

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-000312**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0286**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG Crossbeam CB3**Procedural****Procedural****Description:****Reference Description:** Improper Match Marking, Crossbeam CB3**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to have stenciled match marking identification numbers on two SPCM splice plates using a center punch rather than the required low stress stencil. Both parts are identified as X202E. Both plates are part of OBG crossbeam CB3. They connect the bottom panel of the crossbeam to the east and west lines.

**Applicable reference:**

AWS D1.5 2002 Section 12.4.6: "When heat numbers and other identification markings are applied by die stamping, low-stress dies shall be used."

Who discovered the problem: Steve Hall**Name of individual from Contractor notified:** Peter Ferguson**Time and method of notification:** 10:30, 06-06-09, Email**Name of Caltrans Engineer notified:** Stanley Ku

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 8:00, 06-08-09, Verbal

QC Inspector's Name: Wang Lu

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: 14-Jun-2009

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0286

Job Name: SAS Superstructure
Document No: 05.03.06-000273

Reference Description: Improper Match Marking, Crossbeam CB3

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:** 04

Remarks:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to have stenciled match marking identification numbers on two SPCM splice plates using a center punch rather than the required low stress stencil. Both parts are identified as X202E. Both plates are part of OBG crossbeam CB3. They connect the bottom panel of the crossbeam to the east and west lines. See NCR report No. ZPMC-286 for 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-0286

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: 05.03.06-000273

Subject: NCR No. ZPMC-0286

Dated: 14-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000292 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has provided an internal NCR to identify this nonconformance as well as providing all relative inspection documentation. ZPMC requests closure of this NCR.

ZPMC has provided an internal NCR to identify this nonconformance as well as providing all relative inspection documentation. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000292R00;

Caltrans' comments:

Status: REJ

Date: 18-Aug-2009

The proposed resolution is not acceptable. Per the response to RFI-1894, a repair is required. Please submit the required Critical Weld Repair (CWR) report for the base metal repair, and provide documentation that the repair is acceptable. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0286 at that time.

Submitted by: Wright, Doug

Date: 18-Aug-2009

Attachment(s):



No. B-443

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-11

REGARDING: NCR-000312 (ZPMC-286)

With this letter of response, ZPMC requests closure for Caltrans NCR-000312 (ZPMC-286). We agree what describe in the non-conformance report, and we have instructed the work foreman that will be not allowed to use the center punch to mark the identification on the SPCM parts, but we can use the low stress stencil such as the letter punch not the cusp.

By the way we have submitted one RFI of leaving the CB3 marking plate as them without any repair and waiting for the response from the engineer, so base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report NCR-000312 (ZPMC-286).

Please reference attached document for acceptance and closure the NCR-000312 (ZPMC-286).

ATTACHMENT:

NCR-000312 (ZPMC-286)

ZPMC internal NCR

Zhao Shuangbao

2009.8.11



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-B-193 (NCR-00286) NCR 编号:	
Item: Improper Match Marking 名称描述:		Item Number: N/A 件号:	Drawing: CB3 图号:
Location: CB3 位置:		Date: 2009-06-20 日期:	
Description of Nonconformance: 不符合项状态描述: Caltrans Quality Assurance Inspector observed that the Contractor appears to have stenciled match marking identification numbers on two SPCM splice plates using a center punch rather than the required low stress stencil ,Both parts are identified as X202E. Both plates are part of OBG crossbeam CB3,They connect the bottom panel of the crossbeam to the east and west lines. 加州检验员发现 ZPMC 在两块 SPCM 连接板 X202E 上使用中心冲头敲钢印而不是使用规定低压力模版敲钢印。两块板都是用在 CB3 上的连接板。			
Work By: Li afa IN 施工方:		Prepared by: [Signature] 准备: 09.6.20	Reviewed by QCE: [Signature] 质量工程师批准: 6.20
<input type="checkbox"/> Drawing Error 图纸错误		<input type="checkbox"/> Material Defect 材料缺陷	<input type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因			
Disposition: <input checked="" type="checkbox"/> Use as is 处理措施: 回用		<input type="checkbox"/> Repair 返修	
<input type="checkbox"/> Reject 拒收			
Recommendation: 建议:			
Prepared by: _____ 准备		Approved by QCA: _____ 质量经理批准	
Reason for Nonconformance: 两块 不符合原因: 在 CB3 上的连接板使用中心冲头敲钢印而不是用低压力模版敲钢印, required low stress stencil. On two CB3 connect plates, use a center punch rather than the required low stress stencil. 预防措施: Enhance supervision and inspection, and educate worker to use low stress stencil. 加强监督和检查, 教育工人使用低压力模版敲钢印.			
Approved by/批准: Gao Jun 09.6.21			
Technical Justification for Use-As-Is/Repair: <input type="checkbox"/> Attachment <input checked="" type="checkbox"/> Non-attachment 回用或返修的技术依据: 翻以后用低应力冲头敲钢印, 对相关人员进行教育, 杜绝类似问题再次发生. Low stress stencil shall be used on this kind of occasion afterwards, meanwhile, workers should learn from this incident and don't make this kind of thing happen again.			
Reviewed /批准: Tang Yongbo			
Verification: <input type="checkbox"/> Acceptable 确认: 可接受		<input type="checkbox"/> Unacceptable 不可接受	
Verified by QCI/质检确认: _____		Reviewed by QCA/质检主任审核: _____	



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: 14-Jun-2009

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

Dear: Mr. Charles Kanapicki
 Attention: Mr. Thomas Nilsson Project/Fabrication Manager
 Subject: NCR No. ZPMC-0286

Job Name: SAS Superstructure
 Document No: 05.03.06-000273

Reference Description: Improper Match Marking, Crossbeam CB3

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: 04

Remarks:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to have stenciled match marking identification numbers on two SPCM splice plates using a center punch rather than the required low stress stencil. Both parts are identified as X202E. Both plates are part of OBG crossbeam CB3. They connect the bottom panel of the crossbeam to the east and west lines. See NCR report No. ZPMC-286 for 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-0286

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Ching Chao
 File: 05.03.06

02.02:15.04
 05.03.06-000273,NCT

Received
 NCT-000273 15 JUN 09 Page 1 of 1

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

City: 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-000312

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 06-Jun-2009

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

NCR #: ZPMC-0286

Type of problem:

Welding Concrete Other Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

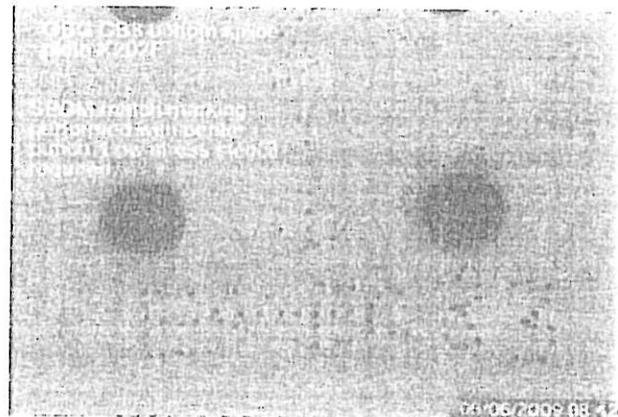
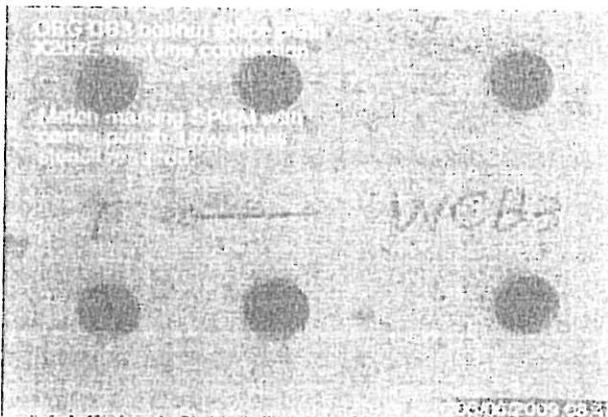
Component: OBG Crossbeam CB3

Procedural Procedural Description:

Reference Description: Improper Match Marking, Crossbeam CB3

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to have stenciled match marking identification numbers on two SPCM splice plates using a center punch rather than the required low stress stencil. Both parts are identified as X202E. Both plates are part of OBG crossbeam CB3. They connect the bottom panel of the crossbeam to the east and west lines.



Applicable reference:

AWS D1.5 2002 Section 12.4.6: "When heat numbers and other identification markings are applied by die stamping, low-stress dies shall be used."

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 10:30, 06-06-09, Email

Name of Caltrans Engineer notified: Stanley Ku

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 8:00, 06-08-09, Verbal

QC Inspector's Name: Wang Lu

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
---------------------	---------------	-----

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000273

Subject: NCR No. ZPMC-0286

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000292 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ABF has instructed ZPMC to grind off the punch marks, weld repair if necessary and submit a report documenting the repair.

ABF has instructed ZPMC to grind off the punch marks, weld repair if necessary and submit a report documenting the repair. ZPMC will submit the necessary inspection reports at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000292R01

Caltrans' comments:

Status: AAP

Date: 28-Aug-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-0286 at that time.

Submitted by: Wright, Doug

Date: 28-Aug-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000273

Subject: NCR No. ZPMC-0286

Dated: 27-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000292 **Rev:** 02

Contractor's Proposed Resolution:

Reference Resolution: Attached is documented evidence the work required addressing removing the unapproved punch marks has been completed. Finished work can be verified via the closed out punch list item on site.

Attached is documented evidence the work required addressing removing the unapproved punch marks has been completed. Finished work can be verified via the closed out punch list item on site. ZPMC request closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000292R02;

Caltrans' comments:

Status: CLO

Date: 01-Sep-2009

The proposed resolution is acceptable. The Department has verified that the unacceptable punch marks were ground sufficiently to satisfy the code requirement. The Department concurs that Non-Conformance ZPMC-0286 is closed.

Submitted by: Wright, Doug

Date: 01-Sep-2009

Attachment(s):



No. B-463

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-26

REGARDING: NCR-000312 (ZPMC-286)

With this letter of response, ZPMC requests closure for Caltrans NCR-000312 (ZPMC-286). We have completely removed the punch indication just by grinding on a little more extendable round. After re-blasting and the primer coating, the Caltrans and ABF inspectors have verified the final condition by visual. The corresponding items in the punchlist all have been closed out with the three parties. By the way we remind here that we marked the new trace number with the low stress stencil.

So based on the above explanation, ZPMC applies to close the Caltrans's report NCR-000312 (ZPMC-286).

Please reference attached document for acceptance and closure of the NCR-000312 (ZPMC-286).

ATTACHMENT:

NCR-000312 (ZPMC-286)

zhao Shuangbao

2009.8.26

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-000312

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 06-Jun-2009

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

NCR #: ZPMC-0286

Type of problem:

Welding Concrete Other

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

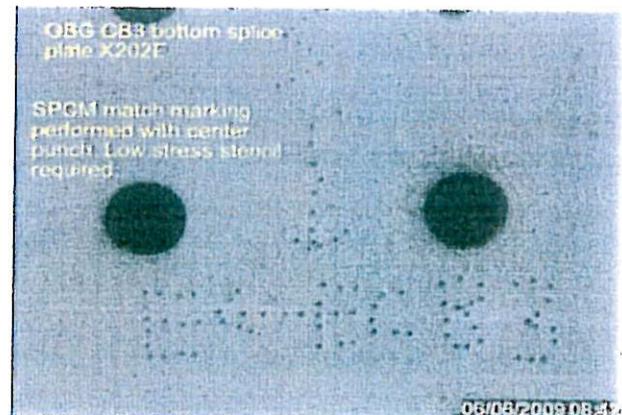
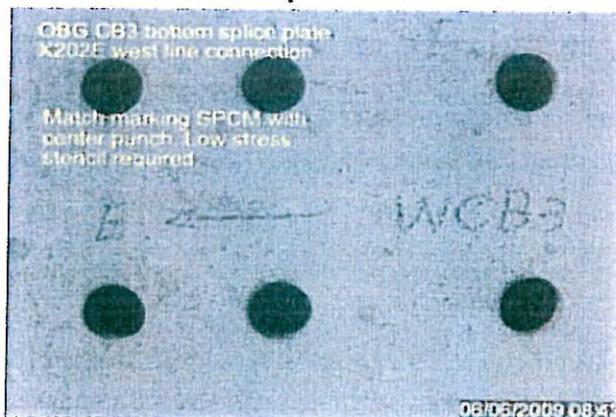
Joint fit-up Coating Other **Component:** OBG Crossbeam CB3

Procedural Procedural Description:

Reference Description: Improper Match Marking, Crossbeam CB3

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to have stenciled match marking identification numbers on two SPCM splice plates using a center punch rather than the required low stress stencil. Both parts are identified as X202E. Both plates are part of OBG crossbeam CB3. They connect the bottom panel of the crossbeam to the east and west lines.



Applicable reference:

AWS D1.5 2002 Section 12.4.6: "When heat numbers and other identification markings are applied by die stamping, low-stress dies shall be used."

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 10:30, 06-06-09, Email

Name of Caltrans Engineer notified: Stanley Ku

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000279**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0286**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: 06-Jun-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to have stenciled match marking identification numbers on two SPCM splice plates using a center punch rather than the required low stress stencil. Both parts are identified as X202E. Both plates are part of OBG crossbeam CB3. They connect the bottom panel of the crossbeam to the east and west lines.

Contractor's proposal to correct the problem:

Contractor has acknowledged that this item must be addressed, and the item was added to the Master Punchlist.

Corrective action taken:

Work was completed and item was cleared on Master Punchlist by Caltrans on 6-2-2009. Submittal of documentation by Contractor being tracked on Documentation Punchlist.

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**