

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



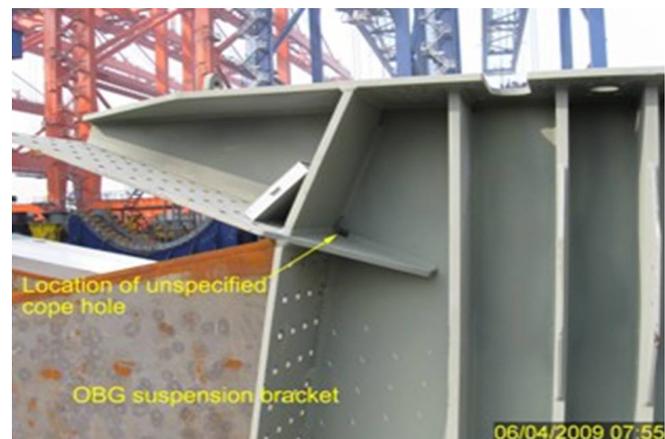
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000314**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0288**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG Suspender Brackets**Procedural****Procedural****Description:**

Reference Description: Fabrication that does not comply with the contract drawings, OBG suspender brackets

Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to either have a complete joint penetration (CJP) weld that has not been completed, or has an unspecified cope hole that is not identified on the approved contract drawings. The weld in question is located on the suspender brackets where the deck panel mounting flange (X53B) intersects and welds to the web plate. This condition was observed on Suspender Brackets SB20E, SB20W, SB22E, SB22W, SB24E, SB24W, SB26E, SB26W, SB28E and SB28W.

**Applicable reference:**

Shop detail drawings SB2, SB3 and SB6

Who discovered the problem: Steve Hall**Name of individual from Contractor notified:** Peter Ferguson**Time and method of notification:** 1030 hours, 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: 0800 hours, 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
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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: 14-Jun-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: 05.03.06-000279

Subject: NCR No. ZPMC-0288

Reference Description: Fabrication that does not comply with the contract drawings, OBG suspender brackets

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:**

Remarks:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to either have a complete joint penetration (CJP) weld that has not been completed, or has an unspecified cope hole that is not identified on the approved contract drawings. The weld in question is located on the suspender brackets where the deck panel mounting flange (X53B) intersects and welds to the web plate. This condition was observed on Suspender Brackets SB20E, SB20W, SB22E, SB22W, SB24E, SB24W, SB26E, SB26W, SB28E and SB28W.

See NCR report No. ZPMC-288 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences and with a repair procedure for addressing the material/workmanship issue in compliance with the contract documents.

Transmitted by: Ching Chao

Attachments: ZPMC-0288

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: 05.03.06-000279

Subject: NCR No. ZPMC-0288

Dated: 14-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000293 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has provided an internal NCR to identify this nonconformance as well as providing statement of work performed. ZPMC requests closure of this NCR.

ZPMC has provided an internal NCR to identify this nonconformance as well as providing statement of work performed. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000293R00;

Caltrans' comments:

Status: CLO

Date: 18-Aug-2009

The proposed resolution is acceptable. This detail is according to what is shown on the contract drawings, and each of the cope holes mentioned in the Non-Conformance has been ground smooth and uniform. The Department concurs that Non-Conformance ZPMC-0288 is closed.

Submitted by: Wright, Doug

Date: 18-Aug-2009

Attachment(s):



No. B-442

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-11

REGARDING: NCR-000314 (ZPMC-288)

With this letter of response, ZPMC requests closure for Caltrans NCR-000314 (ZPMC-288). We agree what describe in the non-conformance report, and we have smooth ground all of the cope hole and made the round flush and uniform in each suspender bracket which mentioned in the NCR. By the way the whole holes final condition have been verify by the inspector and closed out the corresponding items in the punchlist.

So base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report NCR-000314 (ZPMC-288).

Please reference attached document for acceptance and closure the NCR-000314 (ZPMC-288).

ATTACHMENT:

NCR-000314 (ZPMC-288)
ZPMC internal NCR

zhuo shuangbao

2009.8.11

*Following Discussions in
China it was agreed that
this detail is what is shown
on contract drawings,
J. Hunt
ABF QUM
14 AUG. 09*



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 编号: NCR-B-195 (ZPMC-0288)

Item: Fabrication that does not comply with the contract drawings
 名称描述: 不符图纸要求的过焊孔

Item Number: OBG 1BW
 件号: OBG 1BW

Drawing: OBG suspender brackets
 图号: OBG suspender brackets

Location: OBG suspender brackets
 位置: 悬索支架

Date: 2009-06-20
 日期: 2009-06-20

Description of Nonconformance:
 不符合项状态描述:

Caltrans Quality inspector observe that the contractor appear to either have a complete joint penetration(CJP)weld that has not been completed ,or has an unspecified cope hole that is not identified on the approved contract drawings, The weld in question is located on the suspender brackets where the deck panel mounting flange(X53B)intersects and welds to the web plate ,This condition was observed on suspender brackets SB20E, SB20W, SB22E, B22W, SB24E, SB24W, SB26E, SB26W,SB28E,and SB28W.

加州检验在 ZPMC 已制作完成的悬索支架上发现过焊孔未按照图纸要求制作,具体位置在顶部板上的发栏板 X53B。以下悬索支架都有此类问题 SB20E, SB20W, SB22E, B22W, SB24E, SB24W, SB26E, SB26W,SB28E,and SB28W.

Work By: *John Mi Bin* Prepared by: *Wang* Reviewed by QCE: *Wang*
 施工方: *John Mi Bin* 准备: *Wang* 质量工程师批准: *Wang*

Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
 处理措施: 回用 返修 拒收

Recommendation:
 建议:

Prepared by: _____ Approved by QCA: _____
 准备 质量经理批准

Reason for Nonconformance:
 不符合原因:
 因悬索支架顶部板上的法兰板 X53B 位置的过焊孔未 达到图纸要求。
 The unspecified cope hole wasn't identified on the approved contract drawing at suspender bracket deck panel mounting flange (X53B).

Prevention of Re-occurrence:

预防措施:

加强现场^{附件}监控和检查
Enhance supervision and inspection on-site.

Approved by/批准: G 40 Jun 09 06.22

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment

回用或返修的技术依据:

将过焊孔打磨光滑, 并对每个制作错误的悬索支架过焊孔一一检查, 确定是否打磨光滑到位。
同时, 加强现场监控的检查力度严格按照图纸要求进行制作。
Grind the unspecified cope hole to a smooth and shiny finish, and check every unspecified cope hole on the wrong fabricated suspender brackets to ensure all the grindings meet the requirement; meanwhile, enhance supervision and inspection on-site and fabricate in accordance with the shop drawing strictly.

Reviewed/批准: Tong Yongbo

Verification: Acceptable Unacceptable

确认: 可接受 不可接受

Verified by QCI/质检确认: _____ Reviewed by QCA/质检主任审核: _____

En/1001

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
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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-0288

Job Name: SAS Superstructure
Document No: 05.03.06-000279

Reference Description: Fabrication that does not comply with the contract drawings, OBG suspender brackets

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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- 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:

Remarks:

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to either have a complete joint penetration (CJP) weld that has not been completed, or has an unspecified cope hole that is not identified on the approved contract drawings. The weld in question is located on the suspender brackets where the deck panel mounting flange (X53B) intersects and welds to the web plate. This condition was observed on Suspender Brackets SB20E, SB20W, SB22E, SB22W, SB24E, SB24W, SB26E, SB26W, SB28E and SB28W.

See NCR report No. ZPMC-288 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences and with a repair procedure for addressing the material/workmanship issue in compliance with the contract documents.

Transmitted by: Ching Chao

Attachments: ZPMC-0288

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

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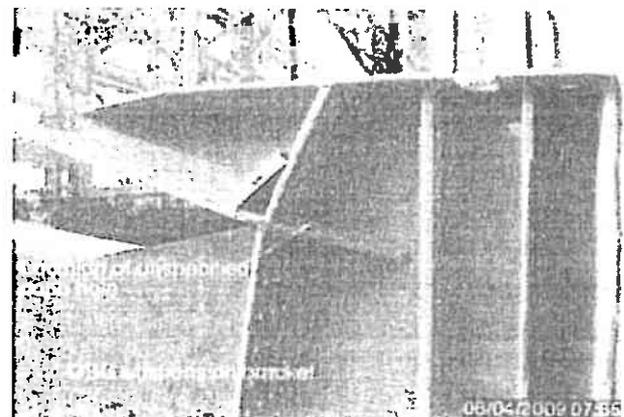
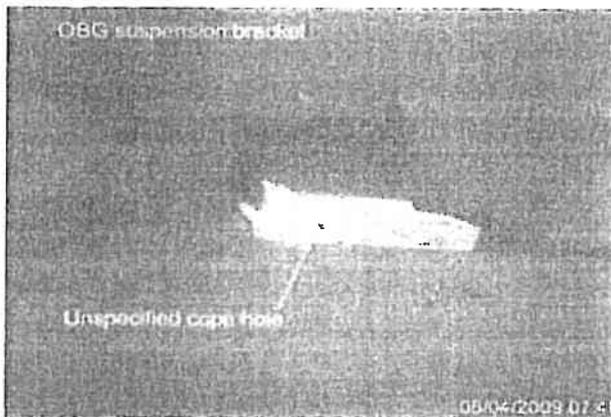
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China**Report No:** NCR-000314**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Jun-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0288**Type of problem:**Welding Concrete Other Welding Curing Procedural **Bridge No:** 34-0006Joint fit-up Coating Other **Component:** OBG Suspender BracketsProcedural Procedural Description:**Reference Description:** Fabrication that does not comply with the contract drawings, OBG suspender brackets**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed that the Contractor appears to either have a complete joint penetration (CJP) weld that has not been completed, or has an unspecified cope hole that is not identified on the approved contract drawings. The weld in question is located on the suspender brackets where the deck panel mounting flange (X53B) intersects and welds to the web plate. This condition was observed on Suspender Brackets SB20E, SB20W, SB22E, SB22W, SB24E, SB24W, SB26E, SB26W, SB28E and SB28W.

**Applicable reference:**

Shop detail drawings SB2, SB3 and SB6

Who discovered the problem: Steve Hall**Name of individual from Contractor notified:** Peter Ferguson**Time and method of notification:** 1030 hours, 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: 0800 hours, 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

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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-000278**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0288**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 either have a complete joint penetration (CJP) weld that has not been completed, or has an unspecified cope hole that is not identified on the approved contract drawings. The weld in question is located on the suspender brackets where the deck panel mounting flange (X53B) intersects and welds to the web plate. This condition was observed on Suspender Brackets SB20E, SB20W, SB22E, SB22W, SB24E, SB24W, SB26E, SB26W, SB28E and SB28W.

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 last item was cleared on Master Punchlist by Caltrans on 6-5-2009. 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