

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-000741

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-May-2010

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

NCR #: ZPMC-0704

Type of problem:

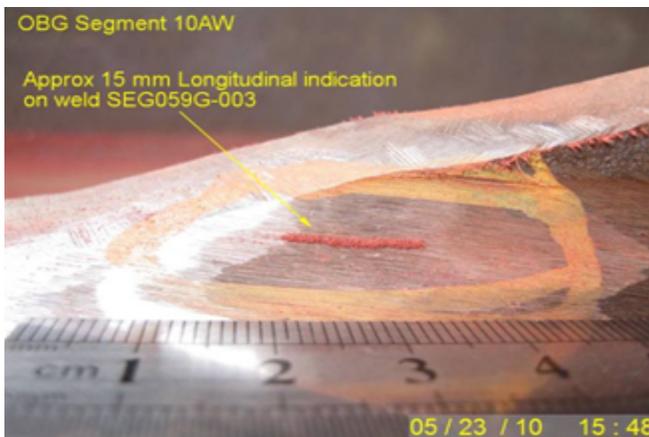
| | | | |
|---------------------|-------------------|--|---|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: Segment 10AW Side Panel |
| Procedural | Procedural | Description: Missed MT indication by QC | |

Reference Description: Missed MT Indication by QC in OBG Segment 10AW Side Panel

Description of Non-Conformance:

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

- One Longitudinal indication approximately 15 mm in length in the CJP weld joining the gusset connection plate identified as X74G to Side Plate 675A at panel point 85.5.
- The weld is identified as SEG059G-003.
- The weld is a designated on the contract drawings as a Seismic Performance Critical Member (SPCM).
- The indication is marked clearly near the weld.
- OBG segment 10AW is located in the segment repair yard north of Fabrication Bay 19.
- The Notice of Witness Inspection (NWIT) Number is 005771. The indication was found inside of the area previously tested and accepted by ZPMC QC personnel. According to the contract documents ZPMC's required percentage of testing is 100% of this weld.



Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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 (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 Hao

Time and method of notification: 1600 hours, 05/23/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1100 hours, 05/24/10, Email

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 |
|---------------------|---------------|-----|



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: 24-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: 05.03.06-000698

Subject: NCR No. ZPMC-0704

Reference Description: Missed MT Indication by QC in OBG Segment 10AW Side Panel

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 10AW, this QA Inspector discovered the following issue:
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 - The Notice of Witness Inspection (NWIT) Number is 005771. The indication was found inside of the area previously tested and accepted by ZPMC QC personnel. According to the contract documents ZPMC's required percentage of testing is 100% of this weld.

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-0704

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-000701 **Rev:** 00

Ref: 05.03.06-000698

Subject: NCR No. ZPMC-0704

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will provide NDT to show these welds are acceptable after the repairs are complete. Based on this proposal ZPMC requests that this NCR be approved, with actions pending.

ZPMC will provide NDT to show these welds are acceptable after the repairs are complete. Based on this proposal ZPMC requests that this NCR be approved, with actions pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000701R00

Caltrans' comments:

Status: AAP

Date: 14-Jun-2010

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: 05.03.06-000698

Subject: NCR No. ZPMC-0704

Dated: 21-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000701 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indications and is providing NDT to show that the weld is acceptable. ZPMC has written and internal NCR.

ZPMC has repaired the indications and is providing NDT to show that the weld is acceptable. ZPMC has written and internal NCR. In addition, ABFJV and ZPMC's QA Manager are having a meeting to discuss the issues of missed indications in the OBG and determine a better way to prevent the missed indications. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000701R01;

Caltrans' comments:

Status: CLO

Date: 23-Jun-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0704 is closed.

Submitted by: Eagen, Sean

Date: 23-Jun-2010

Attachment(s):



No. B-791

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-6-21

REGARDING: NCR-000741(ZPMC-0704)

ZPMC acknowledges one indication was missed and is providing the NDT record shows this indication has been removed, repaired and is now acceptable. Based on this, please consider closure of this NCR.

ATTACHMENT:

NCR-000741(ZPMC-0704)

B787-MT-23807 R1

Log m
6/21/10



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Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
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OAKLAND CA 95607

Date: 24-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: 05.03.06-000698

Subject: NCR No. ZPMC-0704

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Lift: 10

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Action Required and/or Action Taken:

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Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0704

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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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-000741

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-May-2010

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

NCR #: ZPMC-0704

Type of problem:

Welding **Concrete** **Other**

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

Joint fit-up **Coating** **Other** **Component:** Segment 10AW Side Panel

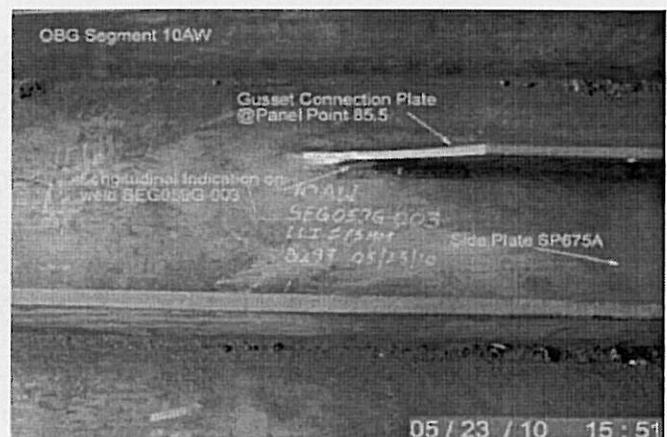
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Who discovered the problem: Anand Upadhye

Name of individual from Contractor notified: Li Hao

Time and method of notification: 1600 hours, 05/23/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1100 hours, 05/24/10, Email

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-000703**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0704**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-May-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on Segment 10AW, 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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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer