

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:** ZPMC's fabrication shop, Changxing Island, China**Report No:** NCR-000024**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 31-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0023**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: SP075-01, T-stiffener fillet welds
Procedural	Procedural	Descriptor:	

Description of Non-Conformance:

ZPMC NDE technician Zhou Dong Yun accepted T-stiffener fillet welds on SP075-01 #016 through #027 after visual inspection and MT. ZPMC did not identify locations where undercut exceeded 1 mm in depth and notches that were located at the fillet weld transitions into the weld access hole of the T-stiffeners.

Applicable reference:

AWS D1.5, 2002, section 6.26.1.5: "... Undercut shall be no more than 1.0mm deep ..." AWS D1.5, 2002, section 3.2.5: "Radii of beam copes and weld access holes shall provide a smooth transition, free of notches or cutting past the points of tangency between adjacent surfaces."

Who discovered the problem: Caltrans Mets QA Inspector Scott Croff**Name of individual from Contractor notified:****Time and method of notification:** 1600, verbal**Name of Caltrans Engineer notified:** Cheng Wen Liu**Time and method of notification:****QC Inspector's Name:** Zhou Dong Yun**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: Lowry, Patrick

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

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: 08-Feb-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000014

Subject: NCR No. ZPMC-0023

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-0023

Remarks:

Please see attached Non-Conformance Report for details.

Transmitted by: Stanley Ku Sr. Bridge Engineer

cc: Rick Morrow, Gary Pursell, Stanley Ku, Brian Boal, Jason Tom, Dave Williams

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000014

Subject: NCR No. ZPMC-0023

Dated: 05-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000051 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: Additional staff and training has been provided to ensure proper inspection techniques.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000051R00;

Caltrans' comments:

Status: CLO
Date: 06-Aug-2008

The Contractor's response is acceptable. ABF Transmittal TL-08-0637 includes the acceptable Visual Weld Inspection Report. The Department concurs that Non-Conformance ZPMC-0023 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-023

Mr. Pursell:

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

NCR # ZPMC-0023

ZPMC NDE technician accepted T-stiffener fillet welds after VT and MT, and did not identify locations where undercut exceeded 1mm depth.

Training has been provided regarding the proper inspection techniques as well as the contract requirements. Additional staffing has been added to insure compliance with the Contract requirements.

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:** ZPMC's fabrication shop, Changxing Island, China**Report No:** NCS-000022**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0023**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: 31-Dec-2007**Description of Non-Conformance:**

ZPMC NDE technician Zhou Dong Yun accepted T-stiffener fillet welds on SP075-01 #016 through #027 after visual inspection and MT. ZPMC did not identify locations where undercut exceeded 1 mm in depth and notches that were located at the fillet weld transitions into the weld access hole of the T-stiffeners.

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:**

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, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Liu, Chengwen **Quality Assurance Inspector****Reviewed By:** Lowry, Patrick **QA Reviewer**