

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-000682

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 18-Feb-2010

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

NCR #: ZPMC-0649

Type of problem:

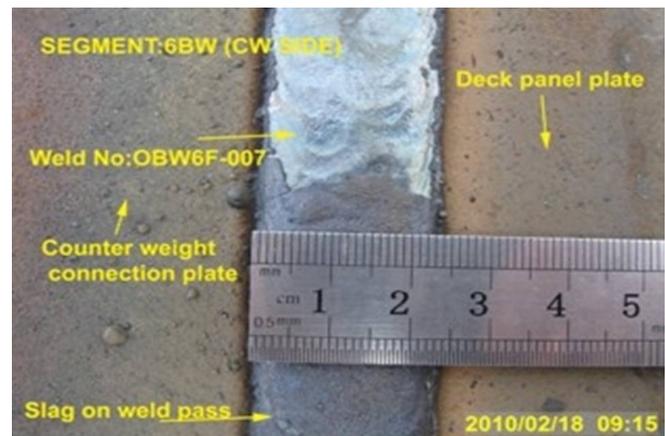
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 6BW Counter Weight Connection Plate
Procedural	Procedural	Description:	

Reference Description: Excessive width on FCAW single weld pass on Segment 6BW Counterweight connection plate

Description of Non-Conformance:

During random in process visual inspection, this Caltrans Quality Assurance Inspector (QA) observed the following issue:

- The width of a single weld pass was measured to be 24 mm.
- This welding was performed in the flat (1G) position.
- The welding process performed was Flux Cored Arc Welding (FCAW).
- The maximum FCAW single weld pass width allowed in this position is 16mm.
- This weld joins the Deck Panel plate to the Counter Weight (CW) connection plate.
- The welding is located on the Deck Plate at segment 6BW CW side.
- This weld is detailed as a complete joint penetration (CJP) weld on approved drawing OBW6F.
- The weld is identified as OBW6F-007.
- Segment 6BW is located outside in the Trial Assembly area.



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 1002 Section 4.14.1.5 FCAW: "When the width of a layer of a groove weld in the flat, horizontal, or overhead position is 16 mm [5/8 in.] or greater, a multiple-pass split-layer technique shall be used."

Who discovered the problem: Surrendra Prabhu

Name of individual from Contractor notified: Wang Hang

Time and method of notification: 0915 hours, 02-18-10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1515 hours, 02-18-10, Verbal

QC Inspector's Name: Yang Qiong and Li Yang

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: 18-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: 05.03.06-000639

Subject: NCR No. ZPMC-0649

Reference Description: Excessive width on FCAW single weld pass on Segment 6BW Counterweight connection plate

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:** 06

Remarks:

During random in process visual inspection, this Caltrans Quality Assurance Inspector (QA) observed the following issue:

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- The weld is identified as OBW6F-007.
- Segment 6BW is located outside in the Trial Assembly area.

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-0649

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: 05.03.06-000639

Subject: NCR No. ZPMC-0649

Dated: 29-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000637 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT of the weld to show that despite the non conformance that the weld is free of defect. Based on this ZPMC requests closure of this NCR.

ZPMC QA has instructed the CWI to pay closer attention to avoid incidents of excessive weld width. ZPMC is providing NDT of the weld to show that despite the non conformance that the weld is free of defect. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000637R00;

Caltrans' comments:

Status: CLO

Date: 05-Apr-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0649 is closed.

Submitted by: Eagen, Sean

Date: 05-Apr-2010

Attachment(s):



No. B-709

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-29

REGARDING: NCR-000682 (ZPMC-0649)

ZPMC acknowledged this problem and the ZPMC QA has instructed the QC/CWI to enhance the welding control and pay more attention on the weld size during welding. ZPMC is providing the NDT record shows the soundness of this weld. Please be noticed the punchlist item has been removed after the verification by CT's representative. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000682 (ZPMC-0649)

B787-UT-11515

A handwritten signature in black ink, appearing to be 'Jm' followed by a flourish.

3/29/10



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 Date: 18-Feb-2010
 375 BURMA ROAD Contract No: 04-0120F4
 OAKLAND CA 95607 04-SF-80-13.2 / 13.9
 Dear: Mr. Charles Kanapicki Job Name: SAS Superstructure
 Attention: Mr. Thomas Nilsson Project/Fabrication Manager Document No: 05.03.06-000639
 Subject: NCR No. ZPMC-0649

Reference Description: Excessive width on FCAW single weld pass on Segment 6BW Counterweight connection plate

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Material Location: OBG Lift: 06

Remarks:

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Transmitted by: Bill Howe Sr. Transportation Engineer
 Attachments: ZPMC-0649

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao
 File: 05.03.06

02.02:15.04
 05.03.06-000639,NCT

Received
 NCT-000639 19 Feb 10 Page 1 of 1

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File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000682

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 18-Feb-2010

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

NCR #: ZPMC-0649

Type of problem:

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

Bridge No: 34-0006

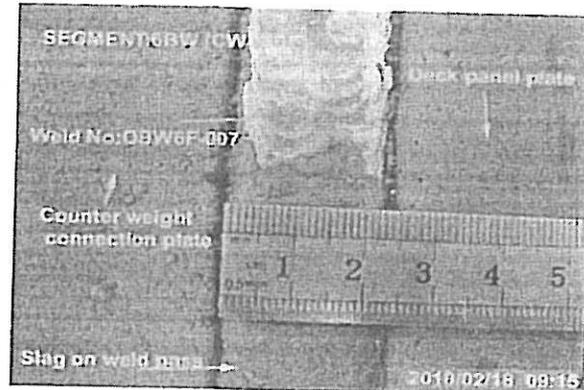
Component: Segment 6BW Counter Weight Connection Plate

Reference Description: Excessive width on FCAW single weld pass on Segment 6BW Counterweight connection plate

Description of Non-Conformance:

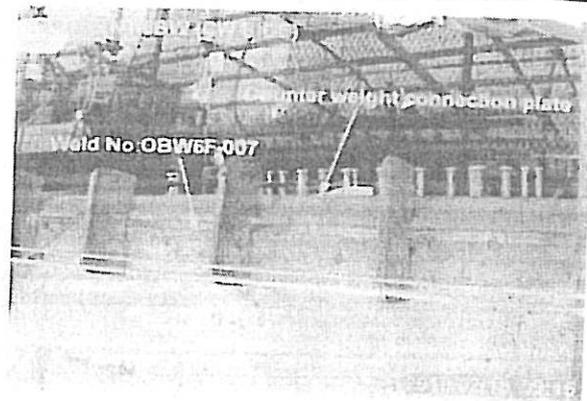
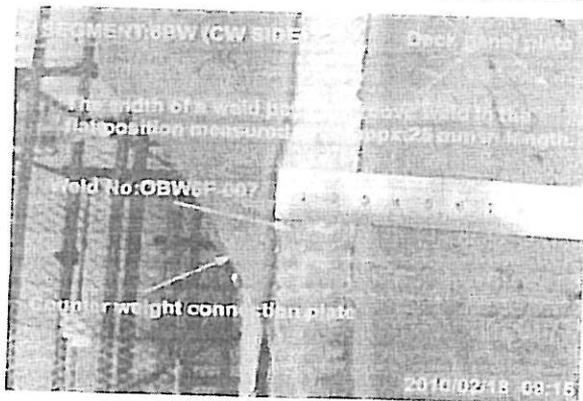
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Who discovered the problem: Surrendra Prabhu

Name of individual from Contractor notified: Wang Hang

Time and method of notification: 0915 hours, 02-18-10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1515 hours, 02-18-10, Verbal

QC Inspector's Name: Yang Qiong and Li Yang

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

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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-000592**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0649**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: 18-Feb-2010**Description of Non-Conformance:**

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Contractor's proposal to correct the problem:

Perform NDT required to verify weld quality.

Corrective action taken:

Contractor supplied Ultrasonic Testing report verifying the weld in question conforms 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:**

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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