

**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-000061**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 31-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0059**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> Tower-89 m Mockup |
| <b>Procedural</b>   | <b>Procedural</b> | <b>Descriptor:</b> |                                     |

**Description of Non-Conformance:**

ABF allowed ZPMC to repair a crack in the root pass of a complete joint penetration weld in diaphragm p213, weld joint #63, of the Tower 89-m mock-up without notifying the Engineer. Special Provisions, Section 8-3.01 states, "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them."

**Applicable reference:**

Special Provisions, Section 8-3.01, "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them." Also the ZPMC Welding Quality Control Plan Section 9, Subsection 9.2, "Weld Repair"

**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:** Jim Reid, Assistant Structure Representative**Time and method of notification:** 2/1/08;1230, Verbal Notification.**QC Inspector's Name:** Xu Jun, ZPMC Quality Control Inspector**Was QC Inspector aware of the problem:** 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

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**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:** 05.03.06-000031

**Subject:** NCR No. ZPMC-0059

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-0059

**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:** 05.03.06-000031

**Subject:** NCR No. ZPMC-0059

**Dated:** 24-Apr-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000022 **Rev:** 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC QC in the future will get the Engineer's approval before performing weld repairs

Please see the attached response from ZPMC. ABF JV has reviewed and concurs with this response and considers this issue resolved. ABF JV 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:** Allen, Lillian

**Attachment(s):** ABF-NPR-000022R00;

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### Caltrans' comments:

**Status:** CLO

**Date:** 24-Jul-2008

ZPMC has indicated that they are aware of the problem and will notify Caltrans in the future when repair welding as required by Special Provisions, Section 8-3.01. Therefore, the Department concurs that Non-Conformance ZPMC-0059 is closed.

If the problem persists in the future, then additional actions will be required.

**Submitted by:** Wright, Doug

**Date:** 24-Jul-2008

**Attachment(s):**

TL-000787R1



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 03/19/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR(NCR-000061) FOR CLOSURE / ZPMC 59 N/E 4/23/08

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.CT-98 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000061. / ZPMC 59 CTL 4/23/08

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

Ruby L.  
PLAN HOLDER

3/19/08  
DATE

ABFJV  
COMPANY

PHONE NO.

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



No. CT-98

## LETTER OF RESPONSE

**TO:** American Bridge/Flour JV

**DATE:** 2007-2 -26

**REGARDING:** NCR-000061 (ZPMC-0059)

ZPMC received CT NCR-000061 on 21-Feb-2008, it mentioned ZPMC repaired a crack in the root pass of a complete joint penetration weld in diaphragm p213, weld joint#63, of the Tower 89m mock-up without notifying the Engineer. Due to the weld had been finished and accepted by UT, ZPMC requests Caltrans can withdraw or close NCR-000061 (ZPMC-0059). ZPMC has been aware of this problem, and in the future ZPMC QC will make sure that Caltrans has been notified at first time prior to repairing an in-process weld.

**ATTACHMENT:**

NCR-000061 (ZPMC-0059)

*Lu Jianhua*  
*02/28/08*

*REVIEWED*  
*P. Austin*  
*ABF CREW*  
*10 APRIL 08*



**DEPARTMENT OF TRANSPORTATION**  
666 Feng Bln Road Room 708, Changxing Island  
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### 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:** 05.03.06-000031

**Subject:** NCR No. ZPMC-0059

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-0059

**Remarks:**

Please see the attached file for details.

**Transmitted by:** Ching Chao

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

**File:** 05.03.06

02.02  
12 05.03.06-000031.NCT

Received  
NCT-000031 15 Feb 08 Page 1 of 1

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 DIVISION OF ENGINEERING SERVICES  
 Office of Structural Materials  
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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-000061

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 31-Jan-2008

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

NCR #: ZPMC-0059

**Type of problem:**

Welding  Concrete  Other   
 Welding  Curing  Procedural  Bridge No: 34-0006  
 Joint fit-up  Coating  Other  Component: Tower-89 m Mockup  
 Procedural  Procedural  Description:

**Description of Non-Conformance:**

ABF allowed ZPMC to repair a crack in the root pass of a complete joint penetration weld in diaphragm p213, weld joint #63, of the Tower 89-m mock-up without notifying the Engineer. Special Provisions, Section 8-3.01 states, "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them."

**Applicable reference:**

Special Provisions, Section 8-3.01, "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them." Also the ZPMC Welding Quality Control Plan Section 9, Subsection 9.2, "Weld Repair"

**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:** Jim Reid, Assistant Structure Representative

**Time and method of notification:** 2/1/08; 1230, Verbal Notification.

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

**Was QC Inspector aware of the problem:**  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

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**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

*( Continued Page 2 of 2 )*

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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-000048**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 19-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0059**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:** 31-Jan-2008**Description of Non-Conformance:**

ABF allowed ZPMC to repair a crack in the root pass of a complete joint penetration weld in diaphragm p213, weld joint #63, of the Tower 89-m mock-up without notifying the Engineer. Special Provisions, Section 8-3.01 states, "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them."

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

ZPMC will ensure that Caltrans is notified when necessary as described in the Special Provisions, Section 8-3.01.

**Corrective action taken:**

ZPMC has not taken any direct action with regards to this NCR, but they have indicated that they are aware of the problem and promised to notify Caltrans in the future when welding as required by Special Provisions, Section 8-3.01. If the problem persists in the future, then additional actions will be required.

**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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

**Inspected By:** McReynolds, Robert

Quality Assurance Inspector

**Reviewed By:** Wahbeh, Mazen

QA Reviewer