

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



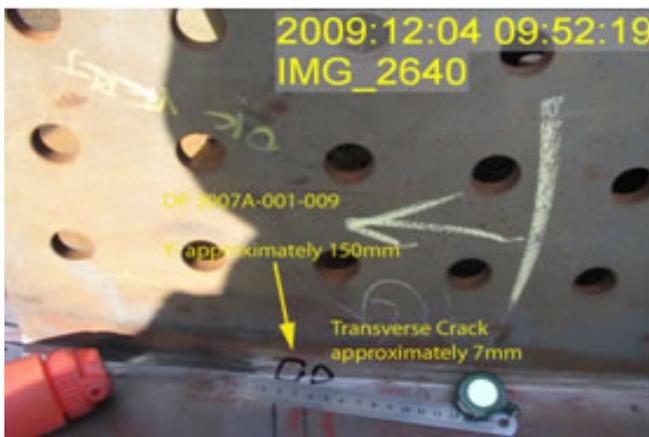
Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-000526**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0499**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Segment 12 AE Deck Panel Weld**Procedural****Procedural****Description:**

**Reference Description:** ZPMC performed a transverse indication on a deck panel weld without prior Engineer's approval for Lift 12AE Deck Panel

**Description of Non-Conformance:**

During random in-process visual inspection, Quality Assurance (QA) Inspector observed ZPMC performing weld repairs of one (1) Transverse Indication measuring approximately 7mm without the prior approval of the Engineer or an approved CWR. The weld is Identified as DP 3007A-001-009 and is a Partial Joint Penetration (PJP) weld joining U-Rib Stiffener (RS3001B) to Deck Plate (PL3007A). This member was located in north outside lay down yard.



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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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### Applicable reference:

Special Provisions 8-3; In addition to the provisions in AWS D1.5, Section 3.7.4 and Section 12.17, regardless of NDT method, and all repairs of cracks require prior approval of the Engineer. The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also the proposed repair procedures to correct them.

AWS D1.5-2002 Section 3.7.2.4 Crack in Weld or Base Metal; The extent of the crack shall be ascertained by the use of MT, PT, or other equally positive means; the metal shall be removed for the full length of the crack plus 50mm [2"] beyond the end of each crack and re-welded.

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

**Who discovered the problem:** Christopher D'sousa

**Name of individual from Contractor notified:** Cao Hai Zhou

**Time and method of notification:** 1345 hours, Verbal

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

**Time and method of notification:** 1500 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.

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**Inspected By:** Carreon,Albert

Lead Reviewer/Task Leader

**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:** 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:** 05.03.06-000487

**Subject:** NCR No. ZPMC-0499

**Reference Description:** ZPMC performed a transverse indication on a deck panel weld without prior Engineer's approval for Lift 12AE Deck Panel

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, Quality Assurance (QA) Inspector observed ZPMC performing weld repairs of one (1) Transverse Indication measuring approximately 7mm without the prior approval of the Engineer or an approved CWR. The weld is Identified as DP 3007A-001-009 and is a Partial Joint Penetration (PJP) weld joining U-Rib Stiffener (RS3001B) to Deck Plate (PL3007A). This member was located in north outside lay down yard.

**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-0499

**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:** 05.03.06-000487

**Subject:** NCR No. ZPMC-0499

**Dated:** 23-Mar-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000634 **Rev:** 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC is providing NDT documentation to show that the repair performed is acceptable and free of defect. Based on these documents, ZPMC requests closure of this NCR.

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**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000634R00;

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### 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-0499 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 05-Apr-2010



No. B-698

## LETTER OF RESPONSE

**TO:** American Bridge/Flour

**DATE:** 2010-3-20

**REGARDING:** NCR-000526(ZPMC-0499)

ZPMC is providing the NDT record show this weld is now acceptable and ZPMC is requesting this NCR to be closed. Please refer to B-CWR1241.

**ATTACHMENT:**

NCR-000526(ZPMC-0499)

B787-MT-19884

*Jm* *W*

*2/20/10*



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: 24-Dec-2009

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

Dear: Mr. Charles Kanapicki  
Attention: Mr. Thomas Nilsson Project/Fabrication Manager  
Subject: NCR No. ZPMC-0499

Job Name: SAS Superstructure  
Document No: 05.03.06-000487

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Transmitted by: Bill Howe

Attachments: ZPMC-0499

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

File: 05.03.06

**DEPARTMENT OF TRANSPORTATION**  
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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-000526

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

**Date:** 04-Dec-2009

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

**NCR #:** ZPMC-0499

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural

Joint fit-up  Coating  Other

Procedural  Procedural  Description:

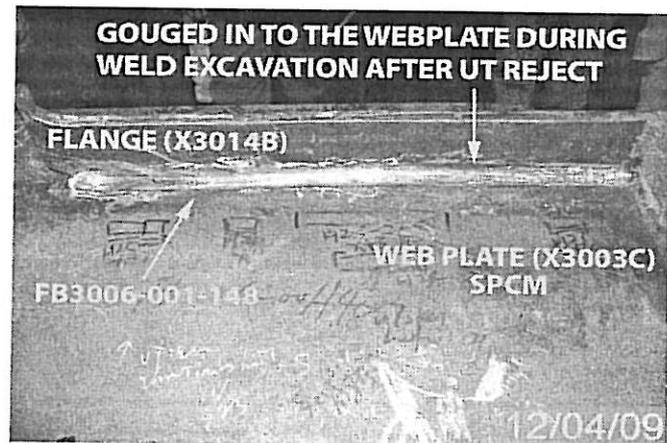
**Bridge No:** 34-0006

**Component:** Segment 12 AE Deck Panel Weld

**Reference Description:** ZPMC performed a transverse indication on a deck panel weld without prior Engineer's approval for Lift 12AE Deck Panel

### Description of Non-Conformance:

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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

**Time and method of notification:** 1500 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.

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**Inspected By:** Carreon, Albert

Lead Reviewer/Task Leader

**Reviewed By:** Wahbeh, Mazen

SMR



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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-000613**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0499**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:** 04-Dec-2009**Description of Non-Conformance:**

During random in-process visual inspection, Quality Assurance (QA) Inspector observed ZPMC performing weld repairs of one (1) Transverse Indication measuring approximately 7mm without the prior approval of the Engineer or an approved CWR. The weld is Identified as DP 3007A-001-009 and is a Partial Joint Penetration (PJP) weld joining U-Rib Stiffener (RS3001B) to Deck Plate (PL3007A). This member was located in north outside lay down yard.

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

Submit CWR for Engineers approval and perform NDT required to ensure weld quality.

**Corrective action taken:**

Contractor submitted CWR for approval along with subsequent NDT report verifying said weld is in conformance with Contract specifications.

**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 152.1675.3703, who represents the Office of Structural Materials for your project.

**Inspected By:** Simonis, Jim

Quality Assurance Inspector

**Reviewed By:** Wahbeh, Mazen

QA Reviewer