

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-000675**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0643**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 12 West Floorbeam
Procedural	Procedural	Description: Improper Storage and Handling	

Reference Description: Improper Storage and Handling of Lift 12 West Floorbeam 3069-004**Description of Non-Conformance:**

During Quality Assurance visual review of welds located on Lift 12W Floor Beams, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Floor Beam had been damage and bent due to improper handling and/or storage.
- This Floor Beam component is identified as FB3069-004.
- The Green Tag number is identified as 11278.
- The material is designated as A709 Grade 345 Non-Seismic Performance Critical Member (Non-SPCM).
- This Floor Beam is located in the outside yard west side of Bay 13.

**Applicable reference:**

Standard Specifications July 1999, Section 6-1.3; "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; "In handling and shipping of the steel work, every care

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.”

Standard Specifications July 1999, Section 55-3.09; “Finish members shall be true to line and free from twists, bends and open joints.”

Who discovered the problem: Vibin Kumar S

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1620 hours, 02-04-10, E-mail

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

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

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, +(86) 134.7247.7571, who represents the 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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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-Feb-2010
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-0643	Document No:	05.03.06-000633
Reference Description:	Improper Storage and Handling of Lift 12 West Floorbeam 3069-004		

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:** 12

Remarks:

- During Quality Assurance visual review of welds located on Lift 12W Floor Beams, this Quality Assurance Inspector (QA) discovered the following issues:
- One (1) Floor Beam had been damage and bent due to improper handling and/or storage.
 - This Floor Beam component is identified as FB3069-004.
 - The Green Tag number is identified as 11278.
 - The material is designated as A709 Grade 345 Non-Seismic Performance Critical Member (Non-SPCM).
 - This Floor Beam is located in the outside yard west side of Bay 13.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0643

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: 05.03.06-000633

Subject: NCR No. ZPMC-0643

Dated: 01-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000675 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the bent angle and is providing the heat straightening record and NDT to show that the repair was successful. Based on this ZPMC requests closure of this NCR.

ZPMC has repaired the bent angle and is providing the heat straightening record and NDT to show that the repair was successful. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000675R00;

Caltrans' comments:

Status: REJ

Date: 03-Jun-2010

The provided HSR does not adequately address the repairs required to resolve the NCR. The HSR indicates that the damage was a result of "bounce distortion" yet the corrective action says to control welding parameters. Additionally, the amount of distortion noted in the NCR could not have been corrected by heat alone. Please provide a description of the methods actually used to repair the bent flange.

Submitted by: Eagen, Sean

Attachment(s):

Date: 03-Jun-2010



No. B-773

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-5-26

REGARDING: NCR-000675(ZPMC-0643)

ZPMC acknowledged this problem and has issued an internal NCR. The bent transition has been rectified by utilizing heat straightening. ZPMC is providing the HSR1(B) report and NDT record what shows the acceptable of the base metal. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000675(ZPMC-0643)

HSR1(B)-8152

B787-MT-23483

[Handwritten signature]
5/26/10



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-Feb-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: 05.03.06-000633

Subject: NCR No. ZPMC-0643

Reference Description: Improper Storage and Handling of Lift 12 West Floorbeam 3069-004

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: 12

Remarks:

During Quality Assurance visual review of welds located on Lift 12W Floor Beams, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Floor Beam had been damage and bent due to improper handling and/or storage.
- This Floor Beam component is identified as FB3069-004.
- The Green Tag number is identified as 11278.
- The material is designated as A709 Grade 345 Non-Seismic Performance Critical Member (Non-SPCM).
- This Floor Beam is located in the outside yard west side of Bay 13.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0643

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
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 Quality Assurance and Source Inspection



Bay Area Branch
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 Vallejo, CA 94592-1133
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 (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-000675

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 04-Feb-2010

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

NCR #: ZPMC-0643

Type of problem:

Welding Concrete Other

Welding Curing Procedural **Bridge No:** 34-0006

Joint fit-up Coating Other **Component:** Lift 12 West Floorbeam

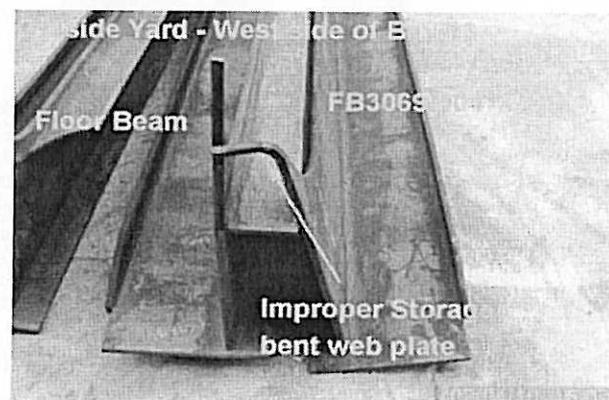
Procedural Procedural **Description:** Improper Storage and Handling

Reference Description: Improper Storage and Handling of Lift 12 West Floorbeam 3069-004

Description of Non-Conformance:

During Quality Assurance visual review of welds located on Lift 12W Floor Beams, this Quality Assurance Inspector (QA) discovered the following issues:

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- This Floor Beam is located in the outside yard west side of Bay 13.



Applicable reference:

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Standard Specifications July 1999, Section 55-1.04; "In handling and shipping of the steel work, every care

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.”

Standard Specifications July 1999, Section 55-3.09; “Finish members shall be true to line and free from twists, bends and open joints.”

Who discovered the problem: Vibin Kumar S

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1620 hours, 02-04-10, E-mail

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

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

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



火工校正记录

Heat Straightening Record(HSR1)

报告号 Report#

HSR1(B)-8152

版本号 Revision #

0

日期 Date

2010.02.15

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:	质检代表/Quality Control Representative
部装 Sub-Assembly:	Xujun
梁段 Gird: 12LIFT	质检经理/Quality Assurance Manager-Approval
塔段 Tower: N/A	Lu Jianhua
焊缝号 Weld No: N/A	
焊缝地图号 Weld Map No: N/A	

情况描述 Description of Condition

Cause 原因 Bounce distortion 撞击变形

Type of Defect 缺陷类型 Bounce distortion 撞击变形

Inspection Method 检查方法 Visual 目检

处置方法 Disposition

缺陷去除方法(Defect Removal Method): Flame Straightening by oxygen acetylene 运用氧乙炔进行校火

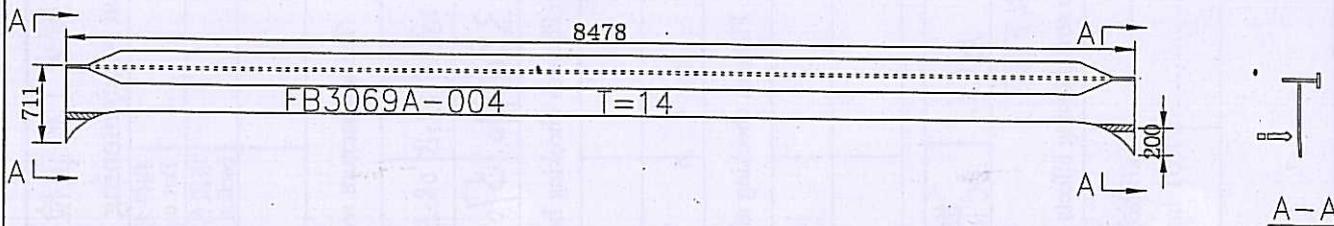
后续NDE(Post-Removal NDE): After finishing heat straightening, the weld of the heat area shall perform NDT according to the approved shop drawing 校火后, 根据图纸要求对热影响区域进行NDT检测。

纠正措施(Corrective Action(s)): Control current, voltage and weld speed according to relevant WPS. If necessary anti-deformation or hold down device can be added. 依据相应的WPS的要求控制电流, 电压和焊接速度。如有必要, 可使用反变形设施进行校正。

实施次数(Number of application): 1~3

最高温度(Maximum temperature): <650°C

简图 Sketch



To be signed when Closing HSR~Verify compliance and all necessary reports are ready to attach

检验员 Inspector:	Li Zhijiang	签字 Signature:	李志江
CWI #	07051311	Closing Date:	2010.3.15
II级探伤 NDE Certification:	Level II		
质检经理 QC Manager		审核日期 Review Date:	

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787-QCP-1101

Approved by Lu Jianhua 2/15/10

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000633

Subject: NCR No. ZPMC-0643

Dated: 22-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000675 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC applied an outside force when performing heat straightening and has revised the HSR to reflect this.

ZPMC applied an outside force when performing heat straightening and has revised the HSR to reflect this. Also ZPMC QA has discussed this issue with the team which moves completed pieces around warned them on the importance of proper handling procedures. Based on this and previously submitted acceptable NDT, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000675R01;

Caltrans' comments:

Status: REJ

Date: 24-Jun-2010

If heat straightening was performed, an HSR, not an HSR1, would be required to be submitted as the amount of distortion to be corrected requires Engineer's approval. Additionally, the application of force as shown in the provided HSR1, is not acceptable.

Submitted by: Eagen, Sean

Attachment(s):

Date: 24-Jun-2010



No. B-797

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-6-21

REGARDING: NCR-000675(ZPMC-0643)

The transition of the floor beam flange was bent during the transportation. ZPMC has written an internal NCR to warn the production on this issue and pay more attention when transport any component. Considering this "bounce distortion" is occurred on the minor part of flange, mechanical method was used in conjunction with the application of heat straightening. After then the bent part has been rectified and has been installed into segment. Please review the previous submitted NDT record what shows the acceptance of the base metal and consider closing this NCR.

ATTACHMENT:

NCR-000675(ZPMC-0643)

HSR1(B)-8152 R1

A handwritten signature in black ink, appearing to be "J. W.", written in a cursive style.

6/21/10



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-Feb-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: 05.03.06-000633

Subject: NCR No. ZPMC-0643

Reference Description: Improper Storage and Handling of Lift 12 West Floorbeam 3069-004

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:** 12

Remarks:

During Quality Assurance visual review of welds located on Lift 12W Floor Beams, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Floor Beam had been damage and bent due to improper handling and/or storage.
- This Floor Beam component is identified as FB3069-004.
- The Green Tag number is identified as 11278.
- The material is designated as A709 Grade 345 Non-Seismic Performance Critical Member (Non-SPCM).
- This Floor Beam is located in the outside yard west side of Bay 13.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0643

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

City: 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-000675**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0643**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Lift 12 West FloorbeamProcedural Procedural Description: Improper Storage and Handling**Reference Description:** Improper Storage and Handling of Lift 12 West Floorbeam 3069-004**Description of Non-Conformance:**

During Quality Assurance visual review of welds located on Lift 12W Floor Beams, this Quality Assurance Inspector (QA) discovered the following issues:

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**Applicable reference:**

Standard Specifications July 1999, Section 6-1.3; "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; "In handling and shipping of the steel work, every care

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.”

Standard Specifications July 1999, Section 55-3.09; “Finish members shall be true to line and free from twists, bends and open joints.”

Who discovered the problem: Vibin Kumar S

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1620 hours, 02-04-10, E-mail

Name of Caltrans Engineer notified: Bill Howe, Ching Chao

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

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR



火工校正记录

Heat Straightening Record(HSR1)

报告号 Report#

HSR1(B)-8152

版本号 Revision #

1

日期 Date

2010.02.15

美国海湾大桥 San Francisco Oakland Bay Bridge

CALTRANS #04-0120F4

工程编号 JOB#: ZP06-787

装配 Assembly:

质检代表/Quality Control Representative

部装 Sub-Assembly:

梁段 Gird: 12LIFT

质检经理/Quality Assurance Manager Approval

塔段 Tower:

N/A

焊缝号 Weld No:

N/A

焊缝地图号 Weld Map No:

N/A

情况描述 Description of Condition

Cause 原因

Bounce distortion 撞击变形

Type of Defect 缺陷类型

Bounce distortion 撞击变形

Inspection Method 检查方法

Visual 目检

处置方法 Disposition

缺陷去除方法(Defect Removal Method): Oxy-acetylene hand torch 氧乙炔火焰校正

后续NDE(Post-Removal NDE):

Provide VT to the heat straightened area and its close area. Perform MT if necessary. 对火工校正区域及其临近区域进行VT检测。如有必要,进行MT检测。

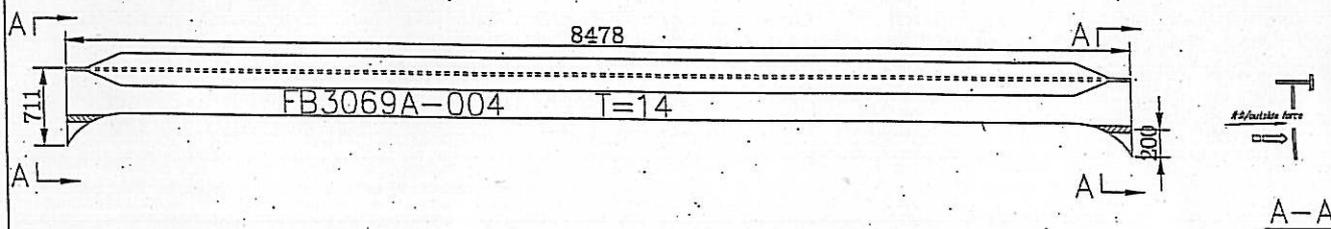
纠正措施(Corrective Action(s)):

Fasten subcomponent to transportation trailer securely prior to transport. 转运之前将构件安全地紧固在转运拖车上。

实施次数(Number of application): 1~3

最高温度(Maximum temperature): <650°C

简图 Sketch



To be signed when Closing HSR. Verify compliance and attach all necessary reports.

检验员 Inspector:

Li Zhijiang

签字 Signature:

李志江

CWI Number:

07056211

Closing Date:

2010.3.15

II 级探伤 NDE Certification:

Level II

质检经理 QC Manager

Li Zhijiang

审核日期 Review Date:

3/15/10

Note: All repair work shall be performed in accordance with applicable CALTRANS approved procedures, contract specifications and AWS D1.5 2002.

#R787-QCP-1100

Approved by Li Zhijiang 2/15/10

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000633

Subject: NCR No. ZPMC-0643

Dated: 27-Aug-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000675 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: In the future, cases of this type damage will be examined on a case by case basis for the most appropriate repair method.

ZPMC has written an internal NCR to address this issue and ZPMC QA has discussed this issue with the material handling department to minimize damage of completed components. In the future, cases of this type damage will be examined on a case by case basis for the most appropriate repair method. Based on this ZPMC request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000675R02

Caltrans' comments:

Status: REJ

Date: 01-Sep-2010

The proposed resolution is unacceptable. Taking action on a "case by case basis" in the future does not really address the quality management issue. It is unacceptable to utilize outside force as required to perform the type of heat straightening done in this case. The piece that was bent should have been removed, or the contractor should have pointed out that the majority of the base material is removed during welding and backgouging removes most of the base material.

Submitted by: Woo, Laraine

Date: 01-Sep-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000633

Subject: NCR No. ZPMC-0643

Dated: 07-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000675 Rev: 03

Contractor's Proposed Resolution:

Reference Resolution: Steps taken to address the non conformance included issuing a ZPMC internal NCR, and a meeting between the ZPMC QA department representative and the material handling department

In response to the Department, steps taken to address the non conformance included issuing a ZPMC internal NCR, and a meeting between the ZPMC QA department representative and the material handling department to reinforce the importance of proper handling of completed components. In such cases where a part is damaged, an assessment of the most appropriate repair method will be conducted. If heat straightening is not acceptable using outside force a welding repair will be proposed to repair the damaged area with NDT after to ensure the soundness of the repair. ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000675R03

Caltrans' comments:

Status: CLO
Date: 14-Sep-2010

The proposed resolution is acceptable. This NCR is considered closed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 14-Sep-2010

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-000803**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0643**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 Quality Assurance visual review of welds located on Lift 12W Floor Beams, this Quality Assurance Inspector (QA) discovered the following issues:

- One (1) Floor Beam had been damaged and bent due to improper handling and/or storage.
- This Floor Beam component is identified as FB3069-004.
- The Green Tag number is identified as 11278.
- The material is designated as A709 Grade 345 Non-Seismic Performance Critical Member (Non-SPCM).
- This Floor Beam is located in the outside yard west side of Bay 13.

Contractor's proposal to correct the problem:

Perform heat straightening per the approved HSR procedures and issue internal NCR.

Corrective action taken:

The member was heat straightened with NDT verification. Steps were taken to address the non-conformance included issuing a ZPMC internal NCR, and a meeting between the ZPMC QA department representative and the material handling department.

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 Devey, (86) 150-0002-6784, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer