

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-000742

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 24-May-2010

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

NCR #: ZPMC-0705

Type of problem:

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

Bridge No: 34-0006

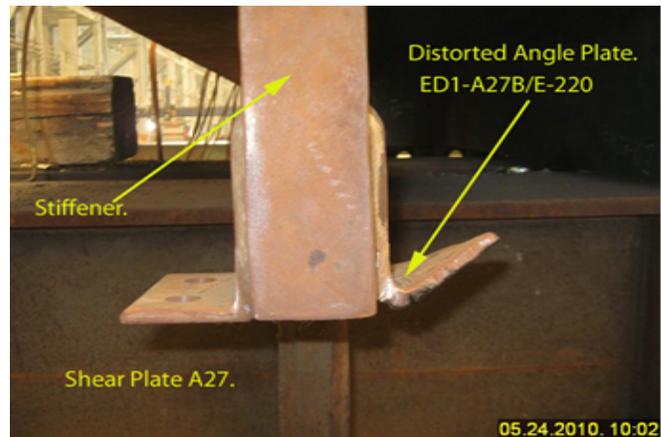
Component: ED1-A27 Angle Plates on Shear Plate

Reference Description: There are two Angle Plates damaged and distorted

Description of Non-Conformance:

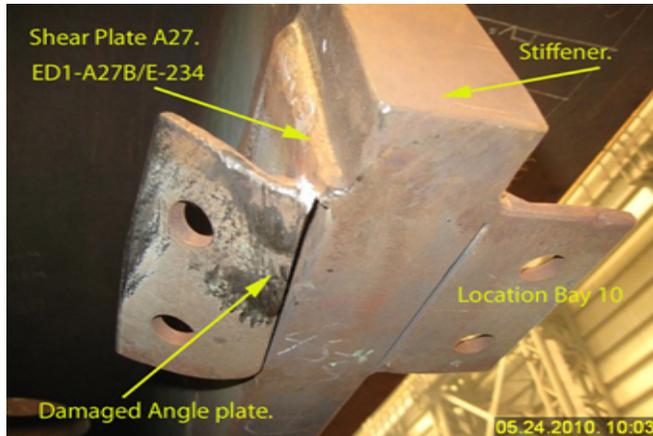
During random visual inspection in Bay 10, Quality Assurance Inspector discovered the following issue:

- Two (2) angle plates in the top elevation of Shear Plate were damaged and distorted.
- The welds are identified as ED1-A27B/E-234, 220; fillet weld.
- Tower Lift 1 Shear Plate ED1-A27.
- The member is located in Bay#10.
- These angle plates were previously VT and MT tested.
- The Notice of Witness Inspection Number (NWIT) is 005737.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Standard Specification-55-1.04

SHIPPING, HANDLING AND STORING MATERIALS

“In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.”

Standard Specification -55-3.09 FINISHED MEMBERS

Finished members shall be true to line and free from twists, bends and open joints.

Who discovered the problem: Shailesh D. Gaikwad

Name of individual from Contractor notified: Mr. Bi De Wei

Time and method of notification: 05/24/10, 1000 Hrs, Verbal

Name of Caltrans Engineer notified: Mr. Ken Lee

Time and method of notification: 5/24/10, 1645 Hrs, Verbal

QC Inspector's Name: Mr. Gao Zhi Chun

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Proposal is Pending from Contractor.

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: Ng,Michael

QA Inspector

Reviewed By: Wahbeh,Mazen

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
 333 Burma Road
 Oakland CA 94607
 Tel: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To:	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	Date:	25-May-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-0705	Document No:	05.03.06-000700

Reference Description: There are two Angle Plates damaged and distorted

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: Tower **Lift:** 01

Remarks:

During random visual inspection in Bay 10, Quality Assurance Inspector discovered the following issue:

- Two (2) angle plates in the top elevation of Shear Plate were damaged and distorted.
- The welds are identified as ED1-A27B/E-234, 220; fillet weld.
- Tower Lift 1 Shear Plate ED1-A27.
- The member is located in Bay#10.
- These angle plates were previously VT and MT tested.
- The Notice of Witness Inspection Number (NWIT) is 005737.

Standard Specification-55-1.04, SHIPPING, HANDLING AND STORING MATERIALS

“In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.”

Standard Specification -55-3.09 FINISHED MEMBERS

Finished members shall be true to line and free from twists, bends and open joints.

Action Required and/or Action Taken:

In accordance with Section 55-1.04 of the Standard Specifications, Shear Plate ED1-A27 is rejected due to damaged/ distorted angle plates as referenced in this transmittal.

Please submit a repair plan for the Engineer's approval prior to any remedial work begins.

After completion of any remedial work, please provide documentations that the repairs are in compliance with the contract requirements.

Documentation provided for the Engineer’s review of the acceptability of the weld repairs shall at a minimum include the procedure utilized and the NDT results.

NCT

(Continued Page 2 of 2)

Transmitted by: Ken Lee Transportation Engineer

Attachments: ZPMC-0705

cc: Rick Morrow, Gary Pursell, Mark Woods

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000700

Subject: NCR No. ZPMC-0705

Dated: 11-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000702 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will repair these and provide the repair report as well as NDT after to show that the damaged plates have been repaired and are acceptable.

ZPMC will repair these and provide the repair report as well as NDT after to show that the damaged plates have been repaired and are acceptable. Based on this proposal ZPMC requests that this NCR be approved, with actions pending.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000702R00

Caltrans' comments:

Status: AAP

Date: 13-Jun-2010

This proposed resolution is accepted with action pending. This NCR will be considered closed once the proper repair report and NDT documentation is submitted and reviewed.

Submitted by: Rizzardo, Gina

Attachment(s):

Date: 13-Jun-2010

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000700

Subject: NCR No. ZPMC-0705

Dated: 15-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000702 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has removed the damaged angles and replaced them with new material. ZPMC is providing NDT to show that the welds of the new angles are acceptable as well as an internal ZPMC inspection report.

ZPMC has removed the damaged angles and replaced them with new material. ZPMC is providing NDT to show that the welds of the new angles are acceptable as well as an internal ZPMC inspection report. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000702R01;

Caltrans' comments:

Status: CLO

Date: 15-Jun-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0705 is closed.

Submitted by: Rizzardo, Gina

Date: 15-Jun-2010

Attachment(s):



No. T-143

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-6-15

**REGARDING: NCR-739(ZPMC-702);
NCR-742 (ZPMC-705)**

ZPMC received NCR-739(ZPMC-702)& NCR-742 (ZPMC-705), it mentioned that CT inspector discovered four angle plates on Shear Plate A25&A27 were damaged and distorted.

Once the site QC inspector acknowledged this problem, he issued the inspection report for solving this problem, and got quick response from ZPMC's technique department. (See attached Inspection report)

We removed the broken angle steel and rebuilt new one. No weld repairing happened. Now all these angle plates has passed NDT check and got green tagged.

Here attached NDT report to show they sound well. So ZPMC hope CT could take a review and close both NCR.

ATTACHMENT:

NCR-739(ZPMC-702)

T787-MT-9360

NCR-742 (ZPMC-705)

T787-MT-9323

ZP06-787-J947 (Inspection Report)

Zhao Jia peng
2010-6-15



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: 510-808-4618 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607
Date: 25-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: 05.03.06-000699
Subject: NCR No. ZPMC-0702
Reference Description: Angle Plates Damaged and Distorted / Tower / Shear Plate WD1- A25

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: Tower **Lift:** 01

Remarks:

During random visual inspection in Bay 11, Quality Assurance Inspector discovered the following issue:

- Two (2) angle plates in the top elevation of Shear Plate were damaged and distorted.
- The welds are identified as WD1-A25B/E-174.187; fillet weld.
- Tower Lift 1 Shear Plate WD1-A25.
- The member is located in Bay#11.
- These angle plates were previously VT and MT tested.
- The Notice of Witness Inspection Number (NWIT) is 005762.

Standard Specification-55-1.04

SHIPPING, HANDLING AND STORING MATERIALS

"In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected."

Standard Specification -55-3.09 FINISHED MEMBERS

Finished members shall be true to line and free from twists, bends and open joints.

Action Required and/or Action Taken:

In accordance with Section 55-1.04 of the Standard Specifications, Shear Plate WD1-A25 is rejected due to damaged/ distorted angle plates as referenced in this transmittal.

Please submit a repair plan for the Engineer's approval prior to any remedial work begins.

After completion of any remedial work, please provide documentations that the repairs are in compliance with the contract requirements.

Documentation provided for the Engineer's review of the acceptability of the weld repairs shall at a minimum include the procedure utilized and the NDT results.

NCT

(Continued Page 2 of 2)

Transmitted by: Ken Lee Transportation Engineer

Attachments: ZPMC-0702

cc: Rick Morrow, Gary Pursell, Mark Woods

File: 05.03.06



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-9323 DATE日期 2010.06.12 PAGE OF页码 1/1 Revision No: 0

PROJECT NO. 工程编号: ZP06-787 CONTRACTOR: 用户: CALTRANS

DRAWING NO. 图号: ED1-A27B/E
1st lifting A27 shear plate and angle-steel CALTRANS CONTRACT NO.: 加州工程编号: 04-0120F4

REFERENCING CODE 参考规范编码 AWS D1.5-2002	ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002	PROCEDURE NO. 程序编号 ZPQC-MT-01	CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2010
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EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5620 5395 5617
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MAGNETIZING METHOD 磁化方法: Continuous magnetic yoke 磁轭式连续法 CURRENT 电流: AC

PARTICLE TYPE 磁粉类型: Dry magnet powder 干磁粉 YOKE SPACING 磁轭间距: 70~150mm

MATERIAL TO BE EXAMINED 检测材料	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 母材,厚度 A709M-345T2-Z 10/65mm
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WELDING PROCESS 焊接方法: SMAW TYPE OF JOINT 焊缝类型: T-JOINT

WELD I.D. 焊缝编号	DISCONTINUITY 不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度			
ED1-A27B/E-220				ACC.		100%MT
ED1-A27B/E-234				ACC.		100%MT
BLANK						

EXAMINED BY 主探 Cai Xinxin <i>Cai Xinxin</i>	REVIEWED BY 审核 <i>Xu Bing</i>
LEVEL - II SIGN 签名 / DATE日期 2010.06.12	LEVEL-II SIGN / DATE日期 2010.06.12
质量经理 / QCM	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

发: 安洪萍 高志春

室编号: ZP06-787-T-ZGGQ-1947 编号: ZP06-787-1947



检查报告

Inspection Report

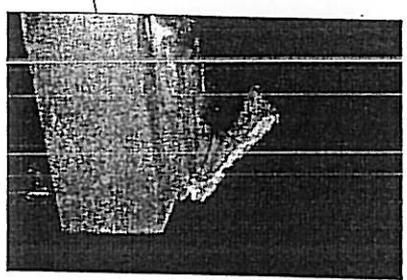
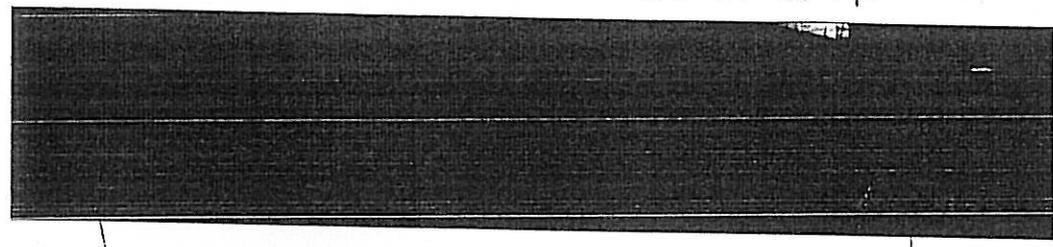
产品名称: 美国海湾大桥 工程编号: ZP06-787
 Project Name: 美国海湾大桥 Project No.: ZP06-787
 构件名称: A25, A27 剪力板 (shear plate) 构件图号: WD1-A25 ED1-A27 Component
 Name: A25, A27 剪力板 (shear plate) Drawing No.: WD1-A25 ED1-A27
 生产部门: 钢构八车间 (重一、二) (Heavy Dept 1 & 2) 生产部门负责人签字: _____
 Fabrication Dept.: 钢构八车间 (重一、二) (Heavy Dept 1 & 2) Fabrication Manager: _____

检查情况叙述 (包括发生的原因):
 Description of quality problem (reasons):

由陈洪萍施工队制作的西塔剪力板 A25, 和胡震施工队制作的东塔剪力板 A27 在翻身时, 角钢被损坏, 具体情况见下图; (A74, 共4件)

When the sub-contractors turned over the Shear Plate A25 & A27, the two side angle steel got broken.

(A74, 4 piece call)



检验员: 安洪萍 室经理: 刘阳 日期: 2010.5.23
 Q.C. Inspector An Hongping Q.C. Manager Liu Yang Date

处理意见:
 Proposed disposition

损坏的角钢去除, 重新下料制作安装 A74. 然后 [Li Jun] 焊接. 5.23/10
 Remove the broken Angle Steel, re-build new Angle steel (A74), then weld. 5.23/10

工艺主管: _____ 室经理: _____ 日期: _____
 Technical Engineer Technical Manager Date

缺损件处理意见:
 Proposed disposition for the lose and broken pieces

分管副总: _____ 日期: _____
 Vice-General Manager Date

检验结果:
 Check result

检验员: _____ 项目主管: _____ 日期: _____
 Q.C. Inspector Q.C. Engineer Date

DEPARTMENT OF TRANSPORTATION

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Vallejo, CA 94592-1133
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(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-000677**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0705**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: 24-May-2010**Description of Non-Conformance:**

During random visual inspection in Bay 10, Quality Assurance Inspector discovered the following issue:

- Two (2) angle plates in the top elevation of Shear Plate were damaged and distorted.
- The welds are identified as ED1-A27B/E-234, 220; fillet weld.
- Tower Lift 1 Shear Plate ED1-A27.
- The member is located in Bay#10.
- These angle plates were previously VT and MT tested.
- The Notice of Witness Inspection Number (NWIT) is 005737.

Contractor's proposal to correct the problem:

ZPMC will remove the distorted angles, and replace the new angles

Corrective action taken:

ZPMC removed the distorted angles, and replaced the new angles with NDT reports provided.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Ng, Michael

Quality Assurance Inspector

Reviewed By: Devey, Jim

QA Reviewer