

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-000715**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0682**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 9DE Floorbeam
Procedural	Procedural	Description:	

Reference Description: Fabrication of Segment 9DE Floorbeam cope holes not according to the approved shop drawings

Description of Non-Conformance:

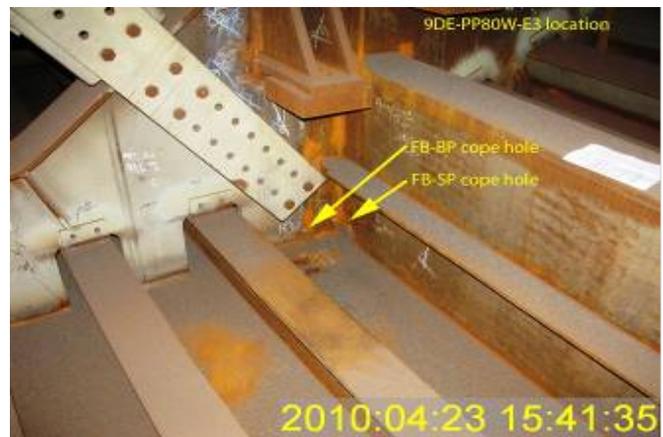
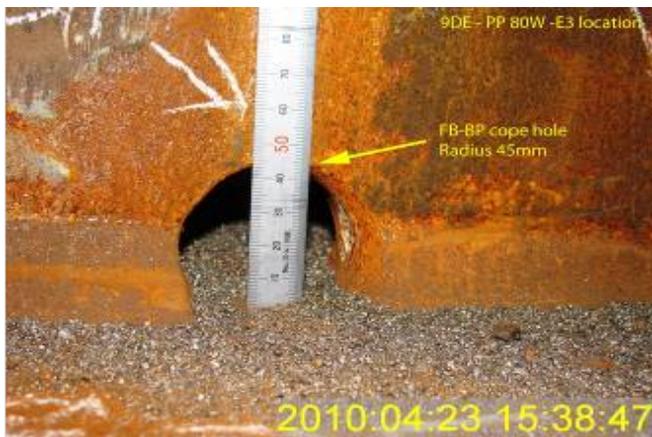
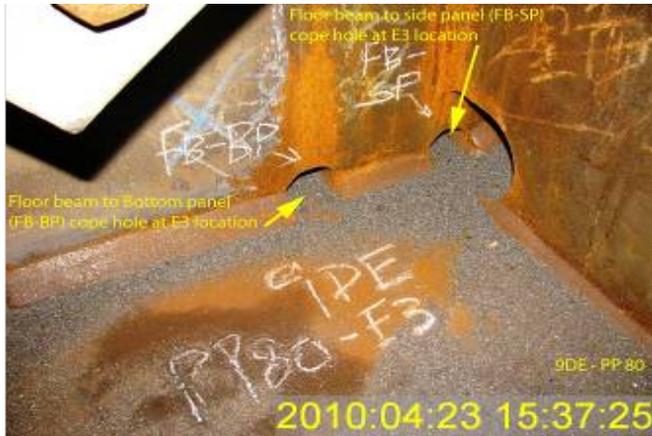
During in-process inspection of Segment 9DE, Caltrans Quality Assurance Inspector found the following issues while measuring the size of the cope holes:

-Some cope holes at the below floorbeam locations are found to be oversized, not fabricated according to approved shop drawings which indicate a radius of 25mm.

- Panel Point (PP) 80, Working Point E3, Floorbeam (FB) to Bottom Panel (BP) cope, 45mm radius
- PP80, Working Point E3, FB to Side Panel (SP) cope, 40mm radius
- PP80, Working Point E4, FB to BP cope, 45mm radius
- PP81, Working Point E3, FB to BP cope, 44mm radius
- PP81, Working Point E3, FB to SP cope, 43mm radius
- PP81, Working Point E4, FB to BP cope, 40mm radius
- PP82, Working Point E3, FB to BP cope, 44mm radius
- PP82, Working Point E3, FB to SP cope, 44mm radius
- PP82, Working Point E4, FB to BP cope, 45mm radius

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Applicable reference:

Approved shop drawings FB5, FB11, and FB12

Who discovered the problem: M.Manikandan

Name of individual from Contractor notified: Lee Man Kit

Time and method of notification: 1400 hours, 4/23/10, Verbal

Name of Caltrans Engineer notified: Stanley Ku, Sean Eagen

Time and method of notification: 1700 hours, 4/23/10, 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: Tsang, Eric

SMR

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: 26-Apr-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: 05.03.06-000672

Subject: NCR No. ZPMC-0682

Reference Description: Fabrication of Segment 9DE Floorbeam cope holes not according to the approved shop drawings

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:** 09

Remarks:

During in-process inspection of Segment 9DE, Caltrans Quality Assurance Inspector found the following issues while measuring the size of the cope holes:

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- PP82, Working Point E3, FB to BP cope, 44mm radius
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- PP82, Working Point E4, FB to BP cope, 45mm radius

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: Sean Eagen Transportation Engineer

Attachments: ZPMC-0682

NCT

(*Continued Page 2 of 2*)

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

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000672

Subject: NCR No. ZPMC-0682

Dated: 06-May-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000651 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has met with ZPMC to discuss ways to prevent over grinding of cope holes so as to prevent future occurrences of these types of nonconformances.

ABF performs dimensional inspections of cope holes. These cope hole inspections are forwarded to CT for review. The cope holes listed on the NCR are slightly oversize, however, ZPMC/ABF prefer to leave these cope holes as is. Further repair by welding to reduce the size of cope holes will undoubtedly cause significant problems with weld quality in these difficult to access areas. The root cause of the oversize holes is over grinding by production personnel not completely understanding the tolerance issues involved. Production personnel were trying to achieve a visually acceptable weld terminations within the cope holes and smooth transitions, which, as shown by the photos, is well within acceptable limits. ABF has met with ZPMC to discuss ways to prevent over grinding of cope holes so as to prevent future occurrences of these types of nonconformances.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000651R00

Caltrans' comments:

Status: CLO

Date: 10-May-2010

This proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0682 is closed.

Submitted by: Eagen, Sean

Date: 10-May-2010

Attachment(s):

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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-000664**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 10-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0682**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: 23-Apr-2010**Description of Non-Conformance:**

During in-process inspection of Segment 9DE, Caltrans Quality Assurance Inspector found the following issues while measuring the size of the cope holes:

-Some cope holes at the below floorbeam locations are found to be oversized, not fabricated according to approved shop drawings which indicate a radius of 25mm.

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- PP82, Working Point E3, FB to SP cope, 44mm radius
- PP82, Working Point E4, FB to BP cope, 45mm radius

Contractor's proposal to correct the problem:

Contractor requested cope holes be accepted as is as they were ground to achieve a smooth transition and workers misunderstood the size requirement.

Corrective action taken:

Cope holes were found to be acceptable as is.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?**

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Yes No

Comments:

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Inspected By:	Simonis,Jim	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer
