

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-000405**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Sep-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0379**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: T-Stiffeners of OBG Seg. Splice 2AE/2BE @ PP16
Procedural	Procedural	Description:	

Reference Description: No Match Mark prior to Turn of Nut bolting at T-stiffener splices**Description of Non-Conformance:**

Caltrans Representative witnessed ZPMC bolting crew performing Turn-of-Nut pretensioning of bolts in the bottom plate T-Stiffeners at the 2AE to 2BE splice without match marking the bolt assemblies. The ZPMC crew had a torque wrench set to 700Nm, and proceeded to turn the nut until the torque wrench clicked. The nut was then marked so as to look as if it were properly tensioned.

Applicable reference:

1. ABF-SUB-000147R07 SFOBB Project HS Bolt Installation and Inspection Plan Section Section 6.3.1:
"After preliminary tightening, matchmark each nut, bolt and steel surface in a straight line."

Who discovered the problem: Aaron Prchlik**Name of individual from Contractor notified:** Jian Shen Bo**Time and method of notification:** 1000 hours, verbal**Name of Caltrans Engineer notified:** Bill Howe**Time and method of notification:** 1300 hours, verbal**QC Inspector's Name:** Lay Tao**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**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: 15-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: 05.03.06-000368

Subject: NCR No. ZPMC-0379

Reference Description: No Match Mark prior to Turn of Nut bolting at T-stiffener splices

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:** 02

Remarks:

Caltrans Representative witnessed ZPMC bolting crew performing Turn-of-Nut pretensioning of bolts in the bottom plate T-Stiffeners at the 2AE to 2BE splice without match marking the bolt assemblies. The ZPMC crew had a torque wrench set to 700Nm, and proceeded to turn the nut until the torque wrench clicked. The nut was then marked so as to look as if it were properly tensioned.

Action Required and/or Action Taken:

Follow approved ABF-SUB-000147R07 SFOBB Project HS Bolt Installation and Inspection Plan Section Section 6.3.1: "After preliminary tightening, matchmark each nut, bolt and steel surface in a straight line."

Transmitted by: Bill Howe

Attachments: ZPMC-0379

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: 05.03.06-000368

Subject: NCR No. ZPMC-0379

Dated: 14-Oct-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000374 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The item was subsequently removed from the Outstanding Work punchlist to document the acceptable resolution by Caltrans.

The non conformance documented in ZPMC-0379 was corrected and witnessed by Caltrans personnel. The item was subsequently removed from the Outstanding Work punchlist to document the acceptable resolution by Caltrans. ZPMC requests closure of the aforementioned NCR.

Submitted by:

Attachment(s): ABF-NPR-000374R00

Caltrans' comments:

Status: CLO

Date: 14-Oct-2009

It has been confirmed that the corrective work has been performed and accepted by CT field personnel at this location. Green tag record is on file.

Submitted by: Chao, Ching

Date: 14-Oct-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, P.R. China**Report No:** NCS-000407**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0379**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: 09-Sep-2009**Description of Non-Conformance:**

Caltrans Representative witnessed ZPMC bolting crew performing Turn-of-Nut pretensioning of bolts in the bottom plate T-Stiffeners at the 2AE to 2BE splice without match marking the bolt assemblies. The ZPMC crew had a torque wrench set to 700Nm, and proceeded to turn the nut until the torque wrench clicked. The nut was then marked so as to look as if it were properly tensioned.

Contractor's proposal to correct the problem:

Perform the correct procedure with Caltrans' witness.

Corrective action taken:

The non-conformance documented in ZPMC-0379 was corrected and witnessed by Caltrans personnel. The item was subsequently removed from the Outstanding Work punchlist to document the acceptable resolution.

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: Tsang, Eric **Quality Assurance Inspector****Reviewed By:** Wahbeh, Mazen **QA Reviewer**