

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-000153

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 25-Jun-2008

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

NCR #: ZPMC-0144

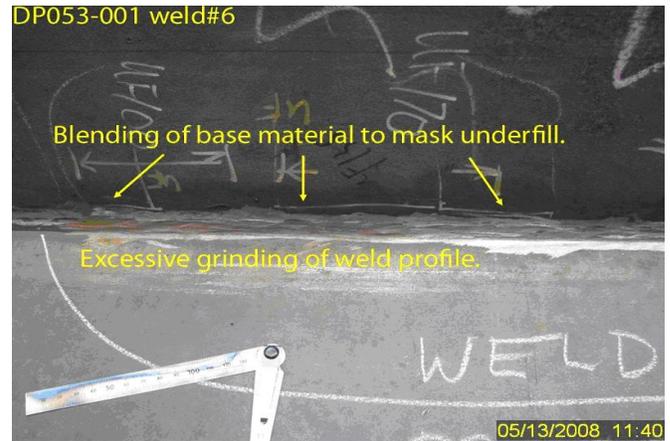
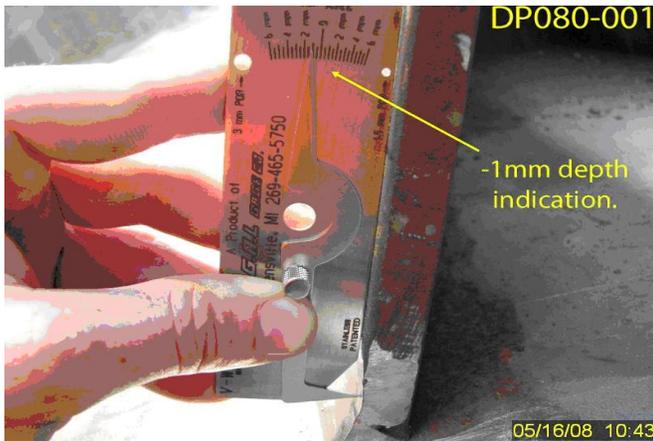
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Various Deck Panels
Procedural	Procedural	Descriptor: OBG Deck Panels	

Reference Description: Improper Underfill Repair

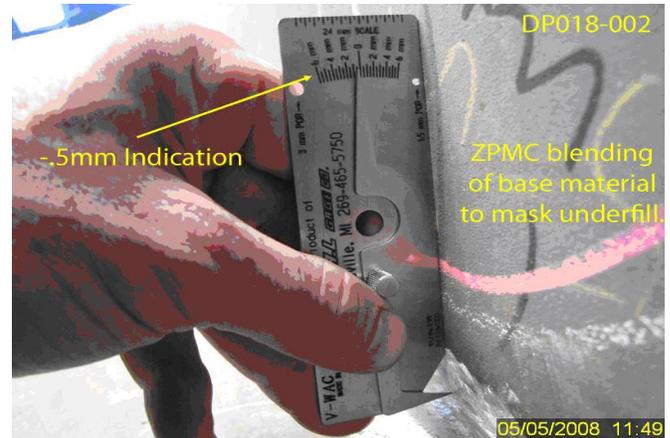
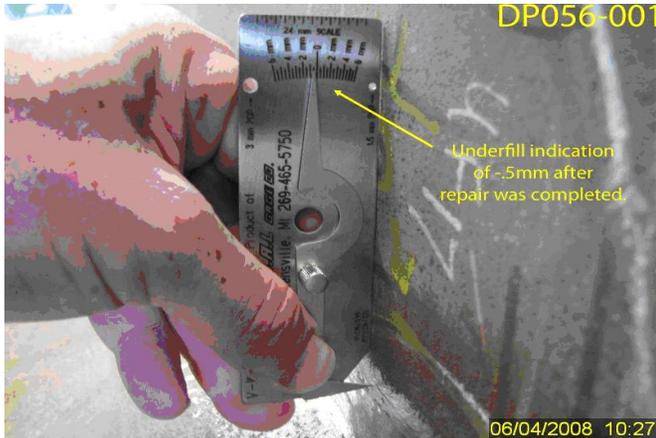
Description of Non-Conformance:

The Contractor performed weld repairs using unapproved procedures. On multiple occasions, the Contractor was observed grinding OBG closed rib base metal to mask areas of underfill. Approved closed rib weld repair procedures require that underfill be repaired with deposition of additional weld metal prior to grinding. This was observed in various deck panels undergoing repairs.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

ABF-SUB-000634R01, Repair Procedure for Closed Rib Welds, steps 2.2 - 2.2.5.

Who discovered the problem: QA Inspector William Clifford

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

Time and method of notification: 13:45 by phone

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: verbal notification on 06-26-2008

QC Inspector's Name: ZPMC QC Inspector Wang Sei Fa

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 Abifhram Velasco, +86-138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Velasco, Abifhram

SMR

Reviewed By: Velasco, Abifhram

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, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 03-Jul-2008

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Dave Williams Consultant
Subject: NCR No. ZPMC-0144

Job Name: SAS Superstructure
Document No: 05.03.06-000127

Reference Description: Improper Underfill Repair

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 performed weld repairs using unapproved procedures. On multiple occasions, the Contractor was observed grinding OBG closed rib base metal to mask areas of underfill. Approved closed rib weld repair procedures require that underfill be repaired with deposition of additional weld metal prior to grinding. This was observed in various deck panels undergoing repairs.

Action Required and/or Action Taken:

A response for the resolution of this issue is expected within 14 days.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0144

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: 05.03.06-000127

Subject: NCR No. ZPMC-0144

Dated: 11-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000156 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been notified that grinding of undercut for repair does not conform to the approved external weld repair procedure and shall be repaired per the external weld repair procedure.

ZPMC has been notified that grinding of undercut for repair does not conform to the approved external weld repair procedure and shall be repaired per the external weld repair procedure. Please note that the instrument used in measuring undercut is only indicated in 1mm increments and cannot be a 100% accurate measurement, but an estimate of some measurement over .25mm in depth. The picture in the NCR only states <1mm.

Submitted by:

Attachment(s): ABF-NPR-000156R00

Caltrans' comments:

Status: CLO

Date: 01-Oct-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0144 is closed.

Submitted by: Wright, Doug

Date: 01-Oct-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-000084**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0144**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: 25-Jun-2008**Description of Non-Conformance:**

The Contractor performed weld repairs using unapproved procedures. On multiple occasions, the Contractor was observed grinding OBG closed rib base metal to mask areas of underfill. Approved closed rib weld repair procedures require that underfill be repaired with deposition of additional weld metal prior to grinding. This was observed in various deck panels undergoing repairs.

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

ZPMC has been notified that grinding of undercut for repair does not conform to the approved external weld repair procedure and shall be repaired per the external weld repair procedure.

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