

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, PRC**Report No:** NCR-000071**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0069**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP-058
Procedural	Procedural	Descriptor:	OBG Deck Panel

Description of Non-Conformance:

The Contractor did not follow approved working drawings. The Contractor did not use a template to determine the amount of grinding required to produce the required depth of groove for the closed rib to deck plate SAW cover pass as described in approved fabrication procedures. This occurred on OBG deck panel DP-058.

Applicable reference:

Deck Plate Panel Fabrication Procedure (ABF-SUB-000025R02, Approved as Noted on 01-29-2008), Sheet DP106, Step 3.1.11: "Template used to determine the amount of grinding required to produce the required depth of groove for the SAW cover pass."

Who discovered the problem: Alfredo Acuna**Name of individual from Contractor notified:** Ady Velasco**Time and method of notification:** Verbal notification at 15:45 on 02-15-2008**Name of Caltrans Engineer notified:** Jason Tom**Time and method of notification:** Verbal notification on 02-15-2008**QC Inspector's Name:** ABF Representative Warren Buehler**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:****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: 20-Feb-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000039

Subject: NCR No. ZPMC-0069

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-0069

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: 05.03.06-000039

Subject: NCR No. ZPMC-0069

Dated: 05-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000064 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: The fabricator will grind the tack weld flush to the same level as the adjacent root pass.
Please see attached.

Submitted by: Kanapicki, Charles
Attachment(s): ABF-NPR-000064R00;

Caltrans' comments:

Status: REJ

Date: 10-Sep-2008

The Contractor's response is not acceptable. The Contractor's request to remove the requirement for the grinding template is not acceptable. Also, please comment on the acceptability of deck panels that have been fabricated without using the grinding template.

Submitted by: Wright, Doug
Attachment(s):

Date: 10-Sep-2008

DEPARTMENT OF TRANSPORTATION
CHINA FABRICATION TEAM
506 Shengcheng Rd, Pudong New District
Shanghai 200120, PRC



REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Dave Williams, American Bridge – Fluor, a Joint Venture
Gary Pursell, Resident Engineer

Review Date: 07-29-2008

From: Ady Velasco, Structural Materials Representative

Contract No.: 04-0120F4

Date/Time Submittal Received: 07-18-2008/ 12:36

China Standard Time
(GMT+08:00)

Contractor's Transmittal #: TL-08-1508 **Rev. #** 0

<input type="checkbox"/> substantially complies with contract requirements and is approved				
<input type="checkbox"/> substantially complies with contract requirements and is approved as noted.				
<input checked="" type="checkbox"/> Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmital				
Verbal Notification		<input type="checkbox"/> No <input checked="" type="checkbox"/> Yes	Date: <u>7/28/2009</u> Time: <u>09:00</u>	
Name of individual from Contractor Notified: <u>Nate Lindell</u>				
This submittal is a:	<input type="checkbox"/> Welding Report	<input type="checkbox"/> Critical Weld Repair		
	<input type="checkbox"/> Request for Information	<input type="checkbox"/> Heat Straightening Request		
	<input type="checkbox"/> Fabrication Procedures	<input checked="" type="checkbox"/> Other: <u>NCR Close Out Documents</u>		
Submitting Contractor: <u>ABF</u>				
ITEMS REVIEWED		COMPLIES		COMMENTS
		<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No	
1.	Response to NCR # ZPMC-0069	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No	The Contractor's request to remove the requirement for the grinding template is not acceptable. Please provide alternate resolution. Please comment on the acceptability of deck panels that have been fabricated without using the grinding template.

Remarks:

Reviewer: Ady Velasco AV

Date: 07-29-2008

Construction Concurrence: AV Initial 7/30/08 Date

Received by (ABFJV): PZ Date: 7/30/08 Time: 1250

July 16, 2008

Mr. Gary Pursell
California Department of Transportation
506 Shang cheng Rd, Pudong New District
Shanghai 200120, China

Reply to: SL-ABF-08-0124

Attention: Mr. Gary Pursell

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

Subject: NCR ZPMC-0069

Mr. Pursell:

This letter is issued to provide ABFJV proposed resolution to ZPMC-0069.

No Template used to determine the amount of grinding required to produce the required depth of groove for the SAW cover pass. Ref: Cal-Trans comment to sheet DP106, step 3.1.11.

ABFJV will delete the Cal-Trans comment from Sheet DP106. A template has not been used on any of the Deck Panels produced to date. The depth of root pass concern is in the area of tack welds. This area receives more weld prior to the SAW pass than the rest of the weld. On the first Deck Panels, the fabricator experienced excessive fillet reinforcement in the tack weld area.

To correct this deficiency, the fabricator has since ground the tack weld locations flush to the same level as the adjacent root pass. This action has proven to be sufficient for the last 274 deck panels.

With the above response, ABFJV considers NCR APMC -0069 as closed.

If further clarifications are needed, please contact me.

AMERICAN BRIDGE / FLUOR JV



Steve Lawton
Foreign Quality Assurance Manager

cc: file

<input type="checkbox"/> APPROVED
<input checked="" type="checkbox"/> APPROVED AS NOTED
<input checked="" type="checkbox"/> RETURNED FOR CORRECTION Pursuant to Section 5-1.02 of the Standard Specifications State of California
DEPARTMENT OF TRANSPORTATION Division of Engineering Service Office of Structure Construction
Structure Representative _____
Date <u>7/20/08</u>

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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000069

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Feb-2008

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

NCR #: ZPMC-0067

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: DP-058
 Procedural Procedural Descripton: OBG Deck Panel

Description of Non-Conformance:

The Contractor performed weld repairs without prior Engineer approval. The Contractor repaired closed ribs to box shell plate using by grinding that was not previously approved by the Engineer. This occurred on weld defects in multiple locations of the SAW cover pass of closed ribs U-64 (weld #1) and U-133 (weld #10) on OBG deck panel DP-058.

Applicable reference:

Special Provisions, Section 10-1.59, Steel Structures, Subsection Welding of Closed Ribs to Box Shell Plate, page 328: "Repair welding methods and procedures shall be approved by the Engineer."

Who discovered the problem: Mike Hasler

Name of individual from Contractor notified: Ady Velasco

Time and method of notification: Verbal notification at 19:00 on 02-15-2008

Name of Caltrans Engineer notified: Jason Tom

Time and method of notification: Verbal notification on 02-15-2008

QC Inspector's Name: ZPMC QC Mr. Fu Yu Hong

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

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: 05.03.06-000039

Subject: NCR No. ZPMC-0069

Dated: 13-Oct-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000064 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ABF Requests that this NPR be closed based on State Letter 05.03.06-000007.

Please find attached.

Submitted by: Mackey, Kim

Attachment(s): ABF-NPR-000064R01;

Caltrans' comments:

Status: CLO

Date: 14-Oct-2008

Per State Letters 05.03.08-000007 and 05.03.01-002773 dated October 6, 2008, the Department concurs that Non-Conformance ZPMC-0069 is closed.

Submitted by: Wright, Doug

Attachment(s):

Date: 14-Oct-2008

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

333 Burma Rd.
Oakland, CA 94607
(510) 622-5660, (510) 286-0550 fax



*Flex your power
Be energy efficient!*

October 06, 2008

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
Letter No. 05.03.08-000007

Michael Flowers
Project Executive
American Bridge/Fluor, A JV
375 Burma Road
Oakland, CA 94607

Dear Michael Flowers,

NCRs 69 & 70 – Closed Rib Plate to Deck Plate Welding

This is to inform you that the State is hereby rescinding the rejection of NPR Numbers 64 and 36 for NCR Numbers 69 and 70, respectively. It is not required for the contractor to re-submit a NPR for resolving those two NCRs.

A State letter is forthcoming to respond to ABF's letter No. 626 regarding their position for both NCRs.

Sincerely,

GARY PURSELL
Resident Engineer

cc: Rick Morrow
Brian Boal
Keith Devonport
Jason Tom
Stanley Ku
Ching Chao

file: 05.03.08

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge Program

333 Burma Rd.
Oakland, CA 94607
(510) 622-5660, (510) 286-0550 fax



*Flex your power
Be energy efficient!*

October 6, 2008

Contract No. 04-0120F4
04-SF-80-13.2 / 13.9
Self-Anchored Suspension Bridge
TC Letter No. 05.03.08-000007

Michael Flowers
Project Executive
American Bridge/Fluor, A JV
375 Burma Road
Oakland, CA 94607

Dear Michael Flowers,

This is to inform you that the State is hereby rescinding the rejection of NPR Numbers 64 and 36 for NCR Numbers 69 and 70, respectively. It is not required for the contractor to re-submit an NPR for resolving those two NCR's.

A State letter is forthcoming to respond to ABFJV's letter No. 626 regarding their position for both NCR's.

Should you have any questions, please feel free to contact Jason Tom.

Sincerely,

A handwritten signature in black ink that appears to read "G. Pursell".

GARY PURSELL
Resident Engineer

cc: R. Morrow
B. Boal
K. Devonport
J. Tom
S. Ku
C. Chao

file: 05.03.01

DEPARTMENT OF TRANSPORTATION

CHINA FABRICATION TEAM
506 Shangcheng Rd., Pudong New District
Shanghai 200120, PRC



REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Dave Williams, American Bridge – Fluor, a Joint Venture

Review Date: 10-05-2008

From: Gary Pursell

Contract No.: 04-0120F4

Date/Time Submittal Received: 08-14-2008

China Standard Time
(GMT+08:00)

Contractor's Transmittal #: AFC-CAL-
LTR-000626

Rev. # 0

<input type="checkbox"/>	substantially complies with contract requirements and is approved		
<input type="checkbox"/>	substantially complies with contract requirements and is approved as noted.		
<input type="checkbox"/>	Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmittal		
Verbal Notification	<input checked="" type="checkbox"/> No	<input type="checkbox"/> Yes	Date: _____ Time: _____
Name of individual from Contractor Notified: _____			
This submittal is a:	<input type="checkbox"/> Welding Report	<input type="checkbox"/> Critical Weld Repair	
	<input type="checkbox"/> Request for Information	<input type="checkbox"/> Heat Straightening Request	
	<input type="checkbox"/> Fabrication Procedures	<input type="checkbox"/> Other: Response to NCR	
Submitting Contractor: <u>ABFJV</u>			
ITEMS REVIEWED	COMPLIES		COMMENTS
1.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	TC Letter No. 05.03.08-000007

Reviewer: _____

Date: _____

Construction Concurrence: SP Initial 10/5/08 Date

Received by (ABFJV): _____

Rosenman

Date: Oct 6, 2008

Time: 14:11 pm

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, Shanghai, PRC**Report No:** NCS-000095**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Oct-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0069**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: 15-Feb-2008**Description of Non-Conformance:**

The Contractor did not follow approved working drawings. The Contractor did not use a template to determine the amount of grinding required to produce the required depth of groove for the closed rib to deck plate SAW cover pass as described in approved fabrication procedures. This occurred on OBG deck panel DP-058.

Contractor's proposal to correct the problem:

The fabricator will grind the tack weld flush to the same level as the adjacent root pass.

Corrective action taken:

The fabricator will grind the tack weld flush to the same level as the adjacent root pass.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Rick Morrow for Gary Pursell **Date:** 06-Oct-2008**Is Engineer's approval attached?** Yes No See State Letter 05.03.01-002773**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: Smith, Ryan

QA Reviewer