

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-000673**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0641**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Lift 6 West Floorbeam**Procedural****Procedural****Description:** Floorbeam Web Panel- Out of required Flatness**Reference Description:** Lift 6 West Floorbeam Web Plates exceeded the "flatness of panels" requirement**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of OBG Lift 6 West in the OBG Trial Assembly area, this QA inspector discovered the Floorbeam Web Plates exceeded the "flatness of panels" requirements at the following Segments and Panel Points:

OBG Segment 6AW:

PP 38 Counterweight side; The FL1 floor beam FB11B; Deflection 6.5mm over 1000mm

PP 40 Crossbeam side; The FL3 floor beam FB33A; Deflection 14mm over 1000mm

OBG Segment 6BW:

PP 42 Crossbeam side; The FL1 floor beam FB15A; Deflection 6.5mm over 1000mm

PP 42 Counterweight side; The FL1 floor beam FB9B; Deflection 8mm over 1000mm

PP 43 Crossbeam side; The FL1 floor beam FB15A; Deflection 7mm over 1000mm

PP 43 Counterweight side; The FL1 floor beam FB9A; Deflection 7mm over 1000mm

OBG Segment 6CW:

PP 44 Crossbeam side; The FL3 floor beam FB35A; Deflection 13mm over 1000mm

PP 45 Crossbeam side; The FL3 floor beam FB31A; Deflection 10mm over 1000mm

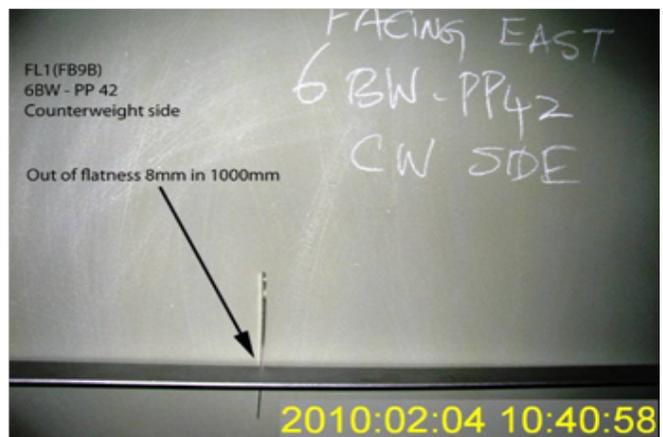
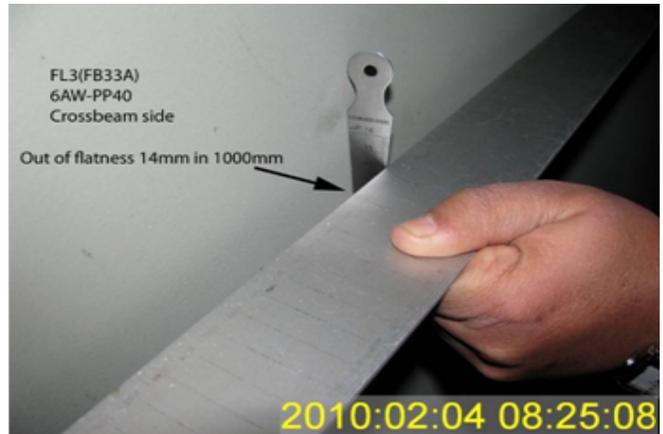
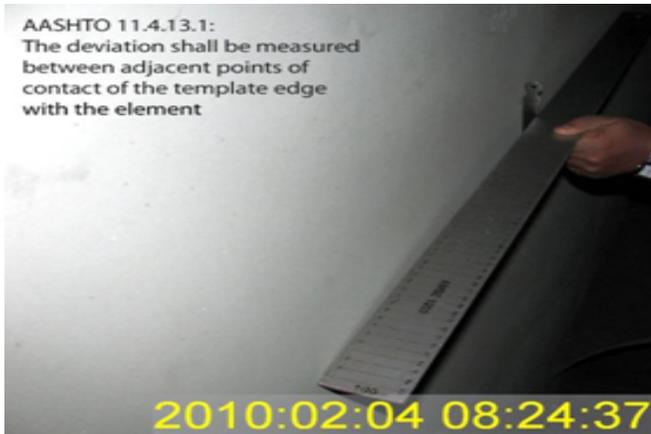
PP 46 Crossbeam side; The FL3 floor beam FB27A; Deflection 7mm over 1000mm

-All the measurements were taken from below the upper Flange plate.

-The maximum out of flatness tolerance allowed per AASHTO 11.4.13.2 requirement is 5mm.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Applicable reference:

AASHTO 11.4.13.2 Flatness of Panels: "The maximum deviation from detailed flatness or curvature of a panel shall not exceed the greater of 5mm or $D/(144*\sqrt{T})$."

AASHTO 11.4.13.1 General: "The template edge may have any length not exceeding the greatest dimension of the element being examined and, for any panel, not exceeding 1.5 times the least dimension of the panel; it may be placed anywhere within the boundaries of the element."

Who discovered the problem: M.Manikandan

Name of individual from Contractor notified: Ding Xing Chi

Time and method of notification: 1600 hours, 02-04-10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1200 hours, 02-05-10, Email

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

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Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
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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-000770**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 19-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0641**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: 04-Feb-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of OBG Lift 6 West in the OBG Trial Assembly area, this QA inspector discovered the Floorbeam Web Plates exceeded the "flatness of panels" requirements at the following Segments and Panel Points:

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PP 45 Crossbeam side; The FL3 floor beam FB31A; Deflection 10mm over 1000mm

PP 46 Crossbeam side; The FL3 floor beam FB27A; Deflection 7mm over 1000mm

-All the measurements were taken from below the upper Flange plate.

-The maximum out of flatness tolerance allowed per AASHTO 11.4.13.2 requirement is 5mm.

Contractor's proposal to correct the problem:

Perform necessary retrofit.

Corrective action taken:

