

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



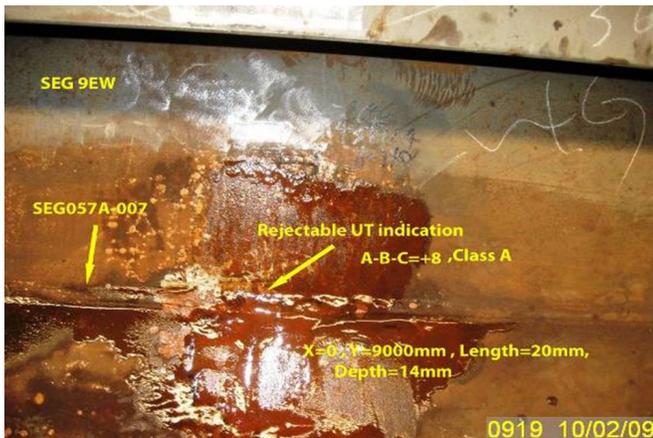
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000452**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Oct-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0425**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 9EW Weld SEG057A-007
Procedural	Procedural	Description: Missed UT Indication	

Reference Description: Missed UT indication on weld joint of bottom to side panel in OBG Segment 9EW**Description of Non-Conformance:**

During a random verification Ultrasonic Testing (UT) of the Bottom to Side Plate weld identified as SEG057A-007 in OBG segment 9EW. The Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one Class A longitudinal indication that measured approximately 20mm in length. This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

**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 D1.5/2002 Table 6.3

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Who discovered the problem: Chandra Kumar Sudalaimuthu

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 1600 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1700 hours, Email

QC Inspector's Name: Wang Lu

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: Carreon,Albert

Lead Reviewer/Task Leader

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: 26-Oct-2009

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Tara Washington Document Control Assistant

Document No: 05.03.06-000415

Subject: NCR No. ZPMC-0425

Reference Description: Missed UT indication on weld joint of bottom to side panel in OBG Segment 9EW

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:** 09

Remarks:

During a random verification Ultrasonic Testing (UT) of the Bottom to Side Plate weld identified as SEG057A-007 in OBG segment 9EW. The Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one Class A longitudinal indication that measured approximately 20mm in length. This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval.
Note: This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

Transmitted by: Bill Howe

Attachments: ZPMC-0425

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: 05.03.06-000415

Subject: NCR No. ZPMC-0425

Dated: 18-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000443 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: After repair, ZPMC or ABFJV will provide NDT documentation to show that the weld is acceptable. ZPMC requests that this response be approved with action pending.

After repair, ZPMC or ABFJV will provide NDT documentation to show that the weld is acceptable. Currently documentation is not available but based on this course of action, ZPMC requests that this response be approved with action pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000443R00

Caltrans' comments:

Status: AAP

Date: 27-Dec-2009

Approved pending required documentation

Submitted by: Howe, Bill

Date: 27-Dec-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000415

Subject: NCR No. ZPMC-0425

Dated: 25-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000443 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ABF is submitting NDT documentation to show that welds with missed indications are acceptable after repair. Based on this ZPMC requests closure of this NCR.

Per discussion in China with representatives of the Department, ABF is submitting NDT documentation to show that welds with missed indications are acceptable after repair. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000443R01;

Caltrans' comments:

Status: CLO

Date: 26-Jan-2010

The documentation submitted by the contractor has been reviewed by the Engineer and is found to be acceptable. Based on the discussion in China with the contractor's representatives, other weld repair reports from ZPMC shall be included in the QA Data Base when available.

Submitted by: Chao, Ching

Date: 26-Jan-2010

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-000494**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0425**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: 02-Oct-2009**Description of Non-Conformance:**

During a random verification Ultrasonic Testing (UT) of the Bottom to Side Plate weld identified as SEG057A-007 in OBG segment 9EW. The Caltrans Quality Assurance (QA) Inspector discovered a total of (1) one Class A longitudinal indication that measured approximately 20mm in length. This weld has been previously tested and accepted by ZPMC Quality Control (UT) Technicians.

Contractor's proposal to correct the problem:

Repair indication and perform required NDT.

Corrective action taken:

ABF submitted internal NDT documentation verifying the weld is now in conformance with Contract specifications. Per Team China discussions, documentation from ZPMC verifying the repairs were made and NDT was performed by ZPMC technicians will be submitted at a later date and added to the Data Base.

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 Jim Simonis 152.1675.3703, who represents the Office of Structural Materials for your project.

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer