

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-000648**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0618**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Counter Weights
Procedural	Procedural	Description: Improper Storage	

Reference Description: Counter Weights outside of the North end of Bay 17 are stored directly on the ground and MEP mounting brackets are bent

Description of Non-Conformance:

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues:

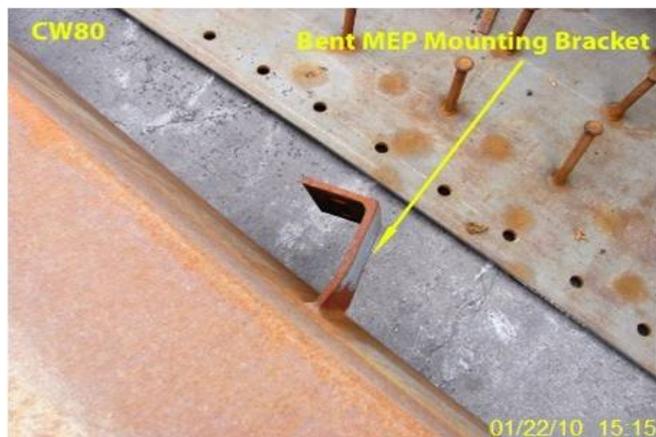
- OBG Counter Weight CW80 MEP mounting brackets (second and last) are bent.
- Nine (9) Counter Weights CW40, CW50, CW80, CW60, CW98, CW78, CW72, CW68 and CW104 were improperly stored. These Counter Weights are stored directly on the ground and are stacked unevenly on each other without the proper storage supports.
- These Counter Weights are located in the outside yard north of Bay 17.

For further information, please see the attached pictures.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Standard Specifications July, 1999 Section 6-1.03 Storage of Material; "Articles or materials to be incorporated in the work shall be stored in such a manner as to ensure the preservation of their quality and fitness for the work and to facilitate inspection".

Standard Specifications July, 1999 Section 55-1.04 Shipping, Handling and Storing Materials; "In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected. Material to be stored shall be placed above the ground upon platforms, skids or other supports."

Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 15:45 hours, 01/22/10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1800 hours, 01/23/10, Email

QC Inspector's Name: Zhang 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,(818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Simonis,Jim

QA Inspector

Reviewed By: Wahbeh,Mazen

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 24-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: 05.03.06-000609

Subject: NCR No. ZPMC-0618

Reference Description: Counter Weights outside of the North end of Bay 17 are stored directly on the ground and MEP mounting brackets are bent

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:** N/A

Remarks:

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues:

- OBG Counter Weight CW80 MEP mounting brackets (second and last) are bent.
- Nine (9) Counter Weights CW40, CW50, CW80, CW60, CW98, CW78, CW72, CW68 and CW104 were improperly stored. These Counter Weights are stored directly on the ground and are stacked unevenly on each other without the proper storage supports.
- These Counter Weights are located in the outside yard north of Bay 17.

For further information, please see the attached pictures.
Please see attached NCR ZPMC-618 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0618

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Dated: 31-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-000642 **Rev:** 00

Ref: 05.03.06-000609

Subject: NCR No. ZPMC-0618

Contractor's Proposed Resolution:

Reference Resolution: CW40 has been inspected and accepted prior to and after final painting. The remaining pieces will undergo the same inspection and verification by the Department prior to shipping.

ZPMC has conducted refresher training with the department which deals with transportation and storage of materials and has issued an internal NCR to ensure other relevant departments are aware of this incident to prevent future occurrences. These parts will be visually inspected again prior to painting to ensure that they are acceptable. CW40 has been inspected and accepted prior to and after final painting. The remaining pieces will undergo the same inspection and verification by the Department prior to shipping. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000642R00

Caltrans' comments:

Status: AAP

Date: 06-Apr-2010

The damage found on Counterweight CW80 will require documentation for closure. Counterweight CW40 is acceptable based on the green tag. The remaining referenced Counterweights will also require green tag documentation for the closure of this NCR.

Submitted by: Eagen, Sean

Date: 06-Apr-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000609

Subject: NCR No. ZPMC-0618

Dated: 21-Apr-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000642 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC had removed the bent angle from CW80 and will repair and MT the final weld. The other counterweights referenced in the NCR are now stored properly.

ZPMC had removed the bent angle from CW80 and will repair and MT the final weld. The other counterweights referenced in the NCR are now stored properly. Based on this ZPMC is requesting closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000642R01;

Caltrans' comments:

Status: AAP

Date: 25-Apr-2010

This proposed resolution is acceptable pending reattachment of the removed angle and applicable NDT results.

Submitted by: Eagen, Sean

Attachment(s):

Date: 25-Apr-2010



No. B-733

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-4-21

REGARDING: NCR-000648(ZPMC-0618)

ZPMC acknowledges this problem and has written an internal NCR regarding this issue. These CWs has been re-stored with proper storage supports now. And ZPMC will replace the bent angle on CW80. Attached photos show the storage for CWs and the removal of the bent angle. ZPMC will perform MT before re-install the new angle at the grinding area on CW80 and after the angle is replaced, CT will be notified to perform NDT. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000648(ZPMC-0618)

PHOTOS

A handwritten signature in black ink, appearing to be "L. J. ...", is written over the word "PHOTOS".

4/28/10



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
666 Feng Bin Road Room 708, Changxing Island
Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 24-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: 05.03.06-000609

Subject: NCR No. ZPMC-0618

Reference Description: Counter Weights outside of the North end of Bay 17 are stored directly on the ground and MEP mounting brackets are bent
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: N/A

Remarks:

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues:

- OBG Counter Weight CW80 MEP mounting brackets (second and last) are bent.
- Nine (9) Counter Weights CW40, CW50, CW80, CW60, CW98, CW78, CW72, CW68 and CW104 were improperly stored. These Counter Weights are stored directly on the ground and are stacked unevenly on each other without the proper storage supports.
- These Counter Weights are located in the outside yard north of Bay 17.

For further information, please see the attached pictures.

Please see attached NCR ZPMC-618 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0618

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

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-000648

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Jan-2010

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

NCR #: ZPMC-0618

Type of problem:

Welding **Concrete** **Other**
Welding **Curing** **Procedural** **Bridge No:** 34-0006
Joint fit-up **Coating** **Other** **Component:** OBG Counter Weights
Procedural **Procedural** **Description:** Improper Storage

Reference Description: Counter Weights outside of the North end of Bay 17 are stored directly on the ground and MEP mounting brackets are bent

Description of Non-Conformance:

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

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Standard Specifications July, 1999 Section 55-1.04 Shipping, Handling and Storing Materials; "In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected. Material to be stored shall be placed above the ground upon platforms, skids or other supports."

Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 15:45 hours, 01/22/10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1800 hours, 01/23/10, Email

QC Inspector's Name: Zhang Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

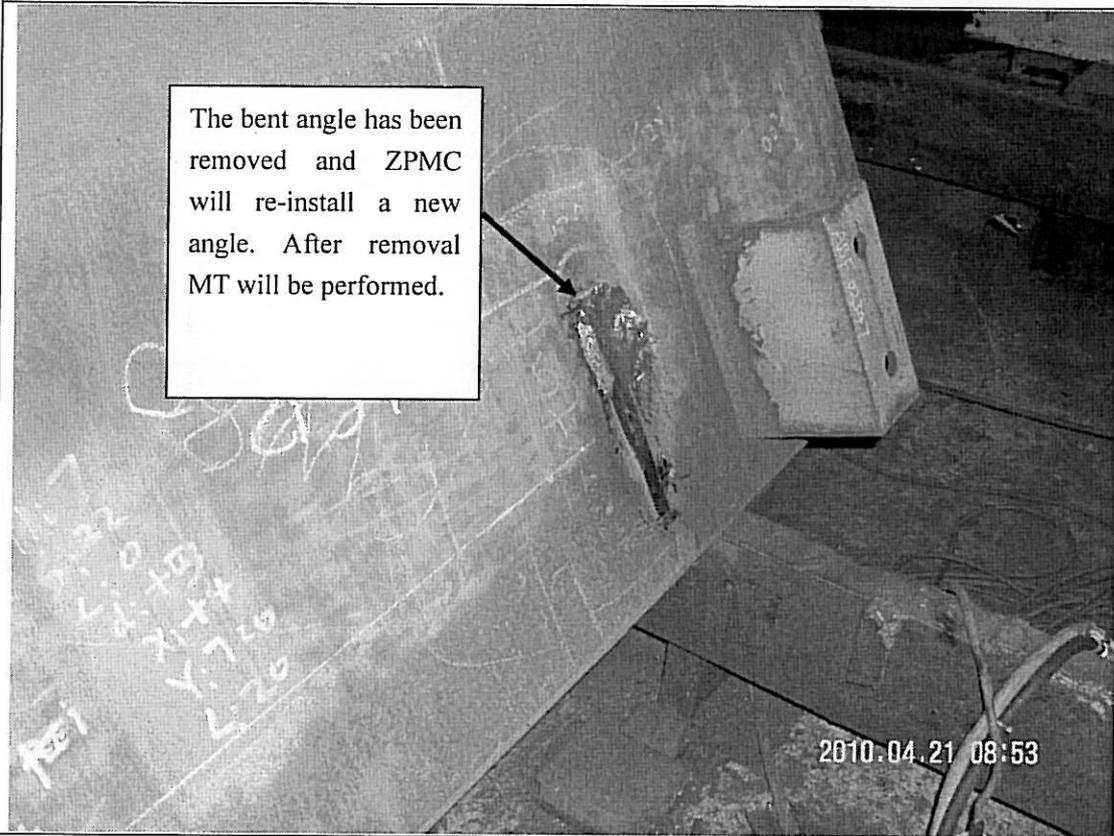
Comments:

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Inspected By: Simonis,Jim	QA Inspector
Reviewed By: Wahbeh,Mazen	SMR



CWs have been re-stored and are acceptable now



NCR PROPOSED RESOLUTION

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

Dated: 10-May-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-000642 Rev: 02

Ref: 05.03.06-000609

Subject: NCR No. ZPMC-0618

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is submitting the requested NDT report and is requesting closure of this NCR based on it.
ZPMC is submitting the requested NDT report and is requesting closure of this NCR based on it.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000642R02;

Caltrans' comments:

Status: CLO

Date: 11-May-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0618 is closed.

Submitted by: Eagen, Sean

Date: 11-May-2010

Attachment(s):



No. B-748

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-5-10

REGARDING: NCR-000648(ZPMC-0618)

As engineer's request in NPR response, ZPMC is providing the NDT record show the acceptance of replacement of the bent angle on CW80 and is requesting closure of this NCR.

ATTACHMENT:

NCR-000648(ZPMC-0618)

B787-MT-22891

By [Signature]

5/10/10



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

666 Feng Bin Road Room 708, Changxing Island

Shanghai 201913 PR China

Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 24-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: 05.03.06-000609

Subject: NCR No. ZPMC-0618

Reference Description: Counter Weights outside of the North end of Bay 17 are stored directly on the ground and MEP mounting brackets are bent

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- Non-Conformance Resolved.

Material Location: OBG

Lift: N/A

Remarks:

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For further information, please see the attached pictures.

Please see attached NCR ZPMC-618 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified recurring non-conformance which constitutes a systematic problem on both materials/workmanship and quality control issues with revised procedures to remedy the defected work and to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0618

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

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-000648

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Jan-2010

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

NCR #: ZPMC-0618

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

Joint fit-up Coating Other Component: OBG Counter Weights

Procedural Description: Improper Storage

Reference Description: Counter Weights outside of the North end of Bay 17 are stored directly on the ground and MEP mounting brackets are bent

Description of Non-Conformance:

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues:

- OBG Counter Weight CW80 MEP mounting brackets (second and last) are bent.
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Standard Specifications July, 1999 Section 6-1.03 Storage of Material; "Articles or materials to be incorporated in the work shall be stored in such a manner as to ensure the preservation of their quality and fitness for the work and to facilitate inspection".

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Who discovered the problem: Subhasis Bera

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 15:45 hours, 01/22/10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1800 hours, 01/23/10, Email

QC Inspector's Name: Zhang 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,(818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Simonis,Jim

QA Inspector

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-000629**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0618**Type of problem:**

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

Date the Non-Conformance Report was written: 23-Jan-2010**Description of Non-Conformance:**

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues:

- OBG Counter Weight CW80 MEP mounting brackets (second and last) are bent.
- Nine (9) Counter Weights CW40, CW50, CW80, CW60, CW98, CW78, CW72, CW68 and CW104 were improperly stored. These Counter Weights are stored directly on the ground and are stacked unevenly on each other without the proper storage supports.
- These Counter Weights are located in the outside yard north of Bay 17.

For further information, please see the attached pictures.

Contractor's proposal to correct the problem:

Remove and replace damaged members.

Corrective action taken:

Damaged members were removed and replaced. Contractor supplied post repair NDT documentation verifying weld is in conformance with Contract weld quality requirements.

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

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer