

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-000767**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0729**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segments 8AE, 8AW, and CB9
Procedural	Procedural	Description:	

Reference Description: QC absence of 1 hour inside OBG Segments 8AE, 8AW, and Crossbeam 9**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of the OBG Segments in the Trial Assembly Area, this QA inspector discovered the following issue:

Three (3) ZPMC welders performed welding at the locations noted below without the presence of QC personnel over a duration of 1 hour (approximately 14:00-15:00 Hours). This time frame exceeds the allowable maximum time for QC Inspection coverage as required by Caltrans Special Provision Section 8-3.01.

Welder 1- Mr. Li Zhengxu (ID#066179)

- Welding was performed on Panel Point 63 to Deck Plate weld joint (Segment 8AW Interior).
- The weld is identified as SSD11A-PP063-168, Non-SPCM
- The weld is a Complete Joint Penetration (CJP).

Welder 2- Mr. Chen Hongjun (ID#067609)

- Welding was performed on Panel Point 63 to Deck Plate weld joint (Segment 8AE Interior).
- The weld is identified as SSD11A-PP063-166, Non-SPCM
- The weld is a Complete Joint Penetration (CJP).

Welder 3- Mr. Ji Hua (ID#045227)

- Welding was performed on Bottom Plate at Crossbeam CB 9 (interior).
- Bottom plate on CB is identified as BP201; horizontal plate on CB is identified as FB202A
- The welds are identified as CB202A-009-010/023, SPCM
- The weld is a Complete Joint Penetration (CJP).

No QC is available to provide the welding procedure specification (WPS) corresponding to the performed work.

Also, no posted WPS is available in the area. This QA Inspector notified ZPMC personnel that QC is needed in the area. No QC personnel were available in locations noted above prior to 15:00 hours. Subsequently, QA saw a ZPMC QC personnel Li Jia was sitting outside of the Segment 8AE (Bikepath side) while leaving the area.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Caltrans Special Provision Section 8-3.01: QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes.

Who discovered the problem: Joe Alaniz

Name of individual from Contractor notified: CK Chan

Time and method of notification: 1515 hours, 06/15/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0830 hours, 06/16/10, Verbal

QC Inspector's Name: Wang Lu

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, (86) 150-0002-6784, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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: 16-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: 05.03.06-000725

Subject: NCR No. ZPMC-0729

Reference Description: QC absence of 1 hour inside OBG Segments 8AE, 8AW, and Crossbeam 9

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:** 08

Remarks:

During the Quality Assurance (QA) random in-process visual inspection of the OBG Segments in the Trial Assembly Area, this QA inspector discovered the following issue:

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NCT

(Continued Page 2 of 2)

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-0729

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: 08-Jul-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-000724 Rev: 00

Ref: 05.03.06-000725

Subject: NCR No. ZPMC-0729

Contractor's Proposed Resolution:

Reference Resolution: See ZPMC's attached response.

See ZPMC's attached response.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000724R00;

Caltrans' comments:

Status: CLO

Date: 13-Jul-2010

This proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0729 is closed.

Submitted by: Woo, Laraine

Date: 13-Jul-2010

Attachment(s):



No. B-815

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-7-8

REGARDING: NCR-000767(ZPMC-0729)

ZPMC has written an internal NCR to address the absence of QC/CWI in field. ABFJV QCM has met with ZPMC's QA manager to discuss this issue. ZPMC quality department is aware of this issue. Refresh training has been performed to all the CWIs. And ZPMC will arrange the CWI's coverage areas more reasonable to improve their monitor ability. ZPMC is providing the NDT records show the welds in question are acceptable. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

N CR-000767(ZPMC-0729)

B787-MT-24607

B787-MT-24608

B787-MT-24609

Lay
7/8/10



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: 16-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: 05.03.06-000725

Subject: NCR No. ZPMC-0729

Reference Description: QC absence of 1 hour inside OBG Segments 8AE, 8AW, and Crossbeam 9

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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- Quality Control (QC) not performed in conformance with contract documents.
- Recurring QC issue that constitutes a systematic problem in quality control.
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Material Location: OBG

Lift: 08

Remarks:

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NCT

(Continued Page 2 of 2)

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-0729

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-000767

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2010

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

NCR #: ZPMC-0729

Type of problem:

Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Segments 8AE, 8AW, and CB9Procedural Procedural Description:

Reference Description: QC absence of 1 hour inside OBG Segments 8AE, 8AW, and Crossbeam 9

Description of Non-Conformance:

During the Quality Assurance (QA) random in-process visual inspection of the OBG Segments in the Trial Assembly Area, this QA inspector discovered the following issue:

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- Welding was performed on Bottom Plate at Crossbeam CB 9 (interior).

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Caltrans Special Provision Section 8-3.01: QC inspections shall be provided to ensure continuous inspection when any welding is being performed. Continuous inspection, as a minimum, shall include (1) having QC Inspectors continually present on the shop floor or project site when any welding operation is being performed, and (2) having a QC Inspector within such close proximity of all welders or operators so that inspections by the QC Inspector of each operation, at each welding location, shall not lapse for a period exceeding 30 minutes.

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Name of individual from Contractor notified: CK Chan

Time and method of notification: 1515 hours, 06/15/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0830 hours, 06/16/10, Verbal

QC Inspector's Name: Wang Lu

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, (86) 150-0002-6784, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

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-000726**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 13-Jul-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0729**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 15-Jun-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of the OBG Segments in the Trial Assembly Area, this QA inspector discovered the following issue:

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