

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-000350**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Jul-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0324**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG Segments 6AW, 7BW, 7DE, and 7DW**Procedural****Procedural****Description:****Reference Description:** Cope Holes not to Specification**Description of Non-Conformance:**

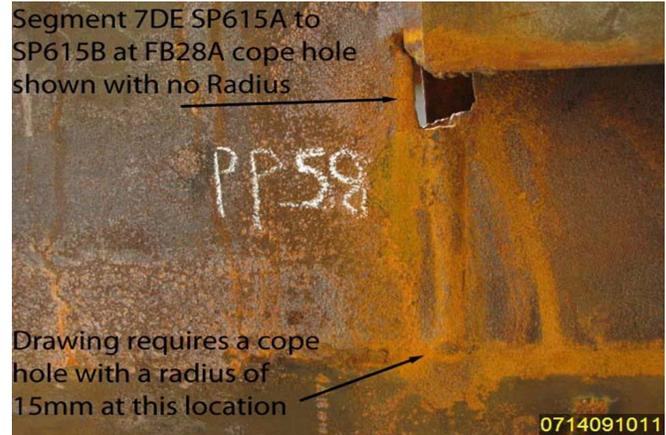
During in-process visual inspection of Segments 6AW, 7BW, 7DE, and 7DW Caltrans Quality Assurance Inspector observed cope hole sizes and locations do not comply with the approved shop drawings. Cope holes are located at the side panel (SP) complete joint penetration (CJP) butt welds and the bottom plates where the FL3 type floor beam (FB) penetrates through the side plates. Additionally, cope holes do not exhibit a smooth transition free from notches. Listed below are the locations of the cope holes.

Segment	Panel Point	SP to SP	Floor Beam	Required Cope Hole Size	Remarks
6AW	38	SP751A-SP751B	FB19A	R=25mm	Needs to be ground smooth
6AW	38	SP751A-SP751B	FB19A	R=25mm	Needs to be ground smooth
6AW	38	SP751A-SP751B	FB19A	R=15mm	Hole is missing
6AW	39	SP751B-SP752A	FB29A	R=25mm	Needs to be ground smooth
6AW	39	SP751B-SP752A	FB29A	R=15mm	Hole is missing
6AW	40	SP752A-SP752B	FB33A	R=25mm	Needs to be ground smooth
6AW	40	SP752A-SP752B	FB33A	R=15mm	Hole is missing
7BW	50	SP757A-SP757B	FB39A	R=25mm	Needs to be ground smooth
7BW	50	SP757A-SP757B	FB39A	R=15mm	Hole is missing
7BW	51	SP757B-SP758A	FB23A	R=25mm	Needs to be ground smooth
7BW	51	SP757B-SP758A	FB23A	R=15mm	Hole is missing
7BW	52	SP758A-SP758B	FB27B	R=25mm	Needs to be ground smooth
7BW	52	SP758A-SP758B	FB27B	R=15mm	Hole is missing
7DE	56	SP614A-SP614B	FB20B	R=25mm	Needs to be ground smooth
7DE	56	SP614A-SP614B	FB20B	R=15mm	Hole is missing
7DE	57	SP614B-SP615A	FB24A	R=25mm	Needs to be ground smooth
7DE	57	SP614B-SP615A	FB24A	R=15mm	Hole is missing
7DE	58	SP615A-SP615B	FB28A	R=25mm	Needs to be ground smooth
7DE	58	SP615A-SP615B	FB28A	R=15mm	Hole is missing

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

7DW	56	SP760A-SP760B	FB19B	R=25mm	Needs to be ground smooth
7DW	56	SP760A-SP760B	FB19B	R=15mm	Hole is missing
7DW	57	SP760B-SP761A	FB23A	R=25mm	Needs to be ground smooth
7DW	57	SP760B-SP761A	FB23A	R=15mm	Hole is missing
7DW	58	SP761A-SP761B	FB27A	R=25mm	Needs to be ground smooth
7DW	58	SP761A-SP761B	FB27A	R=15mm	Hole is missing



Applicable reference:

1. Side Plate Sub-Assembly Drawings SP615, SP615, SP751, SP752, SP757, SP758, SP760, and SP761. Standard Details Drawing SD5 details "5A", "5B", "5C", and "5D" Radius details.
2. AWS D1.5, Paragraph 3.2.5 "Radii of beam copes and weld access holes shall provide a smooth transition, free from notches or cutting past the points of tangency between adjacent surfaces.

Who discovered the problem: Erik Prue
Name of individual from Contractor notified: Man Kit Le
Time and method of notification: 1630, Verbal
Name of Caltrans Engineer notified: Shen Xuejun
Time and method of notification: Ching Chao
QC Inspector's Name: 08:00, Verbal
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 Mazen Wahbeh,(818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Simonis,Jim	QA Inspector
Reviewed By: Wahbeh,Mazen	SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 05-Aug-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-0324

Job Name: SAS Superstructure
Document No: 05.03.06-000332

Reference Description: Cope Holes not to Specification

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:** 07

Remarks:

During in-process visual inspection of Segments 6AW, 7BW, 7DE, and 7DW Caltrans Quality Assurance Inspector observed cope hole sizes and locations do not comply with the approved shop drawings. Cope holes are located at the side panel (SP) complete joint penetration (CJP) butt welds and the bottom plates where the FL3 type floor beam (FB) penetrates through the side plates. Additionally, cope holes do not exhibit a smooth transition free from notches. Listed below are the locations of the cope holes.

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(Continued Page 2 of 2)

7DW	56	SP760A-SP760B	FB19B	R=15mm	Hole is missing
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Action Required and/or Action Taken:

Install and modify cope holes to conform to shop drawings.

Transmitted by: Bill Howe

Attachments: ZPMC-0324

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Brian Boal, Doug Coe, Jason Tom, Contract Files

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000332

Subject: NCR No. ZPMC-0324

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000323 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is currently completing the work. Final inspection will be performed and documented as such during final VT inspection prior to blasting.

ZPMC has informed ABF that the cope holes are not final inspected and therefore are considered inprocess. ZPMC is currently completing the work. Final inspection will be performed and documented as such during final VT inspection prior to blasting. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000323R00

Caltrans' comments:

Status: CLO

Date: 28-Aug-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0324 is closed.

Submitted by: Wright, Doug

Date: 28-Aug-2009

Attachment(s):

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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-000362**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0324**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: 14-Jul-2009**Description of Non-Conformance:**

During in-process visual inspection of Segments 6AW, 7BW, 7DE, and 7DW Caltrans Quality Assurance Inspector observed cope hole sizes and locations do not comply with the approved shop drawings. Cope holes are located at the side panel (SP) complete joint penetration (CJP) butt welds and the bottom plates where the FL3 type floor beam (FB) penetrates through the side plates. Additionally, cope holes do not exhibit a smooth transition free from notches. Listed below are the locations of the cope holes.

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