

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, Shanghai, China**Report No:** NCR-000059**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 01-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0057**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Tower-114m Mockup
Procedural	Procedural	Descriptor:	

Description of Non-Conformance:

ABF allowed ZPMC to proceed with drilling operations for the bolt connection splices of the upper and lower segments of the 114-m mock-up before correcting the misalignment between the side "D" skin plates. The misalignment is approximately 5 mm and exceeds the tolerances allowed in the specifications.

AWS D1.5 (2002), Section 3.5.1.14, "Mechanically connected joints and splices of main stress carrying members with surfaces intended to be parallel planes shall be nearly parallel after connection, and the surfaces to be in contact shall have an offset no greater than 2 mm [U16 in.] after all filler plates have been added, if any."

Applicable reference:

AWS D1.5 (2002), Section 3.5.1.14, "Mechanically connected joints and splices of main stress carrying members with surfaces intended to be parallel planes shall be nearly parallel after connection, and the surfaces to be in contact shall have an offset no greater than 2 mm [U16 in.] after all filler plates have been added, if any."

Special Provisions Section 10, Bolted Connections, page 316,

ABF/ZPMC Tower Dimensional Control Plan

Who discovered the problem: Alfredo Acuna, Quality Assurance Inspector

Name of individual from Contractor notified:

Time and method of notification:

Name of Caltrans Engineer notified: Ching Chao, Structures Construction Representative

Time and method of notification: 02/04/08, Verbal.

QC Inspector's Name: Xu Jun, ZPMC Quality Control Inspector

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Yes No

Contractor's proposal to correct the problem:

None 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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Wahbeh,Mazen

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

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: 15-Feb-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000030

Subject: NCR No. ZPMC-0057

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-0057

Remarks:

Please see the attached file for details.

Transmitted by: Ching Chao

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods, Doug Coe, Jason Tom, Dave Williams, Contract Files, Kannu Balan, Chin

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000030

Subject: NCR No. ZPMC-0057

Dated: 23-Apr-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000021 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC contests NCR as work (hole drilling alignment) was in pre not final assembly, but will use information to ensure proper alignment for final assembly

Please see the attached response from ZPMC. ABFJV has reviewed and concurs with this response and considers this issue resolved. ABFJV believes, based on our understanding of the NCT process that this NCR was issued closed as the top (first) box on the NCT was checked. Please confirm.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000021R00;

Caltrans' comments:

Status: CLO

Date: 08-Jan-2009

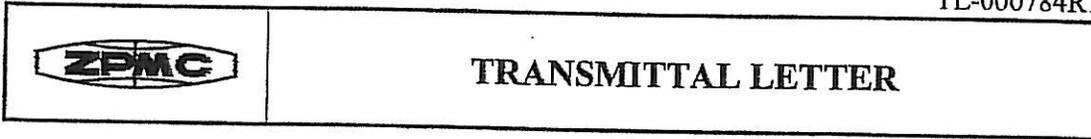
Per State Letter 05.03.01-003242 dated January 7, 2009, the 114m Tower Section Mock-up was successfully completed. The Department concurs that Non-Conformance ZPMC-0057 is closed.

As noted in ABF-CAL-LTR-000766, the Department understands that the appropriate fabrication plans will be modified in accordance with Special Provision Section 10-1.59, "Steel Structures," subsection "Working Drawings" through the FCN process.

Submitted by: Wright, Doug

Attachment(s):

Date: 08-Jan-2009



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 03/17/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: LETTER OF RESPONSE

REQUEST FOR REVIEW & SUBMITTAL TO CALTRANS FOR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

(1) COPY OF LETTER OF RESPONSE WITH NO. ~~CT-096~~, CT-086, ~~CT-087~~, ~~CT-093~~, ~~CT-088~~

(2) COPY OF ~~NCR-000019~~, NCR-000059, ~~NCR-000064~~, ~~NCR-000065~~, ~~NCR-000068~~.

CTL
4/23/08

ZPMC ST CTL 4/23/08

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

Ruby L
PLAN HOLDER

3/19/08 1050
DATE

ABFJV
COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. CT-86

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2007-2 -25

REGARDING: NCR-000059 (ZPMC-0057)

ZPMC received CT NCR-000059 on 21-Feb-2008, it mentioned ZPMC proceed with drilling operations for the bolt connection splices of the upper and lower segments of the 114M mock-up before correcting the misalignment which is approximately 5mm between the side "D" skin plates. As to this nonconformance, ZPMC had explained the mock-up was under the preassembly condition when CT inspected. And ZPMC will modify the final connection to be satisfied with AWS requirement. ZPMC would not accept this NCR, but it will be regarded as a reminder to the final assembly.

ZPMC requests Caltrans can withdraw NCR-000059 (ZPMC-0057).

ATTACHMENT:

NCR-000059 (ZPMC-0057)

Lu Jianhua
02/26/08



DEPARTMENT OF TRANSPORTATION
866 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: 15-Feb-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000030

Subject: NCR No. ZPMC-0057

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-0057

Remarks:

Please see the attached file for details.

Transmitted by: Ching Chao

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods, Doug Coe, Jason Tom, Dave Williams, Contract Files, Kannu Balan, Ct

File: 05.03.06

02 02
TV 05.03.06-000030,NCT

Received
NCT-000030 18 Feb 08 Page 1 of 1

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, China

Report No: NCR-000059

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 01-Feb-2008

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

NCR #: ZPMC-0057

Type of problem:Welding Concrete Other Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: Tower-114m Mockup

Procedural Procedural Description:**Description of Non-Conformance:**

ABF allowed ZPMC to proceed with drilling operations for the bolt connection splices of the upper and lower segments of the 114-m mock-up before correcting the misalignment between the side "D" skin plates. The misalignment is approximately 5 mm and exceeds the tolerances allowed in the specifications.

AWS D1.5 (2002), Section 3.5.1.14, "Mechanically connected joints and splices of main stress carrying members with surfaces intended to be parallel planes shall be nearly parallel after connection, and the surfaces to be in contact shall have an offset

no greater than 2 mm [U16 in.] after all filler plates have been added, if any."

Applicable reference:

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Special Provisions Section 10, Bolted Connections, page 316,

ABF/ZPMC Tower Dimensional Control Plan

Who discovered the problem: Alfredo Acuna, Quality Assurance Inspector

Name of individual from Contractor notified:

Time and method of notification:

Name of Caltrans Engineer notified: Ching Chao, Structures Construction Representative

Time and method of notification: 02/04/08, Verbal.

QC Inspector's Name: Xu Jun, ZPMC Quality Control Inspector

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Yes No

Contractor's proposal to correct the problem:

None at this time.

Comments:

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Inspected By: Wahbeh, Mazen

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, China**Report No:** NCS-000148**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 08-Jan-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0057**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: 01-Feb-2008**Description of Non-Conformance:**

ABF allowed ZPMC to proceed with drilling operations for the bolt connection splices of the upper and lower segments of the 114m mock-up before correcting the misalignment between the side "D" skin plates. The misalignment is approximately 5 mm and exceeds the tolerances allowed in the specifications.

AWS D1.5 (2002), Section 3.5.1.14, "Mechanically connected joints and splices of main stress carrying members with surfaces intended to be parallel planes shall be nearly parallel after connection, and the surfaces to be in contact shall have an offset

no greater than 2 mm [U16 in.] after all filler plates have been added, if any."

Contractor's proposal to correct the problem:

ZPMC explained that the mock-up was under the preassembly condition when it was inspected. Final connection will be modified to comply with AWS D1.5 requirements.

Corrective action taken:

Fabrication procedure has been modified and the 114m mock-up has been fabricated successfully. Letter No. 05.03.01-003242 concluded the successful completion of the 114m mock-up on January 7, 2009.

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 Serge Sinevod, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Reviewed By: Wahbeh,Mazen

QA Reviewer