

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 #: 1.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, PRC**Report No:** NCR-000066**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0065**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 114 Meter Mock-Up Lower Section
Procedural	Procedural	Description:	Joint fit-up

Reference Description:**Description of Non-Conformance:**

1) ABF/ZPMC used five 10 ton hydraulic jacks to aid in the fit-up of four internal bolt connection plates. The plates were 2mm out of alignment but within the tolerances specified in the Special Provisions. The use of jacks is not a step in the ABF/ZPMC approved fabrication plan. Fabrication plans for the mockup must be approved per Special Provisions, Section 10-1.59 "Steel Structures", "Fabrication/Erection Procedure Mock-Ups".

2) ABF/ZPMC began the internal connection plate fit-up at skin A, instead of skin D which deviates from the approved fabrication plan. Fabrication plans for the mockup must be approved per Special Provisions, Section 10-1.59 "Steel Structures", "Fabrication/Erection Procedure Mock-Ups".

Applicable reference:

Special Provisions, Section 10-1.59 "Steel Structures", "Fabrication/Erection Procedure Mock-Ups", pg. 313. "For each mock-up, the Contractor shall prepare a written fabrication and welding sequence. The fabrication and welding sequence shall be submitted for review by the Engineer, and approval shall be given before the mock-up is fabricated."

Who discovered the problem: Greg Bertlesman, Quality Assurance Inspector**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Tai Lin Liu, Assistant Structure Representative**Time and method of notification:** 02/11/08; 1300, Verbal**QC Inspector's Name:** Chan Shi Gang, ZPMC Quality Control Inspector**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:****Comments:**

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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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	SMR
Reviewed By:	Wahbeh,Mazen	SMR

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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, PRC**Report No:** NCS-000066**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0065**Type of problem:**

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

Date the Non-Conformance Report was written: 11-Feb-2008**Description of Non-Conformance:**

1) ABF/ZPMC used five 10 ton hydraulic jacks to aid in the fit-up of four internal bolt connection plates. The plates were 2mm out of alignment but within the tolerances specified in the Special Provisions. The use of jacks is not a step in the ABF/ZPMC approved fabrication plan. Fabrication plans for the mockup must be approved per Special Provisions, Section 10-1.59 "Steel Structures", "Fabrication/Erection Procedure Mock-Ups".

2) ABF/ZPMC began the internal connection plate fit-up at skin A, instead of skin D which deviates from the approved fabrication plan. Fabrication plans for the mockup must be approved per Special Provisions, Section 10-1.59 "Steel Structures", "Fabrication/Erection Procedure Mock-Ups".

Contractor's proposal to correct the problem:

None

Corrective action taken:

METS has recommended to the Contractor that these changes be reflected in their Mock-Up Fabrication and Welding Sequence in order to put controls on the use of the jacks and so the changes are also incorporated into the Contractor's Fabrication Plan for the Tower.

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:**

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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Inspected By: Ishibashi,Josh

Quality Assurance Inspector

Reviewed By: Ishibashi,Josh

QA Reviewer