

**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

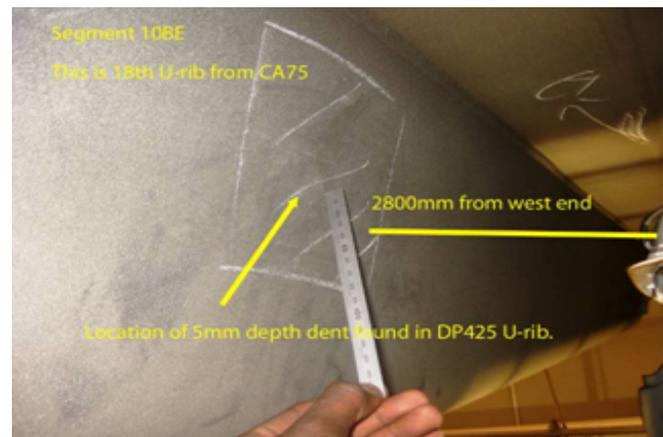
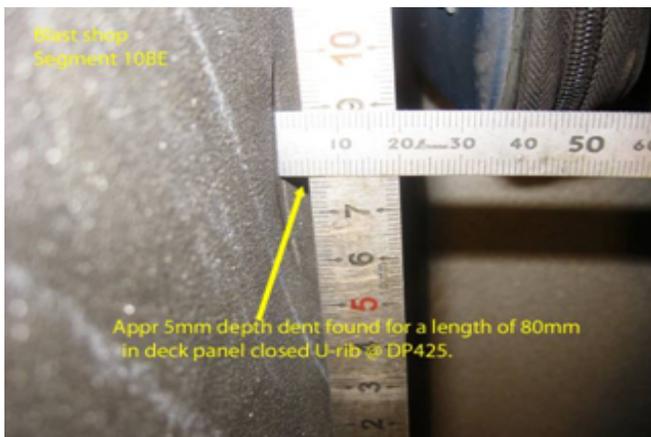
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000820**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Jul-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0782**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Segment 10BE DP425 U-Rib Skin
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b> Bent/Damage Component	

**Reference Description:** Bent/Damage was noted on the Segment 10BE DP425 U-Rib Skin**Description of Non-Conformance:**

During random in-process Visual inspection of OBG Segment 10BE after Abrasive Blasting this Caltrans Quality Assurance Inspector discovered the following issue:

- Damage was observed on the U-Rib Skin.
- A bent mark of approximately 5mm in depth was measured with a 150mm ruler.
- The length of the bent mark is approximately 80mm.
- This deck panel is identified as DP425 (PL445B) and the U-rib is identified as (RS23C).
- This is 18th U-rib from the CA75.
- The location of the distortion is 2800mm away from the west end of the Segment 10BE.
- Prior to this damage, this DP was previously inspected and accepted as documented by green tag #7850.
- The OBG Segment 10BE is located inside the Paint shop#1.

**Applicable reference:**

Caltrans Standard Specifications Section 55-1.04: In handling of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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55-3.09 FINISHED MEMBERS: Finished members shall be true to line and free from twists, bends and open joints.

**Who discovered the problem:** Chandra Sudalaimuthu

**Name of individual from Contractor notified:** Steve Lawton

**Time and method of notification:** 1050, 7-29-10, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 1115, 7-29-10, verbal

**QC Inspector's Name:** Lay 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.

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**Inspected By:** Tsang, Eric

SMR

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**Reviewed By:** Devey, Jim

SMR



**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:** 30-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:** 05.03.06-000777

**Subject:** NCR No. ZPMC-0782

**Reference Description:** Bent/Damage was noted on the Segment 10BE DP425 U-Rib Skin

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:** 10

**Remarks:**

- During random in-process Visual inspection of OBG Segment 10BE after Abrasive Blasting this Caltrans Quality Assurance Inspector discovered the following issue:
- Damage was observed on the U-Rib Skin.
  - A bent mark of approximately 5mm in depth was measured with a 150mm ruler.
  - The length of the bent mark is approximately 80mm.
  - This deck panel is identified as DP425 (PL445B) and the U-rib is identified as (RS23C).
  - This is 18th U-rib from the CA75.
  - The location of the distortion is 2800mm away from the west end of the Segment 10BE.
  - Prior to this damage, this DP was previously inspected and accepted as documented by green tag #7850.
  - The OBG Segment 10BE is located inside the Paint shop#1.

**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-0782

**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:** Siegenthaler, Peter  
Resident Engineer

**Ref:** 05.03.06-000777

**Subject:** NCR No. ZPMC-0782

**Dated:** 04-Nov-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000830 **Rev:** 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC has repaired the damaged area in accordance with the TC RFI and is providing the NDT after to show the repair is acceptable.

ZPMC has repaired the damaged area in accordance with the TC RFI and is providing the NDT after to show the repair is acceptable. In the future great caution will be exercised to prevent this kind of damage. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000830R00;

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### Caltrans' comments:

**Status:** CLO

**Date:** 05-Nov-2010

The proposed resolution is acceptable. This NCR is closed.

**Submitted by:** Woo, Laraine

**Date:** 05-Nov-2010

**Attachment(s):**



PROJECT: S.F.O.B.B.

DATE:2010-11-04

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: OBG NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

(01) LR: No. B-926

(02) NCR-000820(ZPMC-0782)

B787-MT-31383

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

*Lee*

RECEIVED 04 NOV 2010

DATE:

*16:35*

COMPANY:



PHONE NO.

PLAN NUMBER:N/A

#R787-QCP-102



No. B-926

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2010-11-04**

**REGARDING: NCR-000820(ZPMC-0782)**

ZPMC has fixed this problem according to the approved RFI. This issue in punchlist has been verified and removed by department's representative. ZPMC is providing the NDT record to show the acceptance of the affected area. Based on this, please consider closure of this NCR.

**ATTACHMENT:**

NCR-000820(ZPMC-0782)

B787-MT-31383

A handwritten signature in black ink, appearing to be "L. W.", is written over the typed name "L. W." in the signature block.

11/04/2010



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:** 30-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:** 05.03.06-000777

**Subject:** NCR No. ZPMC-0782

**Reference Description:** Bent/Damage was noted on the Segment 10BE DP425 U-Rib Skin

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:** 10

### Remarks:

During random in-process Visual inspection of OBG Segment 10BE after Abrasive Blasting this Caltrans Quality Assurance Inspector discovered the following issue:

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- The length of the bent mark is approximately 80mm.
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- This is 18th U-rib from the CA75.
- The location of the distortion is 2800mm away from the west end of the Segment 10BE.
- Prior to this damage, this DP was previously inspected and accepted as documented by green tag #7850.
- The OBG Segment 10BE is located inside the Paint shop#1.

### 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-0782

**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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 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-000820

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 29-Jul-2010

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

**NCR #:** ZPMC-0782

### Type of problem:

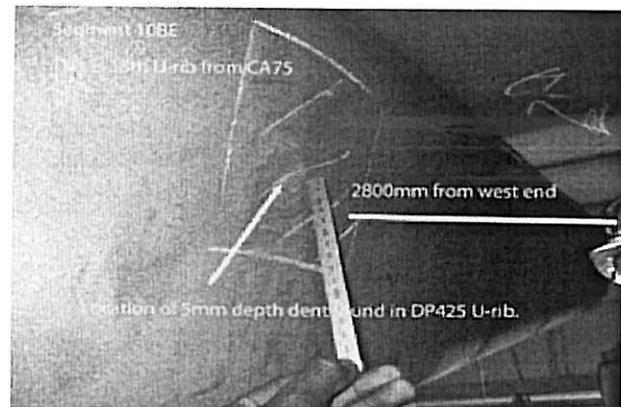
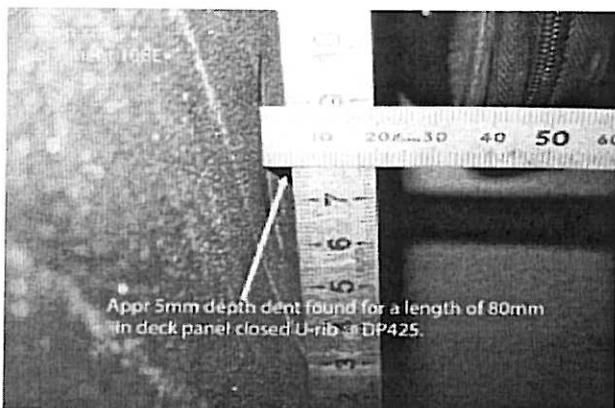
**Welding**  **Concrete**  **Other**   
**Welding**  **Curing**  **Procedural**  **Bridge No:** 34-0006  
**Joint fit-up**  **Coating**  **Other**  **Component:** Segment 10BE DP425 U-Rib Skin  
**Procedural**  **Procedural**  **Description:** Bent/Damage Component

**Reference Description:** Bent/Damage was noted on the Segment 10BE DP425 U-Rib Skin

### Description of Non-Conformance:

During random in-process Visual inspection of OBG Segment 10BE after Abrasive Blasting this Caltrans Quality Assurance Inspector discovered the following issue:

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- The OBG Segment 10BE is located inside the Paint shop#1.



### Applicable reference:

Caltrans Standard Specifications Section 55-1.04: In handling of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected.

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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55-3.09 FINISHED MEMBERS: Finished members shall be true to line and free from twists, bends and open joints.

**Who discovered the problem:** Chandra Sudalaimuthu

**Name of individual from Contractor notified:** Steve Lawton

**Time and method of notification:** 1050, 7-29-10, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 1115, 7-29-10, verbal

**QC Inspector's Name:** Lay 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.

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<b>Inspected By:</b>	Tsang, Eric	SMR
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<b>Reviewed By:</b>	Devey, Jim	SMR
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# REPORT OF MAGNETIC PARTICLE EXAMINATION

## 磁粉检测报告

REPORT NO. 报告编号 B787-MT-31383		DATE 日期 2010.10.28		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: DP425A deck 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 <sup>ST</sup> , 2010			
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 DA-400S	SERIAL NO. 连续编号 17372			
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  12mm			
WELDING PROCESS 焊接方法	SMAW	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			
X23C				ACC.		100%MT
Base metal per B-CWR2047						
BLANK						
EXAMINED BY 主探 Wang Wei <i>Wang Wei</i>			REVIEWED BY 审核 <i>Fu Zhi Qian</i>			
LEVEL - II SIGN 签名 <i>Wang Wei</i> DATE 日期 2010.10.28			LEVEL-II SIGN 1 DATE 日期 2010.10.28			
质量经理 / QCM			用户 CUSTOMER			
签字 SIGN / 日期 DATE			签字 SIGN / 日期 DATE			

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Vallejo, CA 94592-1133  
(707) 649-5453  
(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-000828**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0782**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 29-Jul-2010**Description of Non-Conformance:**

During random in-process Visual inspection of OBG Segment 10BE after Abrasive Blasting this Caltrans Quality Assurance Inspector discovered the following issue:

- Damage was observed on the U-Rib Skin.
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- Prior to this damage, this DP was previously inspected and accepted as documented by green tag #7850.
- The OBG Segment 10BE is located inside the Paint shop#1.

**Contractor's proposal to correct the problem:**

Contractor will repair the damaged area according to TC RFI. Contractor will submit the NDT report to show the repair is acceptable. Contractor will perform the repair work carefully to prevent this kind of damage.

**Corrective action taken:**

Contractor repaired the area according to TC RFI. NDT report is provided, and prove the repaired area is acceptable.

**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:**

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 Wahbeh, Mazen 818-292-0659, who represents the Office of Structural Materials for your project.

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# QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**Inspected By:** Ng,Michael

Quality Assurance Inspector

**Reviewed By:** Wahbeh,Mazen

QA Reviewer