

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 #: 04-0120F4
 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-000128

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 06-May-2008

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

NCR #: ZPMC-0122

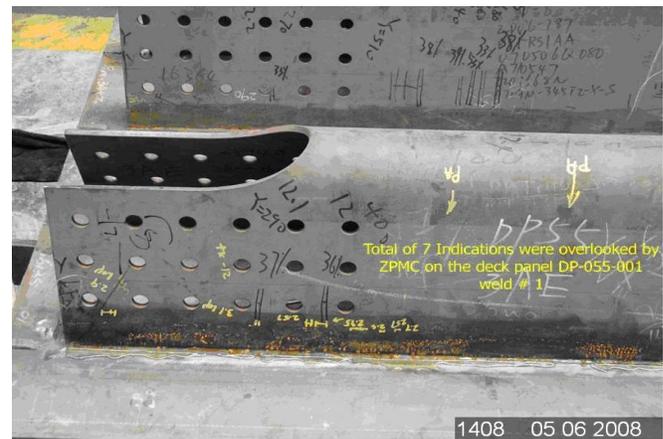
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Changxing Island, Shanghai, PRC
Procedural	Procedural	Descriptor: OBG Deck Panel	

Reference Description: Special Provisions, Sec. 10-1.59 Steel Structures, Welding of Closed Ribs to Box Shell Plate (p. 328):

Description of Non-Conformance:

The Contractor missed rejectable indications while performing UT. The Contractor did not identify areas of closed rib to box shell plate partial joint penetration (PJP) groove welds that have a depth of penetration less than 80% of the rib thickness. There are seven (7) areas on deck panel DP-055-001 that have an accumulative length of 131mm that have depth of penetration of less than 80%. This occurred on weld joint #001 of DP-055-001.



Applicable reference:

Special Provisions, Sec. 10-1.59 Steel Structures, Welding of Closed Ribs to Box Shell Plate (p. 328):

"Welding of closed ribs to box shell plates shall be accomplished with a welding process and procedure that achieves a minimum of 80% penetration of the nominal rib thickness."

Who discovered the problem: Quality Assurance (QA) Inspector Alfredo Acuna

Name of individual from Contractor notified: ABFJV QC Inspector Warren Buehler

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 5-06-2008, by phone conversation

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 12:44, 5-08-2008, in person

QC Inspector's Name: ZPMC QC Inspectors Shen Xu Jun and Li Li Ming

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	SMR
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Reviewed By:	Lowry,Patrick	SMR
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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: 13-May-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: 05.03.06-000104

Subject: NCR No. ZPMC-0122

Reference Description: Special Provisions, Sec. 10-1.59 Steel Structures, Welding of Closed Ribs to Box Shell Plate (p. 328):

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.

Material Location: OBG **Lift:**

Remarks:

The Contractor missed rejectable indications while performing UT. The Contractor did not identify areas of closed rib to box shell plate partial joint penetration (PJP) groove welds that have a depth of penetration less than 80% of the rib thickness. There are seven (7) areas on deck panel DP-055-001 that have an accumulative length of 131mm that have depth of penetration of less than 80%. This occurred on weld joint #001 of DP-055-001.

Action Required and/or Action Taken:

Please propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0122

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: 05.03.06-000104

Subject: NCR No. ZPMC-0122

Dated: 10-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000125 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: Since this time there has been several meetings with ZPMC to discuss the acceptance criteria relative to UT on the deck panels and the criteria is now understood.

At the time of this NCR, ZPMC was interpreting the specifications to mean any Depth of Penetration less than 70% is unacceptable. Since this time there has been several meetings with ZPMC to discuss the acceptance criteria relative to UT on the deck panels and the criteria is now understood.

Submitted by:

Attachment(s): ABF-NPR-000125R00

Caltrans' comments:

Status: CLO

Date: 26-Sep-2008

The resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0122 is closed.

Submitted by: Wright, Doug

Date: 26-Sep-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-000076**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0122**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: 06-May-2008**Description of Non-Conformance:**

The Contractor missed rejectable indications while performing UT. The Contractor did not identify areas of closed rib to box shell plate partial joint penetration (PJP) groove welds that have a depth of penetration less than 80% of the rib thickness. There are seven (7) areas on deck panel DP-055-001 that have an accumulative length of 131mm that have depth of penetration of less than 80%. This occurred on weld joint #001 of DP-055-001.

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

At the time of this NCR, ZPMC was interpreting the specifications to mean any Depth of Penetration less than 70% is unacceptable. Since this time there has been several meetings with ZPMC to discuss the acceptance criteria relative to UT on the deck panels and the criteria is now understood.

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