

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.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, China**Report No:** NCR-000898**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0860**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 14W, SP3131A to BP3087A CJP Weld
Procedural	Procedural	Description:	

Reference Description: New Weld Procedure Requirements for New Welds Not Followed (Rager/McQuaid)**Description of Non-Conformance:**

During Caltrans QA in process observations of the fabrication of OBG Seg 14W, this QA discovered the following issue: ZPMC welding personnel did not appear to be following the NEW WELD PROCEDURE (Rager/McQuaid). The following requirement was not followed:

6. Non Destructive testing (6A)

NOTE: The above reference is relative to section 6 of the NEW WELD PROCEDURE (Rager/McQuaid) and the corresponding paragraph letter.

The weld is identified as SEG3020AX-004.

The welding process used was SMAW.

The weld is a CJP joining SP3131A to BP3087A.

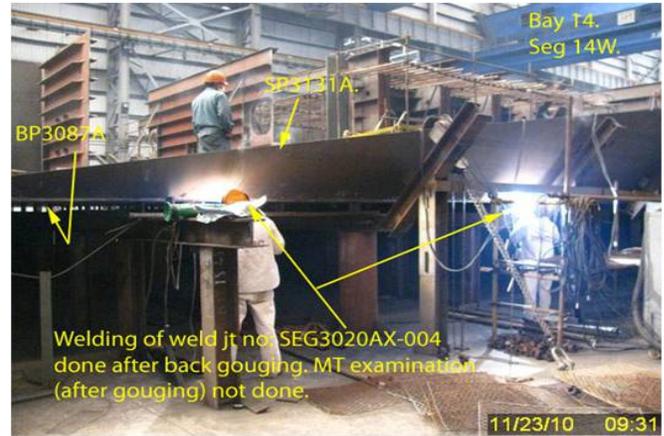
The weld is SPCM.

OBG Seg 14W is located in Bay 14.

Reference the attached pictures below.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

6. Non Destructive Testing.

A. All back gouged groove welds are to have their gouged areas ground to bright metal and inspected 100% by VT and MT examination before welding may begin from the second side.

Who discovered the problem: Shailesh V Wadkar

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 14:30, Verbal, 11/23/10

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 11:00, Email, 11/24/10

QC Inspector's Name: Wang Lu

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: 24-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-0860

Job Name: SAS Superstructure
Document No: 05.03.06-000855

Reference Description: New Weld Procedure Requirements for New Welds Not Followed (Rager/McQuaid)

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:** 14

Remarks:

During Caltrans QA in process observations of the fabrication of OBG Seg 14W, this QA discovered the following issue:
 ZPMC welding personnel did not appear to be following the NEW WELD PROCEDURE (Rager/McQuaid). The following requirement was not followed:
 6. Non Destructive testing (6A)
 NOTE: The above reference is relative to section 6 of the NEW WELD PROCEDURE (Rager/McQuaid) and the corresponding paragraph letter.
 The weld is identified as SEG3020AX-004.
 The welding process used was SMAW.
 The weld is a CJP joining SP3131A to BP3087A.
 The weld is SPCM.
 OBG Seg 14W is located in Bay 14.

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-0860

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: 05.03.06-000855

Subject: NCR No. ZPMC-0860

Dated: 29-Nov-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000853 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The "NEW WELD PROCEDURE (Rager/McQuaid)" quoted as the basis for this NCR is not a contact document only a recommendation from the QA/QC Committee.

The "NEW WELD PROCEDURE (Rager/McQuaid)" quoted as the basis for this NCR is not a contact document only a recommendation from the QA/QC Committee. If the Department wants to incorporate the QA/QC committee's recommendations as a contract requirement a contract change order should be issued. As this NCR was written without basis it should be withdrawn.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000853R00

Caltrans' comments:

Status: REJ

Date: 03-Dec-2010

CT acknowledges contractor's response. However, successful NDT will close this NCR.

Submitted by: Chao, Ching

Attachment(s):

Date: 03-Dec-2010

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000855

Subject: NCR No. ZPMC-0860

Dated: 08-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000853 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: We understand your response and we will not submit the normal NCR closure package with NDT reports for this and expect that CT will close these as the green tags for these components are issued.

We understand your response and we will not submit the normal NCR closure package with NDT reports for this and expect that CT will close these as the green tags for these components are issued.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000853R01

Caltrans' comments:

Status: REJ

Date: 09-Dec-2010

Normal NCR closure package with NDT reports shall be submitted with the NPR to close out the NCR.

Submitted by: Woo, Laraine

Attachment(s):

Date: 09-Dec-2010

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000855

Subject: NCR No. ZPMC-0860

Dated: 01-Mar-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000853 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing acceptable NDT of the weld referenced in the NCR and requests closure of this NCR.
ZPMC is providing acceptable NDT of the weld referenced in the NCR and requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000853R02;

Caltrans' comments:

Status: CLO

Date: 02-Mar-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0860 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 02-Mar-2011



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18406R1 DATE 2011.03.01 PAGE 1 OF 2 Revision No: 0

PROJECT NO.: 工程编号 ZP06-787 CONTRACTOR: CALTRANS

ITEMS NAME: 14W SIDE PLATE SPLICE DRAWING NO.: SEG3020AX CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号

REFERENCING CODE 参考规范 ACCEPTANCE STANDARD 接受标准 PROCEDURE NO. 程序编号
 AWS D1.5-2002 AWS D1.5-2002(Table 6.3) ZPQC-UT-01

WELDING PROCESS 焊接方法 JOINT TYPE 焊缝类型 CALIBRATION DUE DATE 仪器校正有效期
 SMAW BUTT Dec. 28ST, 2011

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE AMERICA EPOCH-4B 07015091

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIV BLOCK TYPE II C.M.C A709M-345T2/F2 30/35mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
AMERICA	70°	2.25MHz	0.75×0.625 in				
Reference Level 参考灵敏度						20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注	
					Indication Level	Reference Level	Attenuation	Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
										a	b	c	d			Length 长度
SEG3020AX-004	1R1	69.1				50									ACC.	100%
	2R1	69.1				50									ACC.	100%
	3R1	69.1				50									ACC.	100%
	4R1	69.1				50									ACC.	100%
	5R1	69.1				50									ACC.	100%
	6R1	69.1				50									ACC.	100%
	7R1	69.1				50									ACC.	100%
	8R1	69.1				50									ACC.	100%

EXAMINED BY 主探 Tang Dingshan REVIEWED BY 审核 XU Rong gang
 LEVEL - I SIGN / DATE 2011.03.01 LEVEL - II SIGN / DATE 2011.03.01

质量经理 / QCM Lu Jianhua 用户 CUSTOMER _____
 签字 SIGN / 日期 DATE 2011.03.01 签字 SIGN / 日期 DATE _____



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18406R1 DATE 2011.03.01 PAGE 2 OF 2 Revision No: 0

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
									a	b	c	d	Length 长度		
	9R1	69.1				50								ACC.	100%
	10R1	69.1				50								ACC.	100%
	11R1	69.1				50								ACC.	100%
	12R1	69.1				50								ACC.	100%
	13R1	69.1				50								ACC.	100%
	14R1	69.1				50								ACC.	100%
	15R1	69.1				50								ACC.	100%
	16R1	69.1				50								ACC.	100%
	17R1	69.1				50								ACC.	100%

AFTER B-CWR2513

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EXAMINED BY 主探 <u>Tang Xinyuan</u> LEVEL - II SIGN DATE 2011.03.01	REVIEWED BY 审核 <u>XU Ronggang</u> LEVEL - II SIGN DATE 2011.03.01
质量经理 / QCM <u>Lu Jianhua</u> 签字 SIGN / 日期 DATE 2011.03.01	用户 CUSTOMER _____ 签字 SIGN / 日期 DATE

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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-000897**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Mar-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0860**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component:
Procedural	Procedural	Description:	

Date the Non-Conformance Report was written: 23-Nov-2010**Description of Non-Conformance:**

During Caltrans QA in process observations of the fabrication of OBG Seg 14W, this QA discovered the following issue: ZPMC welding personnel did not appear to be following the NEW WELD PROCEDURE (Rager/McQuaid). The following requirement was not followed:

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The weld is identified as SEG3020AX-004.

The welding process used was SMAW.

The weld is a CJP joining SP3131A to BP3087A.

The weld is SPCM.

OBG Seg 14W is located in Bay 14.

Reference the attached pictures below.

Contractor's proposal to correct the problem:

Contractor will provide the NDT report to prove the weld is acceptable.

Corrective action taken:

Contractor provided the NDT report. The NDT report shows the weld is acceptable.

Did corrective action require Engineer's approval? Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?**

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Yes No

Comments:

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Inspected By:	Ng,Michael	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer
