

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-000094**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0092**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Various pieces marked X3D, X3T
Procedural	Procedural	Descriptor:	OBG Floorbeam Diagonal Connection Angles

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

The Contractor performed fabrication on unidentified stock material that has not been approved by the Engineer. The Contractor was observed cutting structural steel material (127 mm x 89 mm x 12.7 mm angle iron) to be identified in working drawings as piece marks X3D & X3T connection angles for the fabrication of floorbeam diagonal assemblies. The material has not been identified with certified mill test reports (MTR).

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."

Who discovered the problem: Chuck Franco**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Sean Eagan**Time and method of notification:** Present at time of discovery**QC Inspector's Name:** ZPMC CWI Huang Wen-Pang**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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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: 05.03.06-000064

Subject: NCR No. ZPMC-0092

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 was observed cutting structural steel material (127 mm x 89 mm x 12.7 mm angle iron) to be identified in working drawings as piece marks X3D & X3T connection angles for the fabrication of floorbeam diagonal assemblies. The material has not been identified with certified mill test reports (MTR).

Action Required and/or Action Taken:

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0092

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000064

Subject: NCR No. ZPMC-0092

Dated: 19-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000084 Rev: 00

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-000084R00;

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

Attachment(s):

Date: 11-Sep-2008



American
Bridge / **FLUOR**

A JOINT VENTURE

August 19, 2008

Reply to: SL-ABF-08-0179

Attention: Gary Pursell

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

Subject: NCR# ZPMC-0092

Mr. Pursell:

This letter is issue to provide formal response addressing the proposed resolution to NCR# ZPMC-0092.

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: 05.03.06-000064

Subject: NCR No. ZPMC-0092

Dated: 11-Feb-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000084 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 RFI's requesting lot testing of same size materials that are considered miscellaneous metals. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000084R01

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-0092 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-000206**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0092**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 11-Mar-2008**Description of Non-Conformance:**

The Contractor performed fabrication on unidentified stock material that has not been approved by the Engineer. The Contractor was observed cutting structural steel material (127 mm x 89 mm x 12.7 mm angle iron) to be identified in working drawings as piece marks X3D & X3T connection angles for the fabrication of floorbeam diagonal assemblies. The material has not been identified with certified mill test reports (MTR).

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?** 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.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

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Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer