

**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-000088**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 05-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0086**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> FB-026-001 - X82- X82K
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	OBG Floorbeam

**Description of Non-Conformance:**

The Contractor performed unapproved heat straightening. The Contractor performed heat straightening on a 14-mm thick stiffener that was welded onto a floorbeam web plate. The stiffener was out of straightness by 10 mm in 390 mm. It was observed that the stiffener was out of tolerance when it was fit-up onto the assembly. This occurred on stiffener marked X82 - X82K for floorbeam FB-026-001.

**Applicable reference:**

Special Provisions, Section 8-3 Welding (page 154): "For material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer."

**Who discovered the problem:** Tim McClendon**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 on 03-06-2008**QC Inspector's Name:** ZPMC CWI Mr. Li Zhi Jiang**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, A JV  
375 BURMA ROAD  
OAKLAND CA 95607

**Date:** 14-Mar-2008

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

**Attention:** Dave Williams          Consultant

**Job Name:** SAS Superstructure

**Document No:** 05.03.06-000054

**Subject:** NCR No. ZPMC-0086

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-0086

**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:** 05.03.06-000054

**Subject:** NCR No. ZPMC-0086

**Dated:** 05-Aug-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000060 **Rev:** 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** Additional inspectors and training have been provided to aid in proper heat straightening techniques.  
Please see attached.

**Submitted by:** Kanapicki, Charles  
**Attachment(s):** ABF-NPR-000060R00;

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**Caltrans' comments:**

**Status:** CLO  
**Date:** 07-Aug-2008

The Contractor's response is acceptable. The Department concurs that Non-Conformance ZPMC-0086 is closed.

**Submitted by:** Wright, Doug  
**Attachment(s):**

**Date:** 07-Aug-2008

17 July 2008

Reply to: SL-ABF-08-0xxx

**Attention:** Gary Pursell

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

**Subject:** NCR# ZPMC-0086

Mr. Pursell:

This letter is issued to provide formal response addressing the proposed resolution to the following nonconformance reports:

NCR # ZPMC-0086

The Contractor performed unapproved heat straightening on a 14mm thick stiffener that was welded onto a floorbeam web plate.

ZPMC understand the contract requirements for submitting heat straightening records for approval when required. Additional QC inspectors have been added to help insure proper approval is obtained prior to performing heat straightening. Additionally, training has been provided on proper straightening techniques.

If further clarifications are needed, please contact me.

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Nate S. Lindell  
Quality Assurance Manager  
American Bridge Fluor Joint Venture

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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-000062**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Jul-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0086**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 05-Mar-2008**Description of Non-Conformance:**

The Contractor performed unapproved heat straightening. The Contractor performed heat straightening on a 14-mm thick stiffener that was welded onto a floorbeam web plate. The stiffener was out of straightness by 10 mm in 390 mm. It was observed that the stiffener was out of tolerance when it was fit-up onto the assembly. This occurred on stiffener marked X82 - X82K for floorbeam FB-026-001.

**Contractor's proposal to correct the problem:**

The Contractor acknowledged the non-conformance and generated an internal NCR for this issue. The Contractor will submit necessary HSR's for Engineer approval according to the Contract prior to perform heat straightening.

**Corrective action taken:**

The Contractor has generated an internal NCR to address the non-conformance and has documented the unapproved repair via a Heat Straightening Report.

**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 Ady Velasco, 011-86-138-1694-2685, who represents the Office of Structural Materials for your project.

**Inspected By:** Liu, Chengwen

Quality Assurance Inspector

**Reviewed By:** Velasco, Abifhram

QA Reviewer