

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-000126**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Apr-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0120**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 3BE
Procedural	Procedural	Descriptor:	OBG Box Girder Segment

Reference Description: Standard Specifications, 5-1.02 Plans and Working Drawings**Description of Non-Conformance:**

The Contractor performed fabrication without approved working drawings. The Contractor started assembly of OBG box girder segment without an approved Dimensional Verification Procedure. This incident was noted when it was observed that box girder segment bottom subassembly 3BE-D6 was tack welded to the OBG segment assembly jigs and fixtures.

Applicable reference:

Standard Specifications, 5-1.02 Plans and Working Drawings (p. 23): "Working drawings shall be approved by the Engineer before any work involving the drawings is performed."

Special Provisions, 10-1.59 Steel Structures, Fabrication (pp. 312, 313): "The Contractor shall submit to the Engineer for approval in accordance with the requirements in 'Working Drawings' of these special provisions, written, detailed procedures for the fabrication and erection of the complex assemblies listed below....

C. Box Girder Segment".

Special Provisions, 10-1.59 Steel Structures, Fabrication (p. 312): "Fabrication procedures shall verify the inspectability of welds, include inspection holds points, and reference the dimensional verification procedures, specified elsewhere in these special provisions."

State Letter No. 05.03.01-001681, Submittal 572 - Dimensional Verification Procedures - General & OBG, dated Apr. 3, 2008: "This submittal is 'Returned for Correction'...."

Who discovered the problem: QA Inspector Dave McClary**Name of individual from Contractor notified:** ABFJV QC Inspectors Dave Williams, Steve Lawton**Time and method of notification:** Verbal notification at 08:45 on 04-28-2008**Name of Caltrans Engineer notified:** Ching Chao**Time and method of notification:** Verbal notification at 08:30 on 04-28-2008**QC Inspector's Name:** NA**Was QC Inspector aware of the problem:**

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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	SMR
Reviewed By:	Lowry,Patrick	SMR



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: 30-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: 05.03.06-000101

Subject: NCR No. ZPMC-0120

Reference Description: Standard Specifications, 5-1.02 Plans and Working Drawings

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:** 03

Remarks:

The Contractor started assembly of OBG box girder segment 3BE by tack welding bottom subassembly 3BE-D6 to the OBG assembly jigs and fixtures without an approved Dimensional Verification Plan.
Please refer to the attached NCR #ZPMC-120 for details.

Action Required and/or Action Taken:

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

Transmitted by: Ching Chao

Attachments: ZPMC-0120

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, 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: 05.03.06-000101

Subject: NCR No. ZPMC-0120

Dated: 10-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000124 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC/ABF are jointly performing dimensional verification during the fabrication of segment assembly

ZPMC proceeded with segment assembly, as at this point the segment assembly is at an in-process stage of fabrication and ZPMC's position is that dimensional verification is for a completed segment, however, that does not mean that dimensional verification is not taking place, to the contrary, ZPMC/ABF are jointly performing dimensional verification during the fabrication of segment assembly

Submitted by:

Attachment(s): ABF-NPR-000124R00

Caltrans' comments:

Status: CLO

Date: 28-Dec-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0120 is closed. For a more detailed response, refer to State Letter 05.03.08-000010 dated December 24, 2008.

Submitted by: Wright, Doug

Date: 28-Dec-2008

Attachment(s):

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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-000181**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Feb-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0120**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: 28-Apr-2008**Description of Non-Conformance:**

The Contractor performed fabrication without approved working drawings. The Contractor started assembly of OBG box girder segment without an approved Dimensional Verification Procedure. This incident was noted when it was observed that box girder segment bottom subassembly 3BE-D6 was tack welded to the OBG segment assembly jigs and fixtures.

Contractor's proposal to correct the problem:

According to NPR 124: "ZPMC proceeded with segment assembly, as at this point the segment assembly is at an in-process stage of fabrication and ZPMC's position is that dimensional verification is for a completed segment, however, that does not mean that dimensional verification is not taking place, to the contrary, ZPMC/ABF are jointly performing dimensional verification during the fabrication of segment assembly."

Corrective action taken:

ZPMC/ABF are jointly performing dimensional verification during the fabrication of segment assembly. ABF/ZPMC follow the dimensional control plan in meeting the in-process fabrication tolerances.

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 Eric Tsang, 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer