

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-000797

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 12-Jul-2010

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

NCR #: ZPMC-0759

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 13AW - FB3194A, 13CW - FB3223A
Procedural	Procedural	Description:	

Reference Description: Unapproved Wrapped Welds - Lift 13 Floorbeams

Description of Non-Conformance:

During Quality Assurance (QA) in-process observations of the fabrication of Floor beam Lift 13W, QA discovered the following issue:

- ZPMC personnel welded without according to the approved shop drawings by wrapping the welds around at the ends of the stiffeners.
- The affected Floor beam welds are identified as FB3194-001-032,035,036,025,026 and FB3223-001-049,050.
- This Floor beam is located in Sub assembly Bay#2.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

ABF-RFI-001786R00 dated June 12, 2009: ...terminate welds in accordance with the contract plans and the approved shop drawings.

General Notes GN3 Detail WT1: specifies terminating the weld 6mm from the end of the joint.

AWS D1.5 1002, Section 3.1.5: Welds shall be prohibited on the work except as follows: (1) Base-metal repair performed in conformance with AASHTO... (2) All welds detailed on approved shop drawings. (3) Repair welds authorized by this code (4) Other welds approved by the Engineer.

Who discovered the problem: D.Sukanthan

Name of individual from Contractor notified: Mr.Wang wen bin

Time and method of notification: 18:00 hours, 07-12-2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 10:00_07/13/10_Verbal

QC Inspector's Name: Zhu Jun

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

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: Devey,Jim SMR

Reviewed By: Wahbeh,Mazen SMR

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000755

Subject: NCR No. ZPMC-0759

Dated: 07-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000770 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has removed the wrapped fillet welds by grinding and performed NDT after to show that the welds are acceptable after the grinding.

ZPMC has removed the wrapped fillet welds by grinding and performed NDT after to show that the welds are acceptable after the grinding. ZPMC production is aware that attention must be paid and ensure wrapping only occurs only locations which wrapping is specified in the drawings. ABFJV and ZPMC QC inspectors have been briefed to watch for this potential non conformance and ensure it is halted and welds which are wrapped are not accepted at this time. Based on this and the acceptable NDT, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000770R00;

Caltrans' comments:

Status: CLO

Date: 14-Sep-2010

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

Submitted by: Woo, Laraine

Attachment(s):

Date: 14-Sep-2010



No. B-873

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-09-06

REGARDING: NCR-000797(ZPMC-0759)

ZPMC has removed the unspecified wrapping at the end of fillets by grinding. These welds have passed the NDT as shown in attached records. ZPMC QA personnel have instructed the production on the requirement of perform wrapping according to drawing. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000797(ZPMC-0759)

B787-MT-26113

By [Signature]
9/16/10



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV
375 BURMA ROAD
OAKLAND CA 95607

Date: 14-Jul-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: 05.03.06-000755

Subject: NCR No. ZPMC-0759

Reference Description: Unapproved Wrapped Welds - Lift 13 Floorbeams

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 Quality Assurance (QA) in-process observations of the fabrication of Floor beam Lift 13W, QA discovered the following issue:
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-The affected Floor beam welds are identified as FB3194-001-032,035,036,025,026 and FB3223-001-049,050.
-This Floor beam is located in Sub assembly Bay#2.

Action Required and/or Action Taken:

Proposed 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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0759

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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Date: 12-Jul-2010

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

NCR #: ZPMC-0759

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: 13AW - FB3194A, 13CW - FB3223A

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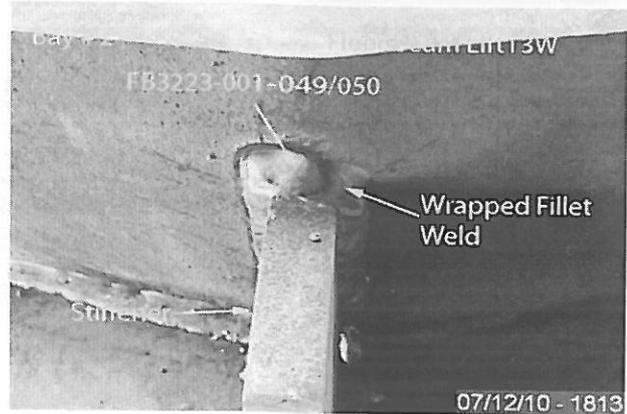
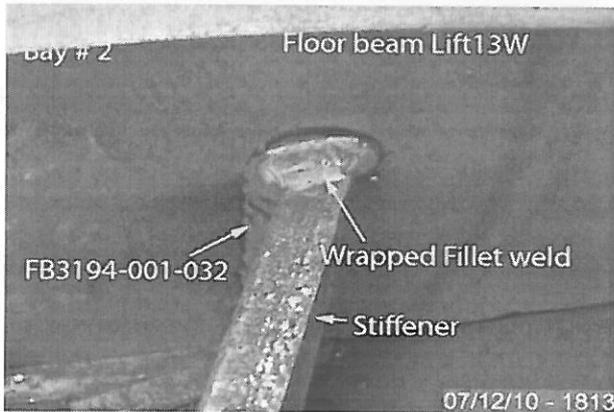
-This Floor beam is located in Sub assembly Bay#2.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Name of individual from Contractor notified: Mr.Wang wen bin

Time and method of notification: 18:00 hours, 07-12-2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 10:00_07/13/10_Verbal

QC Inspector's Name: Zhu Jun

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

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: Devey,Jim

SMR

Reviewed By: Wahbeh,Mazen

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-26005		DATE日期 2010.08.21		PAGE 页码 1/1	Revision No: 0	
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: FB3223 13 LIFTING FLOOR BEAM			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-X 14/20/22mm			
WELDING PROCESS 焊接方法	FCAW	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			
FB3223-001-049				ACC		100%MT
FB3223-001-050				ACC		100%MT
FB3223-001-051				ACC		100%MT
FB3223-001-052				ACC		100%MT
FB3223-001-059				ACC		100%MT
FB3223-001-060				ACC		100%MT
FB3223-001-061				ACC		100%MT
FB3223-001-062				ACC		50%MT
FB3223-001-063				ACC		50%MT
FB3223-001-064				ACC		50%MT
FB3223-001-065				ACC		50%MT
BLANK						
EXAMINED BY主探 GuYunwu <i>Gu Yunwu</i> LEVEL - II SIGN 签名 / DATE日期 2010.8.21			REVIEWED BY 审核 <i>Gai Xin Xin</i> LEVEL-II SIGN / DATE日期 2010.8.21			
质量经理 / QCM			用户CUSTOMER			
签字 SIGN / 日期 DATE			签字 SIGN / 日期 DATE			

(FORM# ZPQC-MT01)

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REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 B787-MT-26113		DATE日期 2010.08.24	PAGE OF页码 3/3	Revision No: 0
PROJECT NO. 工程编号: ZP06-787		CONTRACTOR: 用户: CALTRANS		
DRAWING NO. 图号: FB3194 THE 13th LIFTING FLOOR BEAM		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-X 12/16/20/14mm	
WELDING PROCESS 焊接方法	FCAW	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			
FB3194-001-033				ACC.		25%MT
FB3194-001-034				ACC.		25%MT
FB3194-001-035				ACC.		100%MT
FB3194-001-036				ACC.		100%MT
FB3194-001-037				ACC.		100%MT
FB3194-001-038				ACC.		100%MT
FB3194-001-039				ACC.		25%MT
FB3194-001-040				ACC.		25%MT

AFTER HSR1(B)-8950

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EXAMINED BY主探 He Zhishun He Zhishun 2010.08.24	REVIEWED BY审核 2010.08.24
LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM	LEVEL-II SIGN / DATE日期 用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE



REPORT OF MAGNETIC PARTICLE EXAMINATION
磁粉检测报告

REPORT NO. 报告编号 B787-MT-26113		DATE 日期 2010.08.24		PAGE OF 页码 2/3		Revision No: 0	
PROJECT NO. 工程编号: ZP06-787				CONTRACTOR: 用户: CALTRANS			
DRAWING NO. 图号: FB3194 THE 13th LIFTING FLOOR BEAM				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	
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WELDING PROCESS 焊接方法		FCAW		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				
FB3194-001-013				ACC.		25%MT	
FB3194-001-014				ACC.		25%MT	
FB3194-001-015				ACC.		100%MT	
FB3194-001-016				ACC.		100%MT	
FB3194-001-017				ACC.		25%MT	
FB3194-001-018				ACC.		25%MT	
FB3194-001-021				ACC.		25%MT	
FB3194-001-022				ACC.		25%MT	
FB3194-001-023				ACC.		25%MT	
FB3194-001-024				ACC.		25%MT	
FB3194-001-025				ACC.		100%MT	
FB3194-001-026				ACC.		100%MT	
FB3194-001-031				ACC.		100%MT	
FB3194-001-032				ACC.		100%MT	
EXAMINED BY 主探 He Zhishun Hezhishun 2010.08.24 LEVEL - II SIGN 签名 / DATE 日期				REVIEWED BY 审核 Li Ming 2010.08.24 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-000763**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0759**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: 12-Jul-2010**Description of Non-Conformance:**

During Quality Assurance (QA) in-process observations of the fabrication of Floor beam Lift 13W, QA discovered the following issue:

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- The affected Floor beam welds are identified as FB3194-001-032,035,036,025,026 and FB3223-001-049,050.
- This Floor beam is located in Sub assembly Bay#2.

For further information, please see the attached pictures below.

Contractor's proposal to correct the problem:

Remove said unapproved welds and perform NDT required to verify base metal was not affected.

Corrective action taken:

Contractor removed welds in said locations and submitted NDT reports verifying adjacent base metal was not damaged.

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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Inspected By: Simonis, Jim

Quality Assurance Inspector

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Reviewed By: Wahbeh,Mazen

QA Reviewer