

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-000111**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 05-Apr-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0108**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP-086-001, DP-300-001, DP-275-001, DP-302-001
Procedural	Procedural	Descriptor:	OBG Deck Panels

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

The Contractor did not provide continuous QC inspection while welding was being performed. The presence of the Contractor's QC inspector was not observed during the splicing of deck panels from 15:00 to 16:00 on 04-05-2008. This occurred during the performance of the FCAW root pass of weld joint numbers DP086-001-007, DP300-001-007, DP275-001-007 and DP302-001-007.

Applicable reference:

Special Provisions, Section 8-3.01 Welding, General (p. 150): "QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes."

Who discovered the problem: QA Inspector Sherri Brannon**Name of individual from Contractor notified:** ABFJV QC Inspector Kevin Carpenter**Time and method of notification:** Verbal (phone) notification at 15:30 on 04-05-2008**Name of Caltrans Engineer notified:** Sean Eagan**Time and method of notification:** Verbal notification at 15:15 on 04-07-2008**QC Inspector's Name:** ZPMC QC Inspector Zhang Jiadi**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.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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: 05.03.06-000087

Subject: NCR No. ZPMC-0108

Reference Description: The Contractor did not provide continuous QC inspection while welding was being performed.

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 presence of the Contractor's QC inspector was not observed during the splicing of deck panels from 15:00 to 16:00 on 04-05-2008. This occurred during the performance of the FCAW root pass of weld joint numbers DP086-001-007, DP300-001-007, DP275-001-007 and DP302-001-007.

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-0108

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: 05.03.06-000087

Subject: NCR No. ZPMC-0108

Dated: 09-Jul-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000037 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will ensure GC conducts more stringent inspections.

Please see attached response from ZPMC.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000037R00;

Caltrans' comments:

Status: CLO

Date: 27-Jul-2008

The Contractor's response is acceptable. The Department concurs that Non-Conformance ZPMC-0108 is closed.

Submitted by: Wright, Doug

Attachment(s):

Date: 27-Jul-2008

DEPARTMENT OF TRANSPORTATION

CHINA FABRICATION TEAM

506 Shangcheng Rd., Pudong New District
Shanghai 200120, PRC

REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Dave Williams, American Bridge – Fluor, a Joint VentureGary Pursell, Resident EngineerReview Date: 07/01/2008From: Chengwen Liu, Structure Materials RepresentativeContract No.: 04-0120F4Date/Time Submittal Received: 06-05-2008 China Standard Time
(GMT+08:00)Contractor's Transmittal #: TL-08-1336Rev. # 00

<input checked="" type="checkbox"/>	substantially complies with contract requirements and is approved		
<input type="checkbox"/>	substantially complies with contract requirements and is approved as noted.		
<input type="checkbox"/>	Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmittal		
Verbal Notification		<input type="checkbox"/> No	<input type="checkbox"/> Yes
		Date:	Time:
Name of individual from Contractor Notified:			
This submittal is a:	<input type="checkbox"/> Welding Report	<input type="checkbox"/> Critical Weld Repair	
	<input type="checkbox"/> Request for Information	<input type="checkbox"/> Heat Straightening Request	
	<input type="checkbox"/> Fabrication Procedures	<input checked="" type="checkbox"/> Other: <u>NCR Closure</u>	
Submitting Contractor: <u>ZPMC</u>			
ITEMS REVIEWED	COMPLIES		COMMENTS
1. ZPMC Transmittal TL-001250 NCR No. ZPMC-0108	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Approved.
2.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
3.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
4.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
5.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
6.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
7.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
8.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
9.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
10.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	

Remarks: METS has completed the review of ABF-TL-08-1336, which consists of NCR closure of ZPMC-0108. METS recommends the aforementioned NCR to be closed.

Reviewer: Ady VelascoDate: 07/01/2008 Construction Concurrence: SJE Initial 7/1/08 DateReceived by (ABVJV): Rosemary Date: 7/1/08 Time: 14:25



Page 1 of 1

Date: 4 June 2008

To: Gary Pursell

From: Steve Lawton

Contract No. 04-0120F4

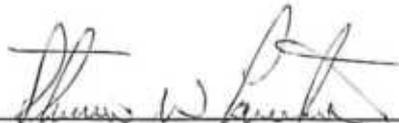
Dear Gary Pursell

This letter is issued to provide formal response addressing the proposed resolution to NCR ZPMC-0108 for Engineer's review and approval.

ZPMC has summarized the above listed NCR's and has generated an internal NCR for each occurrence.

ABFJV considers the NCR's mentioned as closed.

If further clarifications are needed, please contact me.



Steve Lawton
Foreign Quality Assurance Manager
American Bridge Fluor Joint Venture



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 05/23/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000111 FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-257 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000111 (ZPMC-0108) .
- (3) COPY OF ZPMC INTERNAL NCR NCR-B-040

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



 PLAN HOLDER

RECEIVED 23 MAY 2008
 1556

 DATE



 COMPANY

 PHONE NO.

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



No. B-257

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-5-23

REGARDING: NCR-000111 (ZPMC-0108)

With this letter of response, ZPMC requests closure for Caltrans NCR-000111 (ZPMC-0108). Because the QC in charge of the bay one and that deck panel welding repair shop; then it more hard for supervision. ZPMC has realized the problem and will inspect more strictly and QC will check the work circs on both sites more frequently.

So ZPMC considers NCR-000111 can be closed.

Please reference attached documentation for acceptance and closure the NCR-000111.

ATTACHMENT:

NCR-000111 (ZPMC-0108)

ZPMC internal NCR

Zhaoshuangbao

5-23

This document is: APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 6-1.02 of the
Standard Specification
Initial *SJE* Date: *7/1/08*

REVIEWED
J. Smith
ABF QCM
4 JUNE 08



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-000111 (ZPMC-0108) NCR 编号: NCR-B-040	
Item: no QC inspection while welding the deck panel 名称描述: 焊接过程中没有 QC 监控		Item Number: 件号:	Drawing Number: 图号:
Location: DP086-001-007 DP300-001-007 位置: DP275-001-007 DP302-001-007		Date: 日期: 2008-4-5	
Description of Nonconformance: 不符合项状态描述: the contractor did not provide continuous QC inspection while welding was being performed .the presence of the contractor's QC inspector was not observed during the splicing of deck panels from 15:00 to 16:00 on 04-05-2008. this occurred during the performance of the FCAW root pass of weld joint numbers DP086-001-007, DP300-001-007, DP275-001-007 and DP302-001-007. ZPMC 焊接顶板单元的过程中有一小时的时间没有 QC 在现场进行监控。该情况发生在 4 月 5 日下午三点到四点之间。此间焊接的顶板元有 DP086-001-007, DP300-001-007, DP275-001-007 and DP302-001-007.			
Work By: <u>Sunwei</u> 施工方: 08.4.20		Prepared by: <u>Wanglu</u> 准备: 2008.4.18	Reviewed by QCE: <u>Zhao Shuangbo</u> 质量工程师批准: 2008.4.18
<input type="checkbox"/> Drawing Error 图纸错误		<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input checked="" type="checkbox"/> Other 其他原因			
Disposition: <input checked="" type="checkbox"/> Use as is 处理措施: 回用		<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
Recommendation: 建议: 加强巡检, 增加监控力度. Inspect more strictly and strengthen supervision and management.			
Prepared by: <u>Sunwei 08.4.20</u> 准备		Approved by QCA: <u>Hufang 08.4.20</u> 质量经理批准	
Reason for Nonconformance: 不符合原因: 由于两车间距离较远, 在巡检时较为困难, 故无法及时巡检到 在. It is difficult to supervise two shops simultaneously because the shops are a bit far from each other.			
Prevention of Re-occurrence: 预防措施: 加强巡检, 增加监控力度. Inspect more strictly and strengthen supervision and management.			
Technical Justification for Use-As-Is/Repair: <input type="checkbox"/> Attachment 回用或返修的技术依据: QCI 人员需加强巡检并附件		<input checked="" type="checkbox"/> Non-attachment 无附件	
QC personnel shall strengthen the control of fabrication process and inspect more strictly to insure the welding quality. QC 人员需加强巡检, 保证产品的焊接质量. Reviewed/批准: <u>Tang Yongbo 08.4.20</u>			
Verification: <input checked="" type="checkbox"/> Acceptable 确认: 可接受		<input type="checkbox"/> Unacceptable 不可接受	
Verified by QCI/质检确认: <u>Sunwei 07051331</u> Reviewed by QCA/质检主任审核: <u>Hufang</u>			

#R787-QCP-1300

08.5.21

2008.5.21

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Initial SJE Date 7/1/08



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bln 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-0108

Job Name: SAS Superstructure
Document No: 05.03.06-000087

Reference Description: The Contractor did not provide continuous QC inspection while welding was being performed.

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 presence of the Contractor's QC inspector was not observed during the splicing of deck panels from 15:00 to 16:00 on 04-05-2008. This occurred during the performance of the FCAW root pass of weld joint numbers DP086-001-007, DP300-001-007, DP275-001-007 and DP302-001-007.

Action Required and/or Action Taken:

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

This document is APPROVED
State of California
DEPARTMENT OF TRANSPORTATION
Pursuant Section 5-1.02 of the
Standard Specifications
Signed SJE Date: 7/1/08

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0108

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

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
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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-000111

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 05-Apr-2008

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

NCR #: ZPMC-0108

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: DP-086-001, DP-300-001, DP-275-001, DP-302-001
 Procedural Procedural Descripton: OBG Deck Panels

Reference Description:

Description of Non-Conformance:

The Contractor did not provide continuous QC inspection while welding was being performed. The presence of the Contractor's QC inspector was not observed during the splicing of deck panels from 15:00 to 16:00 on 04-05-2008. This occurred during the performance of the FCAW root pass of weld joint numbers DP086-001-007, DP300-001-007, DP275-001-007 and DP302-001-007.

Applicable reference:

Special Provisions, Section 8-3.01 Welding, General (p. 150): "QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes."

Who discovered the problem: QA Inspector Sherri Brannon

Name of individual from Contractor notified: ABFJV QC Inspector Kevin Carpenter

Time and method of notification: Verbal (phone) notification at 15:30 on 04-05-2008

Name of Caltrans Engineer notified: Sean Eagan

Time and method of notification: Verbal notification at 15:15 on 04-07-2008

QC Inspector's Name: ZPMC QC Inspector Zhang Jiadi

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.

This document is APPROVED
 State of California
 DEPARTMENT OF TRANSPORTATION
 Pursuant Section 8-1.02 of the
 Standard Specifications
 Signed SJE Date: 7/1/08

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000040**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0108**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: 05-Apr-2008**Description of Non-Conformance:**

The Contractor did not provide continuous QC inspection while welding was being performed. The presence of the Contractor's QC inspector was not observed during the splicing of deck panels from 15:00 to 16:00 on 04-05-2008. This occurred during the performance of the FCAW root pass of weld joint numbers DP086-001-007, DP300-001-007, DP275-001-007 and DP302-001-007.

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:**

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, (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By: Liu, Chengwen

Quality Assurance Inspector

Reviewed By: Lowry, Patrick

QA Reviewer