

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, PRC

Report No: NCR-000386

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 16-Aug-2009

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

NCR #: ZPMC-0360

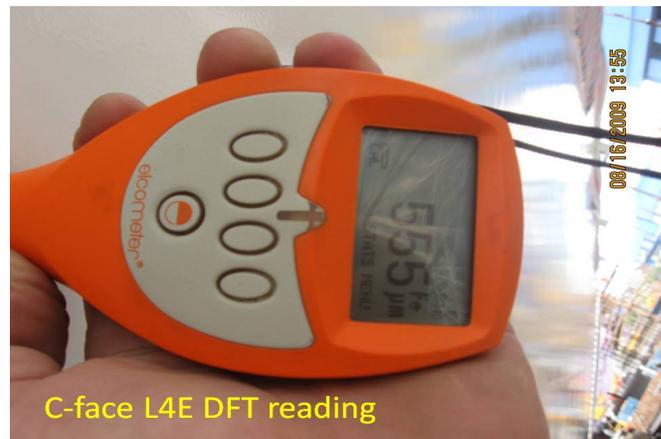
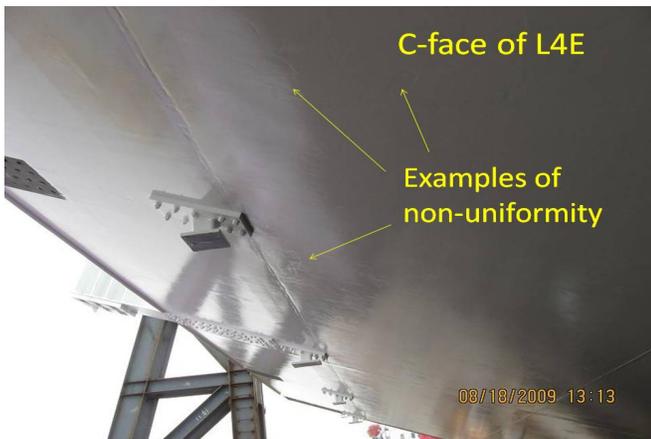
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift L4E
Procedural	Procedural	Description:	

Reference Description: Excessive DFTs, Non-uniform Paint Surface, Lift L4E

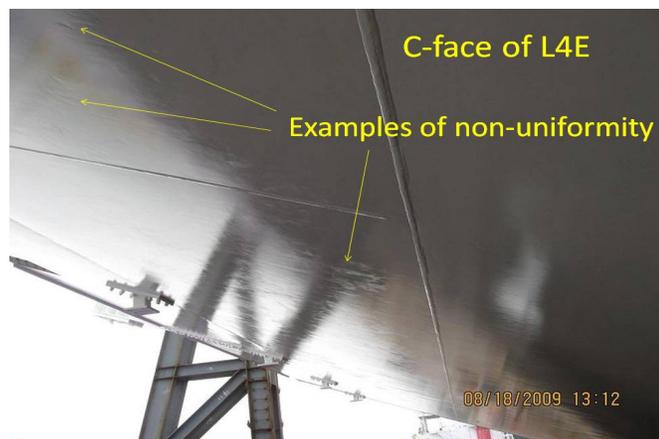
Description of Non-Conformance:

The exterior coating of Lift L4E is unsatisfactory per contract requirements. The dry film thickness (DFT) readings at multiple areas exceed the Special Provisions requirement of 325 μ m and also exceed the maximum allowable spot value of 390 μ m (per SSPC PA2). The painted surface does not possess a uniform appearance. Numerous scabs, scars, and cupped areas from previous applications of the paint system are visible through the most recent application of topcoat. These paint-based blemishes and the general areas where thin DFTs are adjacent to excessively thick DFTs distort the surface finish, resulting in non-uniformity.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Special Provisions: Section 10-1.69 Clean and Paint Structural Steel: Finish Paint: “The total dry film thickness of all applications of inorganic zinc and finish coat paint shall be not less than 200 μ m nor more than 325 μ m.”

Special Provisions: Section 10-1.69 Clean and Paint Structural Steel: Field Repair of Damaged Areas: “All repairs shall be made in a manner to blend the patched area with the adjacent coating. The finished surface of the patched area shall have a smooth even profile with the adjacent surface. The first repair area shall be used as a test section and no more repairs made until the methods are approved by the Engineer. Finish coat repairs shall be applied by either brush or spray. Damaged paint which will be inaccessible for coating after erection shall be repaired and recoated prior to erection.”

Caltrans Standard Specifications, 1999, Section 59-1.03: “Runs, sags, thin and excessively thick areas in the paint film, skips and holidays, or areas of non uniform appearance shall be considered as evidence that the work is unsatisfactory, and the Contractor may be required to blast clean the areas and reapply the paint.”

Who discovered the problem: James Lumley

Name of individual from Contractor notified: Bill Oak

Time and method of notification: 2009/08/16, 14:30, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 2009/08/17, 7:30, Verbal

QC Inspector's Name: Wong Wei

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, 15000422360, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Inspected By: Guest,Skylar

SMR

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: 31-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: 05.03.06-000349

Subject: NCR No. ZPMC-0360

Reference Description: Excessive DFTs, Non-uniform Paint Surface, Lift L4E

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:** 04

Remarks:

The exterior coating of Lift L4E is unsatisfactory per contract requirements. The dry film thickness (DFT) readings at multiple areas exceed the Special Provisions requirement of 325µm and also exceed the maximum allowable spot value of 390µm (per SSPC PA2). The painted surface does not possess a uniform appearance. Numerous scabs, scars, and cupped areas from previous applications of the paint system are visible through the most recent application of topcoat. These paint-based blemishes and the general areas where thin DFTs are adjacent to excessively thick DFTs distort the surface finish, resulting in non-uniformity.

Action Required and/or Action Taken:

Submit a repair plan indicating method to spray an even finish coat.

Transmitted by: Bill Howe

Attachments: ZPMC-0360

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: 05.03.06-000349

Subject: NCR No. ZPMC-0360

Dated: 16-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000356 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABFJV had previously rejected the exterior coating of Lift L4E prior to the CT NCR being issued and already informed ZPMC of remedial actions to be taken. ZPMC requests closure of this NCR.

ABFJV had previously rejected the exterior coating of Lift L4E prior to the CT NCR being issued and already informed ZPMC of remedial actions to be taken, therefore ABFJV takes exception to this NCR. Remedial action includes the items listed in the CT NCR. Inspections will be carried out as normal and documentation will be submitted to CT as all other paint inspection documents. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000356R00

Caltrans' comments:

Status: AAP

Date: 22-Sep-2009

Paint repair work is still ongoing at 4E. Will close NCR after work is completed, accepted and documentation is confirmed.

Submitted by: Chao, Ching

Date: 22-Sep-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000349

Subject: NCR No. ZPMC-0360

Dated: 16-Nov-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000356 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC successfully re-blasted and coated the area in question. This was confirmed by Caltrans. ZPMC requests closure of this NCR.

ZPMC successfully re-blasted and coated the area in question. This was confirmed by Caltrans. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000356R01

Caltrans' comments:

Status: CLO

Date: 16-Nov-2009

CT staff verified the post-repair results to be satisfactory.

Submitted by: Chao, Ching

Date: 16-Nov-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-000388**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0360**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: 16-Aug-2009**Description of Non-Conformance:**

The exterior coating of Lift L4E is unsatisfactory per contract requirements. The dry film thickness (DFT) readings at multiple areas exceed the Special Provisions requirement of 325µm and also exceed the maximum allowable spot value of 390µm (per SSPC PA2). The painted surface does not possess a uniform appearance. Numerous scabs, scars, and cupped areas from previous applications of the paint system are visible through the most recent application of topcoat. These paint-based blemishes and the general areas where thin DFTs are adjacent to excessively thick DFTs distort the surface finish, resulting in non-uniformity.

Contractor's proposal to correct the problem:

Reblast and repaint surface.

Corrective action taken:

Entire surface was reblasted/repainted and is acceptable per contract requirements.

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 Skyler Guest, 15000422360, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer