

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-000524**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0497**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 7BW
Procedural	Procedural	Description:	

Reference Description: Longitudinal indications were discovered with MT after the contractor's acceptance on Segment 7BW

Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 7BW, this Quality Assurance Inspector (QA) discovered the 3 following issues:

-One (1) Longitudinal linear indication measuring approximately 20mm in length.

The weld is identified as SEG-035C-031 @ Panel Point (PP) 51.

The Weld is a Complete Joint Penetration (CJP) butt weld joining the Longitudinal Diaphragm (LD) identified as LD-04A to Floor Beam (FB) identified as FB-023A.

This OBG Segment is located at outside yard.

The Notice of Witness Inspection Number (NWIT) is 004768.

The indication is located in an area that has not been previously tested and accepted by ZPMC Quality Control (QC) personnel.

-One (1) Longitudinal linear indication measuring approximately 20mm in length.

The weld is identified as SP438B-075 @ Panel Point (PP) 051.

The Weld is a Fillet Weld joining the Side Plate, SP438B I rib to Floor Beam, FB23A (FL3) joint.

The Orthotropic Box Girder (OBG) Segment is located at outside yard.

The Notice of Witness Inspection Number (NWIT) is 004768. The indication is located in an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

-One (1) Longitudinal linear indication measuring approximately 20 mm in length.

The weld is identified as SS10-PP50-108 @ Panel Point (PP) 050.

This weld is a fillet weld joining the floor beam to the bottom panel.

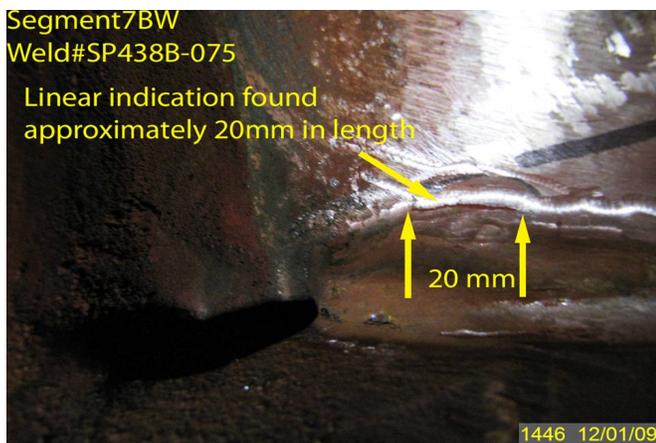
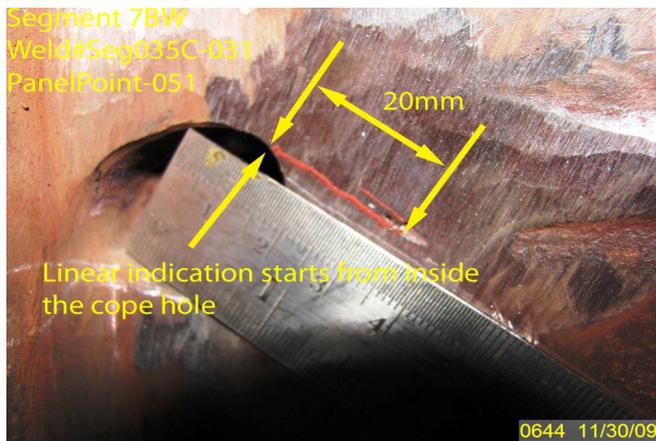
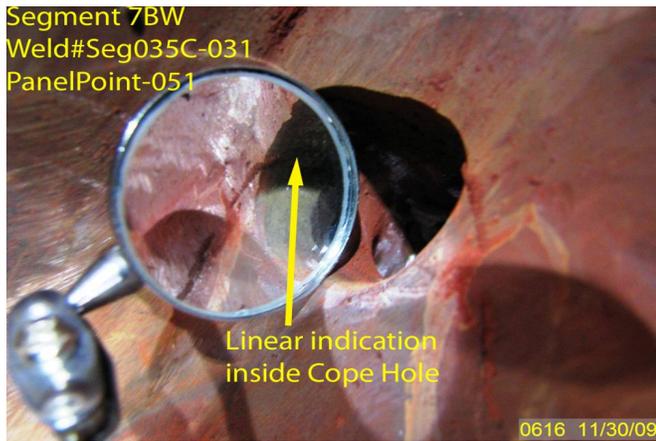
This OBG Segment is located at outside yard.

The Notice of Witness Inspection Number (NWIT) is 004768.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)

The indication is located in an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.



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 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

cracks.

Who discovered the problem: Larry Viars and Hiranch Patel

Name of individual from Contractor notified: Man Kit lee

Time and method of notification: 1330 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1430 hours, Verbal

QC Inspector's Name: Zhang Wei

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: 05.03.06-000485

Subject: NCR No. ZPMC-0497

Reference Description: Longitudinal indications were discovered with MT after the contractor's acceptance on Segment 7BW

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:** 07

Remarks:

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- One (1) Longitudinal linear indication measuring approximately 20 mm in length.
 The weld is identified as SS10-PP50-108 @ Panel Point (PP) 050.
 This weld is a fillet weld joining the floor beam to the bottom panel.
 This OBG Segment is located at outside yard.
 The Notice of Witness Inspection Number (NWIT) is 004768.
 The indication is located in an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

NCT

(Continued Page 2 of 2)

Action Required and/or Action Taken:

Submit a repair plan to the engineer for approval. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe

Attachments: ZPMC-0497

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: 05.03.06-000485

Subject: NCR No. ZPMC-0497

Dated: 25-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000537 Rev: 00

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-000537R00

Caltrans' comments:

Status: REJ

Date: 26-Jan-2010

There is no documentation submitted by the Contractor for the Engineer to review.

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: 05.03.06-000485

Subject: NCR No. ZPMC-0497

Dated: 08-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000537 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: 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.

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-000537R01;

Caltrans' comments:

Status: CLO

Date: 08-Feb-2010

The documentation received is sufficient to close this NCR.

Submitted by: Howe, Bill

Date: 08-Feb-2010

Attachment(s):



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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375 BURMA ROAD
OAKLAND CA 95607

Date: 24-Dec-2009
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Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0497

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Material Location: OBG

Lift: 07

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The weld is identified as SS10-PP50-108 @ Panel Point (PP) 050.
This weld is a fillet weld joining the floor beam to the bottom panel.
This OBG Segment is located at outside yard.
The Notice of Witness Inspection Number (NWIT) is 004768.
The indication is located in an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

NCT

(Continued Page 2 of 2)

Action Required and/or Action Taken:

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Transmitted by: Bill Howe

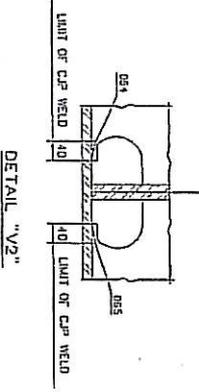
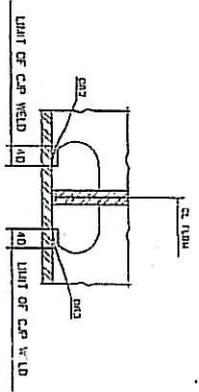
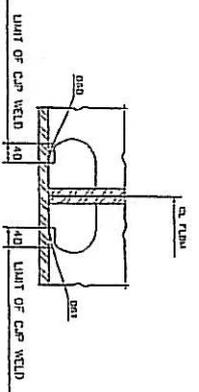
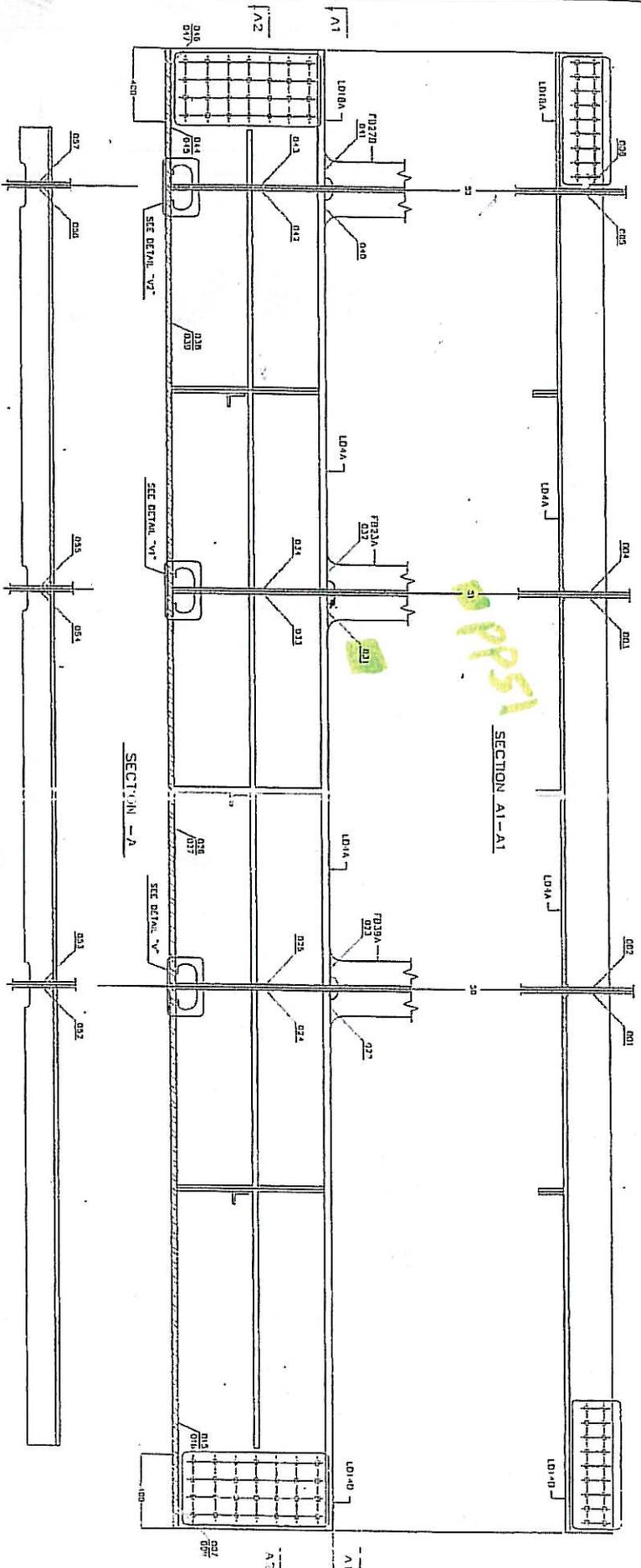
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cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao

File: 05.03.06

Zeon PDF Driver Trial
www.zeon.com.tw

MT-NCR-78W-001 2/4



焊接符号说明: SEG035C XXX

焊接符号

注意:
如有问题请在焊接前
向QC人员加工技术科联系

SEG 035C

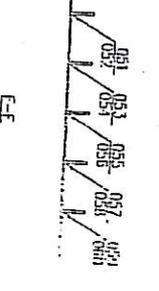
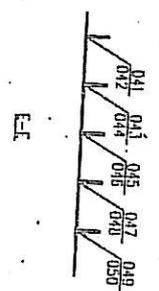
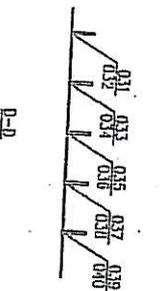
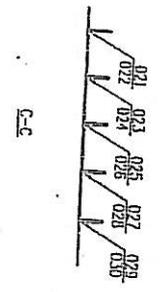
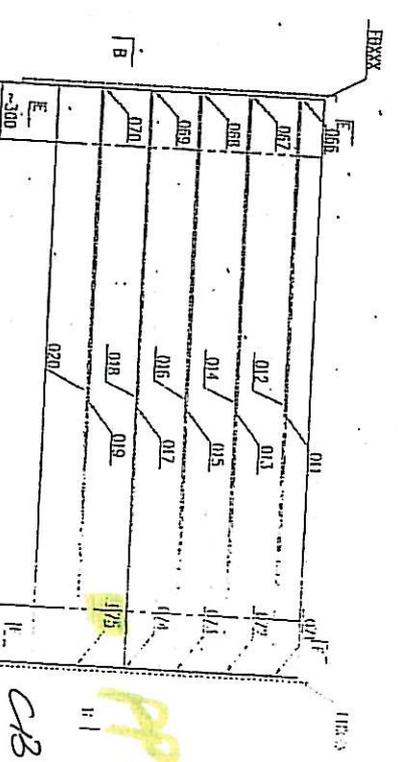
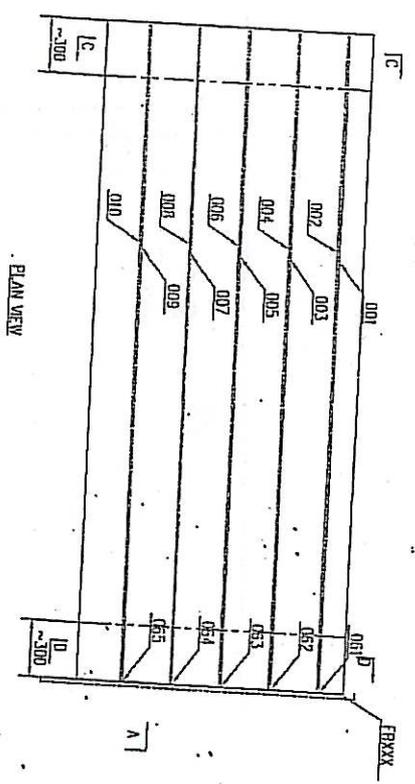
WELDING MAP

1/1

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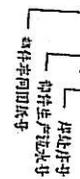
MT-NCR-7BW-001 3/4



EAST

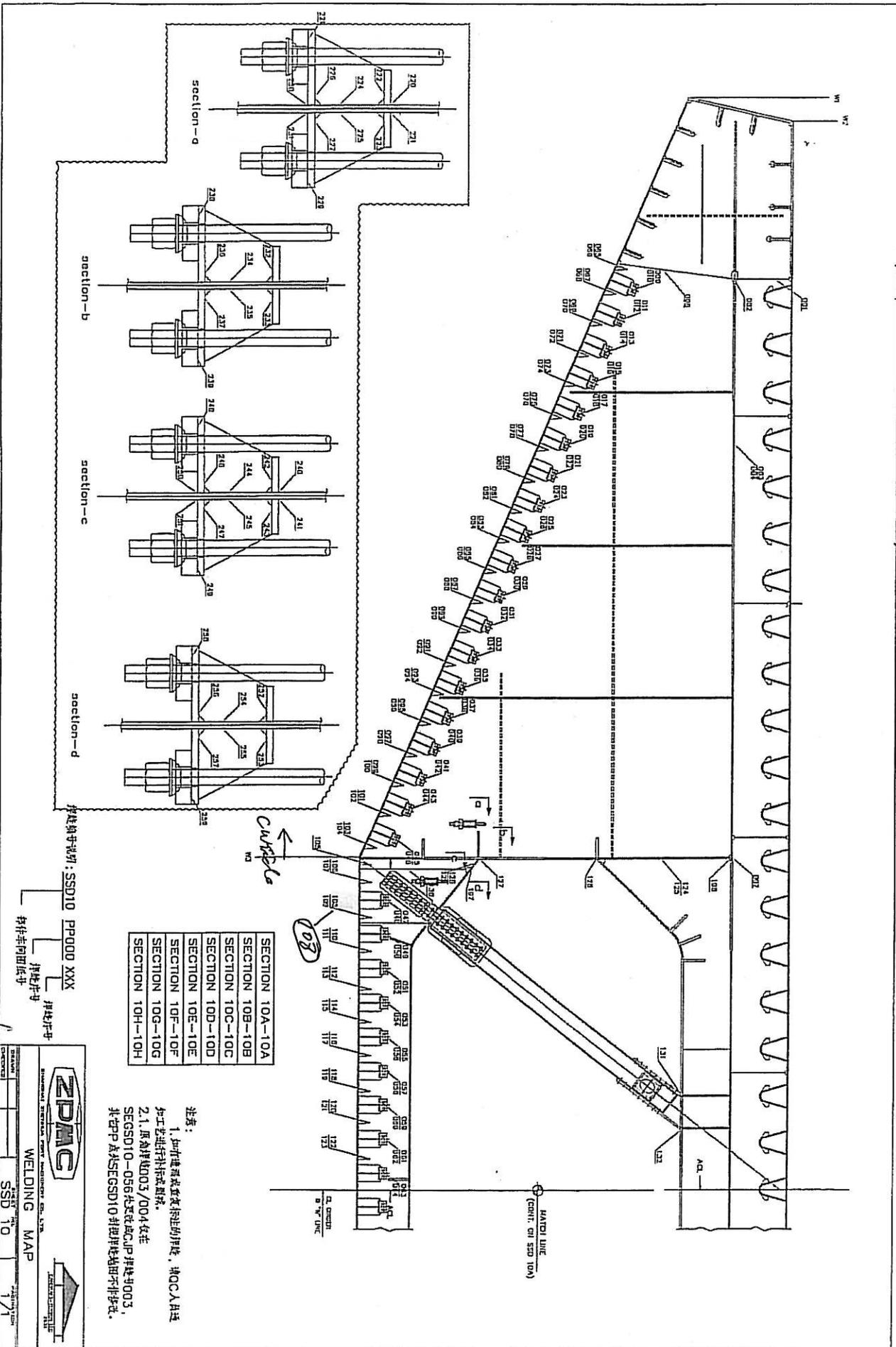
PP51
CB Side

焊缝编号规则: SP000 00 XXX



注意: 如有任何疑问, 请洽: 408-441-1111

MT-NCR-78w-001 4/4



焊接符号: SSD10 PPOOD XXX
 焊接符号
 附件车向面底中

ZPMC
 ZHEJIANG PROVINCE
 WELDING MAP
 1/1

2009 12 7 14:52:11, MANI.Y

DEPARTMENT OF TRANSPORTATION

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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-000503**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0497**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-Dec-2009**Description of Non-Conformance:**

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-One (1) Longitudinal linear indication measuring approximately 20mm in length.

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