

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-000078**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0076**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: U-192, U-194
Procedural	Procedural	Descriptor:	OBG Closed Ribs

Description of Non-Conformance:

The Contractor performed repairs without receiving prior Engineer approval. The Contractor repaired cracks that were found in the GMAW root pass of welds in OBG closed ribs to box shell plate. This occurred on closed ribs U-192 (welds #5 and #6) and U-194 (welds #8 and #10) of deck panel DP062-001.

Applicable reference:

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

Who discovered the problem: Jimmy Cochran, Greg Bertlesman and Larry Viars**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** Verbal notification at 06:45 on 02-25-2008**QC Inspector's Name:** ZPMC QC Inspector Mr. Sun Wei**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: 28-Feb-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000045

Subject: NCR No. ZPMC-0076

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-0076

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: 05.03.06-000045

Subject: NCR No. ZPMC-0076

Dated: 19-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000075 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: Contractor repaired closed ribs to box shell plate using repair methods not previously approved by the engineer. Fabricator generated a root pass repair procedure submitted to the State 7-15-08, 634R4

Please see attached letter.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000075R00;

Caltrans' comments:

Status: REJ

Date: 10-Sep-2008

The response is not acceptable. Submittal 634R04 referenced in this NPR has been Returned for Correction. Please provide documentation of the actual repair performed, and documentation that the required Non-Destructive Testing of the repaired area is acceptable.

Submitted by: Wright, Doug

Attachment(s):

Date: 10-Sep-2008



American
Bridge

FLUOR

A JOINT VENTURE

August 19, 2008

Reply to: SL-ABF-08-0170

Attention: Gary Pursell

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

Subject: NCR# ZPMC-0076

Mr. Pursell:

This letter is issue to provide formal response addressing the proposed resolution to NCR# ZPMC-0076.

The Contractor repaired closed ribs to box shell plate using repair methods and procedures that were not previously approved by the engineer.

The fabricator has generated a root pass repair procedure. This repair procedure was submitted to the State on 15 July 2008 submittal No. 634R4

The repairs performed on the root pass as stated above were performed per the same methods and WPS that are documented within the Root Pass repair procedure.

Please feel free to contact me directly if you require assistance or further clarification.

Sincerely,

Nate Lindell
Quality Assurance Manager
AMERICAN BRIDGE / FLUOR JV

cc: file

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000045

Subject: NCR No. ZPMC-0076

Dated: 24-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000075 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC requests closure of this NCR based on the attached documentation.

Please see attached.

Submitted by:

Attachment(s): ABF-NPR-000075R01;

Caltrans' comments:

Status: CLO

Date: 05-Nov-2008

The proposed resolution is acceptable. The repair procedure was submitted as part of ABF-SUB-634R06, and approved as noted. Also, the welds in question were accepted as shown on the attached NDT reports. The Department concurs that Non-Conformance ZPMC-0076 is closed.

Submitted by: Wright, Doug

Date: 06-Nov-2008

Attachment(s):



No. B-295

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-8-28

REGARDING:

NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123

With this letter of response, ZPMC requests closure for Caltrans NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123 (ZPMC-0067/0068/0076/0110/0093/0096/0095/0111/0113/0082/0119). All of the non-conformance reports describe it is that zpmc repair the deck panel in the work process without received the engineer approval. As considered the welding continuity in the workshop, we directly repaired the defects which caused by the cease-arc, so that the panel fabrication can keep on performing. But not waiting for the CWR report approval for a few days. At the same time we had provided the repair procedure for welding process to government's approval. Then ZPMC can repair any defects in process following that procedure.

Furthermore we also attach the correlative VT and NDT reports which after repair and the final inspection, So that it's can prove those deck panel have reached the special requirements.

So ZPMC considers

NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123 can be closed.

Please reference attached documentation for acceptance and closure the NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123.

ATTACHMENT:

NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123 (ZPMC-0067/0068/0076/0110/0093/0096/0095/0111/0113/0082/0119)

VT and MT reports which in the repair process

FVT and final MT reports for the deck panels

Zhuo Shuangbao

2008.8.28.

Thomas W Lamb
ABF QCM
9 SEPT. 08

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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, PRC

Report No: NCR-000078

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 24-Feb-2008

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

NCR #: ZPMC-007

Type of problem:

Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: U-192, U-194
Procedural Procedural Descripton: OBG Closed Ribs

Description of Non-Conformance:

The Contractor performed repairs without receiving prior Engineer approval. The Contractor repaired cracks that were found in the GMAW root pass of welds in OBG closed ribs to box shell plate. This occurred on closed ribs U-192 (welds #5 and #6) and U-194 (welds #8 and #10) of deck panel DP062-001.

Applicable reference:

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

Who discovered the problem: Jimmy Cochran, Greg Bertlesman and Larry Viars.

Name of individual from Contractor notified:

Time and method of notification:

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: Verbal notification at 06:45 on 02-25-2008

QC Inspector's Name: ZPMC QC Inspector Mr. Sun Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

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Inspected By: Lowry, Patrick

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer



Visual Weld Inspection Report

焊缝目视检查报告

Caltrans Contract No. 04-0120F4
加州合同编号

Project No.: San Francisco Oakland Bay Bridge 美国
项目名称 海湾大桥

Project No.: ZP06-787
项目编号:

Quality Assurance Manager
~Approval
质量控制经理:

Hu Guang

Girder/梁:
Tower/塔:

ORC Urib

NA

Representative:
质检代表:

Lin Tranluana

CWI:
检验员:

Jun Incl 05/13/1

Weld No. 焊缝编号	Welder I.D.# 焊工识别号	Location 位置	Welding consumables 焊接材料	Undercut 咬边	Porosity 气孔	Over lap 焊瘤	Crater 弧坑	Arc strike 电弧擦伤	Spatters 飞溅	Crack 裂纹	Accept or Reject 接受或拒收	Repair 返修	Accept or Reject after repair 返修后接受 或拒收
DP062-001-001	059464	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-002	059468	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-003	059464	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-004	059468	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-005	059361	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-006	062265	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-007	059361	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-008	062265	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-009	059400	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA
DP062-001-010	059355	2G	JW-3	√	√	√	√	√	√	√	Acc	NA	NA

After root weld
 After CWR or WRR No.:

After cover pass
 After HSR No.:

Others

#R787-QCP-603

"√" is no defects. "X" is defects. "NA" is not applicable.

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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-000174**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0076**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: 24-Feb-2008**Description of Non-Conformance:**

The Contractor performed repairs without receiving prior Engineer approval. The Contractor repaired cracks that were found in the GMAW root pass of welds in OBG closed ribs to box shell plate. This occurred on closed ribs U-192 (welds #5 and #6) and U-194 (welds #8 and #10) of deck panel DP062-001.

Contractor's proposal to correct the problem:

Reference: ABF-SUB-634R06

Corrective action taken:

Corrective action was taken and the welds were accepted based on the NDT results.

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 Eric Tsang, +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer