

**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:** Zhenhua Port Machinery Company, Changxing Island**Report No:** NCR-000033**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0032**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 BP004-01
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	Radiographic Acceptance

**Description of Non-Conformance:**

The Contractor missed defects in welds during radiographic inspection. The Contractor did not detect two indications of porosity that are 2 mm in diameter and were separated by a distance of 10 mm in bottom plate BP-004-01.

**Applicable reference:**

AWS D1.5 Figure 6.8: Requires a minimum separation of 20 mm.

**Who discovered the problem:** QA Inspector Bruce J. Berger

**Name of individual from Contractor notified:**

**Time and method of notification:**

**Name of Caltrans Engineer notified:** Jason Tom

**Time and method of notification:** 1/24/08, Verbal.

**QC Inspector's Name:** Kevin Carpenter (ABF)

**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:** 05.03.06-000018

**Subject:** NCR No. ZPMC-0032

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-0032

**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:** 05.03.06-000018

**Subject:** NCR No. ZPMC-0032

**Dated:** 05-Aug-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000052 **Rev:** 00

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**Contractor's Proposed Resolution:**

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

Please see attached.

**Submitted by:** Kanapicki, Charles

**Attachment(s):** ABF-NPR-000052R00;

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**Caltrans' comments:**

**Status:** CLO

**Date:** 06-Aug-2008

The Contractor's response is acceptable. The Department concurs that Non-Conformance ZPMC-0032 is closed.

**Submitted by:** Wright, Doug

**Attachment(s):** NPR CT Comments

**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-032

Mr. Pursell:

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

NCR # ZPMC-0032

The Contractor missed defects (porosity) in welds during RT inspection.

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.

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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:** Zhenhua Port Machinery Company, Changxing Island**Report No:** NCS-000019**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0032**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>Description:</b>	

**Date the Non-Conformance Report was written:** 23-Jan-2008**Description of Non-Conformance:**

The Contractor missed defects in welds during radiographic inspection. The Contractor did not detect two indications of porosity that are 2 mm in diameter and were separated by a distance of 10 mm in bottom plate BP-004-01.

**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