

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-000802

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 14-Jul-2010

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

NCR #: ZPMC-0764

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 9W Side Panels
Procedural	Procedural	Description:	

Reference Description: ZPMC performed welding on wet surfaces (Segment 9BW/9CW Side Panels)

Description of Non-Conformance:

During Quality Assurance (QA) random in-process visual inspection this QA inspector discovered the following issues.

- During the fit up of segment splice 9BW to 9CW, ZPMC personnel performed tack welding of temporary attachments on wet surfaces.
- The tacks are on Side Panel SP770A (9BW) and Side Panel SP771A (9CW) at the counterweight side.
- No ZPMC QC personnel were aware of this issue.
- Segment's 9BW and 9CW are located at the OBG Trial Assembly Yard.



Applicable reference:

AWS D1.5 2002 Section 3.1.3: "Welding shall not be done when the ambient temperature is lower than -20°C [0°F](see 4.2), when surfaces are wet or exposed to rain, snow, or high wind velocities, nor when welders are exposed to inclement conditions."

AWS D1.5 2002 Section 3.2.1: "Surfaces to be welded and surfaces adjacent to a weld shall also be free from

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

loose or thick scale, slag, rust, moisture, grease, and other foreign material that would prevent proper welding or produce objectionable fumes.”

Who discovered the problem: S. Manjunath. Math.

Name of individual from Contractor notified: Ding Xing Chi

Time and method of notification: 16:40 hours, 07/14/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 08:00 hours, 07/15/10, Verbal

QC Inspector's Name: Zhu Zhong Hai

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
 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: 16-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: 05.03.06-000759

Subject: NCR No. ZPMC-0764

Reference Description: ZPMC performed welding on wet surfaces (Segment 9BW/9CW Side Panels)

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) random in-process visual inspection this QA inspector discovered the following issues.
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 - No ZPMC QC personnel were aware of this issue.
 - Segment's 9BW and 9CW are located at the OBG Trial Assembly Yard.

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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0764

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: 05.03.06-000759

Subject: NCR No. ZPMC-0764

Dated: 07-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000769 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC acknowledges this tack welding on wet surfaces is not acceptable and has issued a internal NCR to document this occurrence.

ZPMC acknowledges this tack welding on wet surfaces is not acceptable and has issued a internal NCR to document this occurrence. ZPMC QC's are aware that this is not acceptable, the absence of the QC prevented ZPMC from halting this non conformance. In the future, ABFJV and ZPMC are ensuring that areas across the project are staffed to prevent this type of non conformance from occurring, as the instances of non conformances related to welding over wet material have been infrequent ZPMC and ABF are confident that this action will be sufficient in addressing this issue. Based on these actions and attached NDT documentation which shows the base metal is acceptable where the temporary attachments were welded, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000769R00;

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-872

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-09-06

REGARDING: NCR-000802(ZPMC-0764)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC production department will pay more attention on the removal of water around weld area prior to start welding. ZPMC is providing the MT record show the affected area were tested to be acceptable after the removal of temp-attachment. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000802(ZPMC-0764)

B787-MT-27222

A handwritten signature in black ink, appearing to be 'J. W.' or similar, written in a cursive style.

9/6/10



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: 16-Jul-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-0764

Job Name: SAS Superstructure

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Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0764

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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Cty: SF/ALA Rtc: 80 PM: 13.2/13.9
File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000802

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 14-Jul-2010

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

NCR #: ZPMC-0764

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

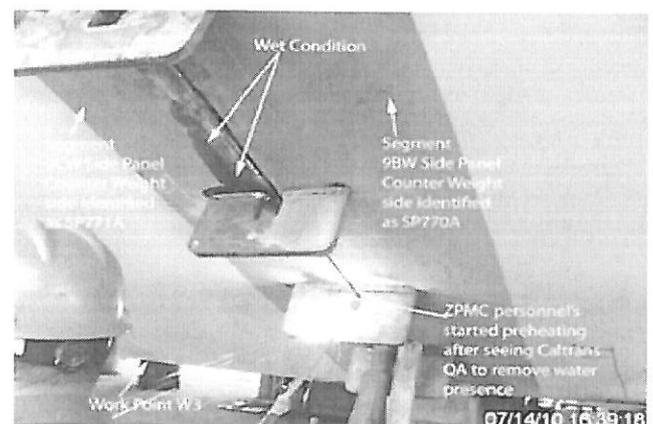
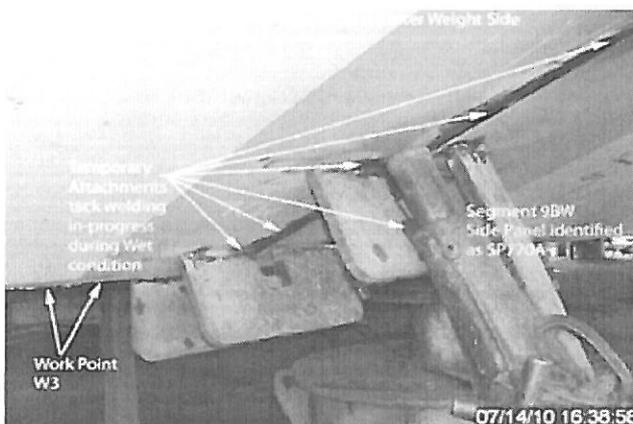
Component: Lift 9W Side Panels

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 08:00 hours, 07/15/10, Verbal

QC Inspector's Name: Zhu Zhong Hai

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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-27222		DATE日期 2010.09.06		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: OBW9 BOTTOM PLATE			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 5948			
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-345F2-X 12mm			
WELDING PROCESS 焊接方法	NA	TYPE OF JOINT 焊缝类型	NA			
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			
SP770A				ACC.		100%MT
SP771A				ACC.		100%MT
BLANK						
EXAMINED BY主探 Xie gen lin Xiegen lin LEVEL - II SIGN 签名 / DATE日期 2010.09.06 质量经理 / QCM				REVIEWED BY 审核 <i>Wang Mei</i> LEVEL-II SIGN / DATE日期 10.09.06 用户CUSTOMER		
签字 SIGN / 日期 DATE				签字 SIGN / 日期 DATE		

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(707) 649-5493

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-000756**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0764**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: 14-Jul-2010**Description of Non-Conformance:**

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- No ZPMC QC personnel were aware of this issue.
- Segment's 9BW and 9CW are located at the OBG Trial Assembly Yard.

Contractor's proposal to correct the problem:

Perform NDT required to verify base metal was not damaged after removal of temporary attachments.

Corrective action taken:

The Contractor has issued an internal NCR in regards to this issue along with the applicable NDT to verify the base metal was not damaged after removal of the temporary attachments.

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

Reviewed By: Wahbeh, Mazen

QA Reviewer