

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, P.R. China**Report No:** NCR-000247**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Mar-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0221**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segments 2BE, 2BW, 2AW, 1BW
Procedural	Procedural	Description:	

Reference Description: Lack of QC coverage**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that ZPMC CWI Quality Control (QC) Inspector Zhang Zhong (AWS CWI # 07051341) was not present throughout the welding operations in OBG Assembly Bay 13 from 0800 to 0930. This time frame exceeds the 30 minutes maximum allowable time lapse for QC inspection coverage.

Applicable reference:

Special Provisions, Section 8-3.01: "QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes."

Who discovered the problem: Dan Hernandez**Name of individual from Contractor notified:** Zheng Chang Song**Time and method of notification:** 03/30/2009, 0930 hours, Verbal**Name of Caltrans Engineer notified:** Ching Chao**Time and method of notification:** 03/30/2009, 1300 hours, Verbal**QC Inspector's Name:** Zhang Zhong**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 Eric Tsang, +(86) 1500.042.2372, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Inspected By:	Tsang, Eric	SMR
Reviewed By:	Wahbeh, Mazen	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: 10-Apr-2009

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project Manager - OBG

Document No: 05.03.06-000213

Subject: NCR No. ZPMC-0221

Reference Description: Lack of QC coverage

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:

Caltrans Quality Assurance (QA) Inspector observed that ZPMC CWI Quality Control (QC) Inspector Zhang Zhong (AWS CWI # 07051341) was not present throughout the welding operations in OBG Assembly Bay 13 from 0800 to 0930. This time frame exceeds the 30 minutes maximum allowable time lapse for QC inspection coverage.

Action Required and/or Action Taken:

Please propose a resolution for the identified non-conformance.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0221

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, 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: 05.03.06-000213

Subject: NCR No. ZPMC-0221

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000211 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has generated an internal NCR to document this occurrence and increase the number of inspectors in the evening.

ZPMC has acknowledged the discrepancy and has taken measures to make sure the inspector is present at the jobsite sufficiently to comply with the 30 minute rule. ZPMC has generated an internal NCR to document this occurrence and increase the number of inspectors in the evening. Attached is the ZPMC internal NCR. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000211R00;

Caltrans' comments:

Status: CLO

Date: 03-Jun-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0221 is closed.

Submitted by: Wright, Doug

Date: 03-Jun-2009

Attachment(s):

	<h2 style="margin: 0;">TRANSMITTAL LETTER</h2>
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PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 05/08/2009

TO: ROSE MARY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: ABF NCR FOR CLOSURE

SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-343 FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000247(ZPMC-0221)
- (3) COPY OF ZPMC INTERNAL NCR

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



PLAN HOLDER

RECEIVED 08 MAY 2009 2:30 pm

DATE

COMPANY

PHONE NO.

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



No. B-343

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2009-5-8

REGARDING: NCR-000247 (ZPMC-0221)

With this letter of response, ZPMC requests closure for caltrans **NCR-000247 (ZPMC-0221)** .we agree what described in the non-conformance report and have traced our QC guy with the reference application. Because the evening work include the out-site segment inspection and the 14th bay touring checking, but not enough QC coverage for those two site. As the current condition we will increase more CWI work in the evening and improve the inspection frequency in some welding areas.

So ZPMC applies to close **NCR-000247 (ZPMC-0221)** .

Please reference attached documentation for acceptance and closure the **NCR-000247 (ZPMC-0221)** .

ATTACHMENT:

NCR-000247 (ZPMC-0221)

ZPMC internal NCR

Zhao Shuangbao

2009. 5. 8.



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-142 (NCR-00247)

Item: Lack of QC coverage
名称描述:

Item Number:
件号:

Drawing:
图号: 2BE,2BW,2AW,1BW

Location:
位置: 2BE,2BW,2AW,1BW

Date:
日期: 2009-04-16

Description of Nonconformance:

Caltrans Quality Assurance Inspector observed that ZPMC CWI Quality Control Inspector Zhang Zhong (AWS CWI #070511341) was not present throughout the welding operations in OBG Assembly Bay 13 from 0800 to 0930. This time frame exceeds the 30 minutes maximum allowable time lapse for QC Inspection coverage.

加州 QA 检验员发现在 3.30 号 8 点到 9 点半超过半小时内没有 CWI 出现在 OBG 拼装 13 车间。超过 30 分钟的最大允许巡检时没有 QC 在现场进行检验。

Work By: Zhang Zhong
施工方: 4.17/09

Prepared by: Wang Lin
准备: 6.9/09

Reviewed by QCE: Zhang Shuangdao
质量工程师批准: 4.16

- 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:

加大 CWI 的巡检频率, 以确保焊缝内部能到达每个位置。

Enlarge CWI inspection frequency to ensure QC inspection coverage within 30 minutes.

Prepared by: Zhang Zhong 09.4.17
准备

Approved by QCA: _____
质量经理批准

Reason for Nonconformance:

不符合原因:

由于14车间的拼装巡检以及外场的箱梁报验,以致于到达14车间的时间较晚,
For No. 14th splice shape inspection and out-shape box final inspection
at same time, which caused it was late to arrive No. 14th shape.

Prevention of Re-occurrence:

预防措施:

增加CWI人员以及加大CWI人员的巡检频率。
Enlarge cwi personel and improve cwi inspection frequency.

Approved by/批准: Zheng Zhong 09.4.17

Technical Justification for Use-As-Is/Repair:

Attachment

Non-attachment

回用或返修的技术依据:

附件

无附件

Reviewed /批准: _____

Verification:

Acceptable

Unacceptable

确认:

可接受

不可接受

Verified by QCI/质检确认: Zheng Zhong

Reviewed by QCA/质检主任审核: _____



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NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 10-Apr-2009

Contract No: 04-0120F4
04-SF-80-13.2 + 13.9

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project Manager - OBG

Document No: 05.03.06-000213

Subject: NCR No. ZPMC-0221

Reference Description: Lack of QC coverage

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Material Location: OBG

Lift:

Remarks:

Caltrans Quality Assurance (QA) Inspector observed that ZPMC CWI Quality Control (QC) Inspector Zhang Zhong (AWS CWI # 07051341) was not present throughout the welding operations in OBG Assembly Bay 13 from 0800 to 0930. This time frame exceeds the 30 minutes maximum allowable time lapse for QC inspection coverage.

Action Required and/or Action Taken:

Please propose a resolution for the identified non-conformance.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0221

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, 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, P.R. China

Report No: NCR-000247

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 30-Mar-2009

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

NCR #: ZPMC-0221

Type of problem:

Welding **Concrete** **Other**

Welding **Curing** **Procedural** **Bridge No:** 34-0006

Joint fit-up **Coating** **Other** **Component:** OBG Segments 2BE, 2BW, 2AW, 1BW

Procedural **Procedural** **Description:**

Reference Description: Lack of QC coverage

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed that ZPMC CWI Quality Control (QC) Inspector Zhang Zhong (AWS CWI # 07051341) was not present throughout the welding operations in OBG Assembly Bay 13 from 0800 to 0930. This time frame exceeds the 30 minutes maximum allowable time lapse for QC inspection coverage.

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Who discovered the problem: Dan Hernandez

Name of individual from Contractor notified: Zheng Chang Song

Time and method of notification: 03/30/2009, 0930 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 03/30/2009, 1300 hours, Verbal

QC Inspector's Name: Zhang Zhong

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 Eric Tsang, +(86) 1500.042.2372, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

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, P.R. China**Report No:** NCS-000230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0221**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 30-Mar-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that ZPMC CWI Quality Control (QC) Inspector Zhang Zhong (AWS CWI # 07051341) was not present throughout the welding operations in OBG Assembly Bay 13 from 0800 to 0930. This time frame exceeds the 30 minutes maximum allowable time lapse for QC inspection coverage.

Contractor's proposal to correct the problem:

ABF issued internal NCR to address the increase inspection coverage for the shift.

Corrective action taken:

ABF addressed this issue with ZPMC through an internal NCR. The inspection coverage will be increased for the shift.

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:**

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Inspected By: Lowry, Patrick **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**