

**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-000031**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0030**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> OBG - Deck Mock-Up
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	Visual Inspection

**Reference Description:****Description of Non-Conformance:**

American Bridge / Fluor (ABF) and ZPMC Quality Control (QC) did not identify all of the visual defects during their inspection of the OBG Deck Mock-UP closed rib welds. The Contractor did not identify areas with where the size of the reinforcing fillet was not within 2- 5 mm as specified in the Special Provisions.

**Applicable reference:**

Section 10-1.59 'Steel Structures,' subsection 'Shop Welding,' subsection 'Welding of Closed Ribs to Box Shell Plate' of the Special Provisions, page 329: "Closed ribs shall conform to the following: ... 4. A uniform reinforcement fillet of between 2 mm and 5 mm shall be included ..."

**Who discovered the problem:** Scott Croff and Alfredo Acuna**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:** Steve Lawton**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

SMR

**Reviewed By:** Lowry,Patrick

SMR

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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-000027**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0030**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:** 08-Dec-2007**Description of Non-Conformance:**

American Bridge / Fluor (ABF) and ZPMC Quality Control (QC) did not identify all of the visual defects during their inspection of the OBG Deck Mock-UP closed rib welds. The Contractor did not identify areas where the size of the reinforcing fillet was not within 2- 5 mm as specified in the Special Provisions.

**Contractor's proposal to correct the problem:**

Contractor agreed to the following Closed Rib Visual Inspection Criteria:

- Reinforcing fillet size to be checked using a bridge cam gauge placed on the closed rib.

**Corrective action taken:**

Per conversations with the Contractor (Gang Jiao) on 14-Feb-08, the Contractor acknowledged that reinforcing fillet weld size shall be included as a visual acceptance criterion for closed rib welds (confirmation email dated 14-Feb-08). The Contractor acknowledged that reinforcing fillet size shall be inspected based on agreed Closed Rib Visual Inspection Criteria.

**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