

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-000083**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Feb-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0081**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: PMT, DP-026-001/DP-030-001
Procedural	Procedural	Descriptor:	Closed rib weld production monitoring test for OBG

Description of Non-Conformance:

The Contractor's performance of NDT did not conform to approved working drawings. The Contractor performed ultrasonic testing (UT) on closed rib weld production monitoring test (PMT) using a correction factor of 0.8 mm. The approved UT procedure requires a correction factor of 1.2 mm. This occurred during UT of PMT performed on 02-28-2008.

Applicable reference:

Supplementary Ultrasonic Testing Procedure to Verify Depth of Penetration of Partial U-ribs Welds, # ZPQC-UT-02 Revision 8

Who discovered the problem: Alfredo Acuna**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 14:20 on 02-28-2008**QC Inspector's Name:** Shen Xue Jun**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: 05-Mar-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000049

Subject: NCR No. ZPMC-0081

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-0081

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: 05.03.06-000049

Subject: NCR No. ZPMC-0081

Dated: 24-Apr-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000030 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC QC will ensure that UT technicians are using the proper correction factor closed rib weld UT

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: Kanapicki, Charles

Attachment(s): ABF-NPR-000030R00;

Caltrans' comments:

Status: CLO

Date: 23-Jun-2008

Based on the fact that ZPMC has corrected its practices, and has been using an acceptable correction factor during Ultrasonic Testing (UT) of the closed rib production monitoring tests, we agree that Non-Conformance ZPMC-0081 is closed.

Regarding the comment about ABF's understanding of the NCT process, each Non-Conformance requires a response unless the NCT form specifically states that the NCR is resolved.

Submitted by: Wright, Doug

Attachment(s):

Date: 23-Jun-2008



No. B-071

LETTER OF RESPONSE

DATE: 2008.03.24

To: AB/F Steve Lawton

From: ZPMC Li Liming

Subject: Response to CT NCR-000083 / ZPMC 01 ^{CT} 4/23/08

Mr. Lawton,

ZPMC has generated internal NCR-B-020 in response to CT NCR-000083, regarding that ZPMC performed UT on closed rib production using a correction factor of 0.8mm while the approved UT procedure requires a correction factor of 1.2mm. In the future, UT will be performed on closed rib production PMT using a correction factor of 1.2mm. / ZPMC 01 ^{CT} 4/23/08

Attached are copies of both ZPMC internal NCR-B-020 and CT NCR-000083. / ZPMC 01 ^{CT} 4/23/08
For further information, please contact me. Thank you.

Sincerely,
Li Liming

Li Liming 2008.03.24

REVIEWED
J. Lawton
ABF QCM
10 APRIL 08



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B
项目名称: 美国加州海湾大桥

NCR Number:
NCR 编号: NCR-B-020 (NCR-000083) / ZPMC 021

Item: UT factor will change to 1.2mm
名称描述: UT 补偿值更改

Item Number:
件号:

Drawing Number:
图号: DP-026/030

C92
4/23/08

Location: OBG Deck Plate(PMT)
位置: 钢箱梁顶板单元(PMT)

Date:
日期: 2008-2-28

Description of Nonconformance:
不符合项状态描述:
 The approved UT procedure requires a correction factor of 1.2mm. The contractor performed UT on closed rib production PMT using a correction factor of 0.8mm.
 现在我们车间内的 PMT UT 检测过程中补偿值用的是 0.8, 而批准的工艺上要求为 1.2. 涉及的 PMT 相关板单元编号为 DP-026-001/DP-030-001.

Work By: Li Liming **Prepared by:** Fu Yuhong **Reviewed by QCE:** Zhao Shuangbao
施工方: sub 03.07 **准备:** sub 03.07 **质量工程师批准:** 2008.3.7

Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
处理措施: 回用 返修 拒收

Recommendation:
建议
 以后 PMT 检测改为 1.2mm 补偿。
 UT will be performed on closed rib production PMT using a correction factor of 1.2mm.

Prepared by: Li Liming 2008.03.07 **Approved by QCA:** Hu Gang 2008.3.7
准备: **质量经理批准**

Reason for Nonconformance:
不符合原因:
 PMT UT 检测补偿用 0.8, 而批准工艺为 1.2mm, 而且之前 Mock-up 一直沿用 0.8 补偿。
 The approved UT procedure requires a correction factor of 1.2mm. The contractor performed UT on closed rib production PMT using a correction factor of 0.8mm. Besides, the correction factor was 0.8mm in the mock-up production.

Prevention of Re-occurrence:
预防措施:
 现场检测改为 1.2 补偿。
 The correction factor shall be changed to 1.2mm.

Approved by/批准: Li Liming 2008.03.07

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
回用或返修的技术依据: 附件 无附件

NA

Reviewed /批准: Ling Shihua 08.03.08

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

Verified by QCI/质检确认: _____ **Reviewed by QCA/质检主任审核:** _____



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: 05-Mar-2008

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

Attention: Dave Williams Consultant
Job Name: SAS Superstructure

Document No: 05.03.06-000049

Subject: NCR No. ZPMC-0081

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-0081

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

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-000083

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-Feb-2008

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

NCR #: ZPMC-0081

Type of problem:

Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: PMT, DP-026-001/DP-030-001
Procedural Procedural Description: Closed rib weld production monitoring test for OBG

Description of Non-Conformance:

The Contractor's performance of NDT did not conform to approved working drawings. The Contractor performed ultrasonic testing (UT) on closed rib weld production monitoring test (PMT) using a correction factor of 0.8 mm. The approved UT procedure requires a correction factor of 1.2 mm. This occurred during UT of PMT performed on 02-28-2008.

Applicable reference:

Supplementary Ultrasonic Testing Procedure to Verify Depth of Penetration of Partial U-ribs Welds, # ZPQC-UT-02 Revision 8

Who discovered the problem: Alfredo Acuna

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 14:20 on 02-28-2008

QC Inspector's Name: Shen Xue Jun

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

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-000033**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 10-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0081**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: 28-Feb-2008**Description of Non-Conformance:**

The Contractor's performance of NDT did not conform to approved working drawings. The Contractor performed ultrasonic testing (UT) on closed rib weld production monitoring test (PMT) using a correction factor of 0.8 mm. The approved UT procedure requires a correction factor of 1.2 mm. This occurred during UT of PMT performed on 02-28-2008.

Contractor's proposal to correct the problem:

METS-OSM will track this issue as a Quality Management Issue and does not request a response from the Contractor at this time. If this issue becomes systemic, METS will elevate this issue to second-tier and request a response from the Contractor.

Corrective action taken:

N/A

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 Patrick Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Liu, Chengwen

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer