

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, China**Report No:** NCR-000038**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0037**Type of problem:**

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

Description of Non-Conformance:

The Contractor performed repairs to welds without prior approval from the Engineer. The Contractor identified transverse cracks in 18 floorbeam web plates during MT inspection and began repairs on 7 without receiving Engineer approval.

Applicable reference:

Special Provisions, Section 8.3, "Welding", Subsection "Welding Quality Control", page 154: "... all repairs of cracks require prior approval of the Engineer."

Who discovered the problem: Timothy McClendon**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Chen Wen Liu**Time and method of notification:** 2200 VIA E-mail on 01-22-2008**QC Inspector's Name:** Fu Xu Jun**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: 05.03.06-000022

Subject: NCR No. ZPMC-0037

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-0037

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: 05.03.06-000022

Subject: NCR No. ZPMC-0037

Dated: 19-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000081 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC understands the requirements of AWS D1.5-02 and the Special Provisions to obtain the approval of the Engineer prior to performing critical weld repairs which shall be submitted for approval prior

Please see attached letter.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000081R00;

Caltrans' comments:

Status: REJ

Date: 09-Sep-2008

In order to resolve Non-Conformance ZPMC-0037, provide documentation of the repairs that were performed, and confirm that the repaired welds are acceptable.

Submitted by: Wright, Doug

Attachment(s):

Date: 09-Sep-2008



A JOINT VENTURE

August 19, 2008

Reply to: SL-ABF-08-0176

Attention: Gary Pursell

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

Subject: NCR# ZPMC-0037

Mr. Pursell:

This letter is issue to provide formal response addressing the proposed resolution to NCR# ZPMC-0037.

ZPMC understands the requirements of AWS D1.5-02 and the Special Provisions to obtain the approval of the Engineer prior to performing critical weld repairs. Future critical weld repairs shall be submitted for approval prior to perform the repair.

Please feel free to contact me directly if you require assistance or further clarification.

Sincerely,

A handwritten signature in black ink, appearing to read 'Nate Lindell'.

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: 05.03.06-000022

Subject: NCR No. ZPMC-0037

Dated: 04-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000081 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has identified this nonconformance of repair of cracks without Engineer's approval and has generated an internal NCR as well as informed QA/QC of this nonconformance.

Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000081R01;

Caltrans' comments:

Status: REJ

Date: 09-Sep-2008

In order to resolve Non-Conformance ZPMC-0037, provide documentation of the repairs that were performed, and confirm that the repaired welds are acceptable.

Submitted by: Wright, Doug

Attachment(s):

Date: 09-Sep-2008



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 08/14/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000038(ZPMC-0037)FOR CLOSURE

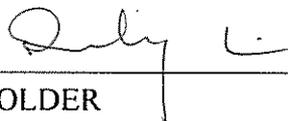
SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-289FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000038(ZPMC-0037).
- (3) COPY OF INTEKNAL NCR NCR-B-084

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



 PLAN HOLDER

RECEIVED 14 AUG 2008
 1307

 DATE



 COMPANY

 PHONE NO.

PLAN NUMBER: N/A
 #R787-QCP-102



No. B-289

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-8-14

REGARDING: NCR-000038 (ZPMC-0037)

With this letter of response, ZPMC requests closure for Caltrans NCR-000038 (ZPMC-0037). ZPMC agrees what describe in the nonconformance report , we had ground the 7 surface cracks without receiving the engineer approval. Obviously it disobeyed the special provisions that all repairs of cracks require prior approval of the engineer, and we have educated the workers that perform the weld or base metal repair must follow the procedure , even if the surface crack which can remove clearly by grinding.

So ZPMC considers NCR-000038 can be closed.

Please reference attached documentation for acceptance and closure the NCR-000038.

ATTACHMENT:

NCR-000038 (ZPMC-0037)

ZPMC internal NCR

Zhuoshuangshao

2008.8.14.



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B

项目名称: 美国加州海湾大桥

NCR Number:

NCR 编号: NCR-B-084 (NCR-000038)

Item: repairing the cracks without the engineer approval

名称描述: 未经工程师批准对裂纹进行返修

Item

Number:

件号:

Drawing Number:

图号: OBG 横隔板

Location: the 7th shop

位置: 横隔板车间

Date:

日期:

2008-1-22

Description of Nonconformance:

不符合项状态描述:

The contractor performed repairs to welds without prior approval from the engineer. The contractor identified transverse cracks in 18 floorbeam web plates during MT inspection and began repairs on 7 without receiving engineer approval.

ZPMC 在生产过程进行返修没有事先得到工程师的批准, 施工队在对横隔板进行 MT 检测的过程中发现 18 处纵向裂纹, 但没经工程师批准就对其中的 7 处进行了返修。

Work By: Lin Jing Fei Prepared by: Shen Xue Jun Reviewed by QCE: Zhao Shuang Bao
施工方: 2008.07.15 准备: 2008.7.14 质量工程师批准: 2008.7.14

- Drawing Error Material Defect Fabrication Error Other
- 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
处理措施: 回用 返修 拒收

Recommendation:

建议: 加强现场监督, 检查, 对现场施工人员进行教育。
Enhance the monitoring and inspection on the spot, and educate the worker on the spot.

Prepared by: Gao Jun 2008-07-15 Approved by QCA: Hu Gang 2008.7.15
准备 质量经理批准

Reason for Nonconformance:

不符合原因: Grind the cracks before approved by engineer. 在未经工程师批准对裂纹进行打磨

预防措施: Enhance the monitoring and inspection on-site; perform according to the procedure in the future.
加强现场监督, 检查, 以后按程序操作。

Approved by/批准: Gao Jun 2008-07-15

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment

回用或返修的技术依据: 加强现场监督与检查, 以后附件 无附件
对生产的产品有裂纹时, 应事先得到工程师批准后方可进行返修。
Enhance supervision and inspection on-site, if cracks find in the production in the future, it can repair after approval by engineer.

Reviewed /批准: Tang Yong bo 7/15/08

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

Verified by QCI/质检确认: Li Shijiang Reviewed by QCA/质检主任审核: Hu Gang
2008.7.31

2008.7.31



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: 05.03.06-000022

Subject: NCR No. ZPMC-0037

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-0037

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

DEPARTMENT OF TRANSPORTATION
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Bay Area Branch
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 (707) 649-5453
 (707) 649-5493

Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, China

Report No: NCR-000038

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 22-Jan-2008

Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

NCR #: ZPMC-0037

Type of problem:

Welding Concrete Other Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: OBG Floor Beams

Procedural Procedural Descripton:

Description of Non-Conformance:

The Contractor performed repairs to welds without prior approval from the Engineer. The Contractor identified transverse cracks in 18 floorbeam web plates during MT inspection and began repairs on 7 without receiving Engineer approval.

Applicable reference:

Special Provisions, Section 8.3, "Welding", Subsection "Welding Quality Control", page 154: "... all repairs of cracks require prior approval of the Engineer."

Who discovered the problem: Timothy McClendon

Name of individual from Contractor notified:

Time and method of notification:

Name of Caltrans Engineer notified: Chen Wen Liu

Time and method of notification: 2200 VIA E-mail on 01-22-2008

QC Inspector's Name: Fu Xu Jun

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000022

Subject: NCR No. ZPMC-0037

Dated: 15-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000081 Rev: 02

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-000081R02

Caltrans' comments:

Status: AAP

Date: 23-Sep-2008

The Contractor's understanding of the "Approved Action Pending" status is correct.

Please provide documentation that the weld repairs were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0037 at that time.

Submitted by: Prchlik, Aaron

Attachment(s):

Date: 23-Sep-2008

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000022

Subject: NCR No. ZPMC-0037

Dated: 03-Dec-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000081 **Rev:** 03

Contractor's Proposed Resolution:

Reference Resolution: ZPMC acknowledges CT request for inspection documentation.

ZPMC acknowledges CT request for inspection documentation. For the floor beams, however, the CT NCR does not specify which floor beams. ZPMC suggests this NCR be closed. All floor beam inspection documents are located within the welding reports and all inspection are verified through the green tagging process.

Submitted by:

Attachment(s): ABF-NPR-000081R03

Caltrans' comments:

Status: CLO

Date: 16-Dec-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0037 is closed.

Submitted by: Wright, Doug

Date: 16-Dec-2008

Attachment(s):

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:** Changxing Island, China**Report No:** NCS-000127**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0037**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-Jan-2008**Description of Non-Conformance:**

The Contractor performed repairs to welds without prior approval from the Engineer. The Contractor identified transverse cracks in 18 floorbeam web plates during MT inspection and began repairs on 7 without receiving Engineer approval.

Contractor's proposal to correct the problem:

ZPMC acknowledges CT request for inspection documentation. For the floor beams, however, the CT NCR does not specify which floor beams. ZPMC suggests this NCR be closed. All floor beam inspection documents are located within the welding reports and all inspection are verified through the green tagging process.

Corrective action taken:

Closed by Caltrans Construction. METS closed the NCR based on Construction's direction.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Stanley Ku and Doug Wright **Date:** 12-Dec-2008**Is Engineer's approval attached?** Yes No Email concurring with recommendation to close NCR is on file.**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 Sang Le, who represents the Office of Structural Materials for your project.

Inspected By:	Dautermann, Peter	Quality Assurance Inspector
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Reviewed By:	Dautermann, Peter	QA Reviewer
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