

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-000453**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Oct-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0426**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** OBG Segment 1AW/1BW Trans. Splice OBW1A-007**Procedural****Procedural****Description:** Repair without Engineer's Approval**Reference Description:** Repair work without Engineer's approval on transverse cracks detected by MT**Description of Non-Conformance:**

During random inspection of the Transverse Segment Splice weld joint 1AW to 1BW on October 3, 2009, Caltrans Quality Assurance (QA) Inspector discovered 2 excavations on Side Panel Splice weld OBW1A-007. QA Inspector performed Magnetic Particle Testing (MT) and discovered two transverse cracks in the excavations. The cracks were located approximately 1750mm and 3130mm from the Counter Weight side of the Longitudinal Diaphragm. The lengths of the indications were 8mm and 5mm in length. On the following day, October 4, 2009, the QA Inspector discovered that the excavations had been repaired without prior Engineer's approval or an approved Critical Weld Repair (CWR).



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Applicable reference:

Special Provisions 8-3; In addition to the provision in AWS D1.5, Section 3.7.4 and Section 12.17, third-time repairs of welds or base metal, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer.

AWS D1.5-2002 Section 3.7.4; Prior Engineer approval shall be obtained for repairs to base metal, repair of major or delayed cracks.

Who discovered the problem: Shrikant Utekar

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 0700 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 0800 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. Thomas Nilsson Project/Fabrication Manager

Document No: 05.03.06-000416

Subject: NCR No. ZPMC-0426

Reference Description: Repair work without Engineer's approval on transverse cracks detected by MT

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 inspection of the Transverse Segment Splice weld joint 1AW to 1BW on October 3, 2009, Caltrans Quality Assurance (QA) Inspector discovered 2 excavations on Side Panel Splice weld OBW1A-007. QA Inspector performed Magnetic Particle Testing (MT) and discovered two transverse cracks in the excavations. The cracks were located approximately 1750mm and 3130mm from the Counter Weight side of the Longitudinal Diaphragm. The lengths of the indications were 8mm and 5mm in length. On the following day, October 4, 2009, the QA Inspector discovered that the excavations had been repaired without prior Engineer's approval or an approved Critical Weld Repair (CWR).

Action Required and/or Action Taken:

Submit a repair plan to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0426

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: 05.03.06-000416

Subject: NCR No. ZPMC-0426

Dated: 03-Dec-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000439 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indications documented in the NCR. ABFJV and Caltrans has conducted the NDT and found that the welds are acceptable which is included in the attached documents.

ZPMC has repaired the indications documented in the NCR. ABFJV and Caltrans has conducted the NDT and found that the welds are acceptable which is included in the attached documents. Based on this ZPMC is requesting closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000439R00;

Caltrans' comments:

Status: CLO

Date: 13-Dec-2009

The documentation submitted has been reviewed by the Engineer and is found to be acceptable.

Submitted by: Chao, Ching

Attachment(s):

Date: 13-Dec-2009

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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-000409**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0426**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: 03-Oct-2009**Description of Non-Conformance:**

During random inspection of the Transverse Segment Splice weld joint 1AW to 1BW on October 3, 2009, Caltrans Quality Assurance (QA) Inspector discovered 2 excavations on Side Panel Splice weld OBW1A-007. QA Inspector performed Magnetic Particle Testing (MT) and discovered two transverse cracks in the excavations. The cracks were located approximately 1750mm and 3130mm from the Counter Weight side of the Longitudinal Diaphragm. The lengths of the indications were 8mm and 5mm in length. On the following day, October 4, 2009, the QA Inspector discovered that the excavations had been repaired without prior Engineer's approval or an approved Critical Weld Repair (CWR).

Contractor's proposal to correct the problem:

Perform repair and verify with NDT, and provide CWR.

Corrective action taken:

ZPMC has repaired the indications documented in the NCR. ABFJV and Caltrans has conducted the NDT and found that the welds are acceptable which is included in the attached documents.

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 Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer