

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



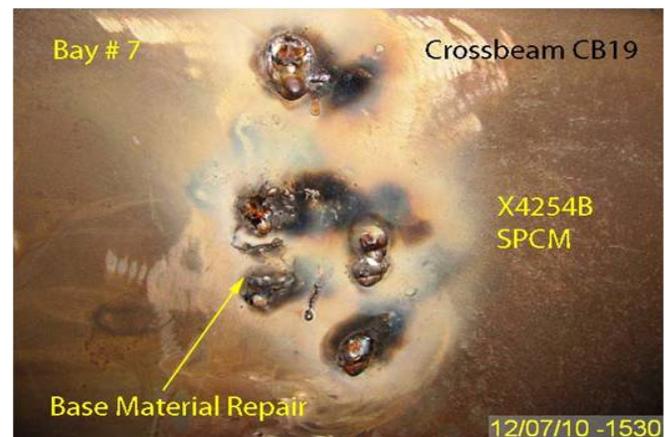
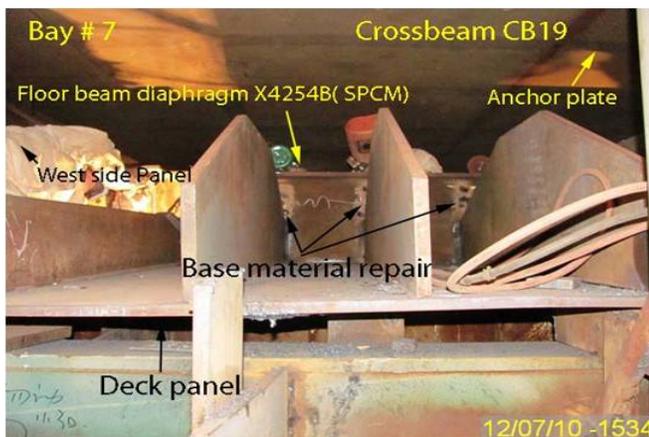
Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-000932**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 07-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0893**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** CB19 - Floorbeam diaphragm FB3246**Procedural****Procedural****Description:****Reference Description:** Base Metal Repair without Prior Approval from the Engineer on Crossbeam 19**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Crossbeam CB19, this QA inspector discovered the following issue:

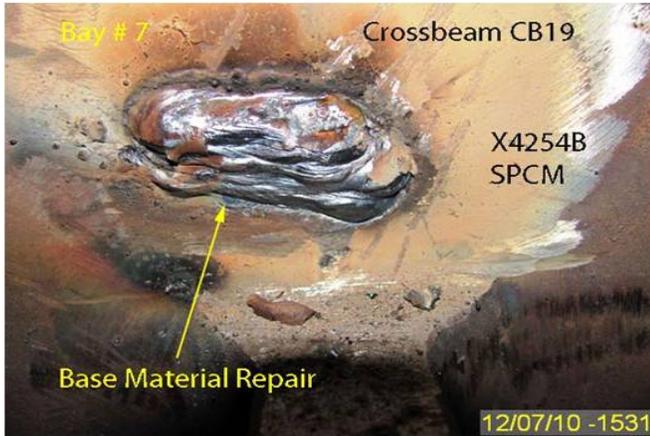
- Base metal repairs being performed without prior approval of the Engineer.
- Repairs were being performed in runoff tab removal areas on the Floor beam diaphragm web plate.
- Floor beam diaphragm is identified as FB3246
- Web plate is identified as X4254B (SPCM)
- The material is A709 Grade 345 Seismic Performance Critical Member (SPCM).
- OBG Cross beam CB19 is located in the Bay 7.

For further information, please see the attached pictures.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Caltrans Special Provision Section 8-3.01: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair."

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: D. Sukanthan

Name of individual from Contractor notified: Mr. Luo Lai Quan

Time and method of notification: 15:45 hours, 12/7/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 14:45 hours, 12/9/10, Verbal

QC Inspector's Name: Mr. Xu hai yang

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: 10-Dec-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: 05.03.06-000889

Subject: NCR No. ZPMC-0893

Reference Description: Base Metal Repair without Prior Approval from the Engineer on Crossbeam 19

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: Xbeam **Lift:**

Remarks:

- During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Crossbeam CB19, Caltrans QA inspector discovered the following issue:
- Base metal repairs being performed without prior approval of the Engineer.
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 - Web plate is identified as X4254B (SPCM)
 - The material is A709 Grade 345 Seismic Performance Critical Member (SPCM).
 - OBG Cross beam CB19 is located in the Bay 7.

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-0893

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: 05.03.06-000889

Subject: NCR No. ZPMC-0893

Dated: 10-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000898 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: "Please see ZPMC's comments, for closure."

"Please see ZPMC's comments, for closure."

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000898R00;

Caltrans' comments:

Status: CLO

Date: 10-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0893 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 10-Jan-2011



No. B-957

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-01-10

REGARDING: NCR-000932(ZPMC-0893)

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC QA personnel have talked with the floor CWI to instruct the requirement of Engineer's approval prior to any base metal repair. ZPMC is providing the NDT record to show the soundness of the repair. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000932(ZPMC-0893)

B787-MT-34893

[Handwritten signature]
1/10/2010



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: 10-Dec-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: 05.03.06-000889
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Material Location: Xbeam

Lift:

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Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0893

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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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, China **Report No:** NCR-000932
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 07-Dec-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0893

Type of problem:

Welding Concrete Other
 Welding Curing Procedural **Bridge No:** 34-0006
 Joint fit-up Coating Other **Component:** CB19 - Floorbeam diaphragm FB3246
 Procedural Procedural **Description:**

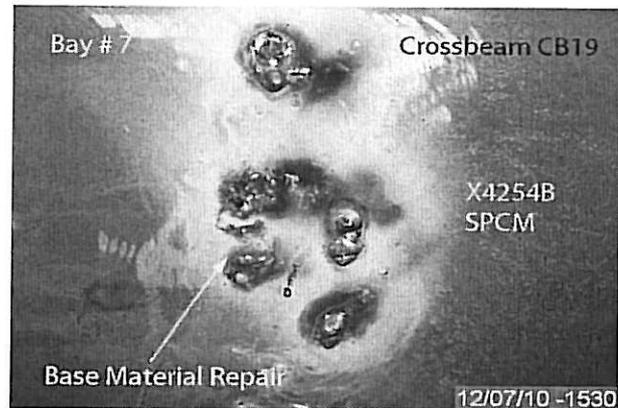
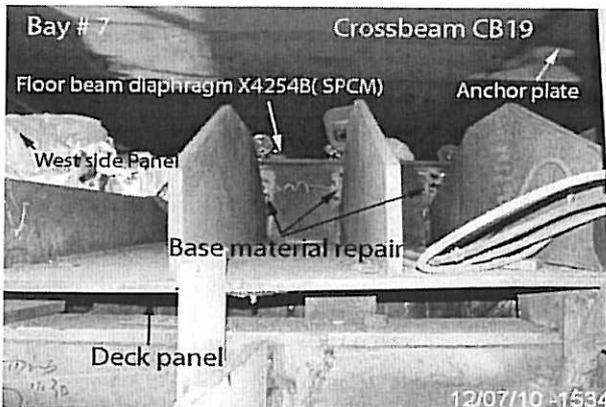
Reference Description: Base Metal Repair without Prior Approval from the Engineer on Crossbeam 19

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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QC Inspector's Name: Mr. Xu hai yang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

Comments:

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Inspected By: Devey,Jim SMR

Reviewed By: Wahbeh,Mazen SMR

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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-000940**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 11-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0893**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: 07-Dec-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process visual inspection of Orthotropic Box Girder (OBG) Crossbeam CB19, this QA inspector discovered the following issue:

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For further information, please see the attached pictures.

Contractor's proposal to correct the problem:

Contractor will repair the defective area, and provide the NDT report to prove the repairs are completed satisfactorily. ZPMC will issue an internal NCR to the QC personnel and will discuss with shop floor CWI regarding the requirement of seeking Engineer's approval prior to any base metal repair.

Corrective action taken:

Contractor repaired the defects. NDT reports provided subsequently show the repairs are acceptable. Contractor also reinforced to the shop floor CWI's that the Engineer needs to be notified prior to base metal repair.

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
