

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-000768

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2010

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

NCR #: ZPMC-0730

Type of problem:

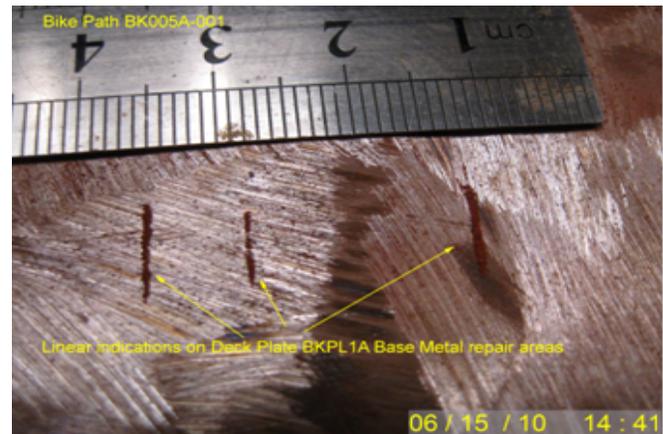
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Bike Path Top Plate
Procedural	Procedural	Description: Missed MT indications by QC	

Reference Description: QA found 12 linear indications on the base metal of the Bikepath Top Plate after the contractor's had tested and accepted the repairs

Description of Non-Conformance:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of Base Metal repair areas located on Bike Path BK005A-001, this QA Inspector discovered the following issue:

- Twelve (12) linear indications measured approximately 5mm to 11mm in length.
- Indications are found on the Bikepath Top Plate Base Metal Repair Areas at Y locations 810mm, 890mm, 1130mm, 1450mm, 1830mm, 1940mm, and 2160mm measured from the Edge Plate side.
- The Bikepath Top Plate is identified as BKPL1A.
- The Bikepath Top Plate is designated on the contract drawings as a Non Seismic Performance Critical Member (Non SPCM).
- The indications are marked clearly on the Bikepath Top Plate.
- Bike Path BK005A-001 is located in the Fabrication Bay 19.
- The Notice of Witness Inspection (NWIT) Number is 005985. The indication was found within the area previously tested and accepted by ZPMC 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: Anand Upadhye

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1600 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: Xu Tao

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.

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	Devey, Jim	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: 16-Jun-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0730

Job Name: SAS Superstructure
Document No: 05.03.06-000726

Reference Description: QA found 12 linear indications on the base metal of the Bikepath Top Plate after the contractor's had tested and accepted the repairs

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: Bike Path **Lift:**

Remarks:

- During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of Base Metal repair areas located on Bike Path BK005A-001, this QA Inspector discovered the following issue:
- Twelve (12) linear indications measured approximately 5mm to 11mm in length.
- Indications are found on the Bikepath Top Plate Base Metal Repair Areas at Y locations 810mm, 890mm, 1130mm, 1450mm, 1830mm, 1940mm, and 2160mm measured from the Edge Plate side.
- The Bikepath Top Plate is identified as BKPL1A.
- The Bikepath Top Plate is designated on the contract drawings as a Non Seismic Performance Critical Member (Non SPCM).
- The indications are marked clearly on the Bikepath Top Plate.
- Bike Path BK005A-001 is located in the Fabrication Bay 19.
- The Notice of Witness Inspection (NWIT) Number is 005985. The indication was found within the area previously tested and accepted by ZPMC QC personnel.

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-0730

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: 05.03.06-000726

Subject: NCR No. ZPMC-0730

Dated: 22-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000718 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The inspection request for this piece was cancelled as it was not ready for final inspection by the Department. The attached canceled notification shows that this piece was not ready for inspection.

The inspection request for this piece was cancelled as it was not ready for final inspection by the Department. The attached canceled notification shows that this piece was not ready for inspection by the Department. Based on this ZPMC requests that this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000718R00;

Caltrans' comments:

Status: CLO

Date: 27-Jun-2010

This proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0730 is closed.

Submitted by: Eagen, Sean

Date: 27-Jun-2010

Attachment(s):



No. B-798

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-6-21

REGARDING: NCR-000768(ZPMC-0730)

The items in question have been canceled in notification 005985 by ZPMC QA personnel. The welds with indications haven't been accepted by ZPMC NDT personnel. Based on this, please consider withdrawal of this NCR.

ATTACHMENT:

NCR-000768(ZPMC-0730)

NOTIFICATION-005985

Lingwei.
6/21/10.



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: 05.03.06-000726

Subject: NCR No. ZPMC-0730

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Material Location: Bike Path

Lift:

Remarks:

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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-000768

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Jun-2010

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

NCR #: ZPMC-0730

Type of problem:

Welding **Concrete** **Other**

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

Joint fit-up **Coating** **Other** **Component:** Bike Path Top Plate

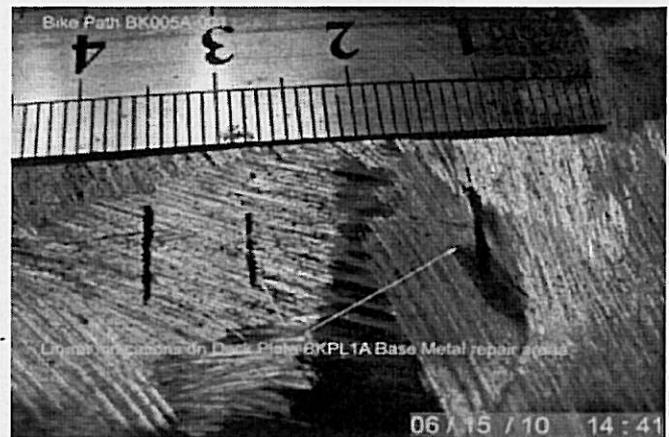
Procedural **Procedural** **Description:** Missed MT indications by QC

Reference Description: QA found 12 linear indications on the base metal of the Bikepath Top Plate after the contractor's had tested and accepted the repairs

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Time and method of notification: 1600 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: Xu Tao

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: Tsang, Eric

SMR

Reviewed By: Devey, Jim

SMR



NDT客户检验通知单
NDT Inspection Notification Sheet

申请递交时间:
Submit time:
2010-6-15 13:30

文件编号: 005985
Document No.

序号 No	检验内容 Inspection	待检验构件 Inspection part	产品分类 Section	检验场地 Inspection Place	计划检验时间 Inspection Time	CT 计划检验时间 CT Estimated Inspection Time
1	MT	BK005A-001	OBC	BAY 19	2010-6-15 14:00	14:00
2	MT	BK006A-002	OBC	BAY 19	2010-6-15 14:00	
3	UT	SAW 8CW X3S TO EP	OBC	TRIAL ASSEMBLY	2010-6-15 14:00	
4						

4. QC检验完成后, QA是否需要复验, 由QA自行决定, QC不再另行通知。复验等待时间通常为24小时。
4. When ZPMC QC finish NDT inspection, Caltrans QA can decide if they want to retest it. ZPMC QC will not inform Caltrans again. The waiting time is 24 hours ordinarily.

5. AB/F预约CT后会在同班时间内通知ZPMC具体CT现场报验时间
5. AB/F to notify ZPMC in the same shift that CT will attend and at what time.
6. 加州现场检验完成后会告知AB/F检验结果, AB/F会在24小时内告知ZPMC加州复验结果。
6. CT to notify AB/F that the work has been completed and the result. AB/ to notify ZPMC that the work has been completed and the result within 24 hours.

签收时间:
Time:

ABF Receiver

CT 签收人:

CT Receiver:

签收时间:
Time:

Testano

John Jones

John O. D. 13:34

Steve Hall

13:34 6/15/10

Cancel
Testano
6/15

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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-000690**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0730**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: 15-Jun-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of Base Metal repair areas located on Bike Path BK005A-001, this QA Inspector discovered the following issue:

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- The Notice of Witness Inspection (NWIT) Number is 005985. The indication was found within the area previously tested and accepted by ZPMC QC personnel.

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

NCR has been rescinded as Contractor elected to rescind notification after initial cracks were discovered.

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