

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-000172**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Jul-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0156**Type of problem:**

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

Reference Description: Unapproved fabrication procedures of OBG Corner Assembly of Segment 3AE**Description of Non-Conformance:**

The Contractor performed OBG corner assembly that did not follow the sequence of the approved fabrication procedures. The Contractor tack welded bulkhead plates onto OBG corner assembly before the splice plates and the truss posts are installed on the bulkhead plates. This occurred on the corner assembly of OBG Segment 3AE.

Applicable reference:

ABF-SUB-000147R03, Corner Section Fabrication Procedure, approved on October 24, 2007.

Who discovered the problem: Chengwen Liu**Name of individual from Contractor notified:** ABFJV QC Peter Shaw**Time and method of notification:** 7/25/08 1000 Verbal notification.**Name of Caltrans Engineer notified:** Ching Chao**Time and method of notification:** Verbal notification at 10:00 on 07-25-2008**QC Inspector's Name:** N/A**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

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: 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: 05.03.06-000146

Subject: NCR No. ZPMC-0156

Reference Description: Unapproved fabrication procedures of OBG Corner Assembly of Segment 3AE

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:** 03

Remarks:

The Contractor performed OBG corner assembly that did not follow the sequence of the approved fabrication procedures. The Contractor tack welded bulkhead plates onto OBG corner assembly before the splice plates and the truss posts are installed on the bulkhead plates. This occurred on the corner assembly of OBG Segment 3AE.

See attached NCR #ZPMC-0156 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-0156

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: 05.03.06-000146

Subject: NCR No. ZPMC-0156

Dated: 25-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000107 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has been notified that the fabrication procedure shall be followed or the procedure shall be revised prior to use

ZPMC has been notified that the fabrication procedure shall be followed or the procedure shall be revised prior to use.

Submitted by: Mackey, Kim

Attachment(s): ABF-NPR-000107R00

Caltrans' comments:

Status: AAP

Date: 11-Nov-2008

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

The proposed resolution states that "ZPMC has been notified that the fabrication procedure shall be followed or the procedure shall be revised prior to use". Please provide documentation that ZPMC has acknowledged the requirement to follow the fabrication procedure or revise it prior to use. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0156 at that time.

Submitted by: Wright, Doug

Attachment(s):

Date: 12-Nov-2008

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000146

Subject: NCR No. ZPMC-0156

Dated: 10-Dec-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000107 Rev: 01

Contractor's Proposed Resolution:

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

Submitted by:

Attachment(s): ABF-NPR-000107R01; doc to close this NCR

Caltrans' comments:

Status: CLO

Date: 21-Dec-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0156 is closed.

Submitted by: Wright, Doug

Date: 22-Dec-2008

Attachment(s):



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 12/10/2008

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-324 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000172(ZPMC-0156).
- (3) COPY OF ZPMC INTERNAL NCR

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

PLAN HOLDER

RECEIVED 10 DEC 2008
1035

DATE



COMPANY

PHONE NO.

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



No. B-324

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-12-10

REGARDING: NCR-000172(ZPMC-0156)

With this letter of response, ZPMC requests closure for Caltrans NCR-000172 (ZPMC-0156). we have sent an internal non-conformance report for the install sequence, according to the response from the technology and fabrication that because the splice rolled shape not approved by the engineer yet, but the fabrication is also in the process, then we make so many temporary support to confirm the pressure and safety before tacking weld the bulkhead plates. Eventually we will use the splice plate and the truss posts which completed primer and approved by supervisor to instead of the temporary structures.

So ZPMC considers NCR-000172(ZPMC-0156) can be closed.

Please check the attached documentation for acceptance and close the NCR-000172(ZPMC-0156).

ATTACHMENT:

NCR-000172(ZPMC-0156)

ZPMC internal non-conformance report

Chao Shuanghao

2008.12.10.

Thomas W. Kuntz
ABF QCM
10 DEC. 08



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B 项目名称: 美国加州海湾大桥		NCR Number: NCR 编号: NCR-B-097 (NCR-000172)	
Item: unapproved fabrication procedures 名称描述: 施工过程中与批准的工艺要求不符		Item Number: 件号: 角单元	Drawing Number: 图号: 3AE
Location: assembly shop 位置: 后场拼装车间		Date: 日期: 2008-8-21	

Description of Nonconformance:
不符合项状态描述:

The contractor performed OBG corner assembly that did not follow the sequence of the approved fabrication procedures. The contractor tack welded bulkhead plates onto OBG corner assembly before the splice plates and the truss posts are installed on the bulkhead plates. This occurred on the corner assembly of OBG segment 3AE. ZPMC 进行角单元生产的过程中违背了批准的施工工艺步骤, 工艺方案中是先安装纵向斜撑以及连接板然后才开始横隔板的装配焊接, 而实际生产是已经开始了隔板的焊接却根本没有安装斜撑和连接板。

Work By: Shi Jiang Gang Prepared by: Wang M Reviewed by QCE: Zhao Shuangbao
施工方: 准备: 质量工程师批准: 2008.8.21

Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
处理措施: 回用 返修 拒收

Recommendation:
建议加强上道工序的材料跟踪情况, 避免影响下道工序生产。
Enhance traceability of shapes inspection to avoid effect next procedure.

Prepared by: Zhang Yan zhi Approved by QCA: _____
准备 08.8.26 质量经理批准

Reason for Nonconformance:
不符合原因: 施工队未按工艺流程施工。
The work team didn't follow the sequence of the approved fabrication procedures.

预防措施: 后续角单元施工要严格按照工艺流程施工, 加强现场的监督。
Follow the sequence of the approved fabrication procedures to assemble OBG corner and enhance inspection on S.F.O.
Approved by/批准: Zhang Yan zhi 08.8.26

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
回用或返修的技术依据: 质检反映, 因前期附件 无附件

角单元中部分型钢还未报验合格, 所以该型钢报验合格后, 再根据现场要求进行焊接。
Corner assembly will be performed according to the fabrication procedure after inspection of the shape steel, which haven't yet been inspected previously.
Reviewed /批准: Tang Yong 2008

Verification: Acceptable Unacceptable
确认: 可接受 不可接受

Verified by QCI/质检确认: Zhang Yan zhi Reviewed by QCA/质检主任审核: Hu Gang



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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: 05.03.06-000146

Subject: NCR No. ZPMC-0156

Reference Description: Unapproved fabrication procedures of OBG Corner Assembly of Segment 3AE

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: 03

Remarks:

The Contractor performed OBG corner assembly that did not follow the sequence of the approved fabrication procedures. The Contractor tack welded bulkhead plates onto OBG corner assembly before the splice plates and the truss posts are installed on the bulkhead plates. This occurred on the corner assembly of OBG Segment 3AE.

See attached NCR #ZPMC-0156 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-0156

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

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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-000172

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 24-Jul-2008

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

NCR #: ZPMC-0156

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: SEG 3AE
 Procedural Procedural Descripton: OBG Corner Assembly of Segment 3AE

Reference Description: Unapproved fabrication procedures of OBG Corner Assembly of Segment 3AE

Description of Non-Conformance:

The Contractor performed OBG corner assembly that did not follow the sequence of the approved fabrication procedures. The Contractor tack welded bulkhead plates onto OBG corner assembly before the splice plates and the truss posts are installed on the bulkhead plates. This occurred on the corner assembly of OBG Segment 3AE.

Applicable reference:

ABF-SUB-000147R03, Corner Section Fabrication Procedure, approved on October 24, 2007.

Who discovered the problem: Chengwen Liu

Name of individual from Contractor notified: ABFJV QC Peter Shaw

Time and method of notification: 7/25/08 1000 Verbal notification.

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: Verbal notification at 10:00 on 07-25-2008

QC Inspector's Name: N/A

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, who represents the Office of Structural Materials for your project.

Inspected By: Velasco, Abifhiram

SMR

Reviewed By: Velasco, Abifhiram

SMR

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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-000157**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jan-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0156**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: 24-Jul-2008**Description of Non-Conformance:**

The Contractor performed OBG corner assembly that did not follow the sequence of the approved fabrication procedures. The Contractor tack welded bulkhead plates onto OBG corner assembly before the splice plates and the truss posts are installed on the bulkhead plates. This occurred on the corner assembly of OBG Segment 3AE.

Contractor's proposal to correct the problem:

Ref: Letter from ZPMC to ABF - NCR 000172 (ZPMC-0156)

Corrective action taken:

Temporary structures to support the area and acknowledging the needs of following the fabrication procedures.

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