

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



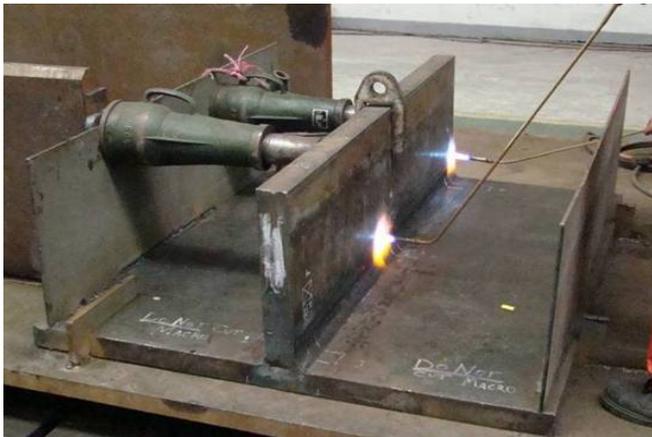
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000143**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Jun-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0136**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Partial Mockup, PMU77-01
Procedural	Procedural	Descriptor:	Stiffener to Skin Partial Mockup (PMU77-01)

Reference Description: 04-0120F4, Special Provisions**Description of Non-Conformance:**

The Contractor has allowed ZPMC to perform heat straightening the 70mm stiffener plate of the Stiffener to Skin Partial Mockup (PMU77-01) without the Engineer's approval. The stiffener was tilted 25mm from the vertical position and ZPMC used hand held torches and two bottle jacks to apply active force and push the stiffener into alignment. This procedure was not approved by the Engineer.

**Applicable reference:**

Special Provisions, Section 8-3, Welding Quality Control, pg. 154 "For material more than 16 mm, the Contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer."

Who discovered the problem: Joshua Ishibashi, Structural Materials Representative**Name of individual from Contractor notified:** Mike Williams, ABF Quality Control Inspector**Time and method of notification:** 6/11/08, 1000, Verbal notification/Present at the time of incident**Name of Caltrans Engineer notified:** Scott Kennedy, Structure Representative**Time and method of notification:** 6/11/08, 1000, Verbal/Present at time of incident

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: None

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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 Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Wahbeh,Mazen

SMR

Reviewed By: Wahbeh,Mazen

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 17-Jun-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: 05.03.06-000119

Subject: NCR No. ZPMC-0136

Reference Description: 04-0120F4, Special Provisions / Revised Partial Mockup (PMU77-01)

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: Tower **Lift:**

Remarks:

The Contractor has allowed ZPMC to perform heat straightening the 70mm stiffener plate of the Stiffener to Skin Partial Mockup (PMU77-01) without the Engineer's approval. The stiffener was tilted 25mm from the vertical position and ZPMC used hand held torches and two bottle jacks to apply active force and push the stiffener into alignment. This procedure was not approved by the Engineer.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to ensure heat straightening that requires the Engineer's approval does not occur prior to the submission to and approval by the Engineer of the procedures to be utilized. In addition, provide documentation of the steps taken by the welding Quality Control Manager to prevent future occurrences.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0136

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000119

Subject: NCR No. ZPMC-0136

Dated: 18-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000070 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The fabricator acknowledges that this requirement technique of heat straightening should have required Engineers approval before and has informed the worker team that ZPMC will submit an HSR.

Please see attached.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000070R00;

Caltrans' comments:

Status: CLO

Date: 22-Aug-2008

Macros were cut from of the weld in question, and were found to be acceptable. The Department concurs that Non-Conformance ZPMC-0136 is closed.

On future proposed resolutions of Non-Conformances for heat straightening without approval of the Engineer, please provide Non-Destructive test reports showing the soundness of the welds in question.

Submitted by: Wright, Doug

Attachment(s):

Date: 22-Aug-2008

DEPARTMENT OF TRANSPORTATION
 CHINA FABRICATION TEAM
 506 Shangcheng Rd., Pudong New District
 Shanghai 200120, PRC



REVIEW OF CONTRACTOR'S TRANSMITTAL

To: Dave Williams, American Bridge – Fluor, a Joint Venture
Gary Pursell, Resident Engineer

Review Date: 08/04/2008

From: Joshua Ishibashi, Structural Materials Representative

Contract No.: 04-0120F4

Date/Time Submittal Recieved: 07/25/2008/ 1325

China Standard Time
 (GMT+08:00)

Contractor's Transmittal #: TL-08-1566 Rev. # 0

<input type="checkbox"/>	substantially complies with contract requirements and is approved		
<input checked="" type="checkbox"/>	substantially complies with contract requirements and is approved as noted.		
<input type="checkbox"/>	Lacks sufficient information and/or contains unacceptable items that must be corrected or prior to resubmital		
Verbal Notification	<input checked="" type="checkbox"/> No	<input type="checkbox"/> Yes	Date: _____ Time: _____
Name of individual from Contractor Notified:			
This submittal is a:	<input type="checkbox"/> Welding Report	<input type="checkbox"/> Critical Weld Repair	
	<input type="checkbox"/> Request for Information	<input type="checkbox"/> Heat Straightening Request	
	<input type="checkbox"/> Fabrication Procedures	<input checked="" type="checkbox"/> Other: NCR Resolution	
Submitting Contractor: <u>ZPMC</u>			

ITEMS REVIEWED	COMPLIES		COMMENTS
1. Serial Letter ABF-SL-08-0129	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	Response to NCR #ZPMC-0136
2.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	
3.	<input type="checkbox"/> Yes	<input type="checkbox"/> No	

Remarks: METS recommends that ABF-TRN-TL-08-1566 be approved. The Contractor is reminded that they must submit a heat straightening request when "For material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer. For material more than 16 mm, the Contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer." as stated in the Special Provisions. Also in this case per AWS D1.5 2002, Section 3.7.3 "Members distorted by welding shall be straightened by mechanical means or by carefully supervised applications of a limited amount of localized heat as approved by the Engineer." If heat straightening and mechanical forces are done without the Engineer's approval again, non destructive testing reports should be submitted to prove the soundness of the weld.

JJI

Reviewer: Joshua Ishibashi

Date: 08/04/2008

Construction Concurrence: Initials DLW Date 2008-08-05

Received by (ABFJV): PZ Date 8/5/08 Time 1430

25 July 2008

Reply to: SL-ABF-08-0129

Attention: Gary Pursell

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

Subject: NCR# ZPMC-0136

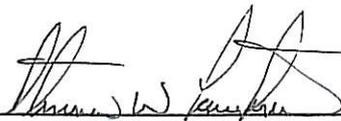
Mr. Pursell:

This letter is issued to provide formal response addressing the proposed resolution to NCR # ZPMC-0136.

The Contractor has allowed ZPMC to perform heat straightening the 70mm stiffener plate of the stiffener to Skin Partial Mockup (PMU77-01) without the Engineer's approval. The stiffener was tilted 25mm from the vertical position and ZPMC used hand held torches and two bottle jacks to apply active force and push the stiffener into alignment. This procedure was not approved by the Engineer.

The fabricator acknowledges that this requirement technique of heat straightening should have required Engineers approval before and has informed the worker team that ZPMC will submit an HSR for those deformations exceeding the heat straightening guide.

If further clarifications are needed, please contact me.

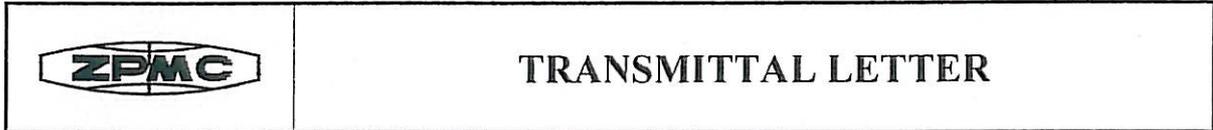


Steve Lawton
Foreign Quality Assurance Manager
American Bridge Fluor Joint Venture

<input checked="" type="checkbox"/> APPROVED
<input type="checkbox"/> APPROVED AS NOTED
<input type="checkbox"/> RETURNED FOR CORRECTION
Pursuant to Section 5-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION
Division of Engineering Service
Office of Structure Construction

Structure Representative

DLW for RM 2008-08-05



PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 07/09/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000143(ZPMC-0136)FOR CLOSURE

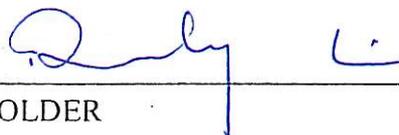
SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.T-016FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000143(ZPMC-0136).

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



 PLAN HOLDER

RECEIVED 09 JUL 2008
 143

 DATE



COMPANY

PHONE NO.

PLAN NUMBER: N/A
 #R787-QCP-102

<input checked="" type="checkbox"/>	APPROVED
<input type="checkbox"/>	APPROVED AS NOTED
<input type="checkbox"/>	RETURNED FOR CORRECTION
Pursuant to Section 5-1.02	
of the Standard Specifications	
State of California	
DEPARTMENT OF TRANSPORTATION	
Division of Engineering Service	
Office of Structure Construction	
Structure Representative	Date

DW for RM 2008-08-05



No. T-016

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-7-9

REGARDING: NCR-000143 (ZPMC-0136)

ZPMC received Caltrans' NCR-000143 on 8-July-2008, it mentioned ZPMC performed heat straightening the 70mm stiffener plate of the stiffener to skin partial mock up (PMU77-01) without the engineer's approval.

ZPMC acknowledged this problem. Due to the first time experienced such separate partial mock up, the worker team did not know the requirement well. But ZPMC QA and QC personnel had infused them with the requirement that should be followed as the real productions', which is that ZPMC will submit the HSR for those deformations exceeding the heat straightening guide to let engineer review included the partial mock up. For another hand, ZPMC had heat-straightened the stiffener to requirement and the PMU77-01 partial mock up macro test had been accepted by Caltrans.

So ZPMC requests Caltrans can close NCR-000143 and hopes Caltrans can issue out the NCR as soon as possible so as to make ZPMC take the correction in time.

ATTACHMENT:

NCR-000143 (ZPMC-0136)

Xujun

2008-7-9

<input checked="" type="checkbox"/> APPROVED	
<input type="checkbox"/> APPROVED AS NOTED	
<input type="checkbox"/> RETURNED FOR CORRECTION	
Pursuant to Section 5-1.02 of the Standard Specifications State of California	
DEPARTMENT OF TRANSPORTATION Division of Engineering Service Office of Structure Construction	
Structure Representative	Date
<i>DLW for RM</i>	<i>2008-08-05</i>

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000063**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0136**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-Jun-2008**Description of Non-Conformance:**

The Contractor has allowed ZPMC to perform heat straightening the 70mm stiffener plate of the Stiffener to Skin Partial Mockup (PMU77-01) without the Engineer's approval. The stiffener was tilted 25mm from the vertical position and ZPMC used hand held torches and two bottle jacks to apply active force and push the stiffener into alignment. This procedure was not approved by the Engineer.

Contractor's proposal to correct the problem:

The Contractor and Fabricator acknowledge that there is a requirement to request Engineer approval before heat straightening of deformations exceeding the tolerances specified in the Special Provisions.

Corrective action taken:

The affected welds were subsequently tested using destructive and non destructive testing and found to be acceptable. The Department acknowledges the Contractors admission that the heat straightening was done without the Engineer's approval.

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 Joshua Ishibashi (011-08-13764710411), who represents the Office of Structural Materials for your project.

Inspected By: Ishibashi, Josh

Quality Assurance Inspector

Reviewed By: Ishibashi, Josh

QA Reviewer