

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-000035**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Dec-2007**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0034**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: BP026-01
Procedural	Procedural	Descriptor:	

Description of Non-Conformance:

ABF's Quality Control did not identify a crack during their visual and MT inspection. ZPMC personnel accepted the weld 014 on BP026-01 after visual inspection and MT had been conducted. ZPMC did not identify a 5 mm long crack indication on weld 014, which was discovered by QA inspector during the 10% MT verification.

Applicable reference:

AWS D1.5, 2002, section 6.26.1.1: "The weld shall have no cracks."

Who discovered the problem: Caltrans METS QA Inspector Scott Croff**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:** ZPMC NDE technician Cai Xin Xin**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Remove cracked weld area, retest base material using magnetic particle testing and reweld.

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: 05.03.06-000020

Subject: NCR No. ZPMC-0034

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-0034

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: 05.03.06-000020

Subject: NCR No. ZPMC-0034

Dated: 05-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000054 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: Additional Staff and training has been provided to ensure proper inspection technique.

Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000054R00;

Caltrans' comments:

Status: CLO

Date: 06-Aug-2008

The Contractor's response in this proposed resolution, as well as in ABF transmittal number TL-08-0481, are acceptable. The Department concurs that Non-Conformance ZPMC-0034 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-034

Mr. Pursell:

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

NCR # ZPMC-0034

The Contractor did not identify a 5mm long crack during their VT and MT inspection on weld 014 on PB 026-01

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

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** ZPMC's fabrication shop, Changxing Island, China**Report No:** NCS-000024**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0034**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 22-Dec-2007**Description of Non-Conformance:**

ABF's Quality Control did not identify a crack during their visual and MT inspection. ZPMC personnel accepted weld #014 on BP026-01 after visual inspection and MT had been conducted. ZPMC did not identify a 5 mm long crack on weld #014, which was discovered by QA inspector during the 10% MT verification.

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**