

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-000116**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Apr-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0112**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP053-001, DP325-001
Procedural	Procedural	Descriptor:	OBG Deck Panels

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

The Contractor performed welding without providing continuous QC inspection. The Contractor was observed performing tack welding closed ribs to deck plates between 22:00 and 23:20 on 04/11/2008 without a certified welding inspector (CWI) present. This occurred on OBG deck panels DP053-001 and DP325-001.

Applicable reference:

Special Provisions, Section 8-3, Welding, "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 Roscoe Dixon**Name of individual from Contractor notified:** ABFJV QC Inspector Dave LaRue**Time and method of notification:** 2245, 04/11/2008, verbal**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** 1215, 04/14/2008, verbal**QC Inspector's Name:** ZPMC QA Wang Lu**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: 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: 05.03.06-000093

Subject: NCR No. ZPMC-0112

Reference Description: The Contractor performed welding without providing continuous QC inspection.

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 was observed performing tack welding closed ribs to deck plates between 22:00 and 23:20 on 04/11/2008 without a certified welding inspector (CWI) present. This occurred on OBG deck panels DP053-001 and DP325-001.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0112

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: 05.03.06-000093

Subject: NCR No. ZPMC-0112

Dated: 05-Aug-2008

Contract No.: 04-0120F 4
04-SF-80-13.2 / 13.9

Job Name: SAS Superstructure

Document No.: ABF-NPR-000061 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: Additional staff and training has been provided to ensure proper inspection techniques.
Please see attached.

Submitted by: Kanapicki, Charles
Attachment(s): ABF-NPR-000061R00;

Caltrans' comments:

Status: CLO
Date: 07-Aug-2008

The Contractor's response is acceptable. ZPMC has generated an internal NCR to address this issue, and has since added more CWI inspectors to cover the increasing work load. The Department concurs that Non-Conformance ZPMC-0112 is closed.

Submitted by: Wright, Doug
Attachment(s):

Date: 07-Aug-2008

17 July 2008

Reply to: SL-ABF-08-0xxx

Attention: Gary Pursell

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

Subject: NCR# ZPMC-112

Mr. Pursell:

This letter is issued to provide formal response addressing the proposed resolution to the following nonconformance reports:

NCR # ZPMC-0112

The Contractor performed welding without providing continuous QC inspection.

Training has been provided regarding the proper inspection techniques as well as the contract requirements. Additional staffing has been added to insure compliance with the Contract requirements.

If further clarifications are needed, please contact me.

Nate S. Lindell
Quality Assurance Manager
American Bridge Fluor Joint Venture

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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-000059**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Jul-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0112**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: 11-Apr-2008**Description of Non-Conformance:**

The Contractor performed welding without providing continuous QC inspection. The Contractor was observed performing tack welding closed ribs to deck plates between 22:00 and 23:20 on 04/11/2008 without a certified welding inspector (CWI) present. This occurred on OBG deck panels DP053-001 and DP325-001.

Contractor's proposal to correct the problem:

The Contractor acknowledged the non-conformance. The Contractor has generated an internal NCR to address this non-conformance and has since added more CWI inspectors to the staff to cover the increasing work load.

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 Ady Velasco, 011-86-138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Liu, Chengwen **Quality Assurance Inspector****Reviewed By:** Velasco, Abifhram **QA Reviewer**