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-000551
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 19-Dec-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0524

Type of problem:

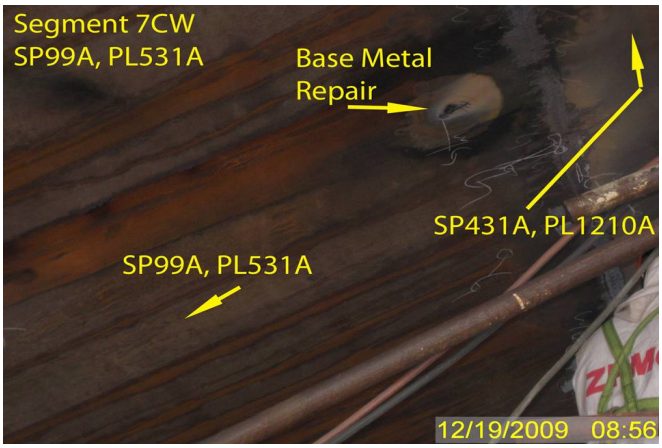
Welding	☑	**Concrete**	☐	**Other**	☐		
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:**	34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:**	Segment 7CW Side Panel
Procedural	☑	**Procedural**	☐	**Description:**			

Reference Description: ZPMC performed base metal repairs without the Engineer's approval on Segment 7CW

Description of Non-Conformance:

During a random visual in-process inspection of Segment 7CW Side Panels (SP), the Caltrans Quality Assurance (QA) Inspector discovered the following issue:

-ZPMC was performing base metal (BM) repairs, caused by the removal of temporary attachments.
-The Side Panels affected are identified as: SP99A and SP431A
-The Side Plates are identified as: PL531A (SP99A) and PL1210A (SP431A)
-The material is identified as: A709 Grade 345 non SPCM
-These BM repairs were performed without the prior approval of the Engineer.
-OBG Segment 7CW is located in the segment repair yard north of the Paint Blast shop.



Applicable reference:

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."

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: Mike Hasler

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 12/19/2009, 0900 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 12/20/2009, 1000 hour, Email

QC Inspector's Name: Wang Wei Ming

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:**	25-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:**	05.03.06-000512
Subject:	NCR No. ZPMC-0524		

Reference Description: ZPMC performed base metal repairs without the Engineer's approval on 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 a random visual in-process inspection of Segment 7CW Side Panels (SP), the Caltrans Quality Assurance (QA) Inspector discovered the following issue:

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-The Side Plates are identified as: PL531A (SP99A) and PL1210A (SP431A)

-The material is identified as: A709 Grade 345 non SPCM

-These BM repairs were performed without the prior approval of the Engineer.

-OBG Segment 7CW is located in the segment repair yard north of the Paint Blast shop.

Action Required and/or Action Taken:

A response for the resolution of this issue is expected within 7 days. Submit the MT results to the engineer. Notify the engineer prior to repair.

Transmitted by: Bill Howe

Attachments: ZPMC-0524

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

File: 05.03.06

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV
P.O. BOX 23223 Oakland, CA 94623
Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000512

Subject: NCR No. ZPMC-0524

Dated: **31-Dec-2009**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000452 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution: The attached procedure, TA100 is an approved procedure to perform repairs for non SPCM temporary attachment areas, therefore, ZPMC requests this NCR to be withdrawn or closed.

This NCR states that base metal repair was performed without Engineers approval, however, ABFJV and ZPMC request CT to direct their attention to procedure TA100 showing an approved as noted and signature by CT on 7 Sept. 09. The attached procedure, TA100 is an approved procedure to perform repairs for non SPCM temporary attachment areas, therefore, ZPMC requests this NCR to be withdrawn or closed.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000452R00;

Caltrans' comments:

Status: CLO

Date: 06-Jan-2010

Notification is required for base metal repair even if TA 100 is the repair method. This NCR is closed.

Submitted by: Howe, Bill

Date: 06-Jan-2010

Attachment(s):

No. B-538

LETTER OF RESPONSE

TO: American Bridge/Flour
DATE: 2009-12-30
REGARDING: NCR-000551(ZPMC-0524)

With this letter of response, ZPMC requests closure for CALTRANS NCR-000551(ZPMC-0524) what mentioned that QA observed base metal repairs without the Engineer's approval..
The QA inspector discovered this issue and awarded this was non SPCM base metal repair after removal of temporary attachments. Before ZPMC performed such repairing work, ZPMC has got an approved repair procedure. So ZPMC think a misunderstanding of the requirement to notify the engineer prior to base metal repair occurred.
So ZPMC provides the Temporary Attachment Removal Procedure, hoping CALTRANS could take a review and consider **withdraw** this NCR.

ATTACHMENT:
NCR-000551(ZPMC-0524)
TEMPORARY ATTACHMENT REMOVAL PROCEDURE

12/30/09

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: 25-Dec-2009

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

Job Name: SAS Superstructure

Document No: 05.03.06-000512

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Subject: NCR No. ZPMC-0524

Reference Description: ZPMC performed base metal repairs without the Engineer's approval on 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:

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Material Location: OBG **Lift:** 07

Remarks:

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Transmitted by: Bill Howe

Attachments: ZPMC-0524

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

File: 05.03.06

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY

Arnold Schwarzenegger, Governor

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

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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-000551
Date: 19-Dec-2009
NCR #: ZPMC-0524

Type of problem:

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

Bridge No: 34-0006
Component: Segment 7CW Side Panel

Reference Description: ZPMC performed base metal repairs without the Engineer's approval on Segment 7CW

Description of Non-Conformance:

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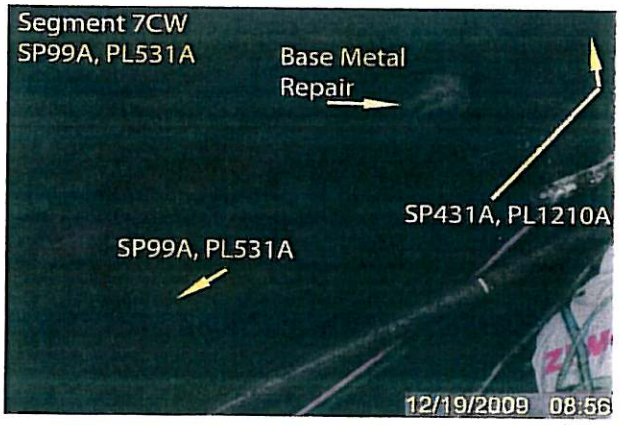

Applicable reference:

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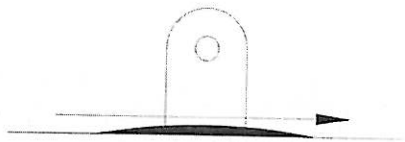
Who discovered the problem: Mike Hasler
Name of individual from Contractor notified: Peter Shaw
Time and method of notification: 12/19/2009, 0900 hours, Verbal
Name of Caltrans Engineer notified: Ching Chao and Bill Howe
Time and method of notification: 12/20/2009, 1000 hour, Email
QC Inspector's Name: Wang Wei Ming
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

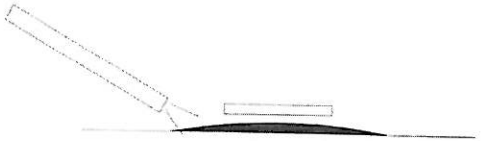
Temporary Attachment Removal Procedure

1. Scope of Applying:
All the temporary pad eye, reinforcement and fixture removal.
The temporary pad eye, reinforcement shall have the same grade as the base metal attached.

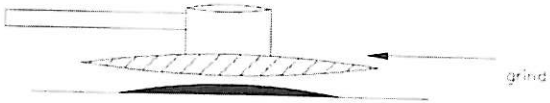
2. Removal sequence of temporary pad eye and reinforcement:
(1) Use flame to cut the temporary attachment off. Attention shall be paid to avoid damaging the base metal.



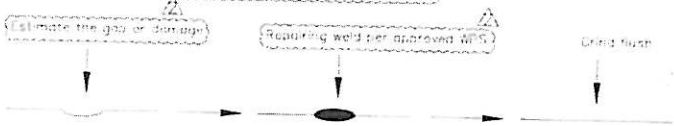
(2) Use carbon arc air gouging or flame cutting to remove the weld. Keep 3~5mm gap from surface of base metal.



(3) Use grinder to grind flush the surface of base metal. And check if there is local distortion.



(4) If there is some damage, the steps below will be followed and then grind flush the surface. (For the detail see WQCP section 9.)



Note: 100%MT will be performed on the surface (where the attachment has been removed)

☐ APPROVED
☑ APPROVED AS NOTED
☐ RETURNED FOR CORRECTION
Pursuant to Section 5-1.02
of the Standard Specifications
State of California
DEPARTMENT OF TRANSPORTATION
Division of Engineering Services
Office of Structure Construction
Structure Representative — Date 9-7-07

NO	DATE	REVISIONS	BY
2	[illegible]	[illegible]	[illegible]

ZPMC SHANGHAI ZHENHUA PORT MACHINERY CO., LTD.

SAN FRANCISCO OAKLAND BAY BRIDGE, EAST SPAN SELF-ANCHORED SUSPENSION SPAN
ROUTE 80 EAST OF YERBA BUENA ISLAND, DISTRICT 04, SF COUNTY, CA
BRIDGE Nos. 34-0006L PM 8.2, KP 13.2 & 34-0006R PM 8.2 KP 13.2
STATE OF CALIFORNIA DEPT. OF TRANSPORTATION CONTRACT NO. 04-0120F4
ENGINEER CALTRANS — T.Y.LIN / MOFFATT & NICHOL JV
CONTRACTOR AMERICAN BRIDGE / FLUOR ENTERPRISES JV

Temporary Attachment Removal Procedure

DRAWN	[illegible]	[illegible]	SHEET NO. TA100	ORDER NO. 085-FP
CHECKED	[illegible]	[illegible]		

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCS-000459
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 14-Jan-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0524

Type of problem:

Welding	☑	**Concrete**	☐	**Other**	☐	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:**
Procedural	☑	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 19-Dec-2009

Description of Non-Conformance:

During a random visual in-process inspection of Segment 7CW Side Panels (SP), the Caltrans Quality Assurance (QA) Inspector discovered the following issue:
-ZPMC was performing base metal (BM) repairs, caused by the removal of temporary attachments.
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-The material is identified as: A709 Grade 345 non SPCM
-These BM repairs were performed without the prior approval of the Engineer.
-OBG Segment 7CW is located in the segment repair yard north of the Paint Blast shop.

Contractor's proposal to correct the problem:

NA

Corrective action taken:

Contractor is not required to notify the Engineer for base metal repairs resulting from temporary the removal of temporary attachments unless repairs are being performed on SPCM material. Further discussion has led to an agreement between ABF and CT to track base metal repairs from temporary attachemt removal through WRRs rather than CWRs.

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