

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-000829

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 30-Aug-2010

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

NCR #: ZPMC-0791

Type of problem:

Welding

Concrete

Other

Welding

Curing

Procedural

Bridge No: 34-0006

Joint fit-up

Coating

Other

Component: CB3002D-018-002 (SP3087A/SP3088A)

Procedural

Procedural

Description:

Reference Description: Heat Straightening without Engineer's Approval on CB3002D-018-002 (CB18)

Description of Non-Conformance:

During Quality Assurance (QA) in-process observations of the fabrication of Crossbeam CB18 Side plates, QA discovered the following issue:

- ZPMC personnel have performed heat straightening excessive distortion on one of the side panels for CB18 without Engineers approval.
- Distortion measured 12mm per 1000mm.
- The weld is identified as CB3002D-018-002.
- The weld is CJP butt joint, joining Side plate (SP3087A) to Side plate (SP3088A).
- The Material thickness is 20 mm.
- This side panel is located in Sub assembly Bay#6.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Caltrans Special Provisions Section 8-3: "For material more than 16 mm, the Contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer".

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Liu Hua Jie

Time and method of notification: 08:00 hours, 08-30-2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:00 hours, 08-31-2010, Email

QC Inspector's Name: Huang min / Mr. Li Jia

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

Inspected By: Devey,Jim SMR

Reviewed By: Wahbeh,Mazen 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: 01-Sep-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: 05.03.06-000786

Subject: NCR No. ZPMC-0791

Reference Description: Heat Straightening without Engineer's Approval on CB3002D-018-002 (CB18)

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: Xbeam **Lift:** 13

Remarks:

- During Quality Assurance (QA) in-process observations of the fabrication of Crossbeam CB18 Side plates, Caltrans QA discovered the following issue:
- ZPMC personnel have performed heat straightening excessive distortion on one of the side panels for CB18 without Engineers approval.
 - Distortion measured 12mm per 1000mm.
 - The weld is identified as CB3002D-018-002.
 - The weld is CJP butt joint, joining Side plate (SP3087A) to Side plate (SP3088A).
 - The Material thickness is 20 mm.
 - This side panel is located in Sub assembly Bay#6.

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-0791

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: 05.03.06-000786

Subject: NCR No. ZPMC-0791

Dated: 14-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000774 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: Measuring determining flatness using 1 meter is not sufficient to determine the if the flatness is out of tolerance. ZPMC requests this NCR be closed.

Measuring determining flatness using 1 meter is not sufficient to determine the if the flatness is out of tolerance, see Item 11.2.2.b from Letter 05.03.01-000419. The tolerance referenced in Section 8-3, Special Provisions (3 over 1000mm) should be used as a ratio when the length of the plate is longer than 1 meter. Based on this clarification and that ZPMC had a valid HSR1 in hand at the time, ZPMC requests this NCR be closed.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000774R00;

Caltrans' comments:

Status: REJ

Date: 27-Sep-2010

The Department's response to the WQCP submittal does not mean a HSR is not required if the distortion measuring the entire member and getting 12mm distortion from end to end when getting the same distortion using a 1 meter straight edge. The Department will make any efforts required to accommodate ZPMC in getting a timely approval to HSRs when required. The Department just needs to be notified.

Submitted by: Woo, Laraine

Attachment(s):

Date: 27-Sep-2010



No. B-875

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-09-09

REGARDING: NCR-000829(ZPMC-0791)

The measurement by utilizing 1000mm template to determine if the out of flatness tolerances on plate have been exceeded as specified in contract was wrong. The special provisions specified, "For material more than 16mm, the contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer". But not specified as 3mm in 1000mm. For ZPMC's understanding, the maximum distortion allowed for heat straightening without engineering approval should be taken by measuring the distortion along with the whole length of material. This criterion was supported by Department's letter 05.03.01-000419. Based on this, please consider withdrawal of this NCR.

ATTACHMENT:

NCR-000829(ZPMC-0791)

A handwritten signature in black ink, appearing to be "Jing W", is written over the attachment information.

9/9/10



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: 01-Sep-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: 05.03.06-000786

Subject: NCR No. ZPMC-0791

Reference Description: Heat Straightening without Engineer's Approval on CB3002D-018-002 (CB18)

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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- 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: Xbeam

Lift: 13

Remarks:

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- This side panel is located in Sub assembly Bay#6.

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-0791

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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DIVISION OF ENGINEERING SERVICESOffice of Structural Materials
Quality Assurance and Source InspectionBay Area Branch
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Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, China**Report No:** NCR-000829**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Aug-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0791**Type of problem:****Welding** **Concrete** **Other** **Welding** **Curing** **Procedural** **Bridge No:** 34-0006**Joint fit-up** **Coating** **Other** **Component:** CB3002D-018-002 (SP3087A/SP3088A)**Procedural** **Procedural** **Description:****Reference Description:** Heat Straightening without Engineer's Approval on CB3002D-018-002 (CB18)**Description of Non-Conformance:**

During Quality Assurance (QA) in-process observations of the fabrication of Crossbeam CB18 Side plates, QA discovered the following issue:

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-The Material thickness is 20 mm.

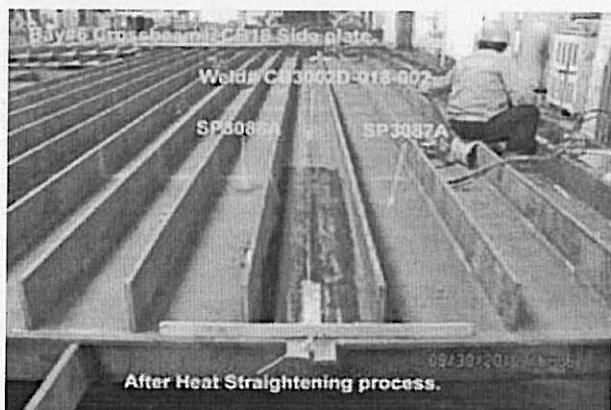
-This side panel is located in Sub assembly Bay#6.

For further information, please see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Caltrans Special Provisions Section 8-3: "For material more than 16 mm, the Contractor shall not heat straighten members more than 3 in 1000 without prior approval of the Engineer".

Who discovered the problem: Surendra Prabhu

Name of individual from Contractor notified: Liu Hua Jie

Time and method of notification: 08:00 hours, 08-30-2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:00 hours, 08-31-2010, Email

QC Inspector's Name: Huang min / Mr. Li Jia

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 Mazen Wahbeh, (818) 292-0659, 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: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000786

Subject: NCR No. ZPMC-0791

Dated: 29-Sep-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000774 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: Refer to the Department's response to ZPMC-0758, a similar situation where the interpretation of the Department's letter was confirmed and the NCR was closed.

Refer to the Department's response to ZPMC-0758, a similar situation where the interpretation of the Department's letter was confirmed and the NCR was closed. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000774R01

Caltrans' comments:

Status: AAP

Date: 07-Oct-2010

Contractor noted that the Department closed a similar issue when it occurred in the past. The Contractor's understanding of the comments under the reply to the original submittal of the WQCP is incorrect regardless if one slipped by the Department in the past. QC is required to submit a HSR for approval when the amount of distortion measured with a 1-m straight edge is greater than the 3mm allowed for plates thicker than 16-mm as stated in Section 8.3 of the Special Provisions. Quality management issue needs to be addressed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 07-Oct-2010

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000786

Subject: NCR No. ZPMC-0791

Dated: 01-Nov-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000774 **Rev:** 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC QC will ensure the cases where distortion in excess of the amount specified in Section 8.3 of the Special Provisions is found the correct repair report is on hand

ZPMC QC will ensure the cases where distortion in excess of the amount specified in Section 8.3 of the Special Provisions is found the correct repair report is on hand. This matter has been documented in a ZPMC internal NCR to ensure all parties at ZPMC are aware of this NCR and to make sure to check the repair documents on hand. As this issue is not widespread on the project ZPMC is confident that these actions are will address the issue, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000774R02

Caltrans' comments:

Status: CLO

Date: 03-Nov-2010

The proposed resolution is acceptable. This NCR is closed.

Submitted by: Woo, Laraine

Date: 03-Nov-2010

Attachment(s):

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, China**Report No:** NCS-000871**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 01-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0791**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: 30-Aug-2010**Description of Non-Conformance:**

During Quality Assurance (QA) in-process observations of the fabrication of Crossbeam CB18 Side plates, QA discovered the following issue:

- ZPMC personnel have performed heat straightening excessive distortion on one of the side panels for CB18 without Engineers approval.
- Distortion measured 12mm per 1000mm.
- The weld is identified as CB3002D-018-002.
- The weld is CJP butt joint, joining Side plate (SP3087A) to Side plate (SP3088A).
- The Material thickness is 20 mm.
- This side panel is located in Sub assembly Bay#6.

Contractor's proposal to correct the problem:

Contractor will repair the location with the excess amount of distortion. Contractor will issue an internal NCR to the workers to avoid the similar future occurrence.

Corrective action taken:

Contractor repaired the location with the excess amount of distortion. Contractor issued an internal NCR to the workers to avoid the similar future occurrence.

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: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer