

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, Shanghai, P.R. China

Report No: NCR-000924

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 28-Nov-2010

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

NCR #: ZPMC-0886

Type of problem:

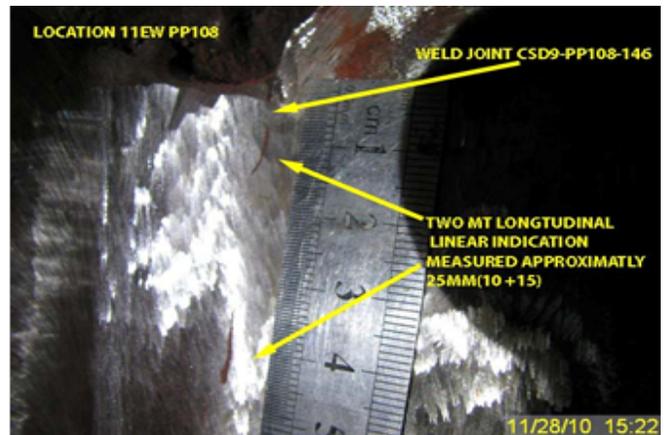
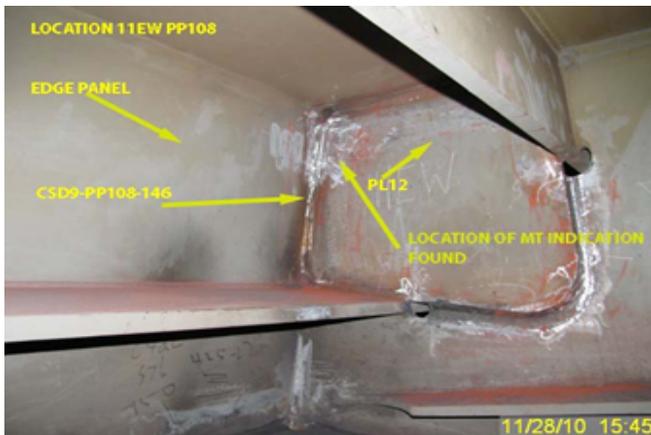
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 11EW PP108
Procedural	Procedural	Description: 2 Missed MT indication by QC	

Reference Description: QA found 2 missed MT indications after ZPMC had tested and accepted the weld at Segment 11EW

Description of Non-Conformance:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on OBG 11EW PP108, this QA Inspector discovered the following issue:

- Two (2) longitudinal indication 10mm and 15mm in length found Toe of the Fillet weld identified as CSD9-PP108-146
- The weld is a fillet weld (CSD9-PP108-146), joining the Floor beam (FB9B) to suspender bracket retrofit plate (PL12).
- The Y location is 6mm measured from the upper termination of the weld and is clearly marked on the material.
- OBG 11EW is located at Trial assembly.
- The Notice of Witness Inspection Number (NWIT) is 07529.
- This weld is within an area previously tested and accepted by ABF Quality Control (QC) personnel.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 Welds that subject to RT or MT in addition to visual inspection shall have no cracks...

Who discovered the problem: Raghavendra Reddy

Name of individual from Contractor notified: Ding Xing Chi

Time and method of notification: 15:00_9/28/10_E-Mail

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 7:45 hours, 11/29/10, Email

QC Inspector's Name: Wu Shi Gao

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

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	Wahbeh, Mazen	SMR
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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: 30-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: 05.03.06-000881

Subject: NCR No. ZPMC-0886

Reference Description: QA found 2 missed MT indications after ZPMC had tested and accepted the weld at Segment 11EW

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:** 11

Remarks:

- During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on OBG 11EW PP108, Caltrans QA Inspector discovered the following issue:
- Two (2) longitudinal indication 10mm and 15mm in length found Toe of the Fillet weld identified as CSD9-PP108-146
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- OBG 11EW is located at Trial assembly.
- The Notice of Witness Inspection Number (NWIT) is 07529.
- This weld is within an area previously tested and accepted by ABF 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-0886

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: 05.03.06-000881

Subject: NCR No. ZPMC-0886

Dated: 20-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000883 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

ZPMC-0886
"Please see ZPMC's response"

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000883R00;

Caltrans' comments:

Status: CLO

Date: 23-Dec-2010

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

Submitted by: Woo, Laraine

Attachment(s):

Date: 23-Dec-2010



No. B-944

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-12-20

REGARDING: NCR-000924(ZPMC-0886)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC has repaired the indications noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed. ABFJV has noted which inspector was responsible for this missed indications and is monitoring his performance as well as all inspector performance, if he continues to miss indications disciplinary action will be undertaken. Based on these actions, ZPMC requests closure of this NCR.

ATTACHMENT:

NCR-000924(ZPMC-0886)

B787-MT-31649 R1

[Handwritten signature]
12/20/2010



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: 30-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: 05.03.06-000881

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- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: OBG

Lift: 11

Remarks:

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Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0886

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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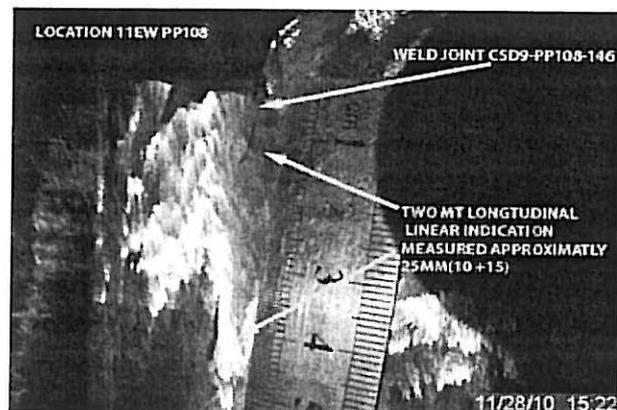
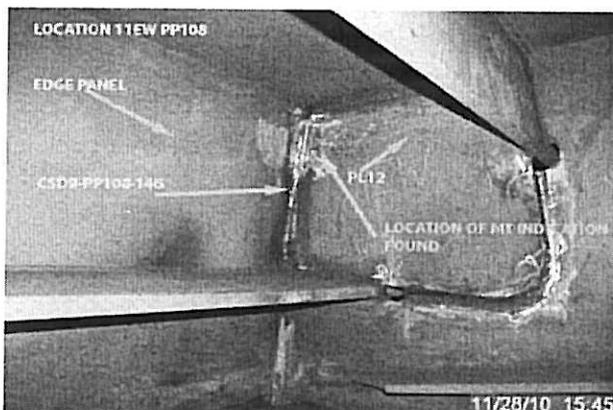
File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China**Report No:** NCR-000924**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0886**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Segment 11EW PP108Procedural Procedural Description: 2 Missed MT indication by QC**Reference Description:** QA found 2 missed MT indications after ZPMC had tested and accepted the weld at Segment 11EW**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on OBG 11EW PP108, this QA Inspector discovered the following issue:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Time and method of notification: 15:00_9/28/10_E-Mail

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 7:45 hours, 11/29/10, Email

QC Inspector's Name: Wu Shi Gao

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 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



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-31649R1		DATE日期 2010.12.12		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: SEG073 11EW corner assembly stiffener			CALTRANS CONTRACT NO.: 加州工程编号 04-0050F4			
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 , 2010		
EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 USA	MODEL NO. 样式编号 #ES-X		SERIAL NO. 连续编号 14234		
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/F2-X A709M- HPS485WT2 12/20/28/30/22mm		
WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型		CORNER 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			
CSD9-PP108-146	1R1				ACC.	100%MT
	2R1				ACC.	100%MT
AFTER B-CWR2359Rev.0						
BLANK						
EXAMINED BY主探 Wang Long <u>Wang Long</u> LEVEL - II SIGN 签名 / DATE日期 2010.12.12 质量经理 / QCM			REVIEWED BY 审核 <u>Yaochunping</u> LEVEL-II SIGN / DATE日期 2010.12.12 用户CUSTOMER			
签字 SIGN / 日期 DATE <u>Wang Long</u> 2010.12.12			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-000872**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0886**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: 28-Nov-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on OBG 11EW PP108, this QA Inspector discovered the following issue:

- Two (2) longitudinal indication 10mm and 15mm in length found Toe of the Fillet weld identified as CSD9-PP108-146
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- OBG 11EW is located at Trial assembly.
- The Notice of Witness Inspection Number (NWIT) is 07529.
- This weld is within an area previously tested and accepted by ABF Quality Control (QC) personnel.

Contractor's proposal to correct the problem:

Contractor will repair the weld with indications, and provide the NDT report to prove the weld is acceptable. Contractor will issue an internal NCR to the inspector who missed the weld indication. Contractor will monitor the inspector's performance. Disciplinary action will be taken if the inspector misses the indications continuously.

Corrective action taken:

Contractor repaired the weld, and provided the NDT report to prove the weld is acceptable. Contractor also issued the internal NCR to the inspector who missed the indication and continued to monitor his performance.

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
