

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-000917**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0879**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Bikepath BK004A-062
Procedural	Procedural	Description:	

Reference Description: ZPMC performed fabrication without following the "Weld Procedure Requirements for New Welds" by Rager/McQuaid

Description of Non-Conformance:

During Caltrans QA in process observations of the fabrication of Bike Path, this QA discovered the following issue(s):

ZPMC welding personnel did not follow the "Weld Procedure Requirements for New Welds" by Rager/McQuaid

The following requirements were not followed:

- 2e) Assembly: All tack welding shall be performed in accordance with an approved WPS and as amended by this procedure.
- 2f) Assembly: Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165°C.

The weld is identified as BK004A6-062-106/107

The welding process used was Shielded Metal Arc Welding (SMAW)

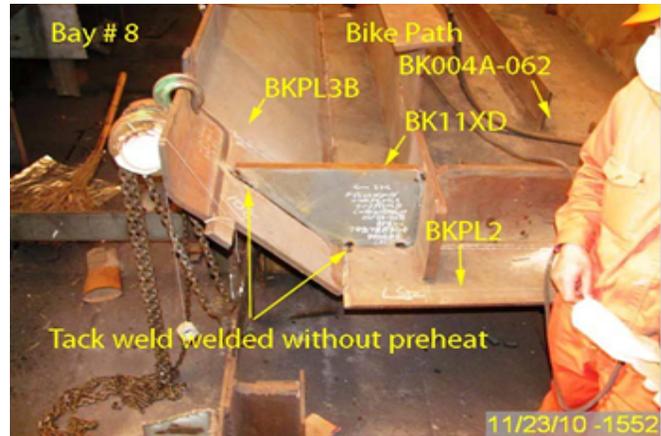
The weld is a Fillet weld joining Side Plate BKPL3B to Bearing Plate BKX11D.

The weld is Non Seismic Performance Critical Member (SPCM).

Bike Path BK004A6-062 is located Bay 8.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

“Weld Procedure Requirements for New Welds” by Rager/McQuaid

-1a) Scope: This procedure is to be used for all new and totally replaced welds that are being made in conformance with the AWS D1.5 Bridge Welding Code, the Caltrans Special Provisions and this Welding Procedure

-2e) Assembly: All tack welding shall be performed in accordance with an approved WPS and as amended by this procedure.

-2f) Assembly: Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165°C.

Who discovered the problem: D. Sukanthan

Name of individual from Contractor notified: Huang wen guang

Time and method of notification: 16:00 hours, 11-23-2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:30_11/24/10_Verbal

QC Inspector's Name: Zhang wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

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 Jim Devey, (86) 150-0002-6784, who represents the Office of Structural Materials for your project.

Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

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: 26-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-0879

Job Name: SAS Superstructure
Document No: 05.03.06-000874

Reference Description: ZPMC performed fabrication without following the "Weld Procedure Requirements for New Welds" by 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: Bike Path

Lift:

Remarks:

During Caltrans QA in process observations of the fabrication of Bike Path, this QA discovered the following issue(s):
ZPMC welding personnel did not follow the "Weld Procedure Requirements for New Welds" by Rager/McQuaid
The following requirements were not followed:

- 2e) Assembly: All tack welding shall be performed in accordance with an approved WPS and as amended by this procedure.
- 2f) Assembly: Preheat shall be applied in such a manner to provide a minimum temperature in the area of the weld of 165°C.

The weld is identified as BK004A6-062-106/107
The welding process used was Shielded Metal Arc Welding (SMAW)
The weld is a Fillet weld joining Side Plate BKPL3B to Bearing Plate BKX11D.
The weld is Non Seismic Performance Critical Member (SPCM).
Bike Path BK004A6-062 is located Bay 8.

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-0879

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: 05.03.06-000874

Subject: NCR No. ZPMC-0879

Dated: 01-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000872 **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-000872R00

Caltrans' comments:

Status: REJ

Date: 03-Dec-2010

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

Submitted by: Chao, Ching

Date: 03-Dec-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000874

Subject: NCR No. ZPMC-0879

Dated: 08-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000872 **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.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000872R01

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

Date: 09-Dec-2010

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000874

Subject: NCR No. ZPMC-0879

Dated: 22-Feb-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000872 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution:

See attached NDT results to show the weld is acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000872R02;

Caltrans' comments:

Status: CLO

Date: 23-Feb-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0879 is closed.

Submitted by: Eagen, Sean

Date: 23-Feb-2011

Attachment(s):

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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-000917**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0879**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Bikepath BK004A-062**Procedural****Procedural****Description:**

Reference Description: ZPMC performed fabrication without following the "Weld Procedure Requirements for New Welds" by Rager/McQuaid

Description of Non-Conformance:

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The weld is identified as BK004A6-062-106/107

The welding process used was Shielded Metal Arc Welding (SMAW)

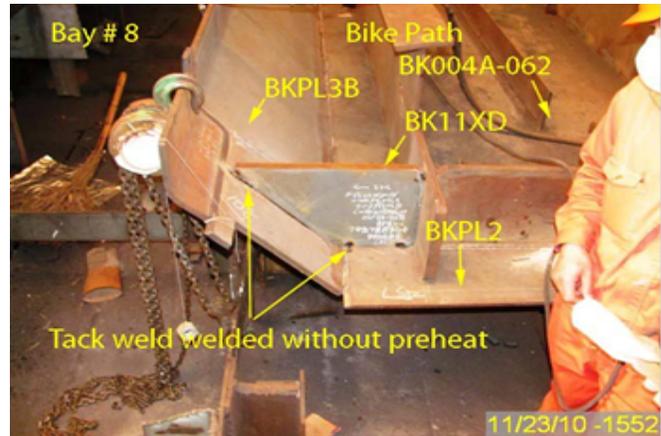
The weld is a Fillet weld joining Side Plate BKPL3B to Bearing Plate BKX11D.

The weld is Non Seismic Performance Critical Member (SPCM).

Bike Path BK004A6-062 is located Bay 8.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

“Weld Procedure Requirements for New Welds” by Rager/McQuaid

-1a) Scope: This procedure is to be used for all new and totally replaced welds that are being made in conformance with the AWS D1.5 Bridge Welding Code, the Caltrans Special Provisions and this Welding Procedure

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Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:30_11/24/10_Verbal

QC Inspector's Name: Zhang wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

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Inspected By: Tsang, Eric

SMR

Reviewed By: Devey, Jim

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-36347		DATE日期 2011.01.22	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: BK004A6 BIKE PATH		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 ST , 2011	
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-345T2 16/25 mm	
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			
BK004A6-062-053				ACC.		100%MT
BK004A6-062-054				ACC.		100%MT
BK004A6-062-055				ACC.		100%MT
BK004A6-062-056				ACC.		100%MT
BK004A6-062-059				ACC.		100%MT
BK004A6-062-060				ACC.		100%MT
BK004A6-062-104				ACC.		100%MT
BK004A6-062-105				ACC.		100%MT
BK004A6-062-106				ACC.		100%MT
BK004A6-062-107				ACC.		100%MT
BK004A6-062-108				ACC.		100%MT
BK004A6-062-109				ACC.		100%MT

BLANK

EXAMINED BY主探 Fu Zhiqiang <i>Fu Zhiqiang</i> 1/22/11	REVIEWED BY审核 Wang Wei <i>Wang Wei</i> 1/22/11
LEVEL - II SIGN 签名 / DATE日期	LEVEL-II SIGN / DATE日期
质量经理 / QCM <i>[Signature]</i>	用户CUSTOMER
签字 SIGN / 日期 DATE	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, P.R. China**Report No:** NCS-000918**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Feb-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0879**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 Bike Path, this QA discovered the following issue(s):

ZPMC welding personnel did not follow the "Weld Procedure Requirements for New Welds" by Rager/McQuaid

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The weld is identified as BK004A6-062-106/107

The welding process used was Shielded Metal Arc Welding (SMAW)

The weld is a Fillet weld joining Side Plate BKPL3B to Bearing Plate BKX11D.

The weld is Non Seismic Performance Critical Member (SPCM).

Bike Path BK004A6-062 is located Bay 8.

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 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? Yes No

Comments:

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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

of Structural Materials for your project.

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer
