

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-000154**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-May-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0145**Type of problem:**

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

Reference Description: Segment 3BE FB Wrapped Fillet Weld to SP and BP**Description of Non-Conformance:**

The Contractor performed welding that does not conform to approved working drawings. The Contractor welded wraparound fillet welds to join OBG floorbeam web plates to the side and bottom panels. Approved shop drawings do not detail weld all around at these locations. This occurred at weld joint numbers 065 through 104 and 107 through 124 of at panel point 23 of SEG 3BE. See attached photos.

**Applicable reference:**

Shop Drawing, Segment Assembly Standard Sections, Sheet No. SEGSD16, approved 03-24-2008.

Who discovered the problem: QA Inspector Mahlon Lindenmuth**Name of individual from Contractor notified:** ABFJV QC Inspector Mr. Art Peterson**Time and method of notification:** 1600 / Verbal**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** 5/30/08 at 1430 verbally**QC Inspector's Name:** ZPMC QC Inspector Chen chih meng / 1030 hrs

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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

Inspected By:	Velasco,Abifhiram	SMR
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Reviewed By:	Velasco,Abifhiram	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: 03-Jul-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: 05.03.06-000128

Subject: NCR No. ZPMC-0145

Reference Description: Segment 3BE FB Wrapped Fillet Weld to SP and BP

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 welding that does not conform to approved working drawings. The Contractor welded wraparound fillet welds to join OBG floorbeam web plates to the side and bottom panels. Approved shop drawings do not detail weld all around at these locations. This occurred at weld joint numbers 065 through 104 and 107 through 124 of at panel point 23 of SEG 3BE.

Action Required and/or Action Taken:

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

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0145

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: 05.03.06-000128

Subject: NCR No. ZPMC-0145

Dated: 11-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000157 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is has issued an RFI to allow for wrap around fillet welds in this case. Questions of corrosion resistance are the issue.

ZPMC is has issued an RFI to allow for wrap around fillet welds in this case. Questions of corrosion resistance are the issue.

Submitted by:

Attachment(s): ABF-NPR-000157R00

Caltrans' comments:

Status: AAP

Date: 01-Oct-2008

The response is acceptable, but the Non-Conformance is not closed.

Please resubmit the proposed resolution when the RFI to request approval for wrap around weld is resolved. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0145 at that time.

Submitted by: Wright, Doug

Date: 01-Oct-2008

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000128

Subject: NCR No. ZPMC-0145

Dated: 11-Mar-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000157 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has issued RFI 1650 to allow for wrap around fillet welds in this case. This RFI has been accepted. ZPMC request closure of this NCR ZPMC-0145.

ZPMC has issued RFI 1650 to allow for wrap around fillet welds in this case. This RFI has been accepted. ZPMC request closure of this NCR ZPMC-0145.

Submitted by:

Attachment(s): ABF-NPR-000157R01

Caltrans' comments:

Status: CLO

Date: 17-Mar-2009

The proposed resolution is acceptable. The Request for Information (RFI-1650) regarding the wrapping of these fillet welds was accepted. The Department concurs that Non-Conformance ZPMC-0145 is closed.

Submitted by: Wright, Doug

Date: 17-Mar-2009

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-000208**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0145**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 29-May-2008**Description of Non-Conformance:**

The Contractor performed welding that does not conform to approved working drawings. The Contractor welded wraparound fillet welds to join OBG floorbeam web plates to the side and bottom panels. Approved shop drawings do not detail weld all around at these locations. This occurred at weld joint numbers 065 through 104 and 107 through 124 of at panel point 23 of SEG 3BE. See attached photos.

Contractor's proposal to correct the problem:

ZPMC has issued RFI 1650 to allow for wrap around fillet welds in this case. This RFI has been accepted.

Corrective action taken:

Per RFI 1650, the welds are acceptable.

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, +(86) 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**