

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-000164**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Jul-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0151**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: DP055-001, DP067-001, DP015-001
Procedural	Procedural	Descriptor:	OBG Deck Panels

Reference Description: Unapproved Closed Rib UT Repairs**Description of Non-Conformance:**

The Contractor performed weld repairs without prior Engineer approval. The Contractor performed internal weld repairs for the lack of penetration (LOP) of OBG deck panel closed rib welds. The Contractor has not satisfied the Engineer's request to demonstrate repair of LOP prior to performing the repairs. This incident happened on deck panels DP055-001, DP067-001 and DP015-001. See photograph for more detail:

**Applicable reference:**

State Letter 05.03.01-001889, Submittal 634, Rev. 2 - Repair Procedure for Closed-Rib Welds, dated 07-May-2008.

State Letter 05.03.08-000005, Submittal 634, Rev. 2 - Internal Weld Repair Demonstration, dated 26-Jun-2008.

Who discovered the problem: Quality Assurance(QA), Roscoe Dixon**Name of individual from Contractor notified:** ABFJV QC Inspector Warren Buehler**Time and method of notification:** 1705**Name of Caltrans Engineer notified:** Stanley Ku

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: Verbal notification at 07:30 on 07-08-2008

QC Inspector's Name: ZPMC QC Inspector Tao Ley

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, +86-183-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Velasco,Abifhram	SMR
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Reviewed By:	Velasco,Abifhram	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: 12-Aug-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: 05.03.06-000140

Subject: NCR No. ZPMC-0151

Reference Description: Unapproved Closed Rib UT Repairs

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:** N/A

Remarks:

The Contractor performed weld repairs without prior Engineer approval. The Contractor performed internal weld repairs for the lack of penetration (LOP) of OBG deck panel closed rib welds. The Contractor has not satisfied the Engineer's request to demonstrate repair of LOP prior to performing the repairs. This incident happened on deck panels DP055-001, DP067-001 and DP015-001.

See attached NCR #ZPMC-0151 for details.

Action Required and/or Action Taken:

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

Transmitted by: Ching Chao

Attachments: ZPMC-0151

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, 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: 05.03.06-000140

Subject: NCR No. ZPMC-0151

Dated: 11-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000141 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC takes exception to this NCR as written. The repair procedure was returned as "Approved As Noted", therefore ABF released the procedure to ZPMC for repairs to take place.

ZPMC takes exception to this NCR as written. The NCR states, weld repairs were performed without prior Engineer approval, when in fact the repair procedure was returned as ~~Approved As Noted~~, therefore ABF released the procedure to ZPMC for repairs to take place.

Submitted by:

Attachment(s): ABF-NPR-000141R00

Caltrans' comments:

Status: CLO

Date: 01-Oct-2008

The proposed resolution is acceptable. State letter 05.03.01-002458 confirmed that the combination of demonstrations held on May 21, 2008 and June 11, 2008 fulfills the requirement stated in Submittal ABF-SUB-000634R02. The Department concurs that Non-Conformance ZPMC-0151 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-000082**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0151**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: 07-Jul-2008**Description of Non-Conformance:**

The Contractor performed weld repairs without prior Engineer approval. The Contractor performed internal weld repairs for the lack of penetration (LOP) of OBG deck panel closed rib welds. The Contractor has not satisfied the Engineer's request to demonstrate repair of LOP prior to performing the repairs. This incident happened on deck panels DP055-001, DP067-001 and DP015-001. See photograph for more detail:

Contractor's proposal to correct the problem:

The repair procedure (ABF-SUB-000634R02) was Approved As Noted. The combination of demonstrations held on May 21, 2008 and June 11, 2008 fulfilled the requirement stated in Submittal ABF-SUB-000634R02.

Corrective action taken:

N/A

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