

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-000093**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0091**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Various rolled shapes
Procedural	Procedural	Descriptor:	203 x 203 x 19 angle

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

The Contractor performed fabrication on unidentified stock material that has not been approved by the Engineer. The Contractor has submitted (transmittal TL-08-0533) a list of rolled shapes, 446 tons, that has not been identified with certified mill test reports (MTR). The Contractor painted shop primer on approximately 75% of the rolled shapes. It was observed that mill tags were attached to some of the shapes. Caltrans QA performed random inspection on a bundle of 203 x 203 x 19 angle marked by the Contractor as Heat Number 5-09969. QA observed mill tags on portions of this material with a different Heat Number (5-09968). This does not meet the requirements of approved working drawings which require the material to be "checked for their size, thickness, surface quality, heat numbers, plate numbers and properties" prior to pre-treatment.

Applicable reference:

Standard Specifications, Section 55-2-07: "Unidentified stock material, consisting of material which cannot be identified with certified mill test reports, may be used on non-fracture critical members subject to the provisions in this section..."

"Fabrication shall not commence until the materials involved have been approved by the Engineer.

"Not more than 13.6 tonnes of unidentified stock material may be used on one contract."

OBG Fabrication Procedures, Steps 3.1 - 3.2: "During pre-treatment, the roll shapes information will be written down after pre-treatment, the direction of rolling, heat numbers, plate sizes and designations shall be re-marked on the pre-treated plates..."

Who discovered the problem: David McClary**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 03-21-2008**QC Inspector's Name:** Steve Lawton**Was QC Inspector aware of the problem:**

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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 - District 4 Toll Bridge
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 95607

Date: 24-Mar-2008

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000063

Subject: NCR No. ZPMC-0091

Reference Description: The Contractor performed fabrication on unidentified stock material that has not been approved by the Engineer.

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Material or Workmanship not in conformance with contract documents.
- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved - No Response Required.

Material Location: OBG **Lift:** N/A

Remarks:

The Contractor has submitted (transmittal TL-08-0533) a list of rolled shapes, 446 tons, that has not been identified with certified mill test reports (MTR). The Contractor painted shop primer on approximately 75% of the rolled shapes. It was observed that mill tags were attached to some of the shapes. Caltrans QA performed random inspection on a bundle of 203 x 203 x 19 angle marked by the Contractor as Heat Number 5-09969. QA observed mill tags on portions of this material with a different Heat Number (5-09968). This does not meet the requirements of approved working drawings which require the material to be "checked for their size, thickness, surface quality, heat numbers, plate numbers and properties" prior to pre-treatment.

Action Required and/or Action Taken:

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0091

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Dated: 19-Aug-2008

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000083 Rev: 00

Ref: 05.03.06-000063

Subject: NCR No. ZPMC-0091

Contractor's Proposed Resolution:

Reference Resolution: ZPMC understands the requirements of AWS D1.5-02 and the Special Provisions to only use approved material.
Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000083R00;

Caltrans' comments:

Status: REJ

Date: 11-Sep-2008

The response is not acceptable. Please resubmit when the Non-Conforming material has been removed and replaced with acceptable material. Also, include in the resubmittal the internal Non-Conformance report referenced in the attached letter.

Submitted by: Wright, Doug

Date: 11-Sep-2008

Attachment(s):



American
Bridge

FLUOR[®]

A JOINT VENTURE

August 19, 2008

Reply to: SL-ABF-08-0178

Attention: Gary Pursell

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

Subject: NCR# ZPMC-0091

Mr. Pursell:

This letter is issue to provide formal response addressing the proposed resolution to NCR# ZPMC-0091.

ZPMC understands the requirements of AWS D1.5-02 and the Special Provisions to only use approved material. The unidentified material referenced in this NCR has been located and identified by painting the material for future removal. Additionally, the material has been documented in an internal nonconformance report.

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: 05.03.06-000063

Subject: NCR No. ZPMC-0091

Dated: 11-Feb-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000083 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC acknowledged that traceability was lost on some Rolled Shape material

ZPMC has acknowledged that traceability was lost on some Rolled Shape material during pre-treating the steel or the steel was not originally marked on the pieces as received by ZPMC from their supplier. To ensure proper traceability, ZPMC has and is currently testing each piece of material. Prior to cutting the material for testing, ABF personnel assign a unique number to each piece of material, this number becomes the heat identification number. ABF witnesses the marking and cutting of the sample piece as well as marking the balance of material. Each sample piece is shipped to an independent laboratory for testing and test results shipped direct to ABF for review and approval before forwarding to CT for review. ABF has also generated RFIs requesting lot testing of same size materials that are considered miscellaneous metals. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000083R01

Caltrans' comments:

Status: CLO

Date: 24-Mar-2009

The proposed resolution is acceptable. The issues of traceability and testing of this material has been addressed in RFIs 1518, 1529, and 1600. The Department concurs that Non-Conformance ZPMC-0091 is closed.

Submitted by: Wright, Doug

Date: 24-Mar-2009

Attachment(s):

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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-000207**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0091**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: 18-Mar-2008**Description of Non-Conformance:**

The Contractor performed fabrication on unidentified stock material that has not been approved by the Engineer. The Contractor has submitted (transmittal TL-08-0533) a list of rolled shapes, 446 tons, that has not been identified with certified mill test reports (MTR). The Contractor painted shop primer on approximately 75% of the rolled shapes. It was observed that mill tags were attached to some of the shapes. Caltrans QA performed random inspection on a bundle of 203 x 203 x 19 angle marked by the Contractor as Heat Number 5-09969. QA observed mill tags on portions of this material with a different Heat Number (5-09968). This does not meet the requirements of approved working drawings which require the material to be "checked for their size, thickness, surface quality, heat numbers, plate numbers and properties" prior to pre-treatment.

Contractor's proposal to correct the problem:

NPR83R01 stated the following: "ZPMC has acknowledged that traceability was lost on some Rolled Shape material during pre-treating the steel or the steel was not originally marked on the pieces as received by ZPMC from their supplier. To ensure proper traceability, ZPMC has and is currently testing each piece of material. Prior to cutting the material for testing, ABF personnel assign a unique number to each piece of material, this number becomes the heat identification number. ABF witnesses the marking and cutting of the sample piece as well as marking the balance of material. Each sample piece is shipped to an independent laboratory for testing and test results shipped direct to ABF for review and approval before forwarding to CT for review. ABF has also generated RFIs requesting lot testing of same size materials that are considered miscellaneous metals."

Corrective action taken:

The issues of traceability and testing of this material has been addressed in NPR83R01; RFIs 1518, 1529, and 1600.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?**

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

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) 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	Quality Assurance Inspector
Reviewed By:	Wahbeh, Mazen	QA Reviewer
