 φ4 TL	508	71007113	2#	10:10	350°C	12:10	130°C	YES	11/10/19 9:30	地量 60g
7	焊条 φ40 JHJ	506	36423	1#	13:30	380°C	15:30	130°C	YES	11/10/19 9:30	地量 74g
8	焊条 φ50 JHJ	506	36523	1#	13:30	380°C	15:30	130°C	YES	11/10/19 9:30	地量 80g
9	焊条 φ40 JHJ	506	36423	1#	8:00	380°C	10:00	130°C	YES	11/10/19 9:30	地量 100g
10	焊条 φ50 JHJ	506	36523	1#	8:00	380°C	10:00	130°C	YES	11/10/19 9:30	地量 100g
11	焊条 φ40 JHJ	506	36423	1#	7:00	380°C	9:00	130°C	YES	11/10/19 9:30	地量 60g
12	焊条 φ50 JHJ	506	36523	1#	7:00	380°C	9:00	130°C	YES	11/10/19 9:30	地量 80g
13	焊条 φ32 TL	508	7099102	2#	7:00	350°C	9:00	130°C	YES	11/10/19 9:30	地量 80g
14	焊条 φ40 TL	508	71007113	2#	7:00	350°C	9:00	130°C	YES	11/10/19 9:30	地量 40g
15	焊条 φ50 TL	508	7099102	2#	7:00	350°C	9:00	130°C	YES	11/10/19 9:30	地量 120g
16	焊条 φ40 TL	508	71007113	2#	8:20	350°C	10:20	130°C	YES	11/10/19 9:30	地量 100g
17	焊条 φ50 TL	508	7099102	2#	8:20	350°C	10:20	130°C	YES	11/10/19 9:30	地量 100g
18	焊条 φ40 JHL	506	36423	1#	15:30	380°C	17:30	130°C	YES	11/10/19 9:30	地量 100g
19	焊条 φ50 JHL	506	36523	1#	15:30	380°C	17:30	130°C	YES	11/10/19 9:30	地量 100g
20	焊条 φ40 JHL	506	36423	1#	15:50	380°C	17:50	130°C	YES	11/10/19 9:30	地量 100g
21	焊条 φ50 JHL	506	71007113	2#	17:40	350°C	19:40	130°C	YES	11/10/19 9:30	地量 100g
22	焊条 φ40 JHL	506	36423	1#	19:00	380°C	21:00	130°C	YES	11/10/19 9:30	地量 100g

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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-000132**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0022**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:** 03-Dec-2007**Description of Non-Conformance:**

ABF has allowed ZPMC to receive and weld with SMAW TL-508 (E-7018) electrodes that were not issued from hermetically sealed containers, per section 4.5.2, nor is there any documented evidence that the electrodes were dried in accordance with AWS D1.5-2002, Section 4.5.2.

**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.

**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