

**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-000265**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0239**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Bike Path Assemblies
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Bike Path Assemblies Fabricated Without Submitted Welding Sequences/Processes**Description of Non-Conformance:**

It has been observed that ZPMC personnel have started the fabrication of bike path assemblies prior to submitting details of the welding sequences and processes used. A total of 14 bike path assemblies have been fabricated at this time.

**Applicable reference:**

Contract Special Provisions, Section 10-1.59, "WORKING DRAWINGS":

"For box girder, crossbeam, tower, and pipe beam fabrication, shop practices shall be described in the working drawings and shall include the following:

E. Details of tack welds and the sequence of all welding; The welding sequences and processes and specified NDT of shop fabrication shall be summarized in a separate shop drawing or fabrication procedure for each welded joint."

Contract Special Provisions, Section 10-1.59, "DEFINITIONS":

"'Box girder' is defined as the two suspended roadway structures, including all internal structures."

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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“Suspended structure’ is comprised of the box girder, crossbeam and bikepath.”

**Who discovered the problem:** Mahlon Lindenmuth  
**Name of individual from Contractor notified:** Steve Lawton  
**Time and method of notification:** 05/01/09, 16:00, Verbal  
**Name of Caltrans Engineer notified:** Ching Chao  
**Time and method of notification:** 05/01/09, 17:00, Email  
**QC Inspector's Name:** Zhao Shuang Bao  
**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.

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<b>Inspected By:</b>	Guest,Skyler	SMR
<b>Reviewed By:</b>	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, PRC**Report No:** NCS-000772**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0239**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

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

It has been observed that ZPMC personnel have started the fabrication of bike path assemblies prior to submitting details of the welding sequences and processes used. A total of 14 bike path assemblies have been fabricated at this time.

**Contractor's proposal to correct the problem:**

Contractor has provided the fabrication procedure through an RFI discussion. Reference RFI 1690R3 for the latest fabrication sequence.

**Corrective action taken:**

Fabricate and inspect according to the latest procedure.

**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:** Tsang, Eric **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**