

**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-000188**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0169**Type of problem:**

|                     |                   |                    |                             |
|---------------------|-------------------|--------------------|-----------------------------|
| <b>Welding</b>      | <b>Concrete</b>   | <b>Other</b>       |                             |
| <b>Welding</b>      | <b>Curing</b>     | <b>Procedural</b>  | <b>Bridge No:</b> 34-0006   |
| <b>Joint fit-up</b> | <b>Coating</b>    | <b>Other</b>       | <b>Component:</b> DP562-001 |
| <b>Procedural</b>   | <b>Procedural</b> | <b>Descriptor:</b> | OBG Deck Panel              |

**Reference Description:** Repair Welding of Deck Panel**Description of Non-Conformance:**

The Contractor's performance of quality control (QC) inspection did not conform to contract requirements or to approved working drawings. During repair welding of deck panel DP562-001, the Caltrans QA inspector noted that the QC inspector was checking but not recording welding parameters.

**Applicable reference:**

Welding Quality Control Plan (approved 26-Oct-2007), Sec 6.4: "Inspections shall be performed at suitable intervals during all phases of the work and the inspection shall include but not be limited to the following...

Verify that the requirements of the Welding Procedure Specification are being followed."

WQCP, Sec. 6.6: "Visual inspections shall be documented on the Continuous Visual Inspection Report."

WQCP, Sec. 7.4.6: "The repair documentation shall include the same information that was required when the original weld was made."

Special Provisions, Sec. 8-3.01 Welding (p. 150): "Inspection and approval of all joint preparations, assembly practices, joint fit-ups, welding techniques, and the performance of each welder, welding operator, and tack welder shall be documented by the QC Inspector on a daily basis for each day that welding is performed. For each inspection, the QC Inspector shall confirm and document compliance with the requirements of the AWS code criteria and the requirements of these special provisions on all weld joints before welding, during welding, and after the completion of each weld."

**Who discovered the problem:** Caltrans Quality Assurance(QA), Kenneth Riley**Name of individual from Contractor notified:** ABF Quality Control Manager, Steve Lawton**Time and method of notification:** In person @ 4:55pm**Name of Caltrans Engineer notified:** Ching Chao**Time and method of notification:** Verbal notification at 12:00 on 09-08-2008**QC Inspector's Name:** ZPMC Quality Control, Fu Yu Hong via phone @ 4:34 pm**Was QC Inspector aware of the problem:**

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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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.

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| <b>Inspected By:</b> | Velasco,Abifhram | SMR |
| <b>Reviewed By:</b>  | 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:** 16-Sep-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:** 05.03.06-000160

**Subject:** NCR No. ZPMC-0169

**Reference Description:** Repair Welding of Deck Panel

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's performance of quality control (QC) inspection did not conform to contract requirements or to the approved working drawings. During repair welding of deck panel DP562-001, the Caltrans QA inspector noted that the QC inspector was checking but not recording welding parameters.

Please refer to the attached NCR #ZPMC-0169 for details.

### Action Required and/or Action Taken:

No Action Required., This issue is considered to be closed for the following reason(s):  
According to METS, the issue was discussed with the contractor's QCM and the deficiency was corrected.

**Transmitted by:** Ching Chao

**Attachments:** ZPMC-0169

**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:** 05.03.06-000160

**Subject:** NCR No. ZPMC-0169

**Dated:** 28-Oct-2008

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000171 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:** Weld parameters are checked for compliance to the WPS, furthermore the Continuous Visual Inspection Report has been deleted from the WQCP section 6.

During weld repairs of Deck Panel DP562-001, ZPMC inspectors were checking the weld parameters, but were not recording them. ZPMC does not consider the recording of parameters for each and every weld repair is required, however, weld parameters are checked for compliance to the WPS, furthermore the Continuous Visual Inspection Report has been deleted from the WQCP section 6.

**Submitted by:**

**Attachment(s):** ABF-NPR-000171R00

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**Caltrans' comments:**

**Status:** CLO

**Date:** 02-Nov-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0169 is closed.

**Submitted by:** Wright, Doug

**Date:** 02-Nov-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-000156**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jan-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0169**Type of problem:**

|                     |                   |                    |                           |
|---------------------|-------------------|--------------------|---------------------------|
| <b>Welding</b>      | <b>Concrete</b>   | <b>Other</b>       |                           |
| <b>Welding</b>      | <b>Curing</b>     | <b>Procedural</b>  | <b>Bridge No:</b> 34-0006 |
| <b>Joint fit-up</b> | <b>Coating</b>    | <b>Other</b>       | <b>Component:</b>         |
| <b>Procedural</b>   | <b>Procedural</b> | <b>Descriptor:</b> |                           |

**Date the Non-Conformance Report was written:** 04-Sep-2008**Description of Non-Conformance:**

The Contractor's performance of quality control (QC) inspection did not conform to contract requirements or to approved working drawings. During repair welding of deck panel DP562-001, the Caltrans QA inspector noted that the QC inspector was checking but not recording welding parameters.

**Contractor's proposal to correct the problem:**

During weld repairs of Deck Panel DP562-001, ZPMC inspectors were checking the weld parameters, but were not recording them. ZPMC does not consider the recording of parameters for each and every weld repair is required, however, weld parameters are checked for compliance to the WPS. Furthermore the Continuous Visual Inspection Report has been deleted from the WQCP section 6.

**Corrective action taken:**

Contractor's explanation noted and accepted.

**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