

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-000625**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0598**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 8CW Deck Panels
Procedural	Procedural	Description: Missed MT indications by QC	

Reference Description: Two Transverse Indications discovered with the Magnetic Particle Method after ZPMC had previously tested and accepted these welds on Segment 8CW Deck Panels.

Description of Non-Conformance:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance Inspector (QA) discovered the following issues:

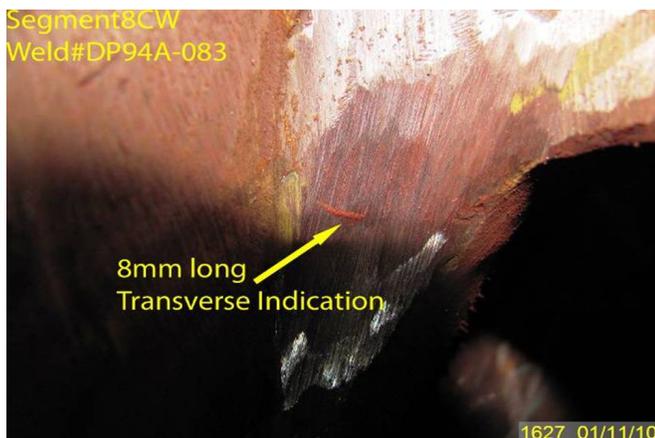
-Two (2) Transverse linear indications measuring approximately 8 mm long on DP94A and 10 mm long on DP148A.

-The welds are identified as: DP094-070-083 and DP148-070-076.

-The welds are a Complete Joint Penetration (CJP) welds joining DP148A and DP94A Closed Ribs to Deck panel diaphragm plate X1.

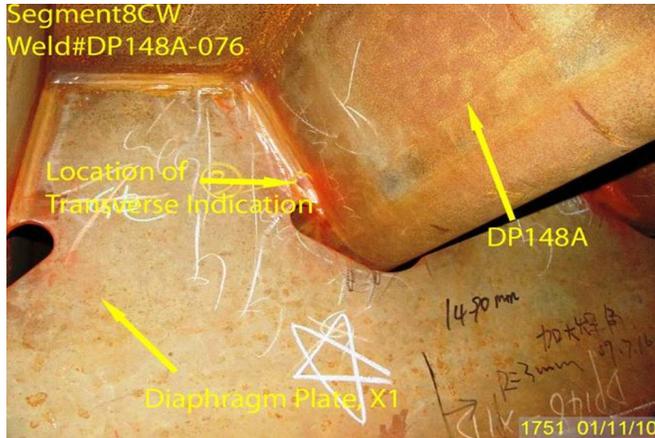
-The OBG 8CW segment is located at In front of blast shop.

The Notice of Witness Inspection Number (NWIT) is 005037. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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 cracks.

Who discovered the problem: Hiranch Patel

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 1700 hours, 01-11-10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 0700 hours, 01-12-10, Verbal

QC Inspector's Name: Zhong 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: 13-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-0598

Job Name: SAS Superstructure
Document No: 05.03.06-000588

Reference Description: Two Transverse Indications discovered with the Magnetic Particle Method after ZPMC had previously tested and accepted these welds.

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:** 08

Remarks:

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance Inspector (QA) discovered the following issues:

- Two (2) Transverse linear indications measuring approximately 8 mm long on DP94A and 10 mm long on DP148A.
- The welds are identified as: DP094-070-083 and DP148-070-076.
- The welds are a Complete Joint Penetration (CJP) welds joining DP148A and DP94A Closed Ribs to Deck panel diaphragm plate X1.
- The OBG 8CW segment is located at In front of blast shop.

The Notice of Witness Inspection Number (NWIT) is 005037. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide training and equipment as required to the ZPMC MT technician in order to detect these indications in the future. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0598

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: 05.03.06-000588

Subject: NCR No. ZPMC-0598

Dated: 22-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000532 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: 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-000532R00;

Caltrans' comments:

Status: CLO

Date: 26-Jan-2010

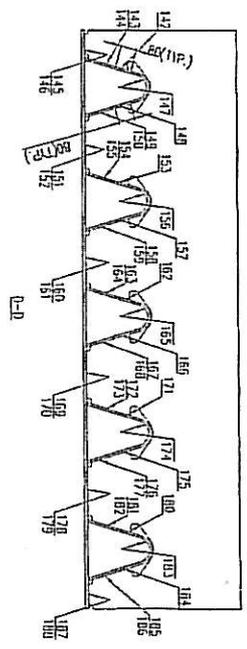
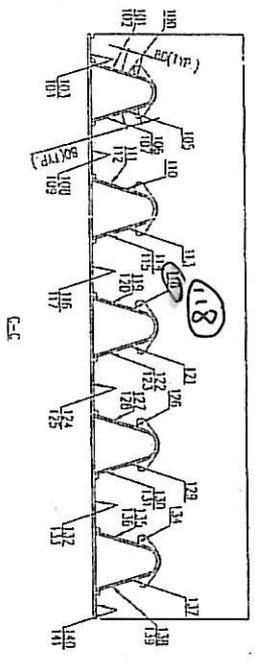
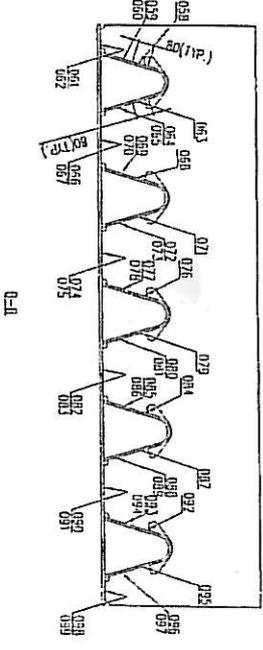
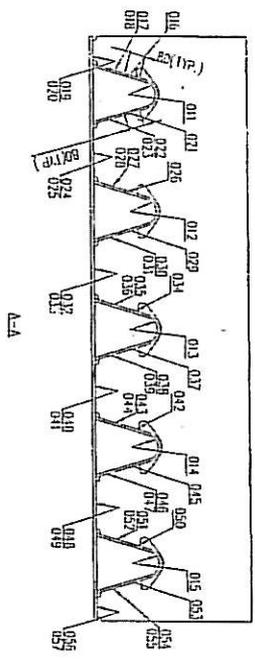
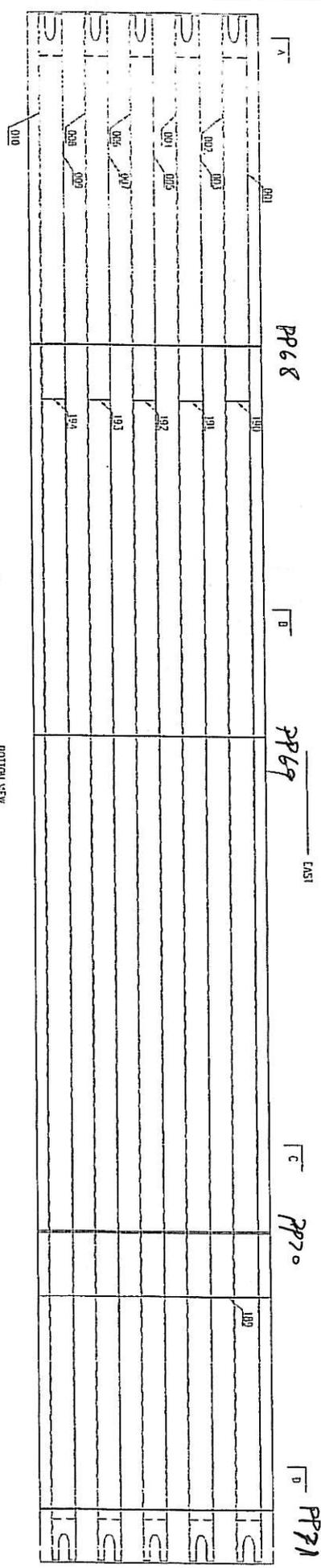
The documentation submitted by the contractor has been reviewed by the Engineer and is found to be acceptable. Based on the discussion in China with the contractor's representatives, other weld repair reports from ZPMC shall be included in the QA Data Base when available.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010

MT-NCR-8CW-005 2/4



注意：
如有变更或更改作法的异址，请
OC人员通知工艺进行制作或组成。

焊接符号说明：OP000 000 XXX
 焊接序号
 软件生产版本号
 软件车间图名字

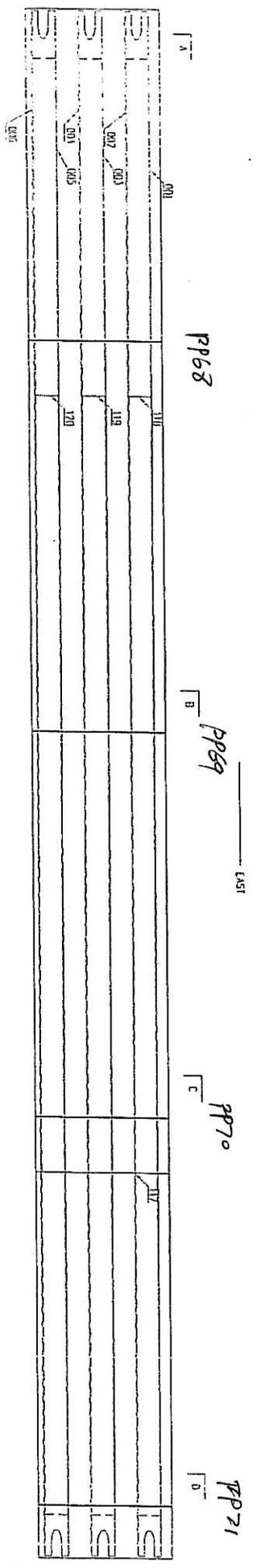


WELDING MAP

DP14B 1/1

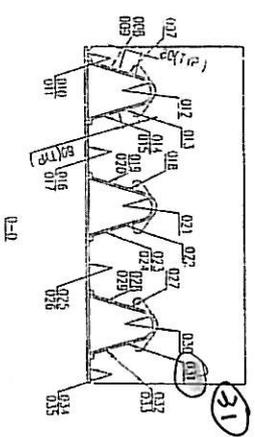
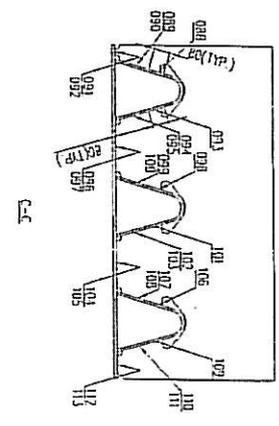
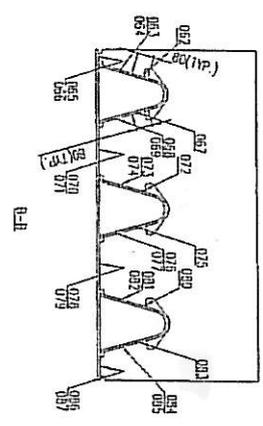
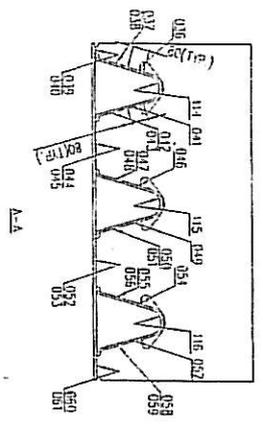
2008-7-9 7:48:22, MANI.Y

MT-NCR-8CW-005 3/4



PP68
 PP69
 PP70
 PP71

BOLTED FLANGE



焊接符号说明: DP000 000 XXX
 焊接序号
 零件生产流水号
 零件车间组号

注意:
 如有变更或更改执行的焊缝, 请
 QC人员通知工艺进行标注或更改。

ZPMC WELDING MAP 1/1
 DP94
 2008-7-9 7:48:03, MAINLY

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
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(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-000490**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0598**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: 11-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on Segment 8CW, this Quality Assurance Inspector (QA) discovered the following issues:

-Two (2) Transverse linear indications measuring approximately 8 mm long on DP94A and 10 mm long on DP148A.

-The welds are identified as: DP094-070-083 and DP148-070-076.

-The welds are a Complete Joint Penetration (CJP) welds joining DP148A and DP94A Closed Ribs to Deck panel diaphragm plate X1.

-The OBG 8CW segment is located at In front of blast shop.

The Notice of Witness Inspection Number (NWIT) is 005037. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. ZPMC's QC personnel are required to perform twenty five (25%) percent MT inspection of this weld.

Contractor's proposal to correct the problem:

Repair indication and perform required NDT.

Corrective action taken:

ABF submitted internal NDT documentation verifying the weld is now in conformance with Contract specifications. Per Team China discussions, documentation from ZPMC verifying the repairs were made and NDT was performed by ZPMC technicians will be submitted at a later date and added to the Data Base.

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