

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-000891**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0853**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Bikepath BK004A-025
Procedural	Procedural	Description: Reduced Plate Thickness	

Reference Description: QA found the thickness of a plate is reduced in the bikepath after ZPMC had tested and accepted the weld visually

Description of Non-Conformance:

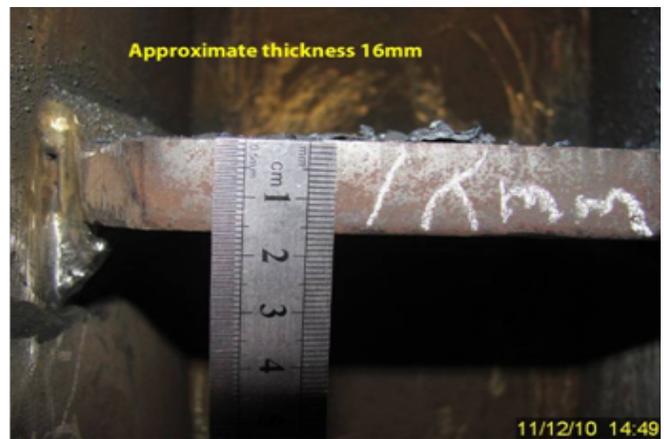
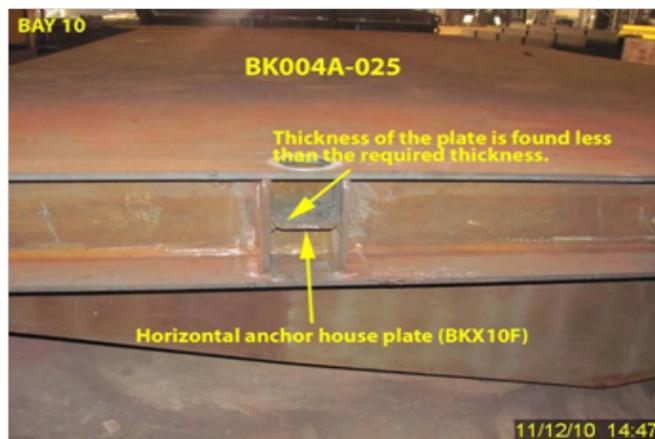
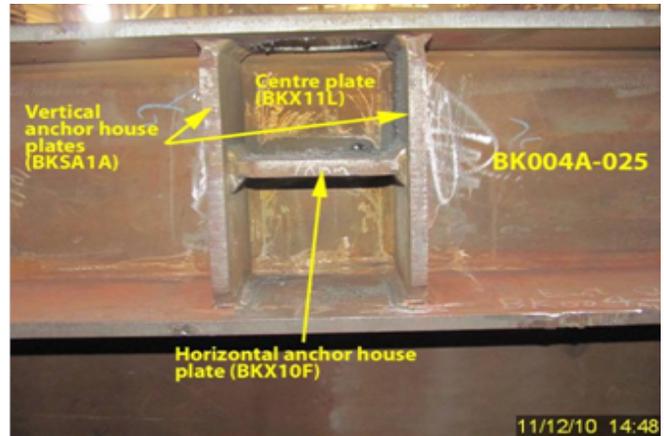
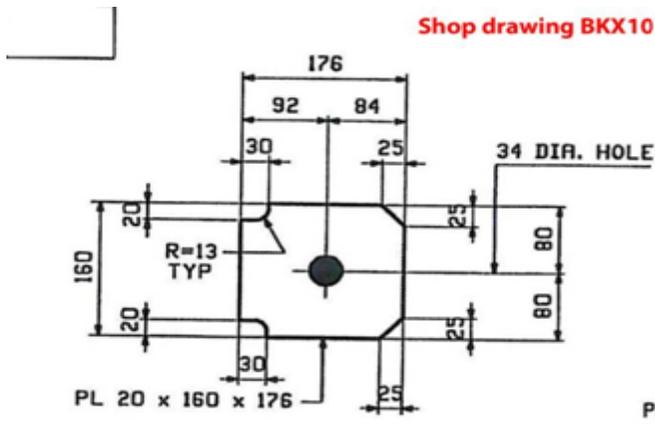
During the Quality Assurance (QA) Visual Testing (VT) verification of welds located on the vertical and horizontal anchor house plate of OBG bike path BK004A-025, this QA Inspector discovered the following issues:

- The thickness of an already welded horizontal anchor house plate (BKX10F) is found 4mm reduced uniformly in comparison to the approved shop drawings.
- As per shop drawing the required nominal thickness of the horizontal anchor house plate (BKX10F) is 20mm.
- The actual thickness of the BKX10F plate welded was found approximately 16mm.
- The material grade for the 16mm horizontal plate is unknown.
- This plate is located at east side of stringer plate 9C.
- The horizontal anchor house plate (BKX10F) joining the vertical anchor house plates and centre plate (BKX11L).
- The weld numbers are identified as; BK004A4-025-080, 100, 082, 101 and BK004A4-025-083, 102 respectively.
- The member is located in Bay 10.

The Notice of Witness Inspection Number (NWIT) is 07326 for visual inspection. These areas have been previously tested and accepted by ZPMC Quality Control (QC) personnel.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Shop Drawing: BKC10 and BK4H

AWS D1.5-02 Section 6.5.1 "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval."

AWS D1.5-02 Section 6.6.2 "The Contractor shall be responsible for visual inspection and NDT described in 6.7 and necessary correction of all deficiencies in materials and workmanship in conformance with the requirements of Clause 3 and 6.26 and as specified elsewhere in the contract documents."

Who discovered the problem: Umesh D. Gaikwad

Name of individual from Contractor notified: Liu Cheng

Time and method of notification: 1630 hours, 11-12-10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0730 hours, 11-13-10, Email

QC Inspector's Name: Li Jun

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	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: 15-Nov-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-0853

Job Name: SAS Superstructure
Document No: 05.03.06-000848

Reference Description: QA found the thickness of a plate is reduced in the bikepath after ZPMC had tested and accepted the weld visually

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: Bike Path **Lift:**

Remarks:

During the Quality Assurance (QA) Visual Testing (VT) verification of welds located on the vertical and horizontal anchor house plate of OBG bike path BK004A-025, Caltrans QA Inspector discovered the following issues:

- The thickness of an already welded horizontal anchor house plate (BKX10F) is found 4mm reduced uniformly in comparison to the approved shop drawings.
- As per shop drawing the required nominal thickness of the horizontal anchor house plate (BKX10F) is 20mm.
- The actual thickness of the BKX10F plate welded was found approximately 16mm.
- The material grade for the 16mm horizontal plate is unknown.
- This plate is located at east side of stringer plate 9C.
- The horizontal anchor house plate (BKX10F) joining the vertical anchor house plates and center plate (BKX11L).
- The weld numbers are identified as; BK004A4-025-080, 100, 082, 101 and BK004A4-025-083, 102 respectively.
- The member is located in Bay 10.

The Notice of Witness Inspection Number (NWIT) is 07326 for visual inspection. These areas have been previously tested and accepted by ZPMC Quality Control (QC) personnel.

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-0853

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000848

Subject: NCR No. ZPMC-0853

Dated: 24-Nov-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000843 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The plate with incorrect thickness has been replaced with a plate of the correct thickness. ZPMC has issued an internal NCR to document this incident.

The plate with incorrect thickness has been replaced with a plate of the correct thickness. ZPMC has issued an internal NCR to document this incident. This has been verified by the Department's inspectors see the attached notification for the date verified. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000843R00;

Caltrans' comments:

Status: CLO

Date: 29-Nov-2010

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

Submitted by: Woo, Laraine

Date: 29-Nov-2010

Attachment(s):



No. B-932

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-11-24

REGARDING: NCR-000891(ZPMC-0853)

ZPMC acknowledged this problem and has released an internal NCR. This unapproved plate has been replaced with correct thickness. According to special provision, this area is not required to perform MT or UT testing. So ZPMC submitted an VT inspection request to QA inspector. This request was accepted and the inspection was completed after then. ZPMC is providing the NWIT and the notification daily document tracking report for engineer for review. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000891(ZPMC-0853)

NWIT 7376

NOI TRACKING SHEET 11/16/10

A handwritten signature in black ink, appearing to be 'Jing W'.

11/24/2010



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: 15-Nov-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: 05.03.06-000848
Subject: NCR No. ZPMC-0853

Reference Description: QA found the thickness of a plate is reduced in the bikepath after ZPMC had tested and accepted the weld visually

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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- Non-Conformance Resolved.

Material Location: Bike Path

Lift:

Remarks:

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-As per shop drawing the required nominal thickness of the horizontal anchor house plate (BKX10F) is 20mm.

-The actual thickness of the BKX10F plate welded was found approximately 16mm.

-The material grade for the 16mm horizontal plate is unknown.

-This plate is located at east side of stringer plate 9C.

-The horizontal anchor house plate (BKX10F) joining the vertical anchor house plates and center plate (BKX11L).

-The weld numbers are identified as; BK004A4-025-080, 100, 082, 101 and BK004A4-025-083, 102 respectively.

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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-0853

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

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 DIVISION OF ENGINEERING SERVICES
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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-000891

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 12-Nov-2010

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

NCR #: ZPMC-0853

Type of problem:

Welding Concrete Other

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

Joint fit-up Coating Other **Component:** Bikepath BK004A-025

Procedural Procedural **Description:** Reduced Plate Thickness

Reference Description: QA found the thickness of a plate is reduced in the bikepath after ZPMC had tested and accepted the weld visually

Description of Non-Conformance:

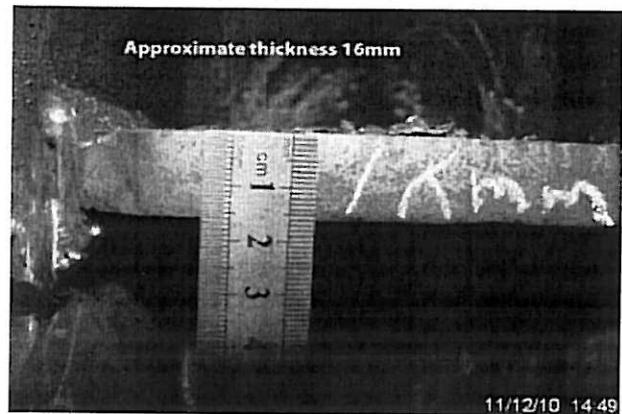
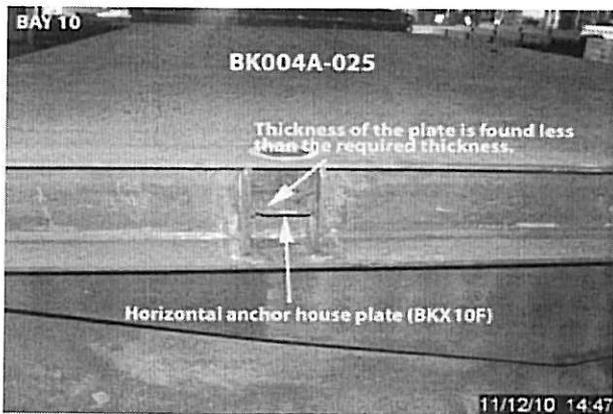
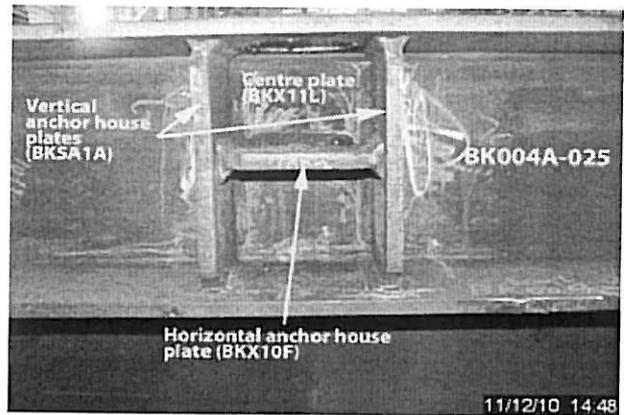
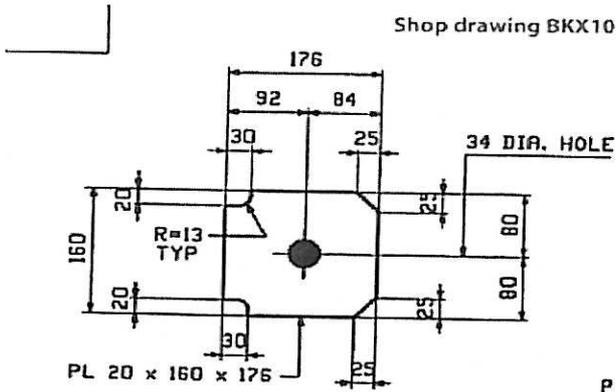
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- As per shop drawing the required nominal thickness of the horizontal anchor house plate (BKX10F) is 20mm.
- The actual thickness of the BKX10F plate welded was found approximately 16mm.
- The material grade for the 16mm horizontal plate is unknown.
- This plate is located at east side of stringer plate 9C.
- The horizontal anchor house plate (BKX10F) joining the vertical anchor house plates and centre plate (BKX11L).
- The weld numbers are identified as; BK004A4-025-080, 100, 082, 101 and BK004A4-025-083, 102 respectively.
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Shop Drawing: BKC10 and BK4H

AWS D1.5-02 Section 6.5.1 "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval."

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Who discovered the problem: Umesh D. Gaikwad

Name of individual from Contractor notified: Liu Cheng

Time and method of notification: 1630 hours, 11-12-10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 0730 hours, 11-13-10, Email

QC Inspector's Name: Li Jun

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
Reviewed By:	Wahbeh, Mazen	SMR



NDT客户检验通知单
NDT Inspection Notification Sheet

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	CT 计划赴检时间 CT Estimated Inspection Time
1	VT FOR WELDS	BK004A4-025-080,082,083,100,101,102	OBG	BAY 10	2010-11-16 13:00 FOR GREEN TAG	

申请递交时间:
Submit time:
2010-11-16 13:30

文件编号:07376
Document No.

ZPMC 联系人:
Requested By:

Zhang Wei

AB/F 签收人: *Wu Yulong*
AB/F Receiver:

签收时间: 2010.11.16. 13:32
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 change the plan, ZPMC will do any inspection according to the HOLD POINT.
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现场报检时间
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/F to notify ZPMC that the work has been completed and the result within 1 hour.

签收时间:
Time:

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-000836**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 29-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0853**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-Nov-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Visual Testing (VT) verification of welds located on the vertical and horizontal anchor house plate of OBG bike path BK004A-025, this QA Inspector discovered the following issues:

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- The member is located in Bay 10.

The Notice of Witness Inspection Number (NWIT) is 07326 for visual inspection. These areas have been previously tested and accepted by ZPMC Quality Control (QC) personnel.

Contractor's proposal to correct the problem:

Replace the non-conforming plate with a plate of correct thickness. Issue internal NCR to the parties involved.

Corrective action taken:

The under thickness plate was replaced, verified by QA inspectors. Internal NCR was issued by ZPMC.

Did corrective action require Engineer's approval?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

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.

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer