

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-000121**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Apr-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0117**Type of problem:**

| | | | |
|---------------------|-------------------|--------------------|------------------------------|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: DP-275-001 |
| Procedural | Procedural | Descriptor: | OBG Deck Panel |

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

The Contractor welded over surfaces that do not conform to requirements for weld preparation. The Contractor performed the GMAW root pass of the closed rib to deck plate weld over areas that contained oil on the welded surfaces. This was observed in weld numbers -002 and -005 of deck panel DP-275-001.

See digital photographs below.

**Applicable reference:**

AWS D1.5, Section 3.2.1: "Surfaces and edges to be welded shall be smooth, uniform, and free from fins, tears, cracks, and other discontinuities which would adversely affect the quality or strength of the weld. Surfaces to be welded and surfaces adjacent to a weld shall also be free from loose or thick scale, slag, rust, moisture, grease, and other foreign material that would prevent proper welding or produce objectionable fumes."

Who discovered the problem: Quality Assurance (QA) Alfredo Acuna**Name of individual from Contractor notified:** ABFJV QC Inspector Art Peterson**Time and method of notification:** 4-17-2008 at 0845 and 1300 verbal notification.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of Caltrans Engineer notified: Sean Eagan

Time and method of notification: 04-18-2008 at 1100, verbal

QC Inspector's Name: ZPMC QC Inspectors Sun Wei and Lay Ta

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: 22-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: 05.03.06-000098

Subject: NCR No. ZPMC-0117

Reference Description: The Contractor welded over surfaces that do not conform to requirements for weld preparation.

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 the GMAW root pass of the closed rib to deck plate weld over areas that contained oil on the welded surfaces. This was observed in weld numbers -002 and -005 of deck panel DP-275-001.

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-0117

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: 05.03.06-000098

Subject: NCR No. ZPMC-0117

Dated: 10-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000121 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC QA/QC acknowledge that welding over oil contamination is unacceptable and have notified the CWI's and production personnel to strictly avoid this recurrence as it leads to welding defects.

ZPMC QA/QC acknowledge that welding over oil contamination is unacceptable and have notified the CWI's and production personnel to strictly avoid this recurrence as it leads to welding defects.

Submitted by: Mackey, Kim

Attachment(s): ABF-NPR-000121R00

Caltrans' comments:

Status: CLO

Date: 14-Sep-2008

The Contractor's response is acceptable. The area of the root pass in question was inspected, and this issue has not been observed since. The Department concurs that Non-Conformance ZPMC-0117 is closed.

Submitted by: Wright, Doug

Attachment(s):

Date: 14-Sep-2008

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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-000051**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Jun-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0117**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: 17-Apr-2008**Description of Non-Conformance:**

The Contractor welded over surfaces that do not conform to requirements for weld preparation. The Contractor performed the GMAW root pass of the closed rib to deck plate weld over areas that contained oil on the welded surfaces. This was observed in weld numbers -002 and -005 of deck panel DP-275-001.

See digital photographs below.

Contractor's proposal to correct the problem:

The same problem has not been observed since then. 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: Velasco, Abifhram

QA Reviewer