

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, P. R. China

Report No: NCR-000484

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 19-Oct-2009

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

NCR #: ZPMC-0457

Type of problem:

Welding **Concrete** **Other**
Welding **Curing** **Procedural**
Joint fit-up **Coating** **Other**
Procedural **Procedural** **Description:**

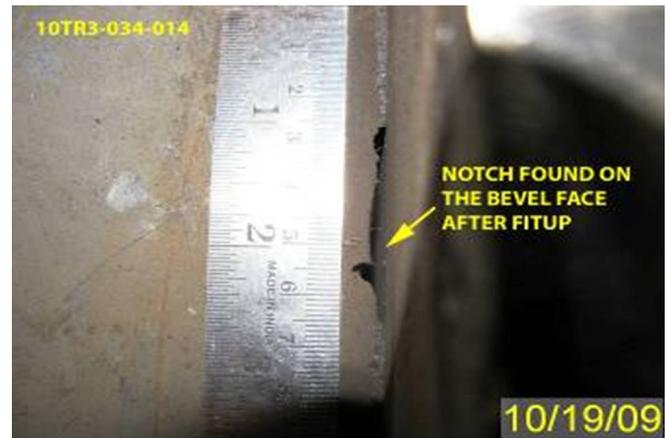
Bridge No: 34-0006

Component: Traveler Rail 10TR3-034-014

Reference Description: ZPMC cut a non-complying notch in the bevel face preparation of the weld joint for the traveler rail

Description of Non-Conformance:

During random visual inspection at Bay 5 of Traveler Rails, Caltrans Quality Assurance (QA) Inspector observed a T-joint weld preparation with a cut notch on the bevel of a Traveler Rail. The surfaces and edges to be welded shall be free from discontinuities which would affect the quality or strength of the weld. This T-joint was identification as 10TR3-034-014.



Applicable reference:

AWS D1.5 2002 section 3.2.1; "Surfaces and edges to be welded shall be smooth, uniform and free from fins, tears, cracks, and other discontinuities which would adversely affect the quality or strength of the weld."

AWS D1.5 2002 section 3.2.2; "In thermal Cutting, the cutting flame shall be so adjusted and manipulated so to avoid cutting beyond (inside) the prescribed lines."

Who discovered the problem: Sandeep Kumar Naddi

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Yu Kim

Time and method of notification: 0930 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1030 hours, Email

QC Inspector's Name: Meng Linnan

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: 17-Nov-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: 05.03.06-000447

Subject: NCR No. ZPMC-0457

Reference Description: ZPMC cut a non-complying notch in the bevel face preparation of the weld joint for the traveler rail

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: Other **Lift:** N/A

Remarks:

During random visual inspection at Bay 5 of Traveler Rails, Caltrans Quality Assurance (QA) Inspector observed a T-joint weld preparation with a cut notch on the bevel of a Traveler Rail. The surfaces and edges to be welded shall be free from discontinuities which would affect the quality or strength of the weld. This T-joint was identification as 10TR3-034-014.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0457

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000447

Subject: NCR No. ZPMC-0457

Dated: 11-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000477 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will submit the required NDT data at a later date to close this NCR.

ABF has discussed the repair of notches and or gouges regarding plate cut edges with ZPMC QA/QC and the requirement of Engineers approval. However, in this case, this gouge is in the weld preparation. Please take note that per AWS D1.5 paragraph 3.3.4.1 root openings twice the thickness of the thinner part or 20mm may be repaired by welding and AWS D1.5 paragraph 12.17.2 (7) allows up to 10mm or ¼ the base metal thickness whichever is less without Engineers approval. On the other hand, these excessive root openings are to be brought into compliance prior to joining the parts by welding or unacceptable weld discontinuities can occur. ZPMC will submit the required NDT data at a later date to close this NCR.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000477R00

Caltrans' comments:

Status: CLO

Date: 12-Jan-2010

Consider this NCR closed.

Submitted by: Howe, Bill

Attachment(s):

Date: 12-Jan-2010

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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-000451**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0457**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: 19-Oct-2009**Description of Non-Conformance:**

During random visual inspection at Bay 5 of Traveler Rails, Caltrans Quality Assurance (QA) Inspector observed a T-joint weld preparation with a cut notch on the bevel of a Traveler Rail. The surfaces and edges to be welded shall be free from discontinuities which would affect the quality or strength of the weld. This T-joint was identification as 10TR3-034-014.

Contractor's proposal to correct the problem:

Repair notch prior to final fit up of weld.

Corrective action taken:

Notch was repaired in accordance with AWS D1.5.

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: Simonis, Jim Quality Assurance Inspector**Reviewed By:** Wahbeh, Mazen QA Reviewer