

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 #: 04-0120F4
 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-000191
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 04-Sep-2008
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0172

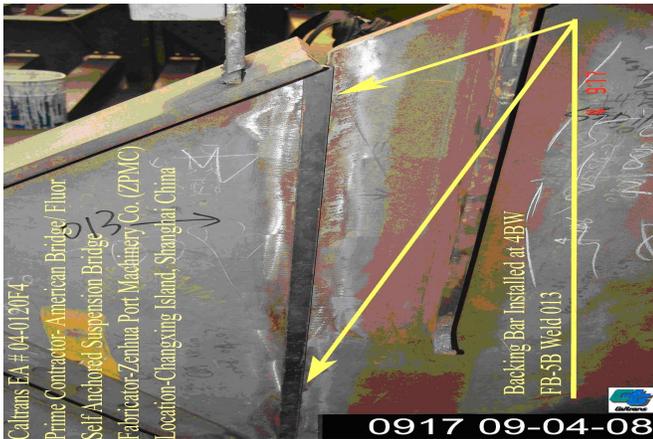
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: SEG4BW FB5B, SEG 3AW FL2-2 to FL3
Procedural	Procedural	Descriptor: OBG Floorbeam, Crossbeam	

Reference Description: Welds that do not conform to detail drawings

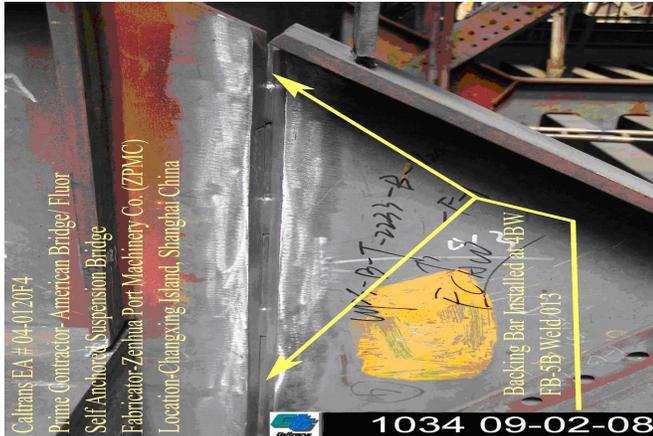
Description of Non-Conformance:

The Contractor's QC allowed welds that do not conform to detail drawings to be performed in fabrication. The Contractor installed backing bars at locations where backing bars have not been specified. This was observed in weld joints 4BW-SSD11-PP027-013 of OBG segment SEG 4BW and 3AW-SSD12-PP022-133 of OBG SEG3AW.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5, Sec. 6.5.1: "The Inspector shall make certain that the size, length, location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval."

Who discovered the problem: Caltrans Quality Assurance Robert H. Vatcher & Robert Cuellar

Name of individual from Contractor notified: ABFJV QC Inspectors Art Peterson, Peter Shaw

Time and method of notification: Verbal notification at 0900 hrs.

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: Verbal notification at 10:30 on 15-Sep-08

QC Inspector's Name: ZPMC QC Inspector Mr. Wang Lu

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: 17-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: 05.03.06-000162

Subject: NCR No. ZPMC-0172

Reference Description: Welds that do not conform to detail drawings

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 QC allowed welds that do not conform to detail drawings to be performed in fabrication. The Contractor installed backing bars at locations where backing bars have not been specified. This was observed in weld joints 4BW-SSD11-PP027-013 of OBG segment SEG 4BW and 3AW-SSD12-PP022-133 of OBG SEG3AW.

Please refer to the attached NCR #ZPMC-0172 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 has been discussed with contractor's QCM and the backing bars have been removed.

Transmitted by: Ching Chao

Attachments: ZPMC-0172

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: 05.03.06-000162

Subject: NCR No. ZPMC-0172

Dated: 28-Oct-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000173 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC installed back-up bars per WPS BT2213-B-U2-F-1 because the root gap was in excess of that allowed for the approved WPS for that joint type.

ZPMC installed back-up bars per WPS BT2213-B-U2-F-1 because the root gap was in excess of that allowed for the approved WPS for that joint type. Once the weld was completed with the back-up bar in place, the back-up bars were then removed, the weld back gouged on the back-up bar removal side and finished welded. The weld then received the required Visual and NDT inspection.

Submitted by:

Attachment(s): ABF-NPR-000173R00

Caltrans' comments:

Status: CLO

Date: 02-Nov-2008

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0172 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-000190**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jan-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0172**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: 04-Sep-2008**Description of Non-Conformance:**

The Contractor's QC allowed welds that do not conform to detail drawings to be performed in fabrication. The Contractor installed backing bars at locations where backing bars have not been specified. This was observed in weld joints 4BW-SSD11-PP027-013 of OBG segment SEG 4BW and 3AW-SSD12-PP022-133 of OBG SEG3AW.

Contractor's proposal to correct the problem:

ZPMC installed backing bars per WPS BT2213-B-U2-F-1 because the root gap was in excess of that allowed for the approved WPS for that joint type. Once the weld was completed with the backing bar in place, the back-up bars were then removed, the weld back gouged on the backing bar removal side and finished welded. The weld then received the required Visual and NDT inspection.

Corrective action taken:

The backing bar was removed. The current weld condition conforms to the detail drawing.

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