

**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, Shasnghai, P.R. China

**Report No:** NCR-000855

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

**Date:** 04-Oct-2010

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

**NCR #:** ZPMC-0817

### 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> 119m Fit Lug
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** East and North Shaft at 119m: Skin E - Fit Lug removal without Engineer's approval

### Description of Non-Conformance:

During the Quality Assurance Inspection of dimension measurements at tower trial assembly area, heavy dock, this Quality Assurance Inspector (QA) discovered the following issues:

-Approx. 55 mm length, 25 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without Engineer's approval.

-The fit lug found in East Tower, Lift 4- 119m top diaphragm.

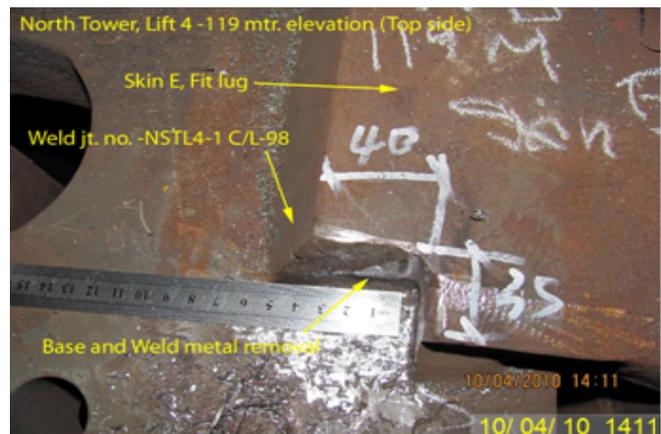
-The weld joint no. of the fit lug weld found to be ESTL4-2 C/L-115.

-Approx. 50 mm length, 35 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without engineer's approval.

-The fit lug found in North Tower, Lift 4- 119m top diaphragm.

-The weld joint no. of the fit lug weld found to be NSTL4-1 C/L-98.

For further information, please see the attached pictures below.



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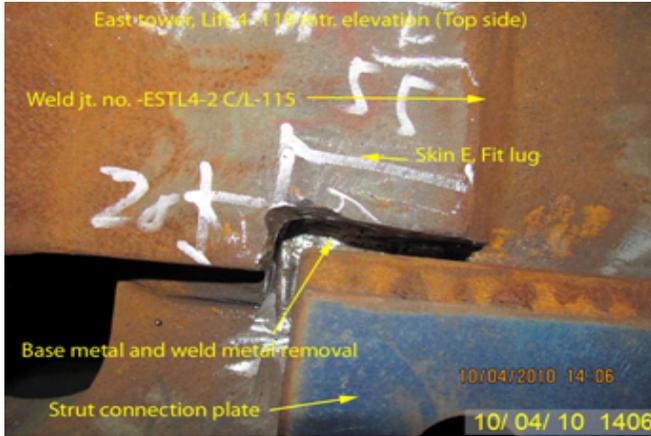
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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Applicable reference:**

AWS D 1.5 Section 3.7.4 – “Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies.”

AWS D1.5 Section 3.7.5- “The Engineer shall be notified before improperly fitted and welded members are cut apart.”

**Who discovered the problem:** Baskar Govindarajan

**Name of individual from Contractor notified:** Mr. Kim

**Time and method of notification:** 1425 hours, 10/04/10, Verbal

**Name of Caltrans Engineer notified:** Jim Reid

**Time and method of notification:** 1330 hours, 10/05/10, Verbal

**QC Inspector's Name:** Mr. Zhu Feng

**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 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Ng,Michael

QA Inspector

**Reviewed By:** Devey,Jim

SMR



**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**

<b>To:</b>	AMERICAN BRIDGE/FLUOR, A JV 375 BURMA ROAD OAKLAND CA 95607	<b>Date:</b>	06-Oct-2010
<b>Dear:</b>	Mr. Charles Kanapicki	<b>Contract No:</b>	04-0120F4 04-SF-80-13.2 / 13.9
<b>Attention:</b>	Mr. Thomas Nilsson Project/Fabrication Manager	<b>Job Name:</b>	SAS Superstructure
<b>Subject:</b>	NCR No. ZPMC-0817	<b>Document No:</b>	05.03.06-000812

**Reference Description:** East and North Shaft at 119m: Skin E - Fit Lug removal without Engineer's approval

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:** Tower **Lift:** 04

**Remarks:**

During the Quality Assurance Inspection of dimension measurements at tower trial assembly area, heavy dock , this Quality Assurance Inspector (QA) discovered the following issues:

- Approx. 55 mm length, 25 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without Engineer's approval.
- The fit lug found in East Tower, Lift 4- 119m top diaphragm.
- The weld joint no. of the fit lug weld found to be ESTL4-2 C/L-115.
- Approx. 50 mm length, 35 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without engineer's approval.
- The fit lug found in North Tower, Lift 4- 119m top diaphragm.
- The weld joint no. of the fit lug weld found to be NSTL4-1 C/L-98.

**Action Required and/or Action Taken:**

Propose resolutions for the identified non-conformance items and document that the various deficiencies have been brought in compliance with contract requirements. Also propose a resolution that addresses the apparent failure of Quality Control to identify the non-conformance with the appropriate Welding Procedure Specification (WPS). Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

**Transmitted by:** Sean Eagen Transportation Engineer  
**Attachments:** ZPMC-0817

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# NCT

( *Continued Page 2 of 2* )

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**cc:** Rick Morrow, Peter Siegenthaler, Brian Boal, Mark Woods, 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:** 05.03.06-000812

**Subject:** NCR No. ZPMC-0817

**Dated:** 23-Nov-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000841 Rev: 00

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**Contractor's Proposed Resolution:**

**Reference Resolution:**

ZPMC-0817

Please see ZPMC's comments

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000841R00;

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**Caltrans' comments:**

**Status:** AAP

**Date:** 25-Nov-2010

This proposed resolution is accepted with action pending. The retrofit work per TC-RFI 0166 for the fit lug on the North Shaft shall be completed and related NDT reports for Weld No. NSTL4-1C/L-98 submitted and reviewed.

**Submitted by:** Eagen, Sean

**Date:** 25-Nov-2010

**Attachment(s):**



No. T-178

## LETTER OF RESPONSE

**TO:** American Bridge/Flour JV

**DATE:** 2010-11-23

**REGARDING:** NCR-000853(ZPMC-0815),  
NCR-000855(ZPMC-0817),  
NCR-000856(ZPMC-0818)

ZPMC received NCR-000853(ZPMC-0815), NCR-000855(ZPMC-0817), NCR-000856(ZPMC-0818), it mentioned that CT inspectors found Skin E fit lugs have been cut without Engineer's approval.

When CT inspector found this problem, ZPMC took positive action and performed NDT work, finally these fit lug issue have been resolved and rechecked by CT site inspector. ZPMC also realized this issue and emphasized to related people it should strictly perform according to approved procedure and criteria during work, once issue appears, it's required to report to site QC immediately, and not permit to treat it privately.

Here attached related NDT reports and inspection notification, hope CT take a review and close these NCRs.

**ATTACHMENT:**

NCR-000853(ZPMC-0815)

NCR-000855(ZPMC-0817)

NCR-000856(ZPMC-0818)

T787-MT-11471

Notification: 07446/07448

*Zhang Tao*  
*2010.11.23*



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-11471      DATE日期 2010.11.21      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: ESTL4-2C/L WSTL4-2C/L SSSL3-1C/L NSTL4-3C/L THE FOURTH LIFTING TOWER		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 17371
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-HPS-485T2-Z 75/40mm
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			
SSTL4-1C/L-41	.			ACC.		AFTER GRINDING
NSTL4-3C/L-41				ACC.		AFTER GRINDING
ESTL4-2C/L-118				ACC.		AFTER GRINDING
ESTL4-2C/L-49				ACC.		AFTER GRINDING
WSTL4-2C/L-118				ACC.		AFTER GRINDING
WSTL4-2C/L-49				ACC.		AFTER GRINDING

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EXAMINED BY主探 Fu Zhiqiang <i>Fuzhiqiang</i>	REVIEWED BY审核 <i>Wangmei</i>
LEVEL - II SIGN 签名 / DATE日期 2010.11.21	LEVEL-II SIGN / DATE日期 2010.11.21
质量经理 / QCM <i>Wangmei</i> 2010.11.21	用户CUSTOMER
签字 SIGN / 日期 DATE	签字 SIGN / 日期 DATE

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 File #: 69.25B

**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

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

**Report No:** NCR-000853

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

**Date:** 29-Sep-2010

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

**NCR #:** ZPMC-0815

**Type of problem:**

**Welding**  **Concrete**  **Other**

**Welding**  **Curing**  **Procedural**

**Bridge No:** 34-0006

**Joint fit-up**  **Coating**  **Other**

**Component:** Skin E, Fit lug- 119m. elevation

**Procedural**  **Procedural**  **Description:**

**Reference Description:** Skin E, Fit lug-119m have been cut without Engineer's approval

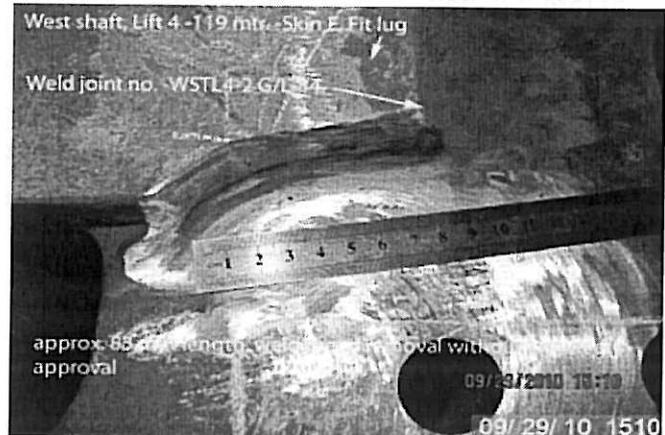
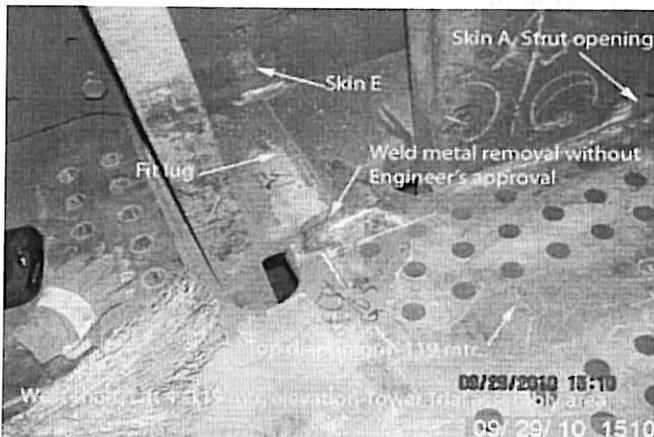
**Description of Non-Conformance:**

During the Quality Assurance Dimensional verification measurements at Tower Trial assembly Heavy Dock area, the following discovered:

- Approximately 85mm in length, (25mm wide) of Fit Lug that was welded to the top diaphragm. Skin Plate E was removed without engineer approval.

For further information, please see the attached pictures below.

- The Fit lug found in top diaphragm, skin E, Lift 4- 119 mtr, West Tower,
- The Weld removed has the following Weld ID: WSTL4-2 C/L-86.



**Applicable reference:**

AWS D1.5 Section 3.7.5- "The Engineer shall be notified before improperly fitted and welded members are cut apart."

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Who discovered the problem:** Baskar Govindarajan  
**Name of individual from Contractor notified:** Mr. Bi De wei  
**Time and method of notification:** 15.25 hours, 09/29/10, Verbal  
**Name of Caltrans Engineer notified:** Sean Eagen  
**Time and method of notification:** 1030Hours, 10/01/10, Verbal  
**QC Inspector's Name:** Mr. Zhao Chen Sun  
**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.

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<b>Inspected By:</b> Ng,Michael	QA Inspector
<b>Reviewed By:</b> Devey,Jim	SMR

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File #: 69.25B

## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

**Location:** Changxing Island, Shasnghai, P.R. China

**Report No:** NCR-000855

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

**Date:** 04-Oct-2010

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

**NCR #:** ZPMC-0817

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural

Joint fit-up  Coating  Other

Procedural  Procedural  Description:

**Bridge No:** 34-0006

**Component:** 119m Fit Lug

**Reference Description:** East and North Shaft at 119m: Skin E - Fit Lug removal without Engineer's approval

### Description of Non-Conformance:

During the Quality Assurance Inspection of dimension measurements at tower trial assembly area, heavy dock, this Quality Assurance Inspector (QA) discovered the following issues:

-Approx. 55 mm length, 25 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without Engineer's approval.

-The fit lug found in East Tower, Lift 4- 119m top diaphragm.

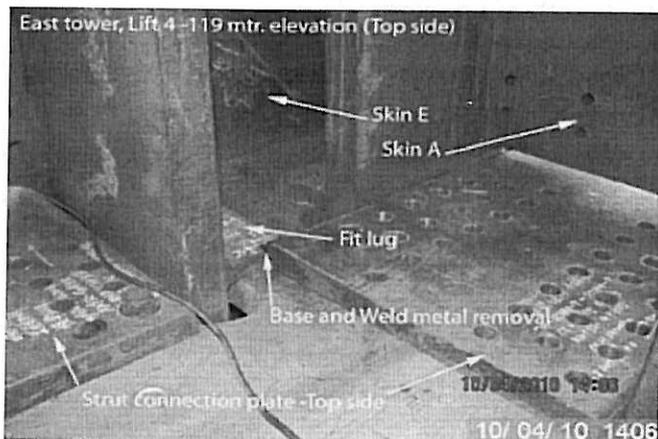
-The weld joint no. of the fit lug weld found to be ESTL4-2 C/L-115.

-Approx. 50 mm length, 35 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without engineer's approval.

-The fit lug found in North Tower, Lift 4- 119m top diaphragm.

-The weld joint no. of the fit lug weld found to be NSTL4-1 C/L-98.

For further information, please see the attached pictures below.



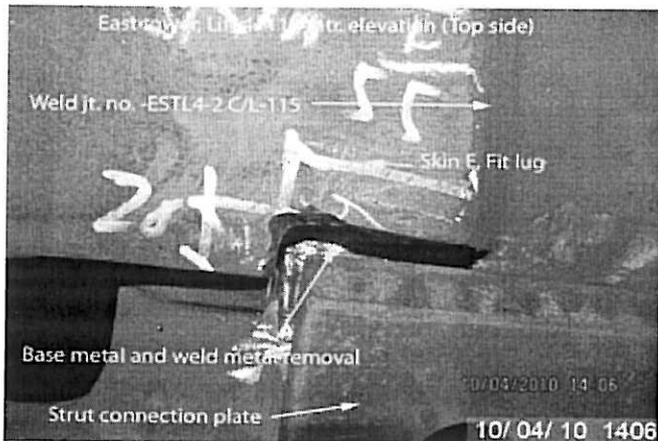
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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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(Continued Page 2 of 2)

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### Applicable reference:

AWS D 1.5 Section 3.7.4 – “Prior approval of the Engineer shall be obtained for repairs to base metal (other than those required by 3.2), repair of major or delayed cracks, repairs to ESW and EGW welds with internal defects, or for a revised design to compensate for deficiencies.”

AWS D1.5 Section 3.7.5- “The Engineer shall be notified before improperly fitted and welded members are cut apart.”

**Who discovered the problem:** Baskar Govindarajan

**Name of individual from Contractor notified:** Mr. Kim

**Time and method of notification:** 1425 hours, 10/04/10, Verbal

**Name of Caltrans Engineer notified:** Jim Reid

**Time and method of notification:** 1330 hours, 10/05/10, Verbal

**QC Inspector's Name:** Mr. Zhu Feng

**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 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Ng, Michael

QA Inspector

**Reviewed By:** Devey, Jim

SMR

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 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-000856

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

**Date:** 04-Oct-2010

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

**NCR #:** ZPMC-0818

### Type of problem:

Welding  Concrete  Other

Welding  Curing  Procedural  **Bridge No:** 34-0006

Joint fit-up  Coating  Other  **Component:** Fit Lug- West Tower

Procedural  Procedural  **Description:**

**Reference Description:** Fit Lug Removal without Engineer's approval located at West Shaft (109m) and South Shaft (119m)

### Description of Non-Conformance:

During the Quality Assurance Inspection of Dimension measurements at Tower trial assembly area, Heavy Dock, this Quality Assurance Inspector (QA) discovered the following issue:

- Approx. 50mm length, weld metal removal observed in Skin E, fit lug weld, without Engineer's approval.
- The fit lug found in West Tower, Lift 3- 109m top diaphragm.
- The weld joint no. of the fit lug weld found to be WSTL3-4 I / K-128.

- Approx. 55mm length, weld metal removal observed in Skin E, fit lug weld, without Engineer's approval.
- The fit lug found in South Tower, Lift 4- 119m top diaphragm.
- The weld joint no. of the fit lug weld found to be SSTL4-1 C/L-98.

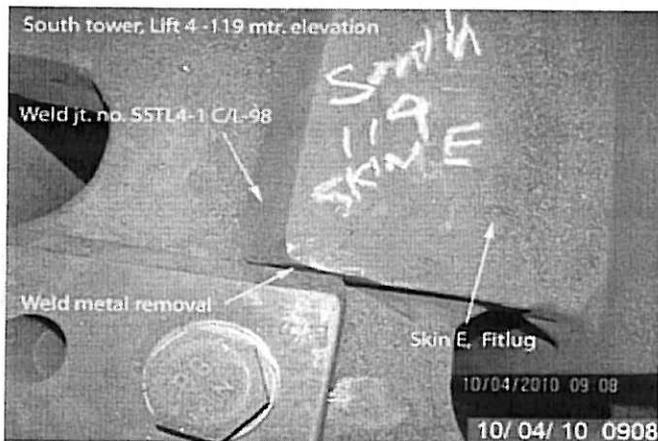
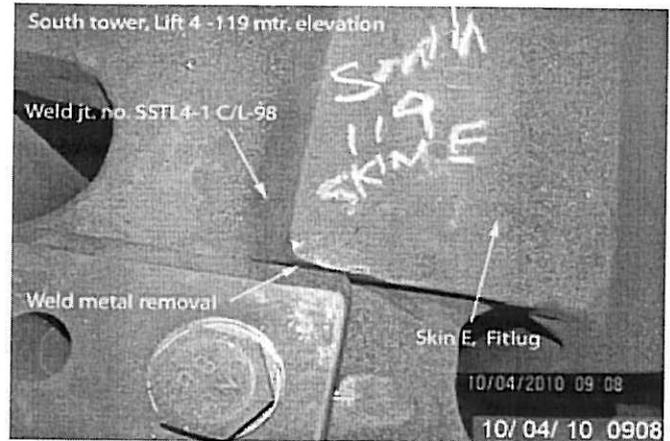
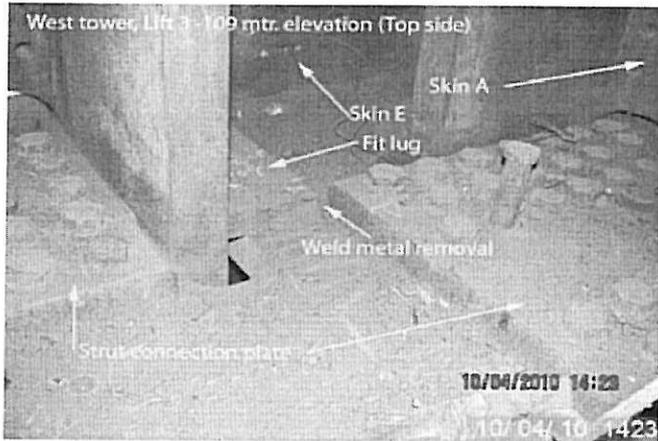
For further information, please see the attached pictures below.

### Applicable reference:

AWS D1.5 Section 3.7.5- "The Engineer shall be notified before improperly fitted and welded members are cut apart."

# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



**Who discovered the problem:** Baskar Govindarajan  
**Name of individual from Contractor notified:** Mr. Kim  
**Time and method of notification:** 1425 hours, 10/04/10, Verbal  
**Name of Caltrans Engineer notified:** Jim Reid  
**Time and method of notification:** 1330 Hours, 10/5/10, Verbal  
**QC Inspector's Name:** Mr. Zhu Feng  
**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 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b> Ng, Michael	QA Inspector
<b>Reviewed By:</b> Devey, Jim	SMR

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CT客户检验通知单

NDT Inspection Notification Sheet

文件编号: 07448 Document No.		申请递交时间: Submit time: 2010-11-22 09:30		CT 计划赴检时间 CT Estimated Inspection Time	
序号 No	检验内容 Inspection	待检验构件 Inspection part	产品分类 Section	检验场地 Inspection Place	计划检验时间 Inspection Time
1	MT FOR WELDS	SSTL4-1C/L-41 NSTL4-3C/L-41 (FOR CLOSE ZPMC-0817)	TOWER LIFT 4 119M FIT LUG	TOWER JETTY	2010-11-22 10:00 FOR GREEN TAG
2					

1、见证通知发出后，现场等待时间通常不超过30分钟；如有变动，现场通知。

1、When ZPMC give this table to AB/F, ZPMC will do the inspection in 30

2、ZPMC根据自己的检验控制点 (HOLD POINT) 进行日常检验。

2、ZPMC will do any inspection according to the HOLD POINT.

3、此单为临时试用单，仅适用于完工焊缝的NDT检验见证通知。

3、This table is a temporary one, just for final NDT inspection notification.

4、QC检验完成后，QA是否需要复验，由QA自行决定，QC不再另行通知。复验等待时间通常为1小时。

4、When ZPMC QC finish NDT inspection, Caltrans QA can decide if they want to retest it. ZPMC QC will not inform Caltrans again. The waiting time is 1 hour ordinarily.

5、AB/F预约CT后会在同班时间内通知ZPMC具体CT现场报验时间

5、AB/F to notify ZPMC in the same shift that CT will attend and at what time.

6、加州现场检验完成后会告知AB/F检验结果，AB/F会在1小时内告知ZPMC加州复检结果。

6、CT to notify AB/F that the work has been completed and the result. AB/ to notify ZPMC that the work has been completed and the result within 1 hour.

ZPMC 联系人:  
Requested By:

Zhang Jindao

AB/F 签收人:  
AB/F Receiver:

Annie Zhang

签收时间:  
Time:

11/22/2010 9:42

签收时间:  
Time:

ZPMC		NDT客户检验通知单 NDT Inspection Notification Sheet			文件编号: 07446 Document No.
序号 No	检验内容 Inspection	待检验构件 Inspection part	产品分类 Section	检验场地 Inspection Place	申请递交时间: Submit time: 2010-11-21 15:15
1	MT FOR WELDS	WSD1-FASA4-2A/E-45~48, 55, 56 WSD1-FESA4-4A/F-24~27, 32~35	TOWER LIFT 4, PADEYE OF SKIN A&E	TOWER JETTY	CT 计划赴检时间 CT Estimated Inspection Time
2	MT FOR WELDS	ESTL4-2C/L-118, 49 WSTL4-2C/L-118, 49 (FOR CLOSE NCR ZPMC/817)	TOWER LIFT 4, 119M FIT LUG	TOWER JETTY	

ZPMC 联系人: *Qian*  
Requested Rv:

AB/F 签收人: *Annie Zhang*  
AB/F Receiver:

签收时间: *11/21/2010 15:24*  
Time:

签收时间:  
Time:

- 1、见证通知发出后，现场等待时间通常不超过30分钟；如有变动，现场通知。
- 1、When ZPMC give this table to AB/F, Zpmc will do the inspection in 30 minutes. If we
- 2、ZPMC根据自己的检验控制点 (HOLD POINT) 进行日常检验。
- 2、ZPMC will do any inspection according to the HOLD POINT.
- 3、此单为临时试用单，仅适用于完工焊缝的NDT检验见证通知。
- 3、This table is a temporary one, just for final NDT inspection notification.
- 4、QC检验完成后，QA是否需要复验，由QA自行决定，QC不再另行通知。复验等待时间通常为1小时。
- 4、QC inspection completed, QA whether need retest, by QA decision, QC no longer notify. Retest waiting time is 1 hour ordinarily.
- 4、When ZPMC QC finish NDT inspection, Caltrans QA can decide if they want to retest it. ZPMC QC will not inform Caltrans again. The waiting time is 1 hour ordinarily.
- 5、AB/F预约CT后会在同班时间内通知ZPMC具体CT现场报验时间
- 5、AB/F to notify ZPMC in the same shift that CT will attend and at what time.
- 6、加州现场检验完成后会告知AB/F检验结果，AB/F会在1小时内告知ZPMC加州复检结果。
- 6、CT to notify AB/F that the work has been completed and the result. AB/ to notify ZPMC that the work has been completed and the result within 1 hour.

## NCR PROPOSED RESOLUTION

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

**Attention:** Siegenthaler, Peter  
Resident Engineer

**Ref:** 05.03.06-000812

**Subject:** NCR No. ZPMC-0817

**Dated:** 11-Jan-2011

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000841 Rev: 01

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**Contractor's Proposed Resolution:**

**Reference Resolution:** Note that NSTL4-3C/L-98 was incorrectly identified in NCRF ZPMC-0817 as NSTL4-1C/L-98, ZPMC is submitting NDT for the correct weld ID.

"Per the Department's comments, attached is the NDT for NSTL4-3C/L-98 and SSSL4-1C/L-98. Note that NSTL4-3C/L-98 was incorrectly identified in NCRF ZPMC-0817 as NSTL4-1C/L-98, ZPMC is submitting NDT for the correct weld ID. Based on this and previously submitted NDT, ZPMC requests closure of this NCR."

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000841R01;

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**Caltrans' comments:**

**Status:** CLO

**Date:** 11-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0817 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 11-Jan-2011



No. T-181

## LETTER OF RESPONSE

**TO: American Bridge/Flour JV**

**DATE: 2010-12-08**

**REGARDING: NCR-000855(ZPMC-0817), NCR-000856(ZPMC-0818)**

ZPMC received NCR-000855(ZPMC-0817), NCR-000856(ZPMC-0818), it mentioned that CT inspectors found Skin E fit lugs have been cut without Engineer's approval.

According to the comments of ABF-NPR-000841 and ABF-NPR-000832, here, providing related NDT reports, hope CT could take review and close these NCRs.

**ATTACHMENT:**

**ABF-NPR-000841**

**ABF-NPR-000832**

**T787-MT-12297**

*Zhang Wadi*  
*2010.12.08*



AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

375 Burma Road  
Oakland, CA 94607  
Telephone (510) 808-4600 Fax (510) 808-4601

### NCR PROPOSED RESOLUTION

To: California Department of Transportation  
333 Burma Road  
Oakland, CA 94607  
Attention: Siegenthaler, Peter  
Resident Engineer  
Ref: 05.03.06-000813  
Subject: NCR No. ZPMC-0818

Dated: 23-Nov-2010  
Contract No.: 04-0120F4  
04-SF-80-13.2/13.9  
Job Name: Self-Anchored Suspension Bridge  
Document No: ABF-NPR-000832 Rev: 1

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**Contractor's Proposed Resolution:****Reference Resolution:**

ZPMC-0818

Please see ZPMC's comments

Submitted By: Ishibashi, Joshua  
Attachment(s): ABF-NPR-000832R01;

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Status: AAP

**Caltrans' comments:**

Date: 25-Nov-2010

This proposed resolution is accepted with action pending. The provided NDT reports do not address the the Lift 4 portion of this NCR. Please provide applicable NDT reports for Weld No. SSTL4-1C/L-98 noted in the NCR.

Submitted By: Eagan, Sean Date: 25-Nov-2010  
Attachment(s): ABF-NPR-000832





AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

375 Burma Road  
Oakland, CA 94607  
Telephone (510) 808-4600 Fax (510) 808-4601

## NCR PROPOSED RESOLUTION

To: California Department of Transportation  
333 Burma Road  
Oakland, CA 94607  
Attention: Siegenthaler, Peter  
Resident Engineer  
Ref: 05.03.06-000812  
Subject: NCR No. ZPMC-0817

Dated: 23-Nov-2010  
Contract No.: 04-0120F4  
04-SF-80-13.2/13.9  
Job Name: Self-Anchored Suspension Bridge  
Document No: ABF-NPR-000841 Rev: 0

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### Contractor's Proposed Resolution:

#### Reference Resolution:

ZPMC-0817

Please see ZPMC's comments

Submitted By: Ishibashi, Joshua

Attachment(s): ABF-NPR-000841R00;

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Status: AAP

Date: 25-Nov-2010

### Caltrans' comments:

This proposed resolution is accepted with action pending. The retrofit work per TC-RFI 0166 for the fit lug on the North Shaft shall be completed and related NDT reports for Weld No. NSTL4-1C/L-98 submitted and reviewed.

Submitted By: Eagan, Sean

Date: 25-Nov-2010

Attachment(s): ABF-NPR-000841





**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


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**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION**


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**Location:** Changxing Island, Shasnghai, P.R. China**Report No:** NCS-000880**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0817**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:** 04-Oct-2010**Description of Non-Conformance:**

During the Quality Assurance Inspection of dimension measurements at tower trial assembly area, heavy dock, this Quality Assurance Inspector (QA) discovered the following issues:

-Approx. 55 mm length, 25 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without Engineer's approval.

-The fit lug found in East Tower, Lift 4- 119m top diaphragm.

-The weld joint no. of the fit lug weld found to be ESTL4-2 C/L-115.

-Approx. 50 mm length, 35 mm width, weld metal and base metal removal observed in Skin E, fit lug weld without engineer's approval.

-The fit lug found in North Tower, Lift 4- 119m top diaphragm.

-The weld joint no. of the fit lug weld found to be NSTL4-1 C/L-98.

For further information, please see the attached pictures below.

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

Contractor will grind the cut corner as per the Designer's requirements. ie. tapering the cut corner and perform MT. Contractor will provide the NDT report to prove the welds are acceptable. Contractor will discuss with the foreman about the issue, and instruct the foreman/ QC notification prior to Engineer is required to any retrofit work being performed.

**Corrective action taken:**

Contractor ground the cut corner as per Designer's request. The forman/QC was warned and instructed that the Engineer has to be notified, and approval has to be sought prior to any retrofit work.

**Did corrective action require Engineer's approval?**

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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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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**Inspected By:**    Ng,Michael

Quality Assurance Inspector

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**Reviewed By:**    Devey,Jim

QA Reviewer