

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

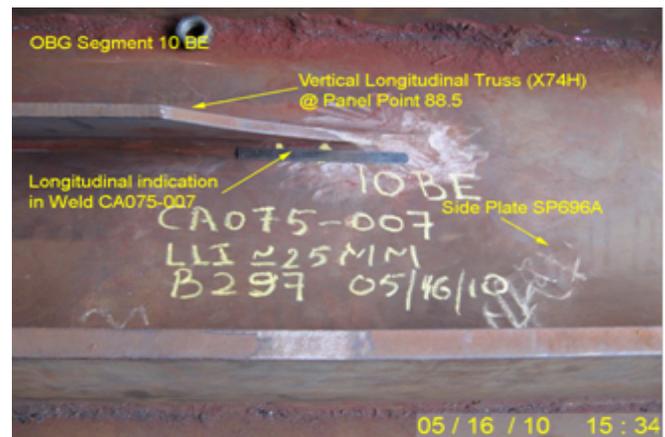
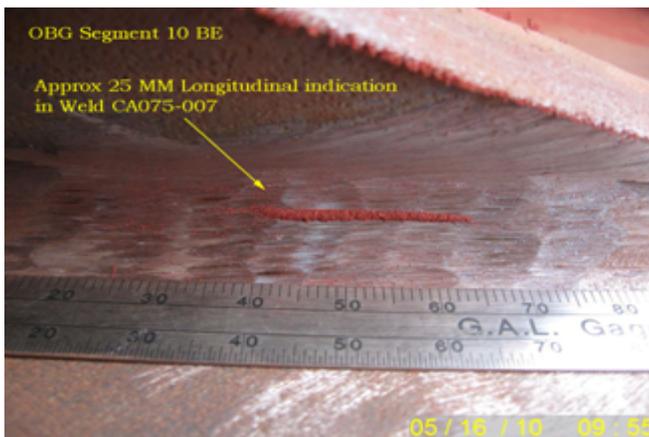
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000734**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0697**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 10BE Corner Assembly
Procedural	Procedural	Description: Missed MT indication by QC	

Reference Description: Missed MT Indication by QC in OBG Segment 10BE Corner Assembly**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Segment 10BE, this QA Inspector discovered the following issue:

- One Longitudinal indication, approximately 25mm in length at Panel Point 88.5.
- The weld identified as CA075-007.
- The weld is a fillet weld joining Vertical Longitudinal Truss identified as X74H to Side Plate SP696A.
- The indication is marked clearly near the weld.
- OBG segment 10BE is located in outside yard, North of Blast Shop.
- The Notice of Witness Inspection (NWIT) Number is 005723. The indication is located inside the area previously tested and accepted by ZPMC personnel.

**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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Who discovered the problem: Anand Upadhye

Name of individual from Contractor notified: Li Man Kit

Time and method of notification: 1730 hours, 05/16/10, Email

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0900 hours, 05/17/10, Verbal

QC Inspector's Name: Wang Wei Ming

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
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Reviewed By:	Wahbeh, Mazen	SMR
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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: 17-May-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: 05.03.06-000692

Subject: NCR No. ZPMC-0697

Reference Description: Missed MT Indication by QC in OBG Segment 10BE Corner Assembly

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:** 10

Remarks:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Segment 10BE, this QA Inspector discovered the following issue:

- One Longitudinal indication, approximately 25mm in length at Panel Point 88.5.
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- OBG segment 10BE is located in outside yard, North of Blast Shop.
- The Notice of Witness Inspection (NWIT) Number is 005723. The indication is located inside the area previously tested and accepted by ZPMC personnel.

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-0697

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

Dated: 11-Jun-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-000692 Rev: 00

Ref: 05.03.06-000692

Subject: NCR No. ZPMC-0697

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indications and is providing the NDT after to show it is acceptable.

ZPMC has repaired the indications and is providing the NDT after to show it is acceptable.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000692R00

Caltrans' comments:

Status: AAP

Date: 14-Jun-2010

NDT results have not been provided with this NPR. This proposed resolution is accepted, action pending. Please provide NDT results for these welds upon completion of the repairs.

Submitted by: Eagen, Sean

Date: 14-Jun-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000692

Subject: NCR No. ZPMC-0697

Dated: 29-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000692 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the missed indication and is providing the NDT after repair to show that the weld is acceptable.

ZPMC has repaired the missed indication and is providing the NDT after repair to show that the weld is acceptable. ZPMC has issued an internal NCR to inform all affected parties that this type of action is unacceptable. In addition, ABFJV has had discussions with the ZPMC QA Manager and he has agreed to increase CWI presence in all areas to prevent lapse in QC oversight in the future. Based on these actions and submitted documents, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000692R01;

Caltrans' comments:

Status: AAP

Date: 07-Jul-2010

The preventative measures taken by the QCM is acceptable. The area has been repaired and NDT documents have been submitted. This NCR is considered closed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 07-Jul-2010



No. B-804

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-6-28

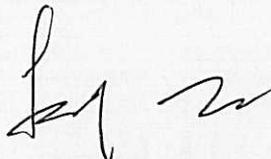
REGARDING: NCR-000734(ZPMC-0697)

ZPMC is providing the missed NDT record in previously submitted files and is requesting closure of this NCR.

ATTACHMENT:

NCR-000734(ZPMC-0697)

B-787-MT-23189R1


6/29/10



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: 17-May-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0697

Job Name: SAS Superstructure
Document No: 05.03.06-000692

Reference Description: Missed MT Indication by QC in OBG Segment 10BE Corner Assembly

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Lift: 10

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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-0697

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Jason Tom, Contract Files, Ching Chao, Bill Casey
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-000734

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 16-May-2010

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

NCR #: ZPMC-0697

Type of problem:

Welding Concrete Other

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

Joint fit-up Coating Other **Component:** OBG Segment 10BE Corner Assembly

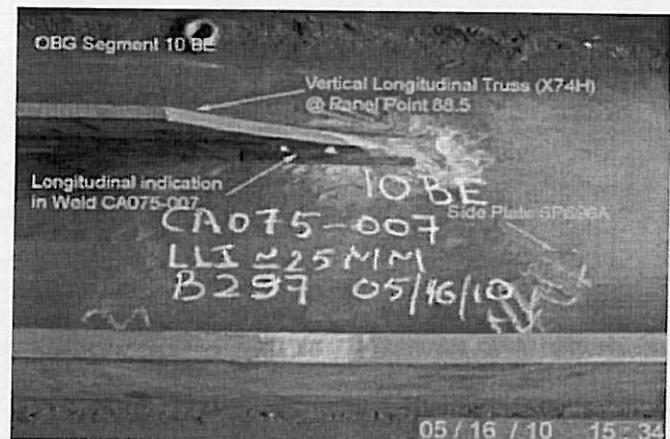
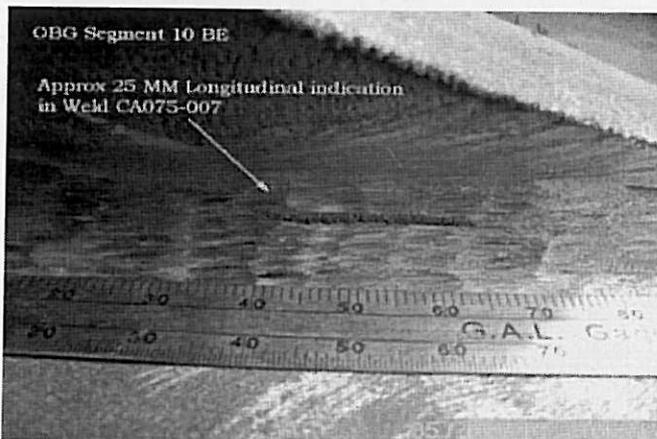
Procedural Procedural **Description:** Missed MT indication by QC

Reference Description: Missed MT Indication by QC in OBG Segment 10BE Corner Assembly

Description of Non-Conformance:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Who discovered the problem: Anand Upadhye

Name of individual from Contractor notified: Li Man Kit

Time and method of notification: 1730 hours, 05/16/10, Email

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0900 hours, 05/17/10, Verbal

QC Inspector's Name: Wang Wei Ming

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

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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-000706**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Jul-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0697**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: 16-May-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Segment 10BE, this QA Inspector discovered the following issue:

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Contractor's proposal to correct the problem:

Repair said indication and perform NDT required to verify weld quality.

Corrective action taken:

Contractor supplied post repair NDT documentation verifying weld conforms with Contract weld quality requirements. An internal NCR was also issued by ZPMC in regards to this issue.

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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Inspected By: Simonis, Jim

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

Reviewed By: Wahbeh,Mazen

QA Reviewer