

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-000170**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Jul-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0154**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: EP-004A
Procedural	Procedural	Descriptor: OBG Edge Panel	

Reference Description: Unapproved Heat Straightening EP-004A**Description of Non-Conformance:**

The Contractor performed straightening using methods that have not been approved by the Engineer. The Contractor performed heat straightening on OBG edge panel EP-004A by blocking up one end of the panel and applying additional mechanical force during heating. This method was not previously approved in the WQCP. For more information, please see the attached picture below.

**Applicable reference:**

ZPMC WQCP Section 11.

Who discovered the problem: Caltrans Quality Assurance Inspector, Steve Hall**Name of individual from Contractor notified:** ABF Quality Control, David LaRue**Time and method of notification:** 7/28/08 // 18:30 // verbal**Name of Caltrans Engineer notified:** Ching Chao**Time and method of notification:** Verbal notification at 08:00 on 07-29-2008**QC Inspector's Name:** ZPMC Quality Control, Lei Tao

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 Abifhram Velasco, 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: 13-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: 05.03.06-000144

Subject: NCR No. ZPMC-0154

Reference Description: Unapproved Heat Straightening EP-004A

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 straightening using methods that have not been approved by the Engineer. The Contractor performed heat straightening on OBG edge panel EP-004A by blocking up one end of the panel and applying additional mechanical force during heating. This method was not previously approved in the WQCP. See attached NCR #ZPMC-0154 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-0154

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, 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: 05.03.06-000144

Subject: NCR No. ZPMC-0154

Dated: 11-Sep-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000144 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has provided instructions to ZPMC that when building up weld preparations on SPCM material, to do so in accordance with Section 12 paragraph 12.17.2 (7).

ZPMC performed weld build up on SPCM material without Engineers approval which is in violation of contract requirements. Discussions with ZPMC revealed they mis-interpreted the code using section 3 when ZPMC should have used section 12. ABF has provided instructions to ZPMC that when building up weld preparations on SPCM material, to do so in accordance with Section 12 paragraph 12.17.2 (7).

Submitted by:

Attachment(s): ABF-NPR-000144R00

Caltrans' comments:

Status: REJ

Date: 01-Oct-2008

This proposed resolution about SPCM material weld build-up does not address the issue in the referenced Non-Conformance ZPMC-0154, which was issued for unapproved heat straightening.

For NCR ZPMC-0154 dealing with unapproved heat straightening, please provide documentation of dimensional checks performed to identify the requirement for straightening, provide documentation of the repairs performed, and confirm that the distortion has been corrected to within acceptable dimensional tolerances.

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: 05.03.06-000144

Subject: NCR No. ZPMC-0154

Dated: 18-Nov-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000144 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC requests closure of this NCR based on the attached documentation.

Please see attached documents.

Submitted by:

Attachment(s): ABF-NPR-000144R01; Close-out document.

Caltrans' comments:

Status: CLO

Date: 20-Nov-2008

The proposed resolution is acceptable. The documents requested in Rev 0 of NPR-0144 have been provided. The Department concurs that Non-Conformance ZPMC-0154 is closed.

Submitted by: Wright, Doug

Date: 21-Nov-2008

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 11/15/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: CALTRANS NCR FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-309R1 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000170(ZPMC-0154).
- (3) COPY OF THE HEAT STRAIGHT CHECKING REPORT

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

J. Acid
PLAN HOLDER

11-15-08
DATE

ABF
COMPANY

PHONE NO.

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



No. B-309R1

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-11-15

REGARDING: NCR-000170 (ZPMC-0154)

With this letter of response, ZPMC requests closure for Caltrans NCR-000170 (ZPMC-0154). As the comments from caltrans: please provide documentation to identify the requirements for straightening, and confirm that the distortion has been corrected to within acceptable dimensional tolerances. So we submit the documentation as follow, they can prove the parameter which performed before and after heat straighten.

So ZPMC considers NCR-000170 (ZPMC-0154) can be closed.

Please check the attached documentation for acceptance and close the NCR-000170 (ZPMC-0154).

ATTACHMENT:

NCR-000170 (ZPMC-0154)

The heat straight checking report

Zhao Shuangbao

2008.11.15

*ABF QCM
17 Nov. 08*

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Contract #: 04-0120F4
Cty: SF/ALArte: 80 PM: 13.2/13.9
File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000170

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-Jul-2008

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

NCR #: ZPMC-0154

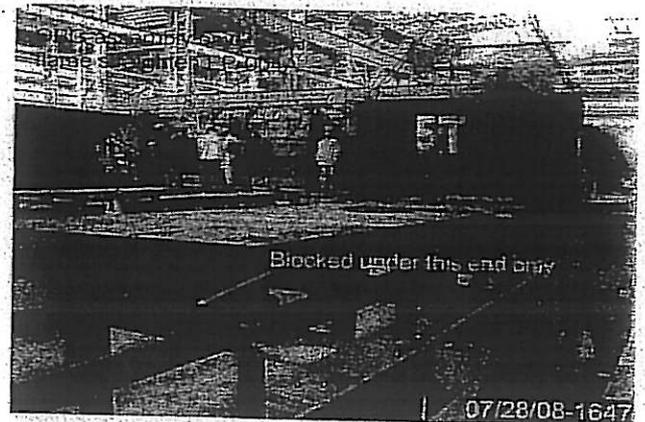
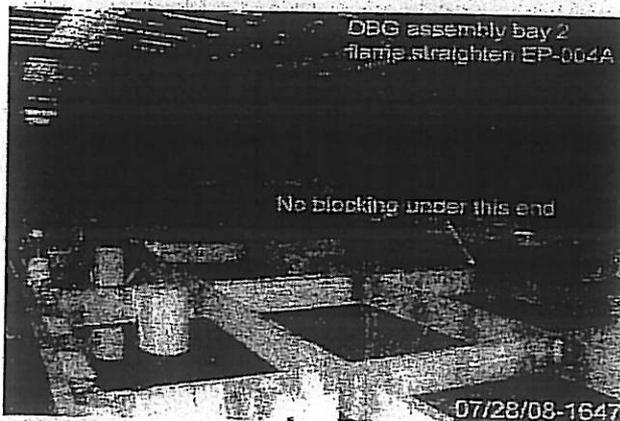
Type of problem:

Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: EP-004A
Procedural Procedural Descripton: OBG Edge Panel

Reference Description: Unapproved Heat Straightening EP-004A

Description of Non-Conformance:

The Contractor performed straightening using methods that have not been approved by the Engineer. The Contractor performed heat straightening on OBG edge panel EP-004A by blocking up one end of the panel and applying additional mechanical force during heating. This method was not previously approved in the WQCP. For more information, please see the attached picture below.



Applicable reference:

ZPMC WQCP Section 11.

Who discovered the problem: Caltrans Quality Assurance Inspector, Steve Hall

Name of individual from Contractor notified: ABF Quality Control, David LaRue

Time and method of notification: 7/28/08 // 18:30 // verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: Verbal notification at 08:00 on 07-29-2008

QC Inspector's Name: ZPMC Quality Control, Lei Tao

美国钢塔/钢桥钢板平整度火工校正检查记录卡

The report of steel plate heat straightening process checking



工程编号 The serial no. of project:	ZP06-787	图号 The drawing no.:	EP4A/PL54C	构件名称 Part name:	腹板
材质 Material:	A709M-345F ₂ 寸	炉批号 The heat no. of plate:	A702408	桥段名称 Section name:	3B-B3-F
移植是否正确 Material mark checking:	正确	轧制方向标注是否正确 Rolling direction checking:	正确		

火工校正温度控制 The temperature record of heat straightening

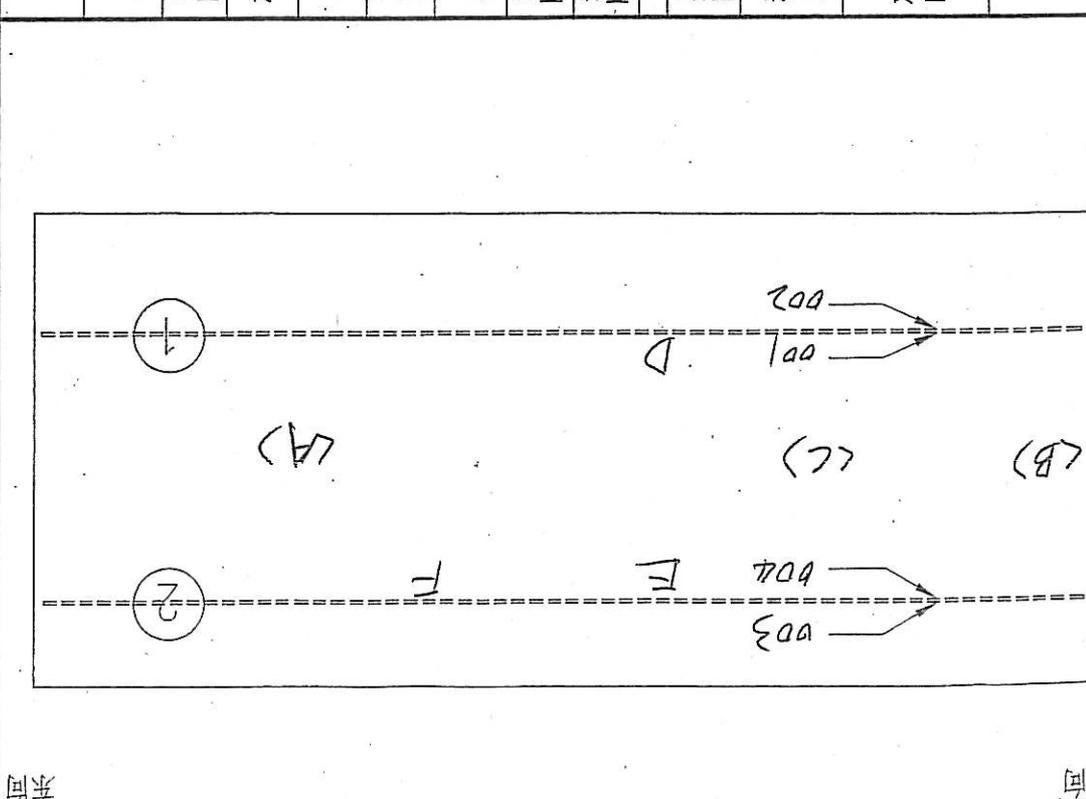
检查时间 Checking time:	8:57	9:17	10:11	13:54					
测量温度 Measure result:	209	314	386	529					

校火前平整度测量 Flatness checking before heat straightening (mm)

测量点 Measure position:	A	B	C	D	E	F			
测量值 Measure result:	4	3.5	3	20	19	17			

校火后平整度测量 Flatness checking after heat straightening (mm)

测量点 Measure position:	A	B	C	D	E	F			
测量值 Measure result:	-0.5	-1	-0.5	6	5	5			



整体平整度/钢板垂直度是否合格
Heat straightening result: ALL

若校正影响焊缝, 请填写以下项目
Fill the following items if the straightening affects the weld

对应NDT报告编号 NDT report no.	UT	N/A	NDT检验员签字 NDT inspector:	N/A	日期 Date:	N/A
	MT	N/A		Shu Yanghua	08.4.20	
	RT	N/A				

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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-000158**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jan-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0154**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: 28-Jul-2008**Description of Non-Conformance:**

The Contractor performed straightening using methods that have not been approved by the Engineer. The Contractor performed heat straightening on OBG edge panel EP-004A by blocking up one end of the panel and applying additional mechanical force during heating. This method was not previously approved in the WQCP. For more information, please see the attached picture below.

Contractor's proposal to correct the problem:

Ref: Letter from ZPMC to ABF- NCR 000170 (ZPMC-0154)

Corrective action taken:

Documentation to show that the work parameters for before and after heat straightening 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) 150.0042.2372, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer