

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



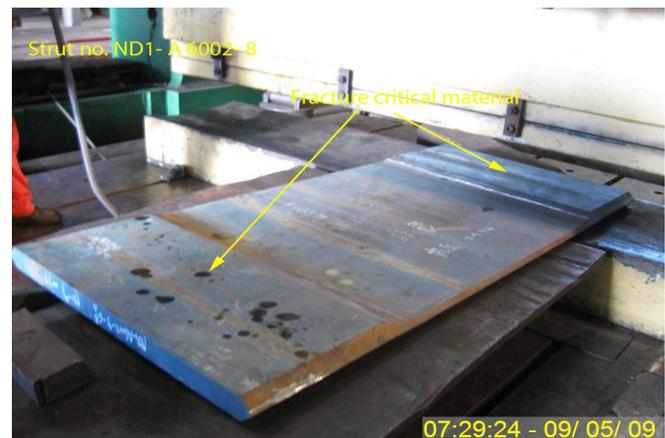
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Sep-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0374**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Strut Web Plate
Procedural	Procedural	Description: Strut Wed Plate ND1-A6002-8	

Reference Description: Cold bending of SPCM Strut Wed Plate ND1-A6002-8**Description of Non-Conformance:**

During in-process inspection, QA discovered ZPMC personnel performing cold bending of distorted web plate for Strut ND1-A6002-8. Strut plates are SPCM (Seismic Performance Critical Members) and are subject to AWS D1.5-2002 Section 12, AASHTO/AWS Fracture Control Plan (FCP), which prohibits cold bending. ZPMC Quality control personnel stated they were not aware that cold bending was prohibited.

**Applicable reference:**

Special Provisions, Section 8-3 Welding, Welding Quality Control - "The welding of seismic performance critical members (SPCM) shall conform to the provisions specified in the Fracture Control Plan (FCP) and the contract."

AWS D1.5-2002 Section 12.12 - "Cold bending shall be prohibited for all fracture critical steels. Bent and distorted material may be corrected prior to assembly and welding by approved upset-shortening methods (heat straightening, curving and cambering)."

Who discovered the problem: Baskar Govindarajan

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Bi Dewei

Time and method of notification: 09-06-2009, 7:45; Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 09-07-2009, 7:00; Verbal

QC Inspector's Name: Mr. Canon

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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Sinevod,Serge	ASMR
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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: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 08-Sep-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: 05.03.06-000365

Subject: NCR No. ZPMC-0374

Reference Description: Cold bending of SPCM Strut Wed Plate ND1-A6002-8

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: Tower **Lift:** N/A

Remarks:

During in-process inspection, QA discovered ZPMC personnel performing cold bending of distorted web plate for Strut ND1-A6002-8. Strut plates are SPCM (Seismic Performance Critical Members) and are subject to AWS D1.5-2002 Section 12, AASHTO/AWS Fracture Control Plan (FCP), which prohibits cold bending. ZPMC Quality control personnel stated they were not aware that cold bending was prohibited.

Special Provisions, Section 8-3 Welding, Welding Quality Control - "The welding of seismic performance critical members (SPCM) shall conform to the provisions specified in the Fracture Control Plan (FCP) and the contract."

AWS D1.5-2002 Section 12.12 - "Cold bending shall be prohibited for all fracture critical steels. Bent and distorted material may be corrected prior to assembly and welding by approved upset-shortening methods (heat straightening, curving and cambering)."

Action Required and/or Action Taken:

The above referenced web plate is rejected. In accordance with Section 5-1.09, Removal of Rejected And Unauthorized Work of the Standard Specifications, you are to either remove and replace this web plate.

In addition, propose a resolution to the non-conformance that addresses the apparent failure of Quality Control and Production to identify the non-conformance with AWS D1.5. Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

Transmitted by: Ken Lee Transportation Engineer
Attachments: ZPMC-0374

cc:
File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000365

Subject: NCR No. ZPMC-0374

Dated: 21-Sep-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000370 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ABF will provide the necessary objective evidence of rejected material as well as instructions to remake this part at a later date for closure of this NCR.

ABF will inform ZPMC that this material is rejected and ZPMC is to provide new material. ABF will provide the necessary objective evidence of rejected material as well as instructions to remake this part at a later date for closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000370R00

Caltrans' comments:

Status: CLO

Date: 21-Sep-2009

Please consider this NCR closed, provided that this rejected material is removed and replaced in accordance with Section 5-1.09, Removal of Rejected And Unauthorized Work, of the Standard Specifications.

Submitted by: Lee, Ken

Date: 21-Sep-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-000326**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0374**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: 07-Sep-2009**Description of Non-Conformance:**

During in-process inspection, QA discovered ZPMC personnel performing cold bending of distorted web plate for Strut ND1-A6002-8. Strut plates are SPCM (Seismic Performance Critical Members) and are subject to AWS D1.5-2002 Section 12, AASHTO/AWS Fracture Control Plan (FCP), which prohibits cold bending. ZPMC Quality control personnel stated they were not aware that cold bending was prohibited.

Contractor's proposal to correct the problem:

Reject strut web plate.

Corrective action taken:

The affected strut web plate has been rejected by ABF.

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 Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Sinevod, Serge **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**