

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, P.R. China **Report No:** NCR-000253
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 28-Apr-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0227

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Counterweight CW001-PP036
Procedural	Procedural	Description:	

Reference Description: Counterweight Plate Section Removal/Replacement

Description of Non-Conformance:

During random in-process inspection of Counterweight CW001-PP36, Caltrans Quality Assurance Inspector discovered that ZPMC personnel had cut and removed a section of the counterweight plate and re-welded a new plate section in place without the Engineer's approval. The dimensions of the base metal section removed are as follows:

Length: 3450mm
 Width: 740mm

The section was removed and replaced due to holes drilled in the plate that were not part of the approved shop drawings.



Applicable reference:

AWS D1.5 (2002), Section 2.1.1 - "Full and complete information regarding location, type, size, and extent of all welds shall be clearly shown on the drawings. The drawings shall clearly distinguish between shop and field

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

welds. Unless specifically indicated in the design, all groove welds, both shop and field, shall be complete joint penetration (CJP) groove welds."

Who discovered the problem: Dhanasingh Sukanthan

Name of individual from Contractor notified: Wang Jiang Hua

Time and method of notification: 04/28/09, 8:00, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 04/30/09, 9:00, Verbal

QC Inspector's Name: Wang Liang

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
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: 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: 05.03.06-000219

Subject: NCR No. ZPMC-0227

Reference Description: Counterweight Plate Section Removal/Replacement

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:** N/A

Remarks:

During random in-process inspection of Counterweight CW001-PP36, Caltrans Quality Assurance Inspector discovered that ZPMC personnel had cut and removed a section of the counterweight plate and re-welded a new plate section in place without the Engineer's approval. The dimensions of the base metal section removed are as follows:

Length: 3450mm
Width: 740mm

The section was removed and replaced due to holes drilled in the plate that were not part of the approved shop drawings.

Please see the attached NCR report #ZPMC-227 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-0227

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: 05.03.06-000219

Subject: NCR No. ZPMC-0227

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000223 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC did not notify CT of removal of this weld per the requirements AWS D1.5 paragraph 3.7.5. ZPMC will provide all inspection documents at a later date.

ZPMC did not notify CT of removal of this weld per the requirements AWS D1.5 paragraph 3.7.5. ZPMC will provide all inspection documents at a later date. ABF has notified ZPMC that removal of welds requires Engineers notification.

Submitted by:

Attachment(s): ABF-NPR-000223R00

Caltrans' comments:

Status: AAP

Date: 27-May-2009

The response is acceptable, but the Non-Conformance is not closed.

Please provide documentation of the weld repairs that were performed and that the repairs were acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0227 at that time.

Submitted by: Wright, Doug

Date: 27-May-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000219

Subject: NCR No. ZPMC-0227

Dated: 13-Jul-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000223 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has responded to the NCR and has attached the necessary documents for closure. ZPMC requests closure of this NCR.

ZPMC has responded to the NCR and has attached the necessary documents for closure. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000223R01;

Caltrans' comments:

Status: CLO

Date: 15-Jul-2009

The proposed resolution is acceptable. The weld in question (CW001A-PP036-237) has been accepted by VT, MT, and UT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0227 is closed.

Submitted by: Wright, Doug

Date: 15-Jul-2009

Attachment(s):



No. B-357

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-5-30

REGARDING: NCR-00253(ZPMC-0227)

With this letter of response, ZPMC requests closure for Caltrans **NCR-00253(ZPMC-0227)**. As the ABF response to caltrans, ZPMC provide the final complete NDT documentation to support the good quality of the additional weld in the NCR's description.

So base on the documentation and the NPR response, ZPMC applies to close the caltrans's report **NCR-00253(ZPMC-0227)**.

Please reference attached documentation for acceptance and closure the **NCR-00253(ZPMC-0227)**.

ATTACHMENT:

NCR-00253(ZPMC-0227)

The final acceptable reports.



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-6867 DATE 2009.05.27 PAGE 1 OF 1 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787 CONTRACTOR: CALTRANS

ITEMS NAME: OBG COUNTERWEIGHT BOXES DRAWING NO.: CW001A CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 FCAW BUTT Dec. 28ST, 2009

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE PANAMETRICS EPOCH-4B 071565311, 061488510, 061495811, 070152011,

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709M-345T2-X 10mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
Changchao	70°	2.5MHz	18×18mm				
Changchao	0°	2.5MHz	20mm	Reference Level 参考灵敏度		20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From X 距X	From Y 距Y		
CW001A-PP036-237		70				34								ACC.	100%
CW001A-PP036-238		70				34								ACC.	100%

AFTER HSR1(B)-6240

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EXAMINED BY 主探 <i>Swjin</i> LEVEL - II SIGN / DATE <i>09.05.27</i> 质量经理 / QCM 签字 SIGN / 日期 DATE	REVIEWED BY 审核 <i>Zshuqin</i> LEVEL - II SIGN / DATE <i>09.05.27</i> 用户 CUSTOMER 签字 SIGN / 日期 DATE
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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-000347**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0227**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: 28-Apr-2009**Description of Non-Conformance:**

During random in-process inspection of Counterweight CW001-PP36, Caltrans Quality Assurance Inspector discovered that ZPMC personnel had cut and removed a section of the counterweight plate and re-welded a new plate section in place without the Engineer's approval. The dimensions of the base metal section removed are as follows:

Length: 3450mm

Width: 740mm

The section was removed and replaced due to holes drilled in the plate that were not part of the approved shop drawings.

Contractor's proposal to correct the problem:

Perform the required NDT to verify that the welds are in conformance with Contract requirements.

Corrective action taken:

ZPMC performed visual inspection along with magnetic particle testing and ultrasonic testing of the area in question and submitted the respective reports showing that the welds are in conformance.

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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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer