

**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-000523

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 30-Nov-2009

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

**NCR #:** ZPMC-0496

### Type of problem:

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Lift 12 FL1 OBG Floor Beams
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Cope holes verified in Lift 12 were not in compliance with the approved contract drawings.

### Description of Non-Conformance:

During random in process visual inspection of lift 12 FL1 OBG floor beam components this Quality Assurance Inspector (QA) observed five (5) stiffener cope-hole radii on four (4) floor beams that did not appear to comply with the dimensions specified on the approved shop drawings. The radii as measured by this QA appeared to be approximately 35 mm to 40 mm. According to the approved shop drawings the cope-hole radii should be 25mm.

The affected floor beams and stiffeners are identified as follows:

FB3089-001 – Stiffener X3242A – Located at Bay # 2

FB3046-001 – Stiffener X3116A – Located outside yard opposite to Bay # 14

FB3023-001 – Stiffener X3120B – Located outside yard opposite to Bay # 14

FB3098-001 – Stiffeners X3260A & X3260B – Located outside yard opposite to Bay # 13



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )



## Applicable reference:

Approved Drawings – FB3089, FB3046, FB3023, and FB3098

**Who discovered the problem:** Sandeep Kumar Naddi

**Name of individual from Contractor notified:** Lui Gui Lin

**Time and method of notification:** 1730 hours, Verbal

**Name of Caltrans Engineer notified:** Ching Chao and Bill Howe

**Time and method of notification:** 1830 hours, Verbal

**QC Inspector's Name:** Yang Qing Feng

**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:** 24-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:** 05.03.06-000484

**Subject:** NCR No. ZPMC-0496

**Reference Description:** Cope holes verified in Lift 12 were not in compliance with the approved contract drawings.

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:** 12

**Remarks:**

During random in process visual inspection of lift 12 FL1 OBG floor beam components this Quality Assurance Inspector (QA) observed five (5) stiffener cope-hole radii on four (4) floor beams that did not appear to comply with the dimensions specified on the approved shop drawings. The radii as measured by this QA appeared to be approximately 35 mm to 40 mm. According to the approved shop drawings the cope-hole radii should be 25mm.

The affected floor beams and stiffeners are identified as follows:

**Action Required and/or Action Taken:**

These holes are outside the additional 5mm tolerance approved by design. Submit a repair procedure to the engineer (prior to the start of repair) for approval. A response for the resolution of this issue is expected within 7 days.

**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0496

**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:** 05.03.06-000484

**Subject:** NCR No. ZPMC-0496

**Dated:** 16-Mar-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000621 **Rev:** 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC is attaching the approved shop drawings for the floorbeams which shows that the radius of the cope holes is 50mm. ZPMC believes that cope holes measured are acceptable.

ZPMC is attaching the approved shop drawings for the floorbeams which shows that the radius of the cope holes is 50mm. Based on this ZPMC, believes that cope holes measured are acceptable and request closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000621R00;

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### Caltrans' comments:

**Status:** CLO

**Date:** 18-Mar-2010

The documentation received is sufficient to close this NCR.

**Submitted by:** Howe, Bill

**Date:** 18-Mar-2010

**Attachment(s):**



No. B-678

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-3-15**

**REGARDING: NCR-000523(ZPMC-0496)**

CT inspector was misreading the drawing. After confirmed with ZPMC technique department, these cope holes are not designed to be 25mm size. According to the FVT acceptance criteria what is been using now. These cope holes are all acceptable. Further, these panels are all green tagged at this moment. Attached is the designed drawing for these components, ZPMC hope CT engineer could take a review and withdraw this NCR.

**ATTACHMENT:**

NCR-000523(ZPMC-0496)

DRAWING: X3120, X3116, X3260, X3242

A handwritten signature in black ink, appearing to be "Jing W", is located below the attachment list.

3/15/10



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:** 24-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

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**Lift:** 12

### Remarks:

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**Transmitted by:** Bill Howe

**Attachments:** ZPMC-0496

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

**File:** 05.03.06

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**DIVISION OF ENGINEERING SERVICES**  
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Cty: 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-000523

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 30-Nov-2009

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

NCR #: ZPMC-0496

### Type of problem:

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

Bridge No: 34-0006

Component: Lift 12 FL1 OBG Floor Beams

Reference Description: Cope holes verified in Lift 12 were not in compliance with the approved contract drawings.

### Description of Non-Conformance:

During random in process visual inspection of lift 12 FL1 OBG floor beam components this Quality Assurance Inspector (QA) observed five (5) stiffener cope-hole radii on four (4) floor beams that did not appear to comply with the dimensions specified on the approved shop drawings. The radii as measured by this QA appeared to be approximately 35 mm to 40 mm. According to the approved shop drawings the cope-hole radii should be 25mm.

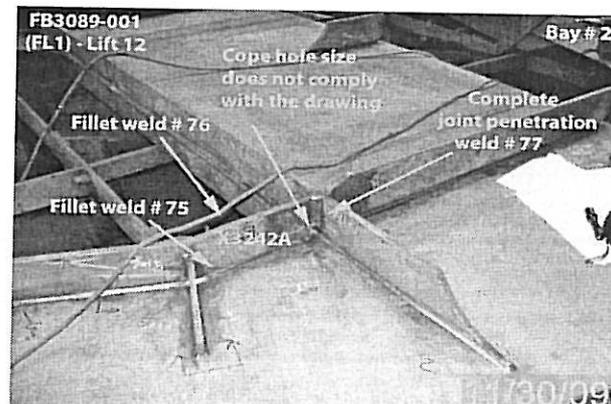
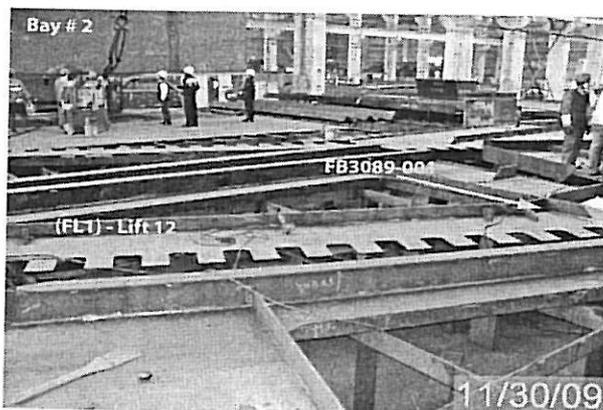
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FB3089-001 – Stiffener X3242A – Located at Bay # 2

FB3046-001 – Stiffener X3116A – Located outside yard opposite to Bay # 14

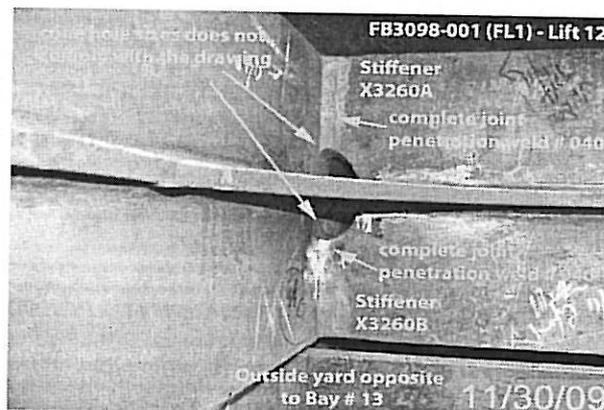
FB3023-001 – Stiffener X3120B – Located outside yard opposite to Bay # 14

FB3098-001 – Stiffeners X3260A &amp; X3260B – Located outside yard opposite to Bay # 13



# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



### Applicable reference:

Approved Drawings – FB3089, FB3046, FB3023, and FB3098

Who discovered the problem: Sandeep Kumar Naddi

Name of individual from Contractor notified: Lui Gui Lin

Time and method of notification: 1730 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1830 hours, Verbal

QC Inspector's Name: Yang Qing Feng

Was QC Inspector aware of the problem:  Yes  No

Contractor's proposal to correct the problem:

N/A

### Comments:

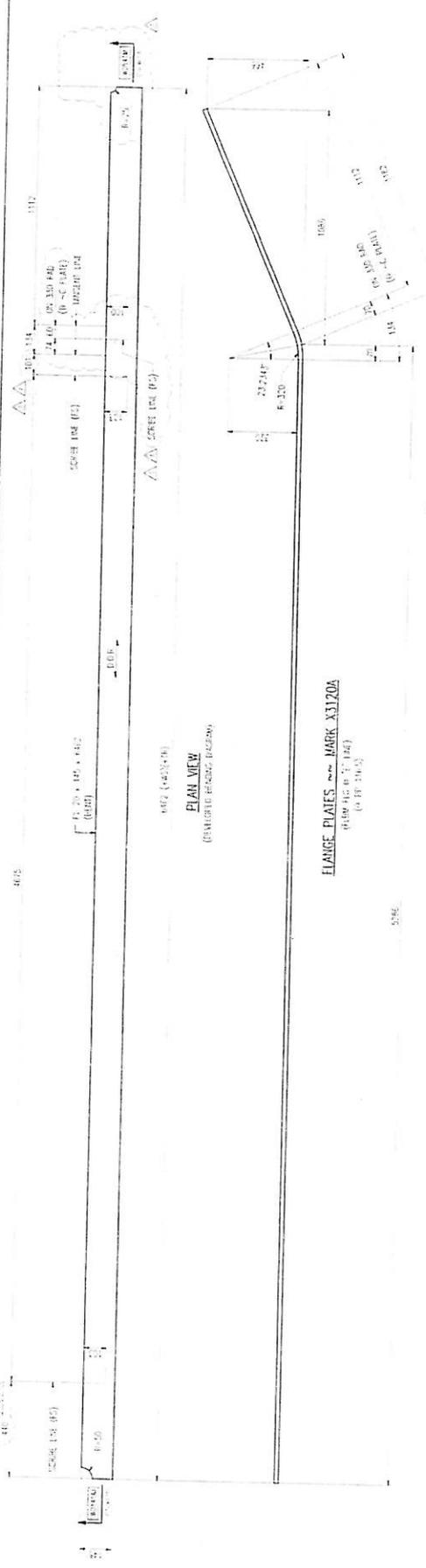
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Carreon, Albert

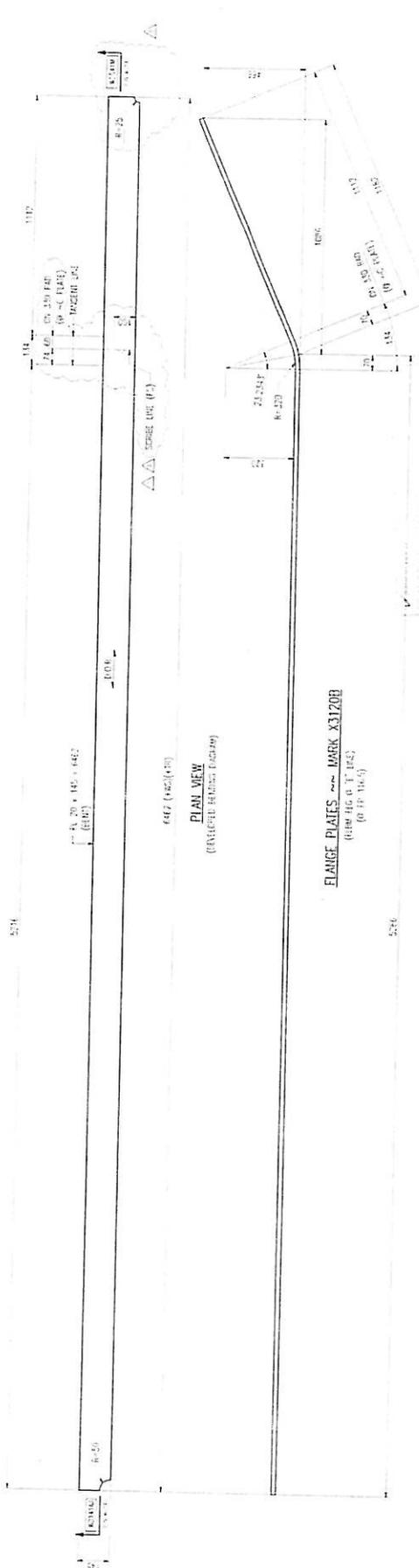
Lead Reviewer/Task Leader

Reviewed By: Wahbeh, Mazen

SMR



FLANGE PLATES ~ MARK X3120A  
(453'-10" x 465')



FLANGE PLATES ~ MARK X3120B  
(453'-10" x 465')

**ZPMC**  
ZIMMERMAN PAVEMENT CONSTRUCTION

241 FRANCISCO (SOUTH) HWY BRIDGE, EAST TANK 211-ALCOHOL TREATMENT, SAN JOSE, CA  
 SHEET NO. 34-00001-002-01-117-A, 34-00001-002-01-117-B  
 DATE OF PREPARATION: 04/14/2014  
 PROJECT: CAHRS - 11710 / BRIDGE & TANKS  
 CONTRACT: 34-00001-002-01-117-A

ORG: ZIMMERMAN PAVEMENT CONSTRUCTION  
 DATE: 04/14/2014  
 DRAWN: J. J. JONES  
 CHECKED: J. J. JONES  
 MARK: X3120  
 DECK

4-14-14

REVISIONS:

NO.	DATE	DESCRIPTION
1	04/14/2014	ISSUED FOR CONSTRUCTION

NOTE:

1. ALL DIMENSIONS ARE TO CENTER UNLESS NOTED OTHERWISE.
2. ALL DIMENSIONS ARE TO CENTER UNLESS NOTED OTHERWISE.
3. ALL DIMENSIONS ARE TO CENTER UNLESS NOTED OTHERWISE.
4. ALL DIMENSIONS ARE TO CENTER UNLESS NOTED OTHERWISE.
5. ALL DIMENSIONS ARE TO CENTER UNLESS NOTED OTHERWISE.

**BILL OF MATERIALS**

NO.	DESCRIPTION	QUANTITY	UNIT	MARK	REMARKS
1	FLANGE PLATES	1	MARK	X3120A	
2	FLANGE PLATES	1	MARK	X3120B	







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(707) 649-5453  
(707) 649-5493

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-000648**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 10-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0496**Type of problem:**

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

**Date the Non-Conformance Report was written:** 30-Nov-2009**Description of Non-Conformance:**

During random in process visual inspection of lift 12 FL1 OBG floor beam components this Quality Assurance Inspector (QA) observed five (5) stiffener cope-hole radii on four (4) floor beams that did not appear to comply with the dimensions specified on the approved shop drawings. The radii as measured by this QA appeared to be approximately 35 mm to 40 mm. According to the approved shop drawings the cope-hole radii should be 25mm.

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FB3023-001 – Stiffener X3120B – Located outside yard opposite to Bay # 14

FB3098-001 – Stiffeners X3260A & X3260B – Located outside yard opposite to Bay # 13

**Contractor's proposal to correct the problem:**

N/A

**Corrective action taken:**

After review, the cope holes were found to be fit for purpose as is

**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, who represents the Office of Structural Materials for your project.

**Inspected By:** Simonis, Jim

Quality Assurance Inspector

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# QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**Reviewed By:** Wahbeh,Mazen

QA Reviewer