

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-000108**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Apr-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0105**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: FB-011-006
Procedural	Procedural	Descriptor:	OBG Floorbeam

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

The Contractor performed welding using welding electrode that did not conform to the approved WPS. The Contractor performed tack welding on an SPCM weld joint using a THJ508Fe-1 type electrode. The WPS for the weld joint specifies using a THJ506Fe-1 electrode. This occurred on OBG floorbeam weld joint FB-011-006-026.

Applicable reference:

Welding Procedure Specification WPS-B-P-2211-B-U2a-FCM.

Who discovered the problem: Roscoe Dixon**Name of individual from Contractor notified:** ABFJV QC Inspector Art Peterson**Time and method of notification:** Verbal notification at 15:00 on 04-03-2008**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** Verbal notification at 14:00 on 04-04-2008**QC Inspector's Name:** ZPMC QC Inspector Hu Wei Qing**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 - 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: 11-Apr-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: 05.03.06-000084

Subject: NCR No. ZPMC-0105

Reference Description: The Contractor performed welding using welding electrode that did not conform to the approved WPS.

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:**

Remarks:

The Contractor performed tack welding on an SPCM weld joint using a THJ508Fe-1 type electrode. The WPS for the weld joint specifies using a THJ506Fe-1 electrode. This occurred on OBG floorbeam weld joint.

Action Required and/or Action Taken:

No Action Required. This issue is considered to be resolved.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0105

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-000089 **Rev:** 00

Ref: 05.03.06-000087

Ref should be: 05.03.06-000084

Subject: NCR No. ZPMC-0105

Contractor's Proposed Resolution:

Reference Resolution: ZPMC QC was not made aware of this correction until after the fact. To date ZPMC QC cannot find the cited non-compliant condition and as such can not offer a proposed corrective action.

Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000089R00; ;

Caltrans' comments:

Status: CLO

Date: 25-Aug-2008

The Contractor's response is acceptable. The Department concurs that Non-Conformance ZPMC-0105 is closed.

Submitted by: Wright, Doug

Date: 25-Aug-2008

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 04/28/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000108(FOR CLOSURE)

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-111 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000108.
- (3) COPY OF CONTINUOUS VISUAL INSPECTION REPORT

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

PLAN HOLDER

RECEIVED 28 APR 2008

1040

DATE



COMPANY

PHONE NO.

PLAN NUMBER: N/A
#R787-QCP-102



No. B-111

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-4-28

REGARDING: NCR-000108 (ZPMC-0105)

With this letter of response, ZPMC requests countermand Caltrans NCR-000108(ZPMC-0105). ZPMC considers that there are some problems in the NCR description. The NCR description it was happened in Apr 1st, but the QC was not informed on that time . Therefore he can't check the non-conformance is truth or not. From the VT report we still can't find any incorrect.

So ZPMC considers NCR-000108 can be cancelled.

Please reference attached documentation for acceptance and cancel the NCR-000084.

ATTACHMENT:

ZPMC-0105 (NCR-000108)

The continuous visual inspection report

zhao shuangbao

4.28.

This document is: APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial *SJE* Date: *5/15/08*

REVIEWED
[Signature]
30 APRIL 08
ABFCem



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-000108 (ZPMC-0105) NCR 编号: NCR-B-037	
Item: welding SPCM by wrong electrode 名称描述: 焊接 SPCM 件时使用错误的焊条		Item Number: 件号: FB-011-006-026	Drawing Number: 图号:
Location: 位置:		Date: 日期: 2008-4-2	

Description of Nonconformance:

不符合项状态描述:

The contractor performed welding using welding electrode that did not conform to the approved WPS .the contractor performed tack welding on an SPCM weld joint using a THJ508Fe-1 type electrode .the WPS for the weld joint specifies using a THJ506Fe-1 electrode. This occurred on OBG floorbeam weld joint FB-011-006-026.

ZPMC 在焊接 SPCM 件的 FB-011-006-026 焊缝时, 没使用 WPS 规定的 THJ506Fe-1 焊条, 而是使用了 THJ508Fe-1 焊条。

Work By: Lin Jing Fei Prepared by: Wang Li Reviewed by QCE: Zhao Shuang Bao
施工方: 准备: 2008.4.18 质量工程师批准: 2008.4.18.

- 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

Prepared by: _____ Approved by QCA: _____
准备 质量经理批准

Reason for Nonconformance:

不符合原因:

Prevention of Re-occurrence:

预防措施

Approved by/批准: _____

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

Reviewed /批准: _____

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

This document is: APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial SJE Date: 5/15/08

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

#R787-QCP-1300



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: 11-Apr-2008

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

Dear: Mr. Charles Kanapicki
 Attention: Mr. Dave Williams Consultant
 Subject: NCR No. ZPMC-0105

Job Name: SAS Superstructure
 Document No: 05.03.06-000084

Reference Description: The Contractor performed welding using welding electrode that did not conform to the approved WPS.

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:

Remarks:

The Contractor performed tack welding on an SPCM weld joint using a THJ508Fe-1 type electrode. The WPS for the weld joint specifies using a THJ506Fe-1 electrode. This occurred on OBG floorbeam weld joint.

Action Required and/or Action Taken:

No Action Required. This issue is considered to be resolved.

Transmitted by: Stanley Ku Sr. Bridge Engineer
 Attachments: ZPMC-0105

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom
 File: 05.03.06

This document is: APPROVED
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant Section 6-1.02 of the
 Standard Specifications
 Initial SJE Date: 5/15/08

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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-000108

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 03-Apr-2008

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

NCR #: ZPMC-0105

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: FB-011-006
 Procedural Procedural Description: OBG Floorbeam

Reference Description:

Description of Non-Conformance:

The Contractor performed welding using welding electrode that did not conform to the approved WPS. The Contractor performed tack welding on an SPCM weld joint using a THJ508Fe-1 type electrode. The WPS for the weld joint specifies using a THJ506Fe-1 electrode. This occurred on OBG floorbeam weld joint FB-011-006-026.

Applicable reference:

Welding Procedure Specification WPS-B-P-2211-B-U2a-FCM.

Who discovered the problem: Roscoe Dixon

Name of individual from Contractor notified: ABFJV QC Inspector Art Peterson

Time and method of notification: Verbal notification at 15:00 on 04-03-2008

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: Verbal notification at 14:00 on 04-04-2008

QC Inspector's Name: ZPMC QC Inspector Hu Wei Qing

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

Reviewed By: Lowry, Patrick

Quality Assurance Inspector
 This document is APPROVED
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant Section 6-1.02 of the
 Standard Specifications
 Initial SJE Date: 5/15/08



CONTINUOUS VISUAL INSPECTION REPORT

焊缝目检报告

WELDING AREA

焊接地点

Checking Time: 检查时间:	8:10	8:40	13:10	14:35		
Weld No.: 焊缝编号:	FB016-014 -026	FB015 -011-026	FB011 -006-026	FB009 -008-026		
Welder ID No.: 焊工编号:	Wang Changfu 058102	058102	058102	058102	058102	058102
WPS No.: WPS编号:	wps-B-P -221-B-U2	wps-B-P -211-B-U2	wps-B-P -221-B-U2	wps-B-P -221-B-U2		
Weld Process: 焊接方法:	SAW	SAW	SAW	SAW		
Position (F,H,V): 焊接位置:	F	F	F	F		
Member ID No.: 构件编号:	FB16	FB15	FB11	FB9		
Base Metal & Grade: 母材金属级别:	A709M-345T -X	A709M -345T-X	A709M-345 T-X	A709M- 345T-X		
Thickness: 厚度:	12/30	12/30	12/30	12/30		
Preheat Temperature: 预热温度:	45°C	55°C	105°C	65°C		
Volts: 电压:	25.1	25.3	25.4	25.3		
Amps: 电流:	170	171	173	168		
Travel Speed: 焊接速度:	109	110	115	114		
Polarity (EN/EP): 极性:	EP	EP	EP	EP		
Weld Metal: 填充金属:	E7018	E7018	E7018	E7018		
Electrode: 焊条/焊丝:	TL-508	TL-508	THJ506FeF	TL-508		
Fillet Size: 角焊缝尺寸:	NA	NA	NA	NA		
Inspector: 检验员签字:	Lizhujiang	Lizhujiang	Lizhujiang	Lizhujiang	This document is: APPROVED State of California DEPARTMENT OF TRANSPORTATION Pursuant Section 6-1.02 of the Standard Specifications Initial SJE Date: 5/15/08	
Date: 日期:	2008.4.1	2008.4.1	2008.4.1	2008.4.1		
Acceptable (Yes/No): 是否接受:	Yes	Yes	Yes	Yes		

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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-000038**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0105**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: 03-Apr-2008**Description of Non-Conformance:**

The Contractor performed welding using welding electrode that did not conform to the approved WPS. The Contractor performed tack welding on an SPCM weld joint using a THJ508Fe-1 type electrode. The WPS for the weld joint specifies using a THJ506Fe-1 electrode. This occurred on OBG floorbeam weld joint FB-011-006-026.

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:**

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Inspected By: Liu, Chengwen

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer