

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-000390

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 20-Aug-2009

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

NCR #: ZPMC-0364

Type of problem:

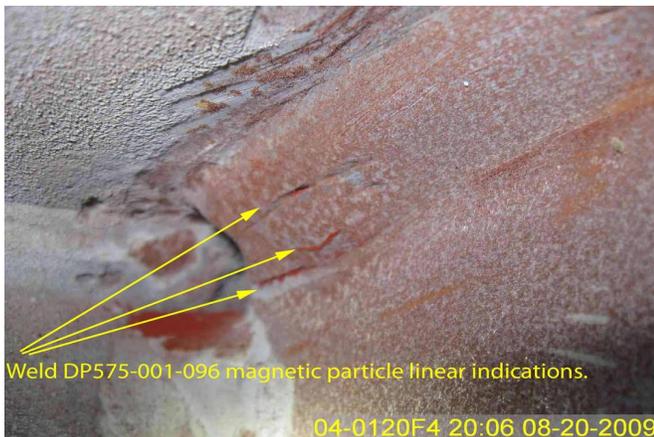
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 1AW
Procedural	Procedural	Description: Missed MT indication	

Reference Description: Missed MT Indications by QC on OBG Segment 1AW

Description of Non-Conformance:

During random Visual Inspections and Magnetic Particle Testing (MT) of welds at panel point 10, Segment 1AW, this Caltrans Quality Assurance (QA) Inspector observed the following: Weld DP575-001-096 has multiple magnetic particle linear indications and is visually rejected; weld DP570-001-096 is visually rejected.

ZPMC CWI Mr. Yumin Xu agreed that both welds listed above are visually unacceptable due to weld contour and spatter. These inspections were performed as requested by ZPMC NDT Inspection Notification Sheet 004018 which indicates ZPMC has accepted the visual and magnetic particle inspections of these welds. See the photographs below for additional information.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

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.”

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

Who discovered the problem: Paul Dawson

Name of individual from Contractor notified: Ji Wei Chen

Time and method of notification: 2045 hours, verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1300 hours, verbal

QC Inspector's Name: Yumin Xu

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: 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: 05.03.06-000353

Subject: NCR No. ZPMC-0364

Reference Description: Missed MT Indications by QC on OBG Segment 1AW

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:** 01

Remarks:

During random Visual Inspections and Magnetic Particle Testing (MT) of welds at panel point 10, Segment 1AW, this Caltrans Quality Assurance (QA) Inspector observed the following: Weld DP575-001-096 has multiple magnetic particle linear indications and is visually rejected; weld DP570-001-096 is visually rejected.

ZPMC CWI Mr. Yumin Xu agreed that both welds listed above are visually unacceptable due to weld contour and spatter. These inspections were performed as requested by ZPMC NDT Inspection Notification Sheet 004018 which indicates ZPMC has accepted the visual and magnetic particle inspections of these welds. See the photographs below for additional information.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval.

Note: Missing indications on welds after they have been accepted by ZPMC welding inspectors is frequent.

Transmitted by: Bill Howe

Attachments: ZPMC-0364

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: 05.03.06-000353

Subject: NCR No. ZPMC-0364

Dated: 21-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000360 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC MT technicians have been under gone training and testing due to the amount of missed indications found, ABF has implemented overchecks on several welds within the OBG

ZPMC MT technicians have been under gone training and testing due to the amount of missed indications found, ABF has implemented overchecks on several welds within the OBG to prevent unacceptable welds from being passed on to CT. ABF has also performed an investigation regarding cracks found during ZPMC, ABF and CT inspections to find a means to prevent these defects from occurring in the first place. As for the specific welds related to this NCR, ZPMC will perform the necessary repairs and submit the repair and inspection documents at a later date for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000360R00

Caltrans' comments:

Status: AAP

Date: 22-Sep-2009

Will review and confirm the acceptance when the repair documentation is submitted.

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: 05.03.06-000353

Subject: NCR No. ZPMC-0364

Dated: 26-Oct-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000360 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has submitted documentation of NDT of the weld after the indication was discovered which shows that the weld is acceptable. The documentation is available on the electronic database.

ZPMC has submitted documentation of NDT of the weld after the indication was discovered which shows that the weld is acceptable. The documentation is available on the electronic database. ZPMC requests closure of the NCR.

Submitted by:

Attachment(s): ABF-NPR-000360R01

Caltrans' comments:

Status: CLO

Date: 11-Nov-2009

The NDT reports have been verified to be sufficient in the QA database.

Submitted by: Chao, Ching

Date: 11-Nov-2009

Attachment(s):

DEPARTMENT OF TRANSPORTATION

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Vallejo, CA 94592-1133
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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-000364**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0364**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: 20-Aug-2009**Description of Non-Conformance:**

During random Visual Inspections and Magnetic Particle Testing (MT) of welds at panel point 10, Segment 1AW, this Caltrans Quality Assurance (QA) Inspector observed the following: Weld DP575-001-096 has multiple magnetic particle linear indications and is visually rejected; weld DP570-001-096 is visually rejected.

ZPMC CWI Mr. Yumin Xu agreed that both welds listed above are visually unacceptable due to weld contour and spatter. These inspections were performed as requested by ZPMC NDT Inspection Notification Sheet 004018 which indicates ZPMC has accepted the visual and magnetic particle inspections of these welds. See the photographs below for additional information.

Contractor's proposal to correct the problem:

Provide NDT report showing that the welds in question are in conformance with Contract requirements.

Corrective action taken:

ABF has submitted ZPMC's NDT reports in the weld Data Base showing that the welds in question are in conformance with 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 , who represents the Office of Structural Materials for your project.

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer