

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-000258

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 13-Apr-2009

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

NCR #: ZPMC-0232

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Crossbeam 1, DP522-001-021, 034
Procedural	Procedural	Description:	

Reference Description: Absence of NDT Notification

Description of Non-Conformance:

During the inspection of Crossbeam 1, Caltrans Quality Assurance (QA) Inspector discovered ZPMC performing Ultrasonic Testing (UT) inspection without providing prior NDT notification to Caltrans.



Applicable reference:

AWS D1.5 (2002) - Section 6.6.6 "The contractor shall schedule NDT to facilitate attendance by the QA Inspector. The QA Inspector shall be advised by the Contractor of operational and NDT schedules and scheduled changes."

Who discovered the problem: Dhanasingh Sukanthan

Name of individual from Contractor notified: Zeng Jian Ping

Time and method of notification: 2009/04/13, 15:29, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 2009/04/13, 18:00, Verbal

QC Inspector's Name: Huang Wen Pang

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 Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	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: 05.03.06-000224

Subject: NCR No. ZPMC-0232

Reference Description: Absence of NDT Notification

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: Xbeam **Lift:** N/A

Remarks:

During the inspection of Crossbeam 1, Caltrans Quality Assurance (QA) Inspector discovered ZPMC performing Ultrasonic Testing (UT) inspection without providing prior NDT notification to Caltrans.

Please see the attached NCR report #ZPMC-232 for more details.

Action Required and/or Action Taken:

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

Transmitted by: Ching Chao

Attachments: ZPMC-0232

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: 05.03.06-000224

Subject: NCR No. ZPMC-0232

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000228 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has agreed they will notify CT prior to performing their NDT, however, this notification will be verbal and may not reflect the exact time of inspection

ZPMC notifies ABF and CT for NDT, however this notification is after ZPMC NDT inspection and is a request for ABF and or CT to perform our final Q.ANDT inspection as necessary. CT is requesting that ZPMC notify them prior to ZPMC inspection. ZPMC has agreed they will notify CT prior to performing their NDT, however, this notification will be verbal and may not reflect the exact time of inspection as these operation are in process and an inspector may get called away to more important matters at hand. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000228R00

Caltrans' comments:

Status: REJ

Date: 03-Jun-2009

The proposed resolution is not acceptable. AWS D1.5 - Section 6.6.6 states that "The contractor shall schedule NDT to facilitate attendance by the QA Inspector. The QA Inspector shall be advised by the Contractor of operational and NDT schedules and scheduled changes."

ZPMC had been providing written notification of NDT inspection, and the Department would like to continue receiving written notification. Please discuss with the Department's representatives in Shanghai to develop a method of notification for NDT schedules and scheduled changes.

Submitted by: Wright, Doug

Date: 03-Jun-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000224

Subject: NCR No. ZPMC-0232

Dated: 03-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000228 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000228R01;

Caltrans' comments:

Status: CLO

Date: 18-Aug-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0232 is closed.

Submitted by: Wright, Doug

Date: 18-Aug-2009

Attachment(s):



No. B-420

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-7-30

REGARDING: NCR-000258 (ZPMC-0232)

With this letter of response, ZPMC requests closure for Caltrans NCR-000258 (ZPMC-0232). The AWS D1.5 Section 6.6.6 states that "the contractor shall schedule NDT to facilitate attendance by the QA inspector. the QA inspector shall be advised by the contractor of operational an NDT schedules and scheduled changes." But we have to remind here that the states require not mean the contractor must notify the QA inspector prior each NDE occurrence. And I think it's also no possible that give the each weld detail to QA in daily work. The site work is very complex and the NDE work can start at any time with the notification not only until received the information from office, and probably the QC receive the paper work a little late or only from the cell phone first. Obviously our guy will clean up the summary or each record after the daily work.

By the way we will give the formal notification sheet to QA after ZPMC own inspection, that means request QA to perform the final QA NDT to verify the final condition prior proceed the green tag, and we all have forwarded the fabrication by this program for long time.

So base on the above explanation, ZPMC applies to close the caltrans's report NCR-000258 (ZPMC-0232).

ATTACHMENT:

NCR-000258 (ZPMC-0232)

Chao Shuangbao

2009. 7. 30

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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-000258
 Prime Contractor: American Bridge/Fluor Enterprises, a JV Date: 13-Apr-2009
 Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island NCR #: ZPMC-0232

Type of problem:

- Welding Concrete Other
- Welding Curing Procedural
- Joint fit-up Coating Other
- Procedural Procedural Description:

Bridge No: 34-0006
 Component: Crossbeam 1, DP522-001-021, 034

Reference Description: Absence of NDT Notification

Description of Non-Conformance:

During the inspection of Crossbeam 1, Caltrans Quality Assurance (QA) Inspector discovered ZPMC performing Ultrasonic Testing (UT) inspection without providing prior NDT notification to Caltrans.



Applicable reference:

AWS D1.5 (2002) - Section 6.6.6 "The contractor shall schedule NDT to facilitate attendance by the QA Inspector. The QA Inspector shall be advised by the Contractor of operational and NDT schedules and scheduled changes."

Who discovered the problem: Dhanasingh Sukanthan
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QC Inspector's Name: Huang Wen Pang

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000224

Subject: NCR No. ZPMC-0232

Dated: 17-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000228 **Rev:** 02

Contractor's Proposed Resolution:

Reference Resolution: Formal inspection notification is provided to CT after ZPMC has completed their final NDT, which is reasonable. ZPMC requests closure of this NCR.

This NCR is written that notification was not provided to CT prior to performing NDT. ZPMC does not feel that CT must be formally notified during NDT in process inspection. As stated in the ZPMC letter, scheduling of ZPMC NDT is complex. If an NDT inspection is scheduled for a given time and the ZPMC inspector is called away at the last minute to perform a more important inspection, it may be several hours to several days before the inspection would take place. Formal inspection notification is provided to CT after ZPMC has completed their final NDT, which is reasonable. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000228R02;

Caltrans' comments:

Status: CLO

Date: 18-Aug-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0232 is closed.

Submitted by: Wright, Doug

Date: 18-Aug-2009

Attachment(s):



No. B-420

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-7-30

REGARDING: NCR-000258 (ZPMC-0232)

With this letter of response, ZPMC requests closure for Caltrans **NCR-000258 (ZPMC-0232)**. The AWS D1.5 Section 6.6.6 states that "the contractor shall schedule NDT to facilitate attendance by the QA inspector. the QA inspector shall be advised by the contractor of operational an NDT schedules and scheduled changes." But we have to remind here that the states require not mean the contractor must notify the QA inspector prior each NDE occurrence. And I think it's also no possible that give the each weld detail to QA in daily work. The site work is very complex and the NDE work can start at any time with the notification not only until received the information from office, and probably the QC receive the paper work a little late or only from the cell phone first. Obviously our guy will clean up the summary or each record after the daily work.

By the way we will give the formal notification sheet to QA after ZPMC own inspection, that means request QA to perform the final QA NDT to verify the final condition prior proceed the green tag, and we all have forwarded the fabrication by this program for long time.

So base on the above explanation, ZPMC applies to close the caltrans's report **NCR-000258 (ZPMC-0232)**.

ATTACHMENT:

NCR-000258 (ZPMC-0232)

Chao Shuangbao

2009. 7. 30

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCR-000258
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 13-Apr-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0232

Type of problem:

- Welding Concrete Other
 Welding Curing Procedural **Bridge No:** 34-0006
 Joint fit-up Coating Other **Component:** Crossbeam 1, DP522-001-021, 034
 Procedural Description:

Reference Description: Absence of NDT Notification

Description of Non-Conformance:

During the inspection of Crossbeam 1, Caltrans Quality Assurance (QA) Inspector discovered ZPMC performing Ultrasonic Testing (UT) inspection without providing prior NDT notification to Caltrans.



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Time and method of notification: 2009/04/13, 18:00, Verbal
QC Inspector's Name: Huang Wen Pang

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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-000348**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0232**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: 13-Apr-2009**Description of Non-Conformance:**

During the inspection of Crossbeam 1, Caltrans Quality Assurance (QA) Inspector discovered ZPMC performing Ultrasonic Testing (UT) inspection without providing prior NDT notification to Caltrans.

Contractor's proposal to correct the problem:

Provide notification to Caltrans after performing NDT.

Corrective action taken:

All parties agree that the non conformance for this particular instance should be closed.

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 Jim Simonis, who represents the Office of Structural Materials for your project.

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer