

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-000530

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Dec-2009

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

NCR #: ZPMC-0503

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 5AW I-Rib Weld
Procedural	Procedural	Description:	

Reference Description: I-Rib components for Segment 5AW were welded in a misaligned position

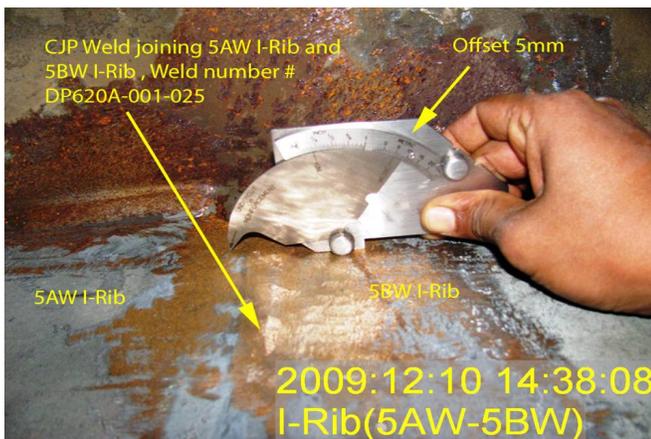
Description of Non-Conformance:

The Caltrans Quality Assurance (QA) Inspector observed an I-Rib weld between 5AW to 5BW Crossbeam side (W5) that was misaligned and welded. The out of tolerance offset measurement across the weld is 5mm and the maximum allowed per AWS D1.5 2002 is 3mm.

The weld is identified as: DP620A-001-025

The weld is a Complete Joint Penetration (CJP) butt weld.

The location of the weld is between 5AW I-Rib to 5BW I-Rib, Cross beam side at W5.



Applicable reference:

AWS D1.5 (02) Section 3.3.3; "Parts to be joined by groove welds shall be carefully aligned. Where the parts are effectively restrained against bending due to eccentricity in alignment, the offset from theoretical alignment shall not exceed 10 percent of the thickness of the thinner part joined, but in no case shall be more than 3 mm

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

[1/8 in].”

Who discovered the problem: M. Manikandan

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 0800 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 0900 hours, Verabal

QC Inspector's Name: Wang Lu

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: 05-Jan-2010

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: 05.03.06-000491

Subject: NCR No. ZPMC-0503

Reference Description: I-Rib components for Segment 5AW were welded in a misaligned position

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:** 05

Remarks:

The Caltrans Quality Assurance (QA) Inspector observed an I-Rib weld between 5AW to 5BW Crossbeam side (W5) that was misaligned and welded. The out of tolerance offset measurement across the weld is 5mm and the maximum allowed per AWS D1.5 2002 is 3mm.

The weld is identified as: DP620A-001-025

Action Required and/or Action Taken:

This NCT was previously sent with a conflicting description on December 24,2009 and has now been corrected. Submit a repair procedure to the engineer for approval. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0503

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

Dated: 09-Mar-2010

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000611 Rev: 00

Ref: 05.03.06-000491

Subject: NCR No. ZPMC-0503

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing dimensional data to show that I rib misalignment is acceptable. Based on this ZPMC is requesting closure of this NCR.

ZPMC is providing dimensional data to show that I rib misalignment is acceptable. Based on this ZPMC is requesting closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000611R00;

Caltrans' comments:

Status: CLO

Date: 18-Mar-2010

The documentation received is sufficient to close this NCR.

Submitted by: Ross, Don

Date: 18-Mar-2010

Attachment(s):



No. B-653

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-8

REGARDING: NCR-000530 (ZPMC-0503)

With this letter of response, ZPMC requests closure of CT NCR-000530 (ZPMC-0503) what mentioned that CT inspector observed misaligned I-rib.

- After ZPMC's confirmation with CT the misalignment for this I-rib was measured to be 3mm what was acceptable.
- Punch List item 344 was closed basing on the measurement by CT.

Based on the responses above and attached data, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-000530 (ZPMC-0503)

SURVEY DATA FOR CORNER ASSEMBLY

Ly *z*
2/9/10



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

Job Name: SAS Superstructure

Document No: 05.03.06-000491

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0503

Reference Description: I-Rib components for Segment 5AW were welded in a misaligned position

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: 85

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located in Segment 5AW on the Deck Plate (DP) diaphragm to Floor Beam (FB) flange repair areas, this Quality Assurance Inspector (QAI) discovered the following issues:

- Two (2) longitudinal linear indications measuring approximately between 8mm to 11mm in length respectively.
- The welds are identified as: Weld # SSD13-PP30-004 and SSD14-PP31-005.
- The welds are Fillet welds joining the DP diaphragm web to the FB flange member.
- The member is located in the OBG Trial Assembly yard.

The Notice of Witness Inspection Number (NWIT) is ABK repair areas over check per MT report 12-05-09. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% inspection of this weld.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval. Missed MT indications are a chronic problem. Provide training to the ZPMC technician and submit documentation that shows competency. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe

Attachments: ZPMC-0503

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao
File: 05.03.06

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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-000530

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Dec-2009

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

NCR #: ZPMC-0503

Type of problem:

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

Bridge No: 34-0006

Component: Segment 5AW I-Rib Weld

Reference Description: I-Rib components for Segment 5AW were welded in a misaligned position

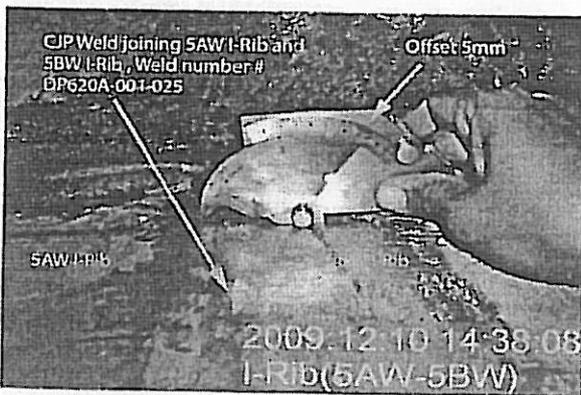
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 0800 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 0900 hours, Verbal

QC Inspector's Name: Wang Lu

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

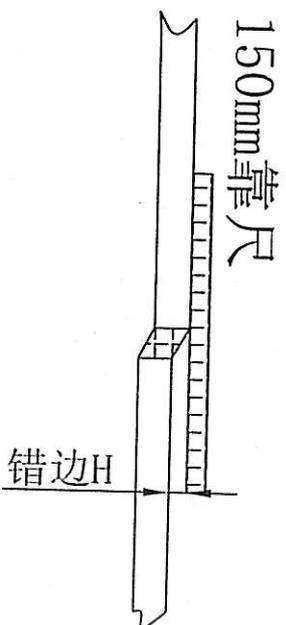
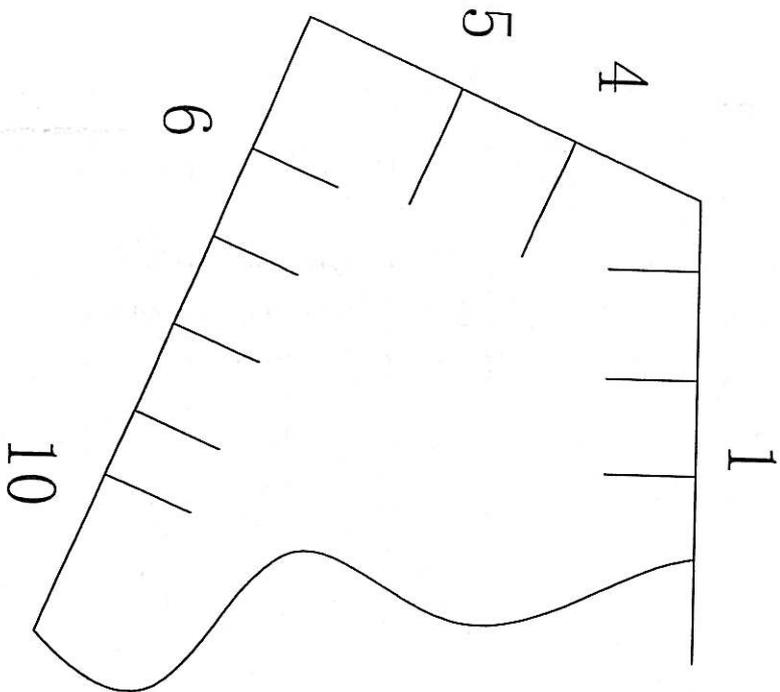
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Inspected By: Carreon, Albert

Reviewed By: Wahbeh, Mazen

Lead Reviewer/Task Leader

SMR



编号	1	2	3	4	5
测量值H	3	1	2	3	2
编号	6	7	8	9	10
测量值H	2	2	1	2	3

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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-000543**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 17-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0503**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: 10-Dec-2009**Description of Non-Conformance:**

The Caltrans Quality Assurance (QA) Inspector observed an I-Rib weld between 5AW to 5BW Crossbeam side (W5) that was misaligned and welded. The out of tolerance offset measurement across the weld is 5mm and the maximum allowed per AWS D1.5 2002 is 3mm.

The weld is identified as: DP620A-001-025

The weld is a Complete Joint Penetration (CJP) butt weld.

The location of the weld is between 5AW I-Rib to 5BW I-Rib, Cross beam side at W5.

Contractor's proposal to correct the problem:

Correct misalignment issue by bringing welded members into conformance with specifications listed in AWS D1.5 Section 3.3.3. for parts to be joined by groove welds.

Corrective action taken:

Contractor supplied survey data showing that the misalignment was corrected and the members were brought within 3mm of each other. This issue was tracked by Voyage 2 Punchlist item no. 344 and was signed off 02-23-2010.

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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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer