

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-000115**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Apr-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0111**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP-298-001
Procedural	Procedural	Descriptor:	OBG Deck Panel

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

The Contractor performed repairs on closed rib to box shell weld without receiving prior Engineer approval.

The Contractor performed repairs for excess porosity in the GMAW root pass on weld number -001 of DP-298-001.

Applicable reference:

Special Provisions, Section 10-1.59 Steel Structures, Subsection, Welding of Closed Ribs to Box Shell Plate (p. 328): "Repair welding methods and procedures shall be approved by the Engineer."

Who discovered the problem: QA Inspector Steve Hall**Name of individual from Contractor notified:** ABFJV QC Inspector Art Peterson**Time and method of notification:** 4/13/08, 2030, verbal via phone**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** 4/14/2008, 1415, verbal**QC Inspector's Name:** ZPMC QC Inspector Li Yan Hua**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: 16-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: 05.03.06-000092

Subject: NCR No. ZPMC-0111

Reference Description: The Contractor performed repairs on closed rib to box shell weld without receiving prior Engineer approval.

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 repairs for excess porosity in the GMAW root pass on weld number -001 of DP-298-001.

Action Required and/or Action Taken:

This is a recurring issue. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0111

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000092

Subject: NCR No. ZPMC-0111

Dated: 10-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000119 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC performed weld repair on in process root pass. Since this time a repair procedure has been submitted to CT. ZPMC performed weld repair on in process root pass. Since this time a repair procedure has been submitted to CT. The repair was performed, inspected and documented.

Submitted by:

Attachment(s): ABF-NPR-000119R00

Caltrans' comments:

Status: AAP

Date: 28-Sep-2008

The response is acceptable, but the Non-Conformance is not closed.

Please provide documentation of the weld repairs that were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0111 at that time.

Submitted by: Wright, Doug

Date: 28-Sep-2008

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000092

Subject: NCR No. ZPMC-0111

Dated: 24-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000119 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC requests closure of this NCR based on the attached documentation.

Please find attached.

Submitted by:

Attachment(s): ABF-NPR-000119R01;

Caltrans' comments:

Status: REJ

Date: 09-Nov-2008

The proposed resolution is not acceptable. The documentation included in this NPR references weld DP-298-001-006. The NCR references weld DP-298-001-001, please re-submit with documentation for this weld. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0111 at that time.

Submitted by: Wright, Doug

Date: 10-Nov-2008

Attachment(s):



No. B-295

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-8-28

REGARDING:

NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123

With this letter of response, ZPMC requests closure for Caltrans NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123 (ZPMC-0067/0068/0076/0110/0093/0096/0095/0111/0113/0082/0119). All of the non-conformance reports describe it is that zpmc repair the deck panel in the work process without received the engineer approval. As considered the welding continuity in the workshop, we directly repaired the defects which caused by the cease-arc, so that the panel fabrication can keep on performing. But not waiting for the CWR report approval for a few days. At the same time we had provided the repair procedure for welding process to government's approval. Then ZPMC can repair any defects in process following that procedure.

Furthermore we also attach the correlative VT and NDT reports which after repair and the final inspection, So that it's can prove those deck panel have reached the special requirements.

So ZPMC considers

NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123 can be closed.

Please reference attached documentation for acceptance and closure the NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123.

ATTACHMENT:

NCR-000069/000070/000078/000114/000095/000098/000097/000115/000118/000084/000123 (ZPMC-0067/0068/0076/0110/0093/0096/0095/0111/0113/0082/0119)

VT and MT reports which in the repair process

FVT and final MT reports for the deck panels

Zhuo Shuangbao

2008.8.28.

Thomas W Lamb
ABF QCM
9 SEPT. 08



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: 16-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-0111

Job Name: SAS Superstructure
Document No: 05.03.06-000092

Reference Description: The Contractor performed repairs on closed rib to box shell weld without receiving prior Engineer approval.

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 repairs for excess porosity in the GMAW root pass on weld number -001 of DP-298-001.

Action Required and/or Action Taken:

This is a recurring issue. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0111

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

File: 05.03.06

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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-000115

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 12-Apr-2008

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

NCR #: ZPMC-011

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: DP-298-001
 Procedural Procedural Descripton: OBG Deck Panel

Reference Description:

Description of Non-Conformance:

The Contractor performed repairs on closed rib to box shell weld without receiving prior Engineer approval.
 The Contractor performed repairs for excess porosity in the GMAW root pass on weld number -001 of DP-298-001.

Applicable reference:

Special Provisions, Section 10-1.59 Steel Structures, Subsection, Welding of Closed Ribs to Box Shell Plate (p. 328): "Repair welding methods and procedures shall be approved by the Engineer."

Who discovered the problem: QA Inspector Steve Hall

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

Time and method of notification: 4/13/08, 2030, verbal via phone

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 4/14/2008, 1415, verbal

QC Inspector's Name: ZPMC QC Inspector Li Yan Hua

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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-659		DATE 日期 2008.04.12	PAGE OF 页码 1/1	Revision No: 0		
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS				
DRAWING NO. 图号: DP298 U-RIB TOP PLATE		CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4				
REFERENCING CODE 参考规范编码: AWS D1.5-2002		ACCEPTANCE STANDARD 接受标准: AWS D1.5-2002		PROCEDURE NO. 程序编号: ZPQC-MT-01		CALIBRATION DUE DATE 仪器校正有效期: Jan. 1 ST , 2009
EQUIPMENT 设备: MT YOKE	MANUFACTURER 制造商: PARKER	MODEL NO. 样式编号: B310S		SERIAL NO. 连续编号: 5395		
MAGNETIZING METHOD 磁化方法: Continuous magnetic yoke 磁轭式连续法		CURRENT 电流: AC				
PARTICLE TYPE 磁粉类型: Dry magnet powder 干磁粉		YOKE SPACING 磁轭间距: 70~150mm				
MATERIAL TO BE EXAMINED 检测材料: <input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造		Material & thickness 母材, 厚度: A709M-345T2-X-S 12/14mm				
WELDING PROCESS 焊接方法: SAW		TYPE OF JOINT 焊缝类型: T-JOINT				
WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
DP298-001-006				ACC.		ROOT PASS
BLANK						
EXAMINED BY 主探: <u>Botianrui</u>				REVIEWED BY 审核: <u>Wangwei</u>		
LEVEL-II SIGN 签名 / DATE 日期 08.04.12				LEVEL-II SIGN / DATE 日期 08.04.12		
质量经理 / QCM				用户 CUSTOMER		
签字 SIGN / 日期 DATE				签字 SIGN / 日期 DATE		

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000092

Subject: NCR No. ZPMC-0111

Dated: 13-Nov-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000119 **Rev:** 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC requests closure of this NCR based on the attached documentation.

ABF has reviewed the CT response with ZPMC. We have come to the conclusion that the CT inspector incorrectly reported the Weld Joint number as WJ-001 when in fact the weld that was repaired is WJ-006. This Panel(DP-296-001) is a 3 rib panel. WJ-001 and WJ-006 are on opposite sides of the panel from one another. We request this NCR be closed as previously submitted which includes attached documentation.

Submitted by:

Attachment(s): ABF-NPR-000119R02

Caltrans' comments:

Status: CLO

Date: 17-Nov-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0111 is closed.

Submitted by: Wright, Doug

Date: 18-Nov-2008

Attachment(s):

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

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Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
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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-000118**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Nov-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0111**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: 12-Apr-2008**Description of Non-Conformance:**

The Contractor performed repairs on closed rib to box shell weld without receiving prior Engineer approval. The Contractor performed repairs for excess porosity in the GMAW root pass on weld number -001 of DP-298-001.

Contractor's proposal to correct the problem:

CT inspector incorrectly reported the Weld Joint number as WJ-001 when in fact the weld that was repaired is WJ-006. This Panel (DP-298-001) is a 3 rib panel. WJ-001 and WJ-006 are on opposite sides of the panel from one another. The Contractor requested this NCR be closed as previously submitted which includes attached documentation.

Corrective action taken:

Documentation in NPR-119R01 was approved by Team China. Closed by Caltrans Construction. METS closed the NCR based on Construction's direction.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:** Stanley Ku and Doug Wright **Date:** 17-Nov-2008**Is Engineer's approval attached?** Yes No Email of concurrence to close NCR is on file.**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 Sang Le, who represents the Office of Structural Materials for your project.

Inspected By: Dautermann, Peter

Quality Assurance Inspector

Reviewed By: Dautermann, Peter

QA Reviewer