

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-000099**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Mar-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0097**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Tower-89m Mockup, Fit Lug to Stiffener Weld
Procedural	Procedural	Descriptor:	

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

ABF allowed ZPMC to weld fit lugs to the Skin B longitudinal stiffeners and the SA13 diaphragm plate on the 89-meter mockup outside of the provisions of the approved Partial Mock-Up fabrication procedure and welding sequence. Per the Special Provisions, Section 10-1.59, "The fabrication and welding sequence shall be submitted for review by the Engineer, and approval shall be given before the mock-up is fabricated."

Applicable reference:

Special Provisions, Section 10-1.59, "Steel Structures", subsection "Fabrication" page 313: "For each mock-up, the Contractor shall prepare a written fabrication and welding sequence. The fabrication and welding sequence shall be submitted for review by the Engineer, and approval shall be given before the mock-up is fabricated. The Engineer shall witness all fit-up and welding for each mock-up."

Who discovered the problem: Joshua Ishibashi, Structural Materials Representative**Name of individual from Contractor notified:****Time and method of notification:****Name of Caltrans Engineer notified:** Scott Kennedy, Structure Representative**Time and method of notification:** 26-Mar-2008 at approx. 1300 hours; Verbal**QC Inspector's Name:** N/A**Was QC Inspector aware of the problem:** Yes No**Contractor's proposal to correct the problem:**

Submit an addendum to previously submitted Partial Mockup Fabrication Procedure.

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Wahbeh, Mazen

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Reviewed By: Wahbeh,Mazen

QA Reviewer



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: American Bridge/Fluor Enterprises, a JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 28-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: 05.03.06-000076

Subject: NCR No. ZPMC-0097

Reference Description: 89m Partial Mockup / Fit Lug Procedure

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: Tower **Lift:**

Remarks:

ABF allowed ZPMC to weld fit lugs to the Skin B longitudinal stiffeners and the SA13 diaphragm plate on the 89-meter mockup outside of the provisions of the approved Partial Mock-Up fabrication procedure and welding sequence.

Action Required and/or Action Taken:

Please refer to the attached Non-Conformance Report for details.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0097

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000076

Subject: NCR No. ZPMC-0097

Dated: 25-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000097 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been notified that the fabrication procedure shall be followed or the procedure shall be revised prior to use

ZPMC has been notified that the fabrication procedure shall be followed or the procedure shall be revised prior to use

Submitted by: Mackey, Kim

Attachment(s): ABF-NPR-000097R00

Caltrans' comments:

Status: CLO

Date: 01-Jan-2009

Per State Letter 05.03.01-003087 dated December 8, 2008, the 77m and 89m Tower Section Mock-ups were successfully completed. The Department concurs that Non-Conformance ZPMC-0097 is closed.

As noted in ABF-CAL-LTR-000758, the Department understands that the appropriate fabrication plans will be modified in accordance with Special Provision Section 10-1.59, "Steel Structures," subsection "Working Drawings" through the FCN process.

Submitted by: Wright, Doug

Attachment(s):

Date: 02-Jan-2009

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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-000139**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0097**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: 26-Mar-2008**Description of Non-Conformance:**

ABF allowed ZPMC to weld fit lugs to the Skin B longitudinal stiffeners and the SA13 diaphragm plate on the 89-meter mockup outside of the provisions of the approved Partial Mock-Up fabrication procedure and welding sequence. Per the Special Provisions, Section 10-1.59, "The fabrication and welding sequence shall be submitted for review by the Engineer, and approval shall be given before the mock-up is fabricated."

Contractor's proposal to correct the problem:

ZPMC has been notified that the fabrication procedure shall be followed or the procedure shall be revised prior to use.

Corrective action taken:

Fabrication procedure has been modified and partial mock-ups have been fabricated successfully. Letter No. 05.03.01-003087 concluded the successful completion of 77m and 89m mock-ups.

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 Serge Sinevod, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge

Quality Assurance Inspector

Reviewed By: Sinevod, Serge

QA Reviewer