

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-000488**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Oct-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0461**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Crossbeam CB13 Side Panel**Procedural****Procedural****Description:****Reference Description:** No preheat on CB13 SPCM material prior to tack welding temporary fixtures**Description of Non-Conformance:**

The Quality Assurance Inspector (QA) observed the contractors welding personnel tack weld a temporary fixture to the SPCM portion of the east Side Panel of Crossbeam CB13. The SPCM material is identified as SP202A. The QA inspector observed the worker did not preheat the material prior to tack welding and no approved welding procedure specification (WPS) was available for review. Prior to the QA inspector arrival, it was noted that the contractor has previously tack welded three (3) temporary fixtures, each on SPCM panels identified as SP205A and FB202A.

**Applicable reference:**

AWS D1.5 2002 section 12, table 12.2: tack weld requirements

AWS D1.5 2002 section 12, table 12.3: minimum preheat and interpass temperatures

Who discovered the problem: Steve Hall**Name of individual from Contractor notified:** Zou Hu

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 1030 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1130 hours, Verbal

QC Inspector's Name: Sun Bo

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
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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:	02-Dec-2009
Dear:	Mr. Charles Kanapicki	Contract No:	04-0120F4 04-SF-80-13.2 / 13.9
Attention:	Mr. Thomas Nilsson Project/Fabrication Manager	Job Name:	SAS Superstructure
Subject:	NCR No. ZPMC-0461	Document No:	05.03.06-000451

Reference Description: No preheat on CB13 SPCM material prior to tack welding temporary fixtures

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: Xbeam **Lift:** 13

Remarks:

The Quality Assurance Inspector (QA) observed the contractors welding personnel tack weld a temporary fixture to the SPCM portion of the east Side Panel of Crossbeam CB13. The SPCM material is identified as SP202A. The QA inspector observed the worker did not preheat the material prior to tack welding and no approved welding procedure specification (WPS) was available for review. Prior to the QA inspector arrival, it was noted that the contractor has previously tack welded three (3) temporary fixtures, each on SPCM panels identified as SP205A and FB202A.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer that include correct preheat.

Transmitted by: Bill Howe

Attachments: ZPMC-0461

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000451

Subject: NCR No. ZPMC-0461

Dated: 25-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000539 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will provide explanation of measures that they took to correct the issue documented in the NCR. In addition, NDT documentation will be provided to show the SPCM material was not damaged.

ZPMC will provide explanation of measures that they took to correct the issue documented in the NCR. In addition, NDT documentation will be provided to show the SPCM material was not damaged. Based on this ZPMC requests that this course of action be approved with action pending. When documents become available ZPMC will request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000539R00

Caltrans' comments:

Status: AAP

Date: 26-Jan-2010

The proposed resolution provided by the contractor is accepted. The NCR will be closed once the required preventative measures are taken and repair documentation are submitted for the Engineer's review and acceptance.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000451

Subject: NCR No. ZPMC-0461

Dated: 23-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000539 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing and MT report of the base metal to show that the material is acceptable despite the lack of preheat.

ZPMC is providing and MT report of the base metal to show that the material is acceptable despite the lack of preheat. ZPMC QA has informed the QC department of this non conformance to prevent future occurrences. Based on this ZPMC requests that this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000539R01;

Caltrans' comments:

Status: CLO

Date: 05-Apr-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0461 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 05-Apr-2010



No. B-699

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-20

REGARDING: NCR-000488(ZPMC-0461)

ZPMC acknowledged this problem and ZPMC QA has instructed the production about the preheat requirement for tack welding on SPCM material. Also ZPMC QC will pay more attention on such issue. ZPMC is providing the NDT record show the base metal's soundness after removal of these tack welds. Based on this, ZPMC requests this NCR to be closed.

ATTACHMENT:

NCR-000488(ZPMC-0461)

B787-MT-19910

Ly W
3/20/10



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: 02-Dec-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: 05.03.06-000451

Subject: NCR No. ZPMC-0461

Reference Description: No preheat on CB13 SPCM material prior to tack welding temporary fixtures

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: Xbeam

Lift: 13

Remarks:

The Quality Assurance Inspector (QA) observed the contractors welding personnel tack weld a temporary fixture to the SPCM portion of the east Side Panel of Crossbeam CB13. The SPCM material is identified as SP202A. The QA inspector observed the worker did not preheat the material prior to tack welding and no approved welding procedure specification (WPS) was available for review. Prior to the QA inspector arrival, it was noted that the contractor has previously tack welded three (3) temporary fixtures, each on SPCM panels identified as SP205A and FB202A.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer that include correct preheat.

Transmitted by: Bill Howe

Attachments: ZPMC-0461

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Contract Files, Ching Chao

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P. R. China

Report No: NCR-000488

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 22-Oct-2009

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

NCR #: ZPMC-0461

Type of problem:

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

Bridge No: 34-0006

Component: Crossbeam CB13 Side Panel

Reference Description: No preheat on CB13 SPCM material prior to tack welding temporary fixtures

Description of Non-Conformance:

The Quality Assurance Inspector (QA) observed the contractors welding personnel tack weld a temporary fixture to the SPCM portion of the east Side Panel of Crossbeam CB13. The SPCM material is identified as SP202A. The QA inspector observed the worker did not preheat the material prior to tack welding and no approved welding procedure specification (WPS) was available for review. Prior to the QA inspector arrival, it was noted that the contractor has previously tack welded three (3) temporary fixtures, each on SPCM panels identified as SP205A and FB202A.



Applicable reference:

AWS D1.5 2002 section 12, table 12.2: tack weld requirements

AWS D1.5 2002 section 12, table 12.3: minimum preheat and interpass temperatures

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Zou Hu

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 1030 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1130 hours, Verbal

QC Inspector's Name: Sun Bo

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

NCR-B-319 (ZPMC-0461)



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-19910 DATE日期 2010.03.04 PAGE OF页码 1/1 Revision No: 0

PROJECT NO. 工程编号: ZP06-787 CONTRACTOR: 用户: CALTRANS

DRAWING NO. 图号: SP202A/SP205A/FB202A CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4
WEB PLATE

REFERENCING CODE 参考规范编码: AWS D1.5-2002 ACCEPTANCE STANDARD 接受标准: AWS D1.5-2002 PROCEDURE NO. 程序编号: ZPQC-MT-01 CALIBRATION DUE DATE 仪器校正有效期: Dec. 28ST, 2010

EQUIPMENT 设备: MT YOKE MANUFACTURER 制造商: PARKER MODEL NO. 样式编号: B310S SERIAL NO. 连续编号: 5395 5617 5620

MAGNETIZING METHOD 磁化方法: Continuous magnetic yoke 磁轭式连续法 CURRENT 电流: AC

PARTICLE TYPE 磁粉类型: Dry magnet powder 干磁粉 YOKE SPACING 磁轭间距: 70~150mm

MATERIAL TO BE EXAMINED 检测材料: WELDING 焊接件 Material & thickness 母材, 厚度: A709M-345F2-X
 CASTING 铸件 12/14/50mm
 FORGING 锻造

WELDING PROCESS 焊接方法: NA TYPE OF JOINT 焊缝类型: NA

WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
PL211B				ACC.		base material
PL213B				ACC.		base material
PL209B				ACC.		base material

BLANK

EXAMINED BY 主探 Ding Acheng Ding Acheng	REVIEWED BY 审核 Sun We
LEVEL - II SIGN 签名 / DATE日期 10.3.4	LEVEL-II SIGN / DATE日期 10.3.4
质量经理 / QCM Luo Jianhua 2010.3.4	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

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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-000616**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0461**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Descriptor:	

Date the Non-Conformance Report was written: 22-Oct-2009**Description of Non-Conformance:**

The Quality Assurance Inspector (QA) observed the contractors welding personnel tack weld a temporary fixture to the SPCM portion of the east Side Panel of Crossbeam CB13. The SPCM material is identified as SP202A. The QA inspector observed the worker did not preheat the material prior to tack welding and no approved welding procedure specification (WPS) was available for review. Prior to the QA inspector arrival, it was noted that the contractor has previously tack welded three (3) temporary fixtures, each on SPCM panels identified as SP205A and FB202A.

Contractor's proposal to correct the problem:

Provide NDT documentation verifying the quality of the affected plates.

Corrective action taken:

Contractor submitted MT report verifying the plates in question are in conformance with Contract specifications after temporary attachments were removed.

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