

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-000224**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Dec-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0199**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: East Tower, Lift 1
Procedural	Procedural	Description: 15mm Tower Fit Lug Welds	

Reference Description: Proposed 15mm Fit Lug Weld Detail**Description of Non-Conformance:**

It was observed by QA that cascading of weld passes at termination was not being performed. The proposed 15mm fit lug weld detail notes "Cascade and grind terminations or cascade and fill craters complete (prior to ceasing the arc on each pass)." The following digital photographs depict the fit lug weld observed in East Tower-Lift 1 and the approved weld on the 89m mock-up.

**Applicable reference:**

Proposed 15mm Fit Lug Weld Detail

Who discovered the problem: William Clifford**Name of individual from Contractor notified:** Don Walton**Time and method of notification:** 12-26-2008, 1000 hours, in person**Name of Caltrans Engineer notified:** Scott Kennedy**Time and method of notification:** 12-29-2008, 0700 hours, in person**QC Inspector's Name:**

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

Inspected By:	Sinevod,Serge	ASMR
----------------------	---------------	------

Reviewed By:	Sinevod,Serge	ASMR
---------------------	---------------	------



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 02-Jan-2009

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: 05.03.06-000192

Subject: NCR No. ZPMC-0199

Reference Description: Proposed 15mm Fit Lug Weld Detail / East Shaft Lift 1

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: Tower **Lift:** 01

Remarks:

It was observed by QA that cascading of weld passes at termination was not being performed. The proposed 15mm fit lug weld detail notes "Cascade and grind terminations or cascade and fill craters complete (prior to ceasing the arc on each pass)."

Action Required and/or Action Taken:

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

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0199

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000192

Subject: NCR No. ZPMC-0199

Dated: 19-Feb-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000196 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: Puposed Resolution to NCR ZPMC-0199

ZPMC informed ABF that the welder performing this weld was not involved in the Mock-up, thus resulting in a weld not being completed per the pre-determined fabrication procedure. As the picture shows, the weld is not in a final condition and was subsequently ground to the proper contour and no defects detected. As a preventative measure, ABF/CT have instituted a training program for both welders and grinders. This specific case of fit lug welding and grinding is one of the training subjects.

Submitted by:

Attachment(s): ABF-NPR-000196R00

Caltrans' comments:

Status: CLO

Date: 24-Mar-2009

The proposed resolution is acceptable. Training has been provided to the welders, and there has not been a recurrence of this issue. The Department concurs that Non-Conformance ZPMC-0199 is closed.

Submitted by: Wright, Doug

Date: 24-Mar-2009

Attachment(s):

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, PRC**Report No:** NCS-000216**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-May-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0199**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: 26-Dec-2008**Description of Non-Conformance:**

It was observed by QA that cascading of weld passes at termination was not being performed on fit lug welds in East Tower, Lift 1. The proposed 15mm fit lug weld detail notes "Cascade and grind terminations or cascade and fill craters complete (prior to ceasing the arc on each pass)."

Contractor's proposal to correct the problem:

Perform weld repairs.

Corrective action taken:

All affected fit lug welds in East Tower, Lift 1 have been repaired and green tagged.

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 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer