

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-000063**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 31-Jan-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0061**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/ZPMC manually drilled full size bolt holes on skin plates A and E of the 114m mockup without using a template with hardened bushings as required by the Standard Specifications, Section 55, Subsection. 55.3.14A (2) which states: "Drilling full size shall be done with the parts assembled or to a steel template with hardened bushings or may be performed with gang drill equipment if approved by the Engineer."

ZPMC drilled the bolt holes utilizing a template with hardened bushings to a depth of 5-10 mm into the skin plates, then the template was removed and the remaining depth of the holes were drilled without a template.

Applicable reference:

Caltrans Standard Specification July 1999, Section 55, Subsection 55.3.14A (2) Drilling:

"Drilling full size shall be done with the parts assembled or to a steel template with hardened bushings or may be performed with gang drill equipment if approved by the Engineer."

Who discovered the problem: Robert Cuellar & Alfredo Acuna, Quality Assurance Inspectors

Name of individual from Contractor notified:

Time and method of notification:

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

Time and method of notification: 1230, 1/31/08, Verbal

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:

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

Inspected By: Wahbeh, Mazen

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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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-000068**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0061**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: 31-Jan-2008**Description of Non-Conformance:**

ABF/ZPMC manually drilled full size bolt holes on skin plates A and E of the 114m mockup without using a template with hardened bushings as required by the Standard Specifications, Section 55, Subsection. 55.3.14A (2) which states: "Drilling full size shall be done with the parts assembled or to a steel template with hardened bushings or may be performed with gang drill equipment if approved by the Engineer."

ZPMC drilled the bolt holes utilizing a template with hardened bushings to a depth of 5-10 mm into the skin plates, then the template was removed and the remaining depth of the holes were drilled without a template.

Contractor's proposal to correct the problem:

None.

Corrective action taken:

METS has made random inspections of the bolt holes in the 114-m Skin plates and has found that removing the template has not adversely affected the drilling of the holes. METS will continue to monitor the Contractor's procedure to ensure the holes are not drilled larger than required or out of vertical alignment. If METS finds the holes to be outside the requirements of the specifications, the issue will be escalated.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Ching Chao, Structures Construction **Date:** 20-Feb-2008**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 Joshua Ishibashi, who represents the Office of Structural Materials for your project.

Inspected By: Ishibashi, Josh Quality Assurance Inspector**Reviewed By:** Ishibashi, Josh QA Reviewer