

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-000252**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0226**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG Segments 3AW-3BW & 4AW-4BW**Procedural****Procedural****Description:****Reference Description:** Distortion of Bottom Panel/Side Panel at Segment Splices 3AW-3BW & 4AW-4BW**Description of Non-Conformance:**

Caltrans Quality Assurance Inspector observed welding distortion occurred at the transverse splice welds joining segments 3AW to 3BW and 4AW to 4BW. The distortion is located on the counterweight side of both segment transverse welds and has been measured at the corners where the side panel meets the bottom panel.

The measured distortion is as follows:

- 3AW/3BW – 10mm in 1000mm
- 4AW/4BW – 8mm in 1000mm



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 (2002), Section 3.4.3 - "The Contractor shall prepare a welding sequence for a member or structure which, in conjunction with the WPSs and overall fabrication methods, will produce members or structures meeting the quality requirements specified. The welding sequence and distortion control program shall be submitted to the Engineer, for information and comment, before the start of welding on a member or structure in which shrinkage or distortion is likely to affect the adequacy of the member or structure."

Who discovered the problem: Rory O'Kane

Name of individual from Contractor notified: Ding Xingchi

Time and method of notification: 04/29/09, 9:00, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 04/30/09, 10:00, Verbal

QC Inspector's Name: Wu Zhicheng

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 Skyler Guest, +(86) 1500 042 2360, who represents the Office of Structural Materials for your project.

Inspected By:	Guest, Skyler	SMR
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Reviewed By:	Wahbeh, Mazen	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: 30-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/Fabrication Manager

Document No: 05.03.06-000218

Subject: NCR No. ZPMC-0226

Reference Description: Distortion of Bottom Panel/Side Panel at Segment Splices 3AW-3BW & 4AW-4BW

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:

Caltrans Quality Assurance Inspector observed welding distortion occurred at the transverse splice welds joining segments 3AW to 3BW and 4AW to 4BW. The distortion is located on the counterweight side of both segment transverse welds and has been measured at the corners where the side panel meets the bottom panel.

The measured distortion is as follows:

- 3AW/3BW – 10mm in 1000mm
- 4AW/4BW – 8mm in 1000mm

Please see the attached NCR report #ZPMC-226 for more details.

Action Required and/or Action Taken:

A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0226

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Doug Wright, 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: 05.03.06-000218

Subject: NCR No. ZPMC-0226

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000222 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The ZPMC survey was not complete prior to this NCR being generated, therefore ZPMC requests this NCR be closed or retracted.

The ZPMC survey was not complete prior to this NCR being generated, therefore ZPMC requests this NCR be closed or retracted. Remedial action has been taken after the ZPMC survey to bring the distortion into compliance.

Submitted by:

Attachment(s): ABF-NPR-000222R00

Caltrans' comments:

Status: CLO

Date: 03-Jun-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0226 is closed.

Submitted by: Wright, Doug

Date: 03-Jun-2009

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-000243**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0226**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: 29-Apr-2009**Description of Non-Conformance:**

Caltrans Quality Assurance Inspector observed welding distortion occurred at the transverse splice welds joining segments 3AW to 3BW and 4AW to 4BW. The distortion is located on the counterweight side of both segment transverse welds and has been measured at the corners where the side panel meets the bottom panel.

The measured distortion is as follows:

- 3AW/3BW – 10mm in 1000mm
- 4AW/4BW – 8mm in 1000mm

Contractor's proposal to correct the problem:

Remedial action has been taken after the ZPMC survey to bring the distortion into compliance.

Corrective action taken:

ZPMC had repaired the areas with subsequent acceptable NDT result.

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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Lowry, Patrick

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer