

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-000748

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-May-2010

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

NCR #: ZPMC-0711

Type of problem:

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

Bridge No: 34-0006

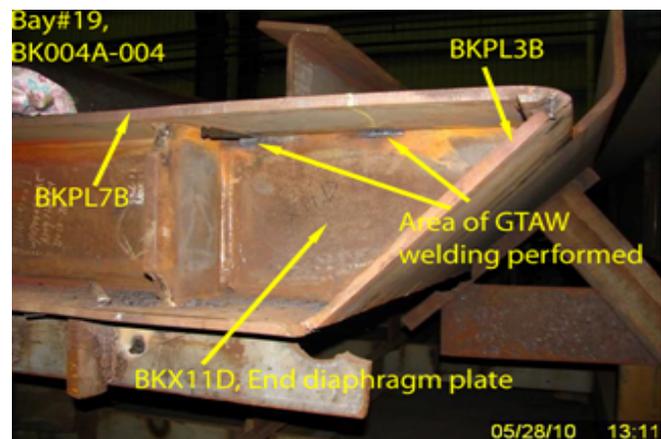
Component: Bike path assembly BK004A-004

Reference Description: Improper welding process was utilized in repair of Bike path assembly BK004A-004

Description of Non-Conformance:

During random in-process visual inspection of bike path assembly BK004A-004, this Quality Assurance (QA) Inspector discovered the following issue:

- Weld buttering being performed at the leading edge of an intended tight fit joint, between the end diaphragm plate (BKX11D) and the bearing plate (BKPL7B) with an unapproved welding process.
- The welding process being utilized during the repair was Gas Tungsten Arc Welding (GTAW).
- The welder is identified as ZP09-1381.
- The ZPMC QC Mr. Zhou Cheng was unable to identify the consumables used at the time of welding.
- Bike Path: BK004A-004 is located in Bay 19.



Applicable reference:

AWS D1.5-2002 Section 1.3.5: "Other welding processes not described in this code may be used if approved by the Engineer."

AWS D1.5-2002 Section 3.2.3.7: "All repair welding shall conform to the requirements of an approved WPS".

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

AWS D1.5-2002 Section 3.5.1.10: "Where tight fit of intermediate stiffeners is specified, it shall be defined as allowing a gap of up to 2mm between stiffener & flange.

Who discovered the problem: Shailesh Wadkar

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 1530 hours, 05/28/10, Verbal

Name of Caltrans Engineer notified: Stanley Ku, Sean Eagen

Time and method of notification: 1900 hours, 05/28/10, Email

QC Inspector's Name: Zhou Cheng

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: Devey, Jim

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: 31-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: 05.03.06-000704

Subject: NCR No. ZPMC-0711

Reference Description: Improper welding process was utilized in repair of Bike path assembly BK004A-004

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: Other **Lift:**

Remarks:

During random in-process visual inspection of bike path assembly BK004A-004, this Quality Assurance (QA) Inspector discovered the following issue:

- Weld buttering being performed at the leading edge of an intended tight fit joint, between the end diaphragm plate (BKX11D) and the bearing plate (BKPL7B) with an unapproved welding process.
- The welding process being utilized during the repair was Gas Tungsten Arc Welding (GTAW).
- The welder is identified as ZP09-1381.
- The ZPMC QC Mr. Zhou Cheng was unable to identify the consumables used at the time of welding.
- Bike Path: BK004A-004 is located in Bay 19.

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-0711

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: 05.03.06-000704

Subject: NCR No. ZPMC-0711

Dated: 02-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000677 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC corrected the non conformance within the shift and before 24 hours had elapsed. Based on this ZPMC requests closure of this NCR.

ZPMC corrected the non conformance within the shift and before 24 hours had elapsed. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000677R00;

Caltrans' comments:

Status: CLO

Date: 03-Jun-2010

This proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0711 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 03-Jun-2010



No. B-777

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-5-31

REGARDING: NCR-000748(ZPMC-0711)

The unsatisfied welds have been removed. A WRR has been written in order to fix this area. ZPMC QC will enhance the welding control during welding. The non-conformance in NCR has been cleared. Please consider to close this NCR.

ATTACHMENT:

NCR-000748(ZPMC-0711)

Notification for weld's removal

A handwritten signature in black ink, appearing to be "Jing" followed by a flourish.

5/31/10



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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: 31-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: 05.03.06-000704

Subject: NCR No. ZPMC-0711

Reference Description: Improper welding process was utilized in repair of Bike path assembly BK004A-004

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: Other

Lift:

Remarks:

During random in-process visual inspection of bike path assembly BK004A-004, this Quality Assurance (QA) Inspector discovered the following issue:

- Weld buttering being performed at the leading edge of an intended tight fit joint, between the end diaphragm plate (BKX11D) and the bearing plate (BKPL7B) with an unapproved welding process.
- The welding process being utilized during the repair was Gas Tungsten Arc Welding (GTAW).
- The welder is identified as ZP09-1381.
- The ZPMC QC Mr. Zhou Cheng was unable to identify the consumables used at the time of welding.
- Bike Path: BK004A-004 is located in Bay 19.

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-0711

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
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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

Report No: NCR-000748

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-May-2010

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

NCR #: ZPMC-0711

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: Bike path assembly BK004A-004

Reference Description: Improper welding process was utilized in repair of Bike path assembly BK004A-004

Description of Non-Conformance:

During random in-process visual inspection of bike path assembly BK004A-004, this Quality Assurance (QA) Inspector discovered the following issue:

- Weld buttering being performed at the leading edge of an intended tight fit joint, between the end diaphragm plate (BKX11D) and the bearing plate (BKPL7B) with an unapproved welding process.
- The welding process being utilized during the repair was Gas Tungsten Arc Welding (GTAW).
- The welder is identified as ZP09-1381.
- The ZPMC QC Mr. Zhou Cheng was unable to identify the consumables used at the time of welding.
- Bike Path: BK004A-004 is located in Bay 19.



Applicable reference:

AWS D1.5-2002 Section 1.3.5: "Other welding processes not described in this code may be used if approved by the Engineer."

AWS D1.5-2002 Section 3.2.3.7: "All repair welding shall conform to the requirements of an approved WPS".

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

AWS D1.5-2002 Section 3.5.1.10: "Where tight fit of intermediate stiffeners is specified, it shall be defined as allowing a gap of up to 2mm between stiffener & flange.

Who discovered the problem: Shailesh Wadkar

Name of individual from Contractor notified: Peter Ferguson

Time and method of notification: 1530 hours, 05/28/10, Verbal

Name of Caltrans Engineer notified: Stanley Ku, Sean Eagen

Time and method of notification: 1900 hours, 05/28/10, Email

QC Inspector's Name: Zhou Cheng

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: Devey, Jim

SMR

FW: BIKE PATH buttering weld to be cut

发件人: Peter Ferguson <pferguson@abfjv.com>

收件人: 'Mahlon Lindenmuth' <mlindenmuth@sasbridge.com> , 'Eric Tsang' <etsang@sasbridge.com>
'Jim Simonis' <jsimonis@sasbridge.com> , . . .

日期: 2010-5-28 13:35:35

Per AWS D1.5 Section 3.7.5, please take this as notification that ZPMC intends to remove completed welds as noted below.

This pertains to ZPMC NCR-0707.

Kindest regards,

Peter Ferguson.

Fabrication Superintendent.

San Francisco Oakland Bay Bridge Project - SAS Bridge.

American Bridge / Fluor, A Joint Venture.

Room 5, 4th Floor, 4th Building,

No. 666 Fengbin Rd,

Changxing Island,

Shanghai, China.

201913

Office:- +86 021 5685 6666 ext 564021

Mobile:- +86 159 2169 3142

pferguson@abfjv.com



Please consider the environment before printing this e-mail.

From: 张伟 [mailto:zhangwei_zj@zpmc.net]

Sent: Friday, May 28, 2010 1:17 PM

To: Peter Ferguson; steve lawton; Jiao Gang

Cc: lujianhua; zhaoshuangbao

Subject: BIKE PATH buttering weld to be cut

Gentlemen:

Please notified bike path weld which was welded by the unqualified welder will be cut. The bike path is BK004A-004. It will start at approximately 13:45 this afternoon. Please inform CT about this. Thank you.

Best Regards,

Zhang Wei

张伟

2010-5-28

This message has been scanned for viruses and dangerous content by MailScanner, and is believed to be clean.

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dangerous content by MailScanner, and is
believed to be clean.

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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-000658**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0711**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: 28-May-2010**Description of Non-Conformance:**

During random in-process visual inspection of bike path assembly BK004A-004, this Quality Assurance (QA) Inspector discovered the following issue:

- Weld buttering being performed at the leading edge of an intended tight fit joint, between the end diaphragm plate (BKX11D) and the bearing plate (BKPL7B) with an unapproved welding process.
- The welding process being utilized during the repair was Gas Tungsten Arc Welding (GTAW).
- The welder is identified as ZP09-1381.
- The ZPMC QC Mr. Zhou Cheng was unable to identify the consumables used at the time of welding.
- Bike Path: BK004A-004 is located in Bay 19.

Contractor's proposal to correct the problem:

Remove said welds and replace utilizing an approved welding process.

Corrective action taken:

Welds were removed within the workshift and have since been replaced with the appropriate welding process.

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

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer