

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-000758
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 09-Jun-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0720

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Floorbeam FL2, PP118, Lift 13AE
Procedural	Procedural	Description: QA Missed MT Transverse Indication on FB3106-001	

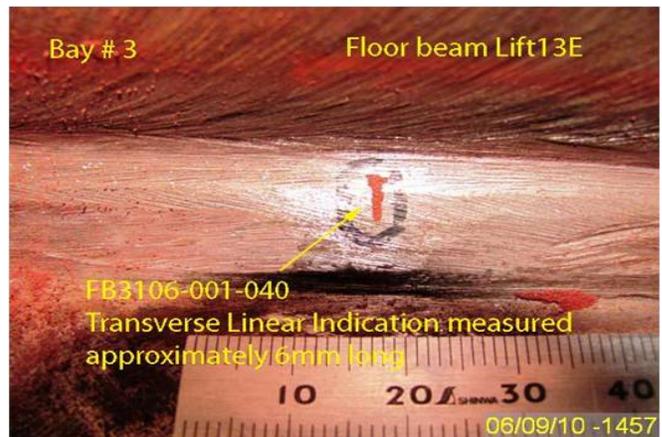
Reference Description: QC Missed (1) Transverse Indication found on weld number: FB3106-001-040 by QA

Description of Non-Conformance:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of weld located on Floorbeam Sub Assembly FB3106A for 13AE, QA discovered the following issue:

- One (1) Transverse indication measuring approximately 6mm in length.
- The weld is a fillet T-joint joining the Stiffener to the floor beam web.
- The weld is identified as FB3106-001-040.
- The indication is clearly marked on the material near the weld.
- OBG Floor beam FB3106-001 is located in bay 3.

The Notice of Witness Inspection Number (NWIT) is 005939. The indication is located within an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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 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: D. Sukanthan

Name of individual from Contractor notified: Wang Wen Bin

Time and method of notification: 1645 hours, 6/9/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0800 hours, 6/10/10, 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 Jim Devey, 150.0002.6784, who represents the Office of Structural Materials for your project.

Inspected By:	Devey,Jim	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: 10-Jun-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: 05.03.06-000716

Subject: NCR No. ZPMC-0720

Reference Description: QC Missed (1) Transverse Indication found on weld number: FB3106-001-040 by QA

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:** 13

Remarks:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of weld located on Floorbeam Sub Assembly FB3106A for 13AE, QA discovered the following issue:

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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-0720

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: 05.03.06-000716

Subject: NCR No. ZPMC-0720

Dated: 21-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000717 Rev: 00

Contractor's Proposed Resolution:

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

ZPMC has repaired the indication 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-000717R00;

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-0720 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 23-Jun-2010



No. B-796

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-6-21

REGARDING: NCR-000758(ZPMC-0720)

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

ATTACHMENT:

NCR-000758(ZPMC-0720)

B787-MT-23852 R1

A handwritten signature in black ink, appearing to be "L. W.", is located below the attachment list.

6/21/10



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Attachments: ZPMC-0720

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File: 05.03.06

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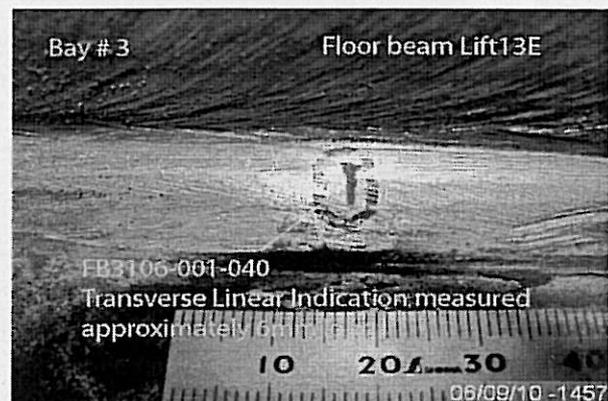
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000758**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0720**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Floorbeam FL2, PP118, Lift 13AEProcedural Procedural Description: QA Missed MT Transverse Indication on FB3106-001**Reference Description:** QC Missed (1) Transverse Indication found on weld number: FB3106-001-040 by QA**Description of Non-Conformance:**

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0800 hours, 6/10/10, 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:

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Inspected By: Devey, Jim

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-000697**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0720**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: 09-Jun-2010**Description of Non-Conformance:**

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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