

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, China**Report No:** NCR-000907**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0869**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: SEG3009V-001, Lift 13BE Vertical Plate
Procedural	Procedural	Description:	

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

During the Quality Assurance (QA) random in-process observations of the fabrication of OBG Lift 13BE Bay # 14, this Caltrans QA Inspector observed the following:

ZPMC welding personnel did not appear to be following the New Weld Procedure

The following requirements were not followed:

2. Assembly (2F)

- ZPMC personnel performed welding for the splice weld between VP3005A (PL3277A) and VP3006A (PL3278A) without adequate preheating of the adjacent base material.

-During the welding This QA Inspector observed a 160 degree Celsius Tempstick did not melt when applied to the adjacent base material.

-Weld number identified as SEG3009V-104

-The weld is complete joint penetration (CJP) weld.

-PL3277A and PL3278A are designated on the approved shop drawings as Seismic Performance Critical Members (SPCM).

-The welding performed with Submerged Arc Welding (SAW) process.

-The area was being preheated using electric strip heaters.

See attached photographs for additional detail.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

NEW WELD PROCEDURE (Rager/McQuaid)

2) Assembly:F. Preheat shall be applied in such manner to provide a minimum temperature in the area of the weld 165 degree Celsius

Who discovered the problem: Shrikant Utekar

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: General Notification 11/23/10

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:00hrs, Email, 11/25/10

QC Inspector's Name: Wang Lu (Testino)

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: 25-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-0869

Job Name: SAS Superstructure
Document No: 05.03.06-000864

Reference Description: New Weld Procedure 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:** 13

Remarks:

During the Quality Assurance (QA) random in-process observations of the fabrication of OBG Lift 13BE Bay # 14, this Caltrans QA Inspector observed the following:
 ZPMC welding personnel did not appear to be following the New Weld Procedure (Rager/McQuaid)
 The following requirements were not followed:

2. Assembly (2F)

- ZPMC personnel performed welding for the splice weld between VP3005A (PL3277A) and VP3006A (PL3278A) without adequate preheating of the adjacent base material.
- During the welding This QA Inspector observed a 160 degree Celsius Tempstick did not melt when applied to the adjacent base material.
- Weld number identified as SEG3009V-104
- The weld is complete joint penetration (CJP) weld.
- PL3277A and PL3278A are designated on the approved shop drawings as Seismic Performance Critical Members (SPCM).
- The welding performed with Submerged Arc Welding (SAW) process.
- The area was being preheated using electric strip heaters.

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

NCT

(Continued Page 2 of 2)

Attachments: ZPMC-0869

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: 05.03.06-000864

Subject: NCR No. ZPMC-0869

Dated: 01-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000862 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: As this NCR was written without a contractual basis it should be withdrawn.

The "NEW WELD PROCEDURE (Rager/McQuaid)" quoted as the basis for this NCR is not a contract 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 a contractual basis it should be withdrawn.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000862R00

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: 05.03.06-000864
Subject: NCR No. ZPMC-0869

Dated: 08-Dec-2010
Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9
Job Name: SAS Superstructure
Document No.: ABF-NPR-000862 **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-000862R01

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: 05.03.06-000864

Subject: NCR No. ZPMC-0869

Dated: 01-Mar-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000862 **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. This weld was misidentified in the NCR as SEG3009V-104, the actual weld ID is SEG3009V-001

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000862R02;

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-0869 is closed.

Submitted by: Eagen, Sean

Date: 02-Mar-2011

Attachment(s):



REPORT OF ULTRASONIC EXAMINATION

UT探伤报告

REPORT NO. 报告编号 B787-UT-18350 DATE 2010.12.02 PAGE 1 OF 1 Revision No: 0

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

ITEMS NAME: 13BE VERTICALITY PLATE DRAWING NO.: SEG3009V CALTRANS CONTRACT NO.: 04-0120F4
 部件名称 图号 加州工程编号 ZP06-787

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
 SAW BUTT Dec. 28ST, 2010

EQUIPMENT 设备 MANUFACTURER 制造商 MODEL NO. 样式编号 SERIAL NO. 序列编号
 UT SCOPE GE USM35 10526a

CALIBRATION BLOCK 试块 COUPLANT 耦合剂 MATERIAL/THICKNESS 材料厚度
 AWS IIW BLOCK TYPE II C.M.C A709M-345F2 25mm

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	0.75×0.625in				
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		
SEG3009V-001		70				42								ACC.	100%

AFTER HSR1(B)-9915

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EXAMINED BY 主探 Riv Guan fu REVIEWED BY 审核 Tang Xing shan
 LEVEL - II SIGN 1 DATE 20/0.12.02 LEVEL - II SIGN 1 DATE 20/0.12.02

质量经理 / QCM [Signature] 用户CUSTOMER _____
 签字 SIGN / 日期 DATE 20/0.12.02 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-000899**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Mar-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0869**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: 24-Nov-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process observations of the fabrication of OBG Lift 13BE Bay # 14, this Caltrans QA Inspector observed the following:

ZPMC welding personnel did not appear to be following the New Weld Procedure

The following requirements were not followed:

2. Assembly (2F)

- ZPMC personnel performed welding for the splice weld between VP3005A (PL3277A) and VP3006A (PL3278A) without adequate preheating of the adjacent base material.

-During the welding This QA Inspector observed a 160 degree Celsius Tempstick did not melt when applied to the adjacent base material.

-Weld number identified as SEG3009V-104

-The weld is complete joint penetration (CJP) weld.

-PL3277A and PL3278A are designated on the approved shop drawings as Seismic Performance Critical Members (SPCM).

-The welding performed with Submerged Arc Welding (SAW) process.

-The area was being preheated using electric strip heaters.

See attached photographs for additional detail.

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 to prove the weld is acceptable. The Weld ID SEG3009V-104 referenced in the NCR has been changed to SEG3009V-001.

