

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-000376**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Jul-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0350**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Bottom Panel
Procedural	Procedural	Description:	

Reference Description: Missed MT Transverse Indication by QC on Bottom Panel 3019 (Seg 12BE)**Description of Non-Conformance:**

During random verification Magnetic Particle Testing of the internal components of OBG Bottom Plate. Caltrans Quality Assurance (QA) Inspector discovered one (1) Transverse Indication 15mm in length. This indication was located in the weld metal of component BP3019-001-108 for Segment 12BE. This weld area was outside ZPMC's percentage of NDT testing and was not previously tested and accepted.

**Applicable reference:**

-AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

-Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

Who discovered the problem: Chandrakumar S.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Hu Gui Hua

Time and method of notification: 1630 hours, verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 0800 hours, verbal

QC Inspector's Name: Liu Fa Wen

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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, +(86) 134.7247.7571, 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

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: 16-Aug-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: 05.03.06-000339

Subject: NCR No. ZPMC-0350

Reference Description: Missed MT Transverse Indication by QC on Bottom Panel 3019 (Seg 12BE)

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:** 12

Remarks:

During random verification Magnetic Particle Testing of the internal components of OBG Bottom Plate. Caltrans Quality Assurance (QA) Inspector discovered one (1) Transverse Indication 15mm in length. This indication was located in the weld metal of component BP3019-001-108 for Segment 12BE. This weld area was outside ZPMC's percentage of NDT testing and was not previously tested and accepted.

Action Required and/or Action Taken:

Submit repair procedure to engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0350

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: 05.03.06-000339

Subject: NCR No. ZPMC-0350

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000344 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has notified ZPMC of the missed MT indications and ZPMC has completed the necessary repairs. ABF is also conducting an investigation of why ZPMC is experiencing cracking of welds.

ABF has notified ZPMC of the missed MT indications and ZPMC has completed the necessary repairs. ABF has taken action by hiring several MT technicians to perform overchecks of several types of welds due to the amount of missed indications. ABF is also conducting an investigation of why ZPMC is experiencing cracking of welds. This investigation is being performed by both onsite ABF personnel as well as welding experts hired by ABF for this purpose. Recently CT has brought in their own welding consultant to discuss ABF findings and preventive actions. Preventive actions such as increased preheats have been discussed with ZPMC. When the investigation is completed, ABF will submit the findings to ZPMC and CT. ABF will continue to perform overchecks until we are sure this issue is corrected and preventive actions are implemented. ZPMC will submit the repair documents at a later date to close this NCR.

Submitted by:

Attachment(s): ABF-NPR-000344R00

Caltrans' comments:

Status: AAP

Date: 09-Sep-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-0350 at that time.

Submitted by: Wright, Doug

Date: 09-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000339

Subject: NCR No. ZPMC-0350

Dated: 22-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000344 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ABF is submitting NDT documentation to show that welds with missed indications are acceptable after repair.

Per discussion in China with representatives of the Department, ABF is submitting NDT documentation to show that welds with missed indications are acceptable after repair. To clarify the panel was incorrectly identified as belonging to segment 12BE, it is actually located in 12AW. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000344R01;

Caltrans' comments:

Status: CLO

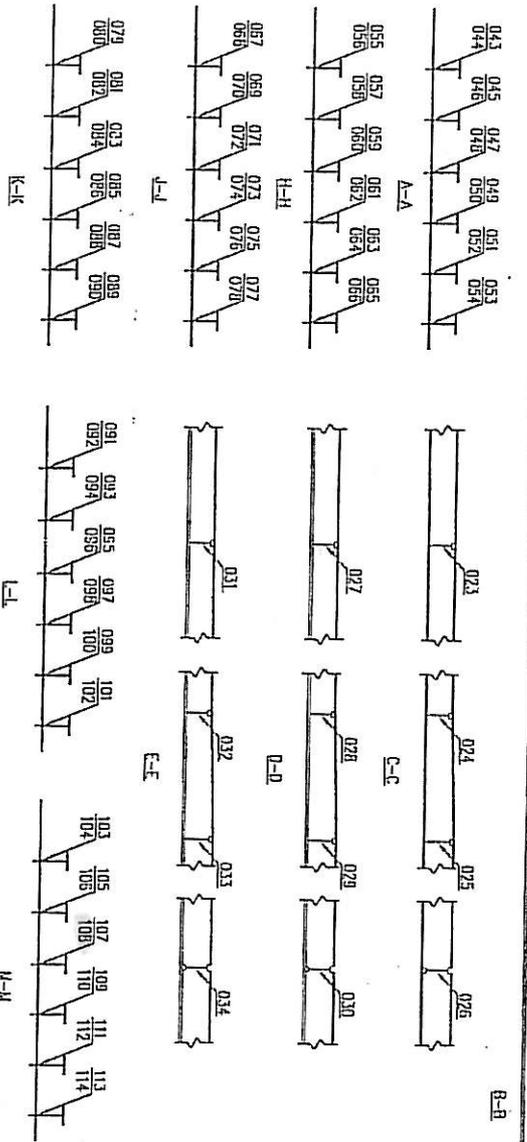
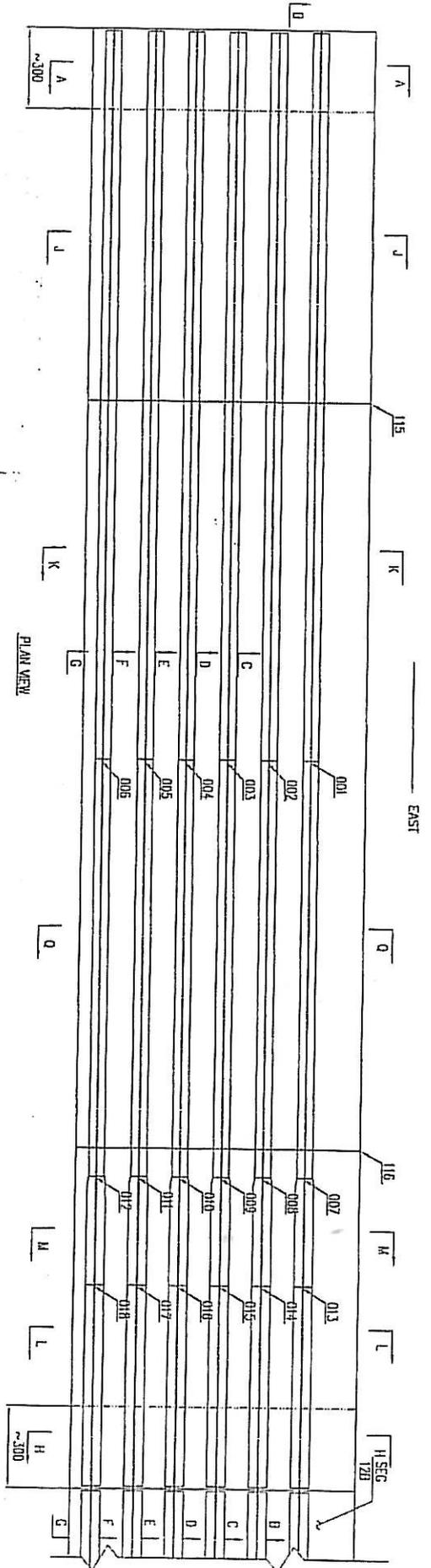
Date: 26-Jan-2010

The documentation submitted by the contractor has been reviewed by the Engineer and is found to be acceptable.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010



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注: 上标为最外层焊缝, 中为内层
 且为工段标注符号

ZPMC
 WELDING MAP
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DEPARTMENT OF TRANSPORTATION

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Bay Area Branch
690 Walnut Ave. St. 150
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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-000485**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0350**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: 29-Jul-2009**Description of Non-Conformance:**

During random verification Magnetic Particle Testing of the internal components of OBG Bottom Plate. Caltrans Quality Assurance (QA) Inspector discovered one (1) Transverse Indication 15mm in length. This indication was located in the weld metal of component BP3019-001-108 for Segment 12BE. This weld area was outside ZPMC's percentage of NDT testing and was not previously tested and accepted.

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

The indication in question was discovered outside of the area inspected ZPMC QC Technicians, thus the Non Conformance will be closed and the repair will be tracked on the 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:**

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Inspected By: Simonis, Jim Quality Assurance Inspector**Reviewed By:** Wahbeh, Mazen QA Reviewer