

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, China

Report No: NCR-000778

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Jun-2010

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

NCR #: ZPMC-0740

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Suspender Bracket SB48W
Procedural	Procedural	Description:	

Reference Description: Missed MT Longitudinal & Transverse Cracks by QC - Suspender Bracket SB48W

Description of Non-Conformance:

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Suspender bracket SB48W, QA discovered the following issues:

- Three linear longitudinal crack indications that measured approximately 15mm to 60mm in length.
- The weld is identified as SB007-048-001
- The weld is a complete joint penetration (CJP) connecting the Deck plate to the Flange.
- Ten linear transverse crack indications that measured approximately 3mm to 6mm in length.
- The weld is identified as SB007-048-032.
- The weld is a Fillet weld connecting the Bottom plate to Bearing plate.
- OBG suspender bracket SB007-048-001 is located in BAY#19.
- The indications are clearly marked on the material on/near the weld.
- The Notice of Witness Inspection Number (NWIT) is 006064.
- The indications are located within the 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: Chandra Sudalaimuthu

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 14:00, 06/27/10, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 14:50, 6/28/10, Email

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 Mazen Wahbeh,(818) 292-0659, 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: 29-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: 05.03.06-000736

Subject: NCR No. ZPMC-0740

Reference Description: Missed MT Longitudinal & Transverse Cracks by QC - Suspender Bracket SB48W

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:** N/A

Remarks:

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Suspender bracket SB48W, QA discovered the following issues:

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- The indications are located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

See attached NCR No. ZPMC-0740 for details.

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: Ching Chao

Attachments: ZPMC-0740

NCT

(Continued Page 2 of 2)

cc: Gary Pursell, Peter Siegenthaler, Stanley Ku, 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: 05.03.06-000736

Subject: NCR No. ZPMC-0740

Dated: 22-Jul-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000731 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has issued an internal NCR and has discussed preventative measures with the ABF QCM. ZPMC has attached the acceptable MT report after repair. ZPMC requests closure of this NCR.

ZPMC has issued an internal NCR and has discussed preventative measures with the ABF QCM. ZPMC has attached the acceptable MT report after repair. ZPMC requests closure of this NCR.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000731R00;

Caltrans' comments:

Status: CLO

Date: 29-Jul-2010

The proposed resolution is acceptable. This NCR is considered closed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 29-Jul-2010



No. B-829

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-7-21

REGARDING: NCR-000778(ZPMC-0740)

ZPMC has issue an internal NCR to address this issue and ZPMC QA personnel have talked with the head of the NDT department. The missed indications have been repaired and were tested to be acceptable. ZPMC is providing the NDT records and is requesting closure of this NCR.

ATTACHMENT:

NCR-000778(ZPMC-0740)

B787-MT-24478 R1

A handwritten signature in black ink, appearing to be "Ley M".

7/21/10



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: 29-Jun-2010

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

Job Name: SAS Superstructure

Document No: 05.03.06-000736

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Attention: Mr. Thomas Nilsson Project/Fabrication Manager

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Transmitted by: Ching Chao

Attachments: ZPMC-0740

02.02.02 14
05.03.06-000736,NCT

Received
NCT-000736 05 Mar 10 Page 1 of 2

NCT

(Continued Page 2 of 2)

cc: Gary Pursell, Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, China

Report No: NCR-000778

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 27-Jun-2010

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

NCR #: ZPMC-0740

Type of problem:

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

Bridge No: 34-0006

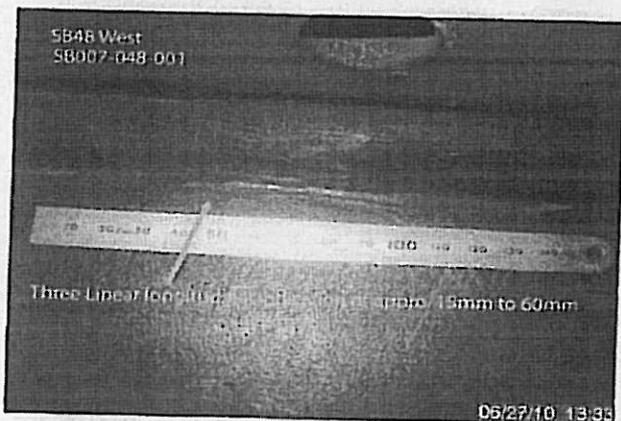
Component: Suspender Bracket SB48W

Reference Description: Missed MT Longitudinal & Transverse Cracks by QC - Suspender Bracket SB48W

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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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: Devey, Jim

SMR

Reviewed By: Wahbeh, Mazen

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

0740

REPORT NO. 报告编号 B787-MT-24478R1		DATE日期 2010.07.12	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: SB48W SUSPENDER BRACKET		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	
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 B310S	SERIAL NO. 连续编号 5395 5617 5620	
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 35/20/75mm	
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			
SB007-048-001	1R1			ACC.		100%MT
SB007-048-032	1R1			ACC.		100%MT

AFTER B-CWR1677 REV0/CWR1676 REV0

BLANK

EXAMINED BY主探 Su wei SU Wei 20/0.07.12	REVIEWED BY 审核 Sun Gomy chany 20/0.07.12
LEVEL - II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
质量经理 / QCM	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

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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, China**Report No:** NCS-000693**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Jul-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0740**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: 27-Jun-2010**Description of Non-Conformance:**

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on OBG Suspender bracket SB48W, QA discovered the following issues:

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Contractor's proposal to correct the problem:

Repair said indications 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?**

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

Yes No

Comments:

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Inspected By:	Simonis,Jim	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer
