

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-000146**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Jun-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0138**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Various SSD joints
Procedural	Procedural	Descriptor:	Floorbeam Diagonal Support Connection Plates to FL

Reference Description: Floorbeam Diagonal Support Undersized Welds**Description of Non-Conformance:**

The Contractor's Quality Control accepted welds that do not conform to approved shop drawings. Fillet welds between floorbeam diagonal support connection plates and horizontal flange plate were undersized by 3 - 5mm for approximately 70 - 100% of the weld lengths. This was observed in 6 different locations on various floorbeams.

**Applicable reference:**

AWS D1.5, Section 6.26.1.7: "A fillet weld in any single continuous weld may underrun the nominal fillet weld size specified by 2 mm [1/16 in.] without correction, provided that the undersize portion of the weld does not exceed 10 percent of the length of the weld."

Who discovered the problem: Quality Assurance(QA), Alfredo Acuna**Name of individual from Contractor notified:** ABF representative, Peter Shaw**Time and method of notification:** 1430, June 06-2008, verbal notification**Name of Caltrans Engineer notified:** Ching Chao

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 06-09-2008 at 1425 hours, verbal

QC Inspector's Name: ZPMC Fu Yu Hong. verbal notification

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

Inspected By:	Velasco,Abifhiram	SMR
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Reviewed By:	Wahbeh,Mazen	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, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 19-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: 05.03.06-000121

Subject: NCR No. ZPMC-0138

Reference Description: Floorbeam Diagonal Support Undersized Welds

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's Quality Control accepted welds that do not conform to approved shop drawings. Fillet welds between floorbeam diagonal support connection plates and horizontal flange plate were undersized by 3 - 5mm for approximately 70 - 100% of the weld lengths. This was observed in 6 different locations on various floorbeams.

Action Required and/or Action Taken:

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

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0138

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: 05.03.06-000121

Subject: NCR No. ZPMC-0138

Dated: 10-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000133 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been instructed by ABF QA personnel on measurement techniques for this skewed joint design.

ZPMC did not measure these fillet welds correctly, undersize fillet welds will require additional weld, as well as visual and NDT of the welds as required in the contract. ZPMC has been instructed by ABF QA personnel on measurement techniques for this skewed joint design.

Submitted by:

Attachment(s): ABF-NPR-000133R00

Caltrans' comments:

Status: CLO

Date: 29-Sep-2008

The Contractor's response is acceptable. ZPMC has been instructed on measurement techniques for this skewed joint design, and this has no longer been an issue. The Department concurs that Non-Conformance ZPMC-0138 is closed.

Submitted by: Wright, Doug

Date: 29-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-000078**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0138**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-Jun-2008**Description of Non-Conformance:**

The Contractor's Quality Control accepted welds that do not conform to approved shop drawings. Fillet welds between floorbeam diagonal support connection plates and horizontal flange plate were undersized by 3 - 5mm for approximately 70 - 100% of the weld lengths. This was observed in 6 different locations on various floorbeams.

Contractor's proposal to correct the problem:

The Contractor acknowledged ZPMC did not measure these fillet welds correctly, undersized fillet welds will require additional weld, as well as visual and NDT of the welds as required in the contract.

Corrective action taken:

ZPMC has been instructed by ABF QA personnel on measurement techniques for this skewed joint design.

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, Abifhiram

QA Reviewer