

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-000538**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0511**Type of problem:**

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

Reference Description: Base Metal Repairs without Engineer's Approval, Segment 7CW**Description of Non-Conformance:**

During the Quality Assurance random in-process visual inspection of Segment 7CW, this Quality Assurance Inspector (QA) discovered the following issue:

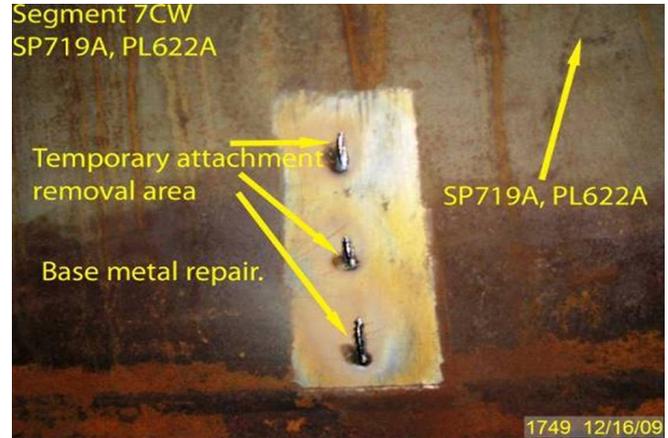
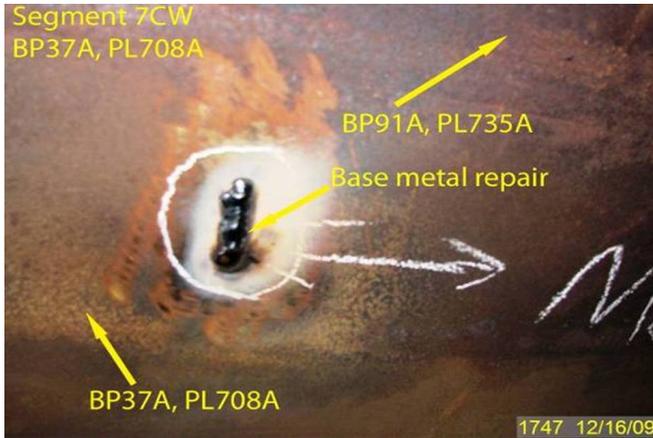
-Base metal repairs being performed in way of temporary attachment removal areas on the bottom and side plates without the prior approval of the engineer.

The plate identifications under repair are identified as:

- SP126A, Plate number-PL250A
- SP153A, Plate Number-PL533A
- SP719A, Plate Number-PL622A
- SP481A, Plate Number-PL621A
- SP440A, Plate Number-PL1279A
- BP91A, Plate Number-PL735A
- BP37A, Plate Number-PL708A
- BP145A, Plate Number-PL789A
- The material is A709 Grade 345 non SPCM

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Standard Specifications (99) section 8-3.01: "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 of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair."

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Hiranch Patel

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1700 hours, 12/16/09, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 0730 hours, 12/18/09, Verbal

QC Inspector's Name: Zhang Wei

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Yes No

Contractor's proposal to correct the problem:

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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Guest,Skylar	SMR
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
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-0511	Document No:	05.03.06-000499

Reference Description: Base Metal Repairs without Engineer's Approval, Segment 7CW

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:

During the Quality Assurance random in-process visual inspection of Segment 7CW, this Quality Assurance Inspector (QA) discovered the following issue:

-Base metal repairs being performed in way of temporary attachment removal areas on the bottom and side plates without the prior approval of the engineer.

The plate identifications under repair are identified as:

- SP126A, Plate number-PL250A
- SP153A, Plate Number-PL533A
- SP719A, Plate Number-PL622A
- SP481A, Plate Number-PL621A
- SP440A, Plate Number-PL1279A
- BP91A, Plate Number-PL735A
- BP37A, Plate Number-PL708A
- BP145A, Plate Number-PL789A
- The material is A709 Grade 345 non SPCM

Action Required and/or Action Taken:

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

Attachments: ZPMC-0511

NCT

(Continued Page 2 of 2)

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: 05.03.06-000499

Subject: NCR No. ZPMC-0511

Dated: 14-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000487 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: CT/ABF and ZPMC have established a procedure in which non-SPCM temporary attachment removal base metal repairs are performed in accordance with procedure TA100 supplemented with a WRR.

CT/ABF and ZPMC have established a procedure in which non-SPCM temporary attachment removal base metal repairs are performed in accordance with procedure TA100 supplemented with a WRR that contains a pre-established weld repair disposition as agreed to by CT, ABF and ZPMC. The WRR will reference the location and number of areas to be weld repaired. The QA inspector will be notified prior to weld repairs for the purposes of performing QA verification if of the areas prepared for welding. The QA inspector will also be notified when the finished weld repair has been accepted by ZPMC and ABF for QA verification. The WRR and applicable weld procedure must be available on site during the welding operation.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000487R00;

Caltrans' comments:

Status: CLO

Date: 25-Jan-2010

The documentation submitted by the contractor has been reviewed by the Enigneer and is found to be acceptable.

Submitted by: Chao, Ching

Date: 25-Jan-2010

Attachment(s):



No. B-579

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-1-12

REGARDING: NCR-00585/584/597/538 (ZPMC-0558/557/570/511)

With this letter of response, ZPMC requests closure of CT NCR-00585/584/597/538 (ZPMC-0558/557/570/511), since we have made an agreement with three parties that just the SPCM base metal repair will be prepared one CWR and first got the approval from CT's engineer, so the criteria from the above non-conformance report can be removed and not be used for the reference further. Meanwhile the four NCR can't exist with the formal documentation with the false applicable standard.

So base on the above clarification, ZPMC requests to close out NCR-00585/584/597/538 (ZPMC-0558/557/570/511)

ATTACHMENT:

NCR-00585/584/597/538 (ZPMC-0558/557/570/511)

Chao Shuangbo

2010. 1. 12



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: 03-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: 05.03.06-000548

Subject: NCR No. ZPMC-0558

Reference Description: Base Metal Repair on Segment 10AW Deck Panel without Engineer's Approval

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: 10

Remarks:

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Segment 10AW, this QA inspector discovered the following issue:

-Base metal repairs were being performed that were caused by the removal of temporary attachments on two (2) Deck Plates, without the prior approval of the Engineer.

-The Deck Panels are identified as: DP262A (PL309A) and DP235A (PL366A)

-The weld splice joining Deck Panels DP262A and DP235A are identified as: SEG059*007

-The steel deck material is A709 Grade 345 non SPCM.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Notify the engineer prior to starting base metal repair. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0558

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

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
 DIVISION OF ENGINEERING SERVICES
 Office of Structural Materials
 Quality Assurance and Source Inspection



Bay Area Branch
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 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
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island
Report No: NCR-000585
Date: 02-Jan-2010
NCR #: ZPMC-0558

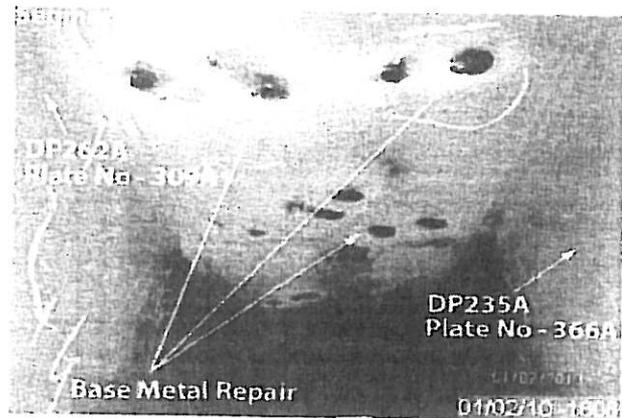
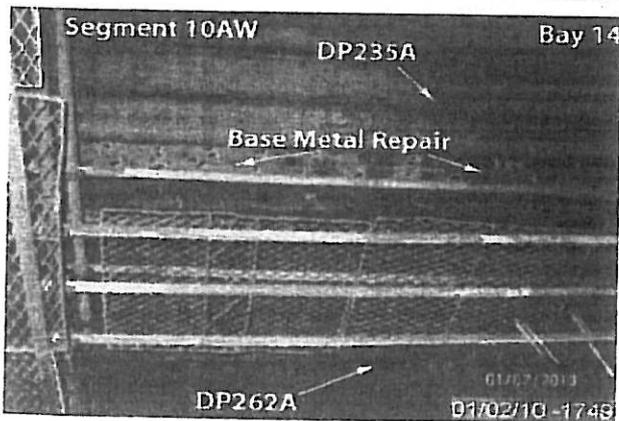
Type of problem:

- Welding Concrete Other
 Welding Curing Procedural **Bridge No:** 34-0006
 Joint fit-up Coating Other **Component:** Segment 10AW Deck Panel
 Procedural Procedural **Description:**

Reference Description: Base Metal Repair on Segment 10AW Deck Panel without Engineer's Approval

Description of Non-Conformance:

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Segment 10AW, this QA inspector discovered the following issue:
 -Base metal repairs were being performed that were caused by the removal of temporary attachments on two (2) Deck Plates, without the prior approval of the Engineer.
 -The Deck Panels are identified as: DP262A (PL309A) and DP235A (PL366A)
 -The weld splice joining Deck Panels DP262A and DP235A are identified as: SEG059*007
 -The steel deck material is A709 Grade 345 non SPCM.



Applicable reference:

Caltrans Special Provision Section 8-3.01: "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 of the proposed repair procedures to correct them. For requests to perform repairs, the contractor shall include an engineering evaluation of the proposed repair."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Vibin Kumar Selvanayaham

Name of individual from Contractor notified: Lee Man Kit

Time and method of notification: 1615 hours, 01/02/10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1045 hours, 01/03/10, Email

QC Inspector's Name: Xu Tao

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, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

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: 03-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: 05.03.06-000547

Subject: NCR No. ZPMC-0557

Reference Description: Base Metal Repair on Segment 9BW Deck Plate without Engineer's approval

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: 09

Remarks:

During the Quality Assurance (QA) random in-process visual inspection of Segment 9BW, this QA inspector discovered the following issue:

- Base metal repairs were being performed that were caused by the removal of temporary attachments on two (2) Deck Plates, without the prior approval of the Engineer.
- The Deck Plates are identified as: DP231A (PL359A) and DP258A (PL305A)
- The material is A709M Grade 345 non SPCM:
- OBG Segment 9BW is located in the outside yard north of Bay 17.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Notify the engineer prior to performing base metal repair. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0557

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

File: 05.03.06

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: 13.2/13.9File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000584

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 02-Jan-2010

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

NCR #: ZPMC-0557

Type of problem:

Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Segment 9BW Deck PlateProcedural Procedural Description:

Reference Description: Base Metal Repair on Segment 9BW Deck Plate without Engineer's approval

Description of Non-Conformance:

During the Quality Assurance (QA) random in-process visual inspection of Segment 9BW, this QA inspector discovered the following issue:

-Base metal repairs were being performed that were caused by the removal of temporary attachments on two (2) Deck Plates, without the prior approval of the Engineer.

-The Deck Plates are identified as: DP231A (PL359A) and DP258A (PL305A)

-The material is A709M Grade 345 non SPCM:

-OBG Segment 9BW is located in the outside yard north of Bay 17.



Applicable reference:

Caltrans Special Provision Section 8-3.01: "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 of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair."

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Ji Cai Fang

Time and method of notification: 1545 hours, 01/02/10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1015 hours, 01/03/10, Email

QC Inspector's Name: Wang Xing Qin

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, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric SMR

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: 06-Jan-2010

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-0570

Job Name: SAS Superstructure
 Document No: 05.03.06-000561

Reference Description: ZPMC performed base metal repairs without the Engineer's approval in Segment 6AW Deck Plate

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: 06

Remarks:

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Base metal repairs (BMR) were being performed that were discovered from the removal of temporary attachments on a Deck Plate, without the prior approval of the Engineer.
- There are a total of 22 locations of these base metal repairs.
- The approximate length of the BMR is random. They are running adjacent to the X71D Counter Weight attachment plate.
- The Counterweight side of Deck Plate is identified as: DP623A
- The Counterweight attachment plate is identified as X71D.
- The material is A709M Grade 345 non SPCM.
- Deck Plate is located on top of Segment 6AW in the Trial Assembly area.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Do not initiate base metal repair until the engineer is notified. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer
 Attachments: ZPMC-0570

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

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-000597

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Jan-2010

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

NCR #: ZPMC-0570

Type of problem:

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

Bridge No: 34-0006

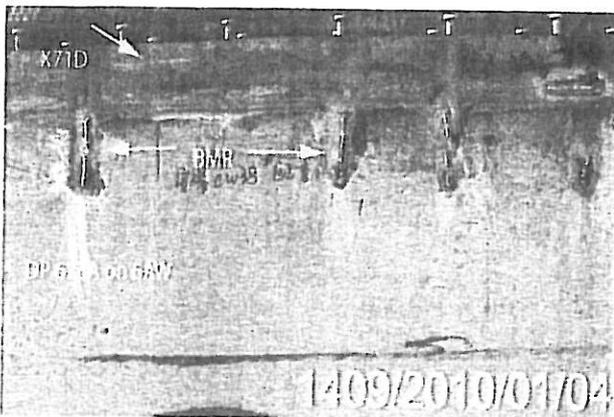
Component: OBG Segment 6AW Deck Plate

Reference Description: ZPMC performed base metal repairs without the Engineer's approval in Segment 6AW Deck Plate

Description of Non-Conformance:

During the Quality Assurance (QA) random in-process visual inspection of the OBG segments in the Trial Assembly area, this QA inspector discovered the following issue:

- Base metal repairs (BMR) were being performed that were discovered from the removal of temporary attachments on a Deck Plate, without the prior approval of the Engineer.
- There are a total of 22 locations of these base metal repairs.
- The approximate length of the BMR is random. They are running adjacent to the X71D Counter Weight attachment plate.
- The Counterweight side of Deck Plate is identified as: DP623A
- The Counterweight attachment plate is identified as X71D.
- The material is A709M Grade 345 non SPCM.
- Deck Plate is located on top of Segment 6AW in the Trial Assembly area.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT
(Continued Page 2 of 2)

Applicable reference:

Special Provisions Section 8-3.01: "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 of the proposed repair procedures to correct them. For requests to perform repairs, the contractor shall include an engineering evaluation of the proposed repair."

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Joe Alaniz

Name of individual from Contractor notified: Li Jingbo

Time and method of notification: 1500 hours, 01-04-10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1000 hours, 01-05-10, Verbal

QC Inspector's Name: Wu Zhi Cheng

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
 Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure
 Document No: 05.03.06-000499

Subject: NCR No. ZPMC-0511

Reference Description: Base Metal Repairs without Engineer's Approval, Segment 7CW

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

Remarks:

During the Quality Assurance random in-process visual inspection of Segment 7CW, this Quality Assurance Inspector (QA) discovered the following issue:

-Base metal repairs being performed in way of temporary attachment removal areas on the bottom and side plates without the prior approval of the engineer.

The plate identifications under repair are identified as:

- SP126A, Plate number-PL250A
- SP153A, Plate Number-PL533A
- SP719A, Plate Number-PL622A
- SP481A, Plate Number-PL621A
- SP440A, Plate Number-PL1279A
- BP91A, Plate Number-PL735A
- BP37A, Plate Number-PL708A
- BP145A, Plate Number-PL789A

-The material is A709 Grade 345 non SPCM

Action Required and/or Action Taken:

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

Attachments: ZPMC-0511

NCT

(Continued Page 2 of 2)

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

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-000538

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 16-Dec-2009

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

NCR #: ZPMC-0511

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: OBG Segment 7CW

Reference Description: Base Metal Repairs without Engineer's Approval, Segment 7CW

Description of Non-Conformance:

During the Quality Assurance random in-process visual inspection of Segment 7CW, this Quality Assurance Inspector (QA) discovered the following issue:

-Base metal repairs being performed in way of temporary attachment removal areas on the bottom and side plates without the prior approval of the engineer.

The plate identifications under repair are identified as:

-SP126A, Plate number-PL250A

-SP153A, Plate Number-PL533A

-SP719A, Plate Number-PL622A

-SP481A, Plate Number-PL621A

-SP440A, Plate Number-PL1279A

-BP91A, Plate Number-PL735A

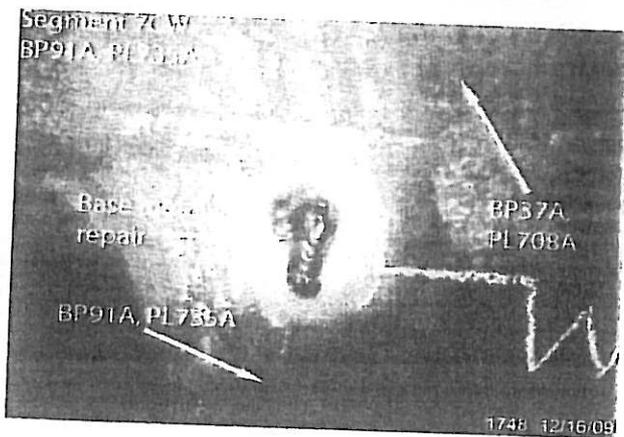
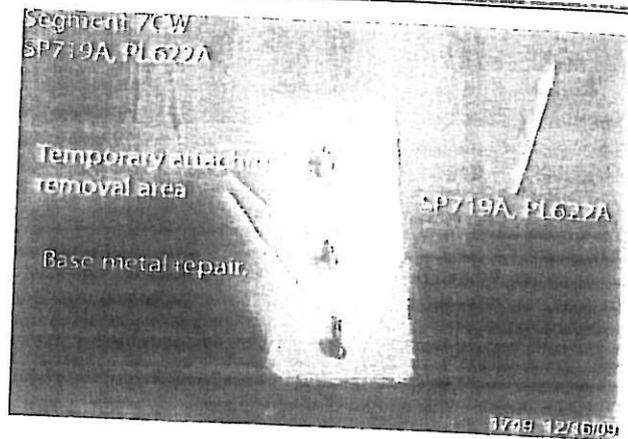
-BP37A, Plate Number-PL708A

-BP145A, Plate Number-PL789A

-The material is A709 Grade 345 non SPCM

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Standard Specifications (99) section 8-3.01: "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 of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair."

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Hiranch Patel
Name of individual from Contractor notified: Peter Shaw
Time and method of notification: 1700 hours, 12/16/09, Verbal
Name of Caltrans Engineer notified: Bill Howe
Time and method of notification: 0730 hours, 12/18/09, Verbal
QC Inspector's Name: Zhang Wei
Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Yes No

Contractor's proposal to correct the problem:

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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

SMR

Reviewed By: Wahbeh, Mazen

SMR

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000466**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0511**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: 16-Dec-2009**Description of Non-Conformance:**

During the Quality Assurance random in-process visual inspection of Segment 7CW, this Quality Assurance Inspector (QA) discovered the following issue:

-Base metal repairs being performed in way of temporary attachment removal areas on the bottom and side plates without the prior approval of the engineer.

The plate identifications under repair are identified as:

- SP126A, Plate number-PL250A
- SP153A, Plate Number-PL533A
- SP719A, Plate Number-PL622A
- SP481A, Plate Number-PL621A
- SP440A, Plate Number-PL1279A
- BP91A, Plate Number-PL735A
- BP37A, Plate Number-PL708A
- BP145A, Plate Number-PL789A
- The material is A709 Grade 345 non SPCM

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

In accordance with the Fabrication Procedures, the Contractor is not required to obtain the Engineer's approval prior to performing base metal repairs resulting from temporary attachment removal on non-SPCM material. Further discussions have led to a mutual agreement that WRRs will be used to track the locations of such base metal repairs on non-SPCM members.

