

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-000445

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 13-Oct-2009

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

NCR #: ZPMC-0418

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: East Tower
Procedural	Procedural	Description: East Tower, Lift 4	

Reference Description: Unapproved turning of East Tower, Lift 4

Description of Non-Conformance:

During in-process Visual Inspection (VT), QA observed that East Tower, Lift 4 had been rotated utilizing steel cables supported by temporary attachments. The approved Tower Shaft Fabrication Procedure outlines a procedure utilizing "rotisserie rings" and a chain roller system.



Applicable reference:

Tower Shaft Segment Fabrication Procedure (ABF-SUB-000285R03), Sheet No. FP-MUG-18, Section 7.2 indicates that Tower Shafts will be rotated in turning jigs during welding.

Who discovered the problem: William Clifford

Name of individual from Contractor notified: Gene Rosamilia

Time and method of notification: 10/12/2009, 4:00; Verbal

Name of Caltrans Engineer notified: Scott Kennedy

Time and method of notification: 10/12/2009, 4:00; Verbal

QC Inspector's Name: Li Xiu Yang

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 14-Oct-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: 05.03.06-000408

Subject: NCR No. ZPMC-0418

Reference Description: Failure to follow Approved Procedure / East Shaft Lift 4 / Rotation

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:** 04

Remarks:

During in-process Visual Inspection (VT), QA observed that East Tower, Lift 4 had been rotated utilizing steel cables supported by temporary attachments. The approved Tower Shaft Fabrication Procedure outlines a procedure utilizing "rotisserie rings" and a chain roller system.

Tower Shaft Segment Fabrication Procedure (ABF-SUB-000285R03), Sheet No. FP-MUG-18, Section 7.2 indicates that Tower Shafts will be rotated in turning jigs during welding.

Action Required and/or Action Taken:

Propose a resolution that addresses the non-conformance with regard to the failure to follow the submitted and approved procedures / fabrication plan.

While it has been indicated that a previous submittal of the fabrication plan addressed the procedure being utilized, the final approved plan does not nor do the plans address the use of wire rope slings. Currently a modified procedure has been utilized in the initial lifting and rotation of both South and East lifts 4 and the subsequent rotation of South Lift 4.

If the Contractor intends to modify approved procedures, revised procedures must be submitted for review and approval prior to implementation.

Transmitted by: Scott Kennedy Sr. Bridge Engineer

Attachments: ZPMC-0418

cc: Rick Morrow, Gary Pursell, Mark Woods, Doug Coe

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000408

Subject: NCR No. ZPMC-0418

Dated: 19-Oct-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000401 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC rotated Lift 4, East shaft in accordance with Submittal 285R02 "T1 Tower Shaft Segment Fabrication Procedure", which was previously approved as noted by Caltrans.

ZPMC rotated Lift 4, East shaft in accordance with Submittal 285R02 "T1 Tower Shaft Segment Fabrication Procedure", which was previously approved as noted by Caltrans. Although the method was not included in the most recent submittal it was still approved by Caltrans for use and not detrimental to the shaft. In future cases where previously approved fabrication procedures will be used, ZPMC will ensure that Caltrans is aware. Based on these finding ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000401R00

Caltrans' comments:

Status: CLO

Date: 08-Nov-2009

The Department disagrees with the statement, "ZPMC rotated Lift 4, East shaft in accordance with Submittal 285R02 'T1 Tower Shaft Segment Fabrication Procedure', which was previously approved as noted by Caltrans". ZPMC's method currently being used is materially different than the one specified in the referenced submittal. However, this apparent failure to follow approved fabrication procedure is negated by the fact that a new revision (SUB-0285R04) has been submitted. As such, this NCR is now closed.

Submitted by: Lee, Ken

Date: 08-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-000319**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 06-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0418**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: 13-Oct-2009**Description of Non-Conformance:**

During in-process Visual Inspection (VT), QA observed that East Tower, Lift 4 had been rotated utilizing steel cables supported by temporary attachments. The approved Tower Shaft Fabrication Procedure outlines a procedure utilizing "roisserie rings" and a chain roller system.

Contractor's proposal to correct the problem:

Submit revised fabrication procedure.

Corrective action taken:

A revised fabrication procedure (ABF-SUB-000285R04) outlining the new shaft rotating method has been submitted and subsequently approved as noted.

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