

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-000936
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 10-Dec-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0897

Type of problem:

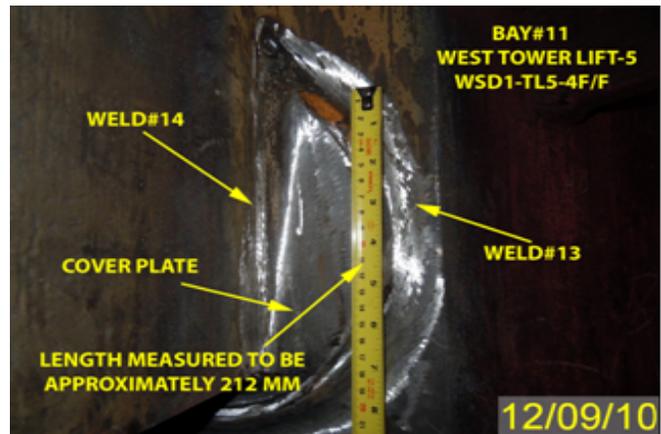
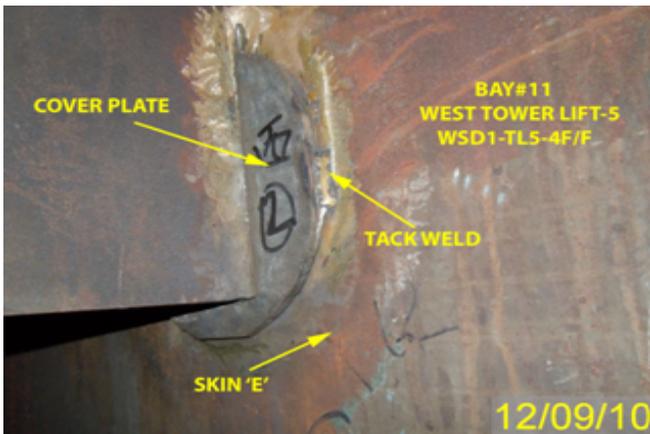
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: West Tower Cover Plates
Procedural	Procedural	Description:	

Reference Description: West Tower Cover Plates Re-installed without following Approved Shop Drawing

Description of Non-Conformance:

During the Caltrans Quality Assurance (QA) in-process observation on West tower lift-5 Cover plate, this QA Inspector discovered the following issue:

- ZPMC fabrication personnel removed 2 cover plates involving a total four (4) Non-SPCM fillet welds without notifying the Engineer .
- ZPMC re-welded with new cover plates, where the dimensions of the cover plates do not comply with the approved drawings.
- As per the shop drawing the required length of the cover plate is 151.4 mm. The length measured was approximately 212 mm.
- Welds are fillet welds joining cover plate to skin 'E'.
- The weld designations are WSD1-TL5-4F/F#13; 14; 15; 16.
- This component located at fabrication Bay#11.
- NCR ZPMC-827 had been issued on 10/19/2010 for the two non-conforming cover plates that were removed. Response to this NCR is still outstanding today.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5 2002 Section 3.7.5: "The Engineer shall be notified before improperly fitted and welded members are cut apart".

Approved Shop Drawing: "WSD1-TL5-4F-F".

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Bi Dewei

Time and method of notification: 1000 hours, 12/09/10, Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 1000 hours, 12/10/10, Verbal

QC Inspector's Name: Mr. Sun Zi Wang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: 510-286-0539 Fax: 510-286-0550

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: 05.03.06-000893

Subject: NCR No. ZPMC-0897

Reference Description: West Tower Cover Plates Re-installed without following Approved Shop Drawing

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: Tower **Lift:** 05

Remarks:

During the Caltrans Quality Assurance (QA) in-process observation on West tower lift-5 Cover plate, this QA Inspector discovered the following issue:

- ZPMC fabrication personnel removed 2 cover plates involving a total four (4) Non-SPCM fillet welds without notifying the Engineer .
- ZPMC re-welded with new cover plates, where the dimensions of the cover plates do not comply with the approved drawings.
- As per the shop drawing the required length of the cover plate is 151.4 mm. The length measured was approximately 212 mm.
- Welds are fillet welds joining cover plate to skin 'E'.
- The weld designations are WSD1-TL5-4F/F#13; 14; 15; 16.
- This component located at fabrication Bay#11.
- NCR ZPMC-827 had been issued on 10/19/2010 for the two non-conforming cover plates that were removed. Response to this NCR is still outstanding today.

References:

- AWS D1.5 2002 Section 3.7.5: "The Engineer shall be notified before improperly fitted and welded members are cut apart".
- Approved Shop Drawing: "WSD1-TL5-4F-F".

Action Required and/or Action Taken:

Propose resolutions for the identified non-conformance items and document that the various deficiencies have been brought in compliance with contract requirements. Also propose a resolution that addresses the apparent failure of Quality Control to identify the non-conformance with the appropriate Welding Procedure Specification (WPS). Provide documentation of the steps taken by the Quality Control Manager to prevent future occurrences.

The response for the resolution of this issue is requested within 7 days.

NCT

(*Continued Page 2 of 2*)

Transmitted by: Gina Rizzardo Transportation Engineer

Attachments: ZPMC-0897

cc: Rick Morrow, Peter Siegenthaler, Mark Woods

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000893

Subject: NCR No. ZPMC-0897

Dated: 27-Dec-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000890 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

See ZPMC's comments.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000890R00;

Caltrans' comments:

Status: AAP

Date: 28-Dec-2010

This proposed resolution is accepted with action pending. This NCR will be considered closed once the proper NDT documentation is submitted and reviewed. The NDT documentation submitted with the current NPR was for Weld IDs WSD1-TL5-2F/F-13, -14, -15, and -16. The weld IDs associated with this NCR are Weld IDs WSD1-TL5-4F/F-13, -14, -15, and -16.

Submitted by: Eagen, Sean

Date: 28-Dec-2010

Attachment(s):



TRANSMITTAL LETTER

PROJECT: S.F.O.B.B.

DATE:2010-12-27

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: TOWER NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

- (01) LR: No. T-182
- (02) NCR-000865(ZPMC-0827)
- NCR-000935(ZPMC-0896)
- NCR-000936(ZPMC-0897)
- T787-MT-12200
- T787-MT-12174
- DRAWING:A5-1

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

Rosemary

DATE: 12-27
RECEIVED 27 DEC 2010

COMPANY:

PHONE NO.

PLAN NUMBER:N/A
#R787-QCP-102



No. T-182

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2010-12-27

REGARDING:

NCR-000865(ZPMC-0827), NCR-000935(ZPMC-0896), NCR-000936(ZPMC-0897)

ZPMC received NCR-000865(ZPMC-0827), NCR-000935(ZPMC-0896), NCR-000936(ZPMC-0897), they all mentioned that CT inspectors found ZPMC used incorrect dimension component without prior approval by Engineer.

Here we clarify as below, as ZPMC got the oral agreement "RFF" drawing, so it was thought can be used without submitting formal documentation, but actually it should be. So it was a misapprehension, in the future we will take more care and make more communication with each other to avoid such problem. As a result the drawing was approved by Engineer and welds were accepted and green tagged.

Here we attach related documents, hope CT could take a review and close these NCRs.

ATTACHMENT:

NCR-000865(ZPMC-0827)

NCR-000935(ZPMC-0896)

NCR-000936(ZPMC-0897)

T787-MT-12200

T787-MT-12174

Drawing: A5-1

Zhang Jiali 2010.12.27

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DIVISION OF ENGINEERING SERVICES
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Contract #: 04-0120F4

Cty: 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-000865

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 16-Oct-2010

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

NCR #: ZPMC-0827

Type of problem:

Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:

Bridge No: 34-0006

Component: North Tower Lift 5, Cover Plate

Reference Description: Lift 5: North Grillage Cover Plate dimension for Longitudinal Grillage plate do not match with Drawing

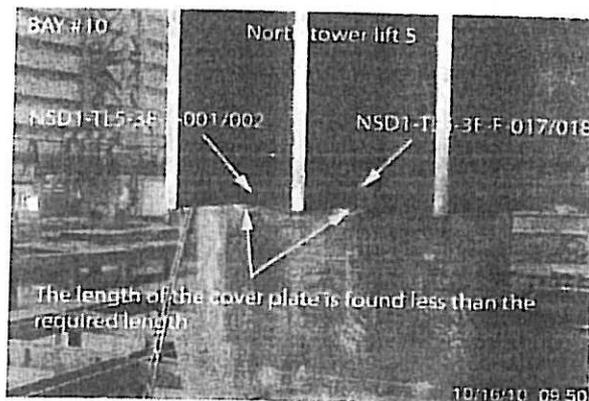
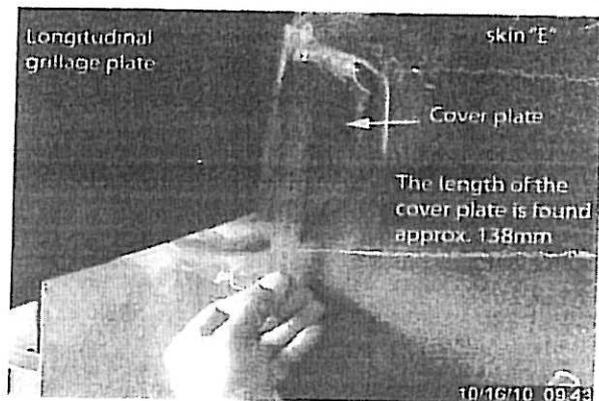
Description of Non-Conformance:

During the Quality Assurance Visual Testing (VT) verification of welds located on Cover Plate for the Longitudinal Grillage plate of North Tower lift 5, this Quality Assurance (QA) Inspector discovered the following issues:

- The dimensions of Cover Plate do not match the approved shop drawings.
- As per shop drawing the required length of the Cover Plate is 151.4mm.
- Cover Plate weld # NSD1-TL5-3E/F-001/002, the length of the Cover Plate was measured as 138mm.
- Cover Plate weld # NSD1-TL5-3E/F-017/018, the length of the Cover Plate was measured as 118mm and 143mm.
- These welds are fillet welds, joining the Cover Plate to the Skin Plate and Longitudinal Grillage plate.
- The member is located in Bay 10.

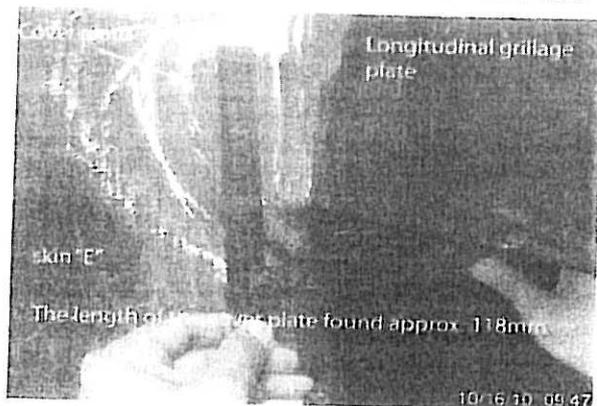
The Notice of Witness Inspection Number (NWIT) is 06975. These areas have been previously tested and accepted by ZPMC Quality Control (QC) personnel.

-Attached photographs provide additional location details.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Shop Drawing: NSD1-TL5-3E-F

AWS D1.5-02 Section 6.5.1 "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval."

AWS D1.5-02 Section 6.6.2 "The Contractor shall be responsible for visual inspection and NDT described in 6.7 and necessary correction of all deficiencies in materials and workmanship in conformance with the requirements of Clause 3 and 6.26 and as specified elsewhere in the contract documents."

Standard Specifications July 1999, section 5-1.03; Work and materials shall conform to the lines, grades, typical cross sections, dimensions and material requirements, including tolerances, shown on the plans or indicated in the specifications. The Engineer shall be the sole judge as to whether the work or materials deviate from the plans and specifications, and the Engineers' decision as to any allowable deviations therefrom shall be final.

Who discovered the problem: Umesh D. Gaikwad

Name of individual from Contractor notified: Yang Yi Heng

Time and method of notification: 1300 hours, 10-16-10, Telephone

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 1300hours, 10-18-10, Verbal

QC Inspector's Name: Qiu Wen

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 , who represents the Office of Structural Materials for your project.

Inspected By: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR

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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, P.R. China

Report No: NCR-000935

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 09-Dec-2010

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

NCR #: ZPMC-0896

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

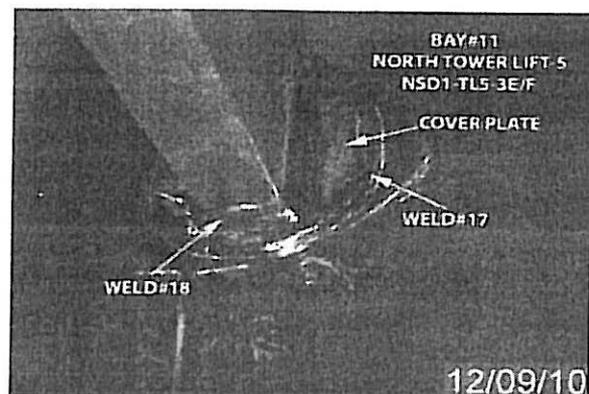
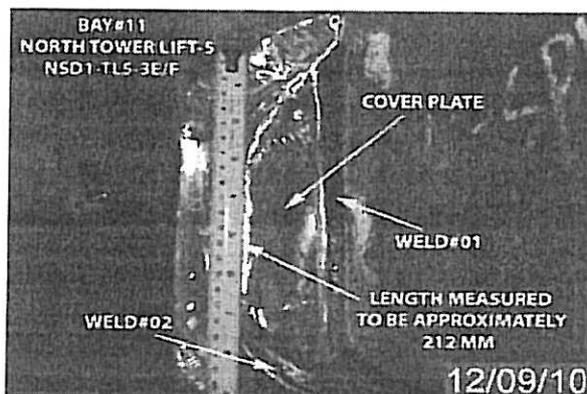
Component: North Tower Lift-5 Cover plate

Reference Description: North Tower Lift 5 Cover Plate Re-Installed Not in accordance to Approved Shop Drawing

Description of Non-Conformance:

During the Caltrans Quality Assurance (QA) in-process observation on North Tower Lift 5 Cover plate, this QA Inspector discovered the following issue:

- ZPMC fabrication personnel removed 2 cover plates involving a total four (4) Non-SPCM fillet welds without notifying the Engineer .
- ZPMC re-welded with new cover plates, where the dimension of the cover plates does not comply with the approved drawings.
- As per the shop drawing the required length of the cover plate is 151.4 mm. The length measured was approximately 212 mm.
- Welds are fillet welds joining cover plate to skin 'E'.
- The weld designations are NSD1-TL5-3E/F#01; 02; 17; 18.
- This component located at fabrication Bay#11.
- NCR ZPMC-827 had been issued on 10/19/2010 for the two non-conforming cover plates that were removed. Response to this NCR is still outstanding todate.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5 2002 Section 3.7.5: "The Engineer shall be notified before improperly fitted and welded members are cut apart".

Approved Shop Drawing: "NSD1-TL5-3E-F".

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Bi Dewei

Time and method of notification: 1000 hours, 12/09/10, Verbal

Name of Caltrans Engineer notified: Jim Reid

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

QC Inspector's Name: Mr. Sun Zi Wang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR

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DIVISION OF ENGINEERING SERVICES
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Contract #: 04-0120F4

City: 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-000936

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Dec-2010

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

NCR #: ZPMC-0897

Type of problem:

Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:

Bridge No: 34-0006

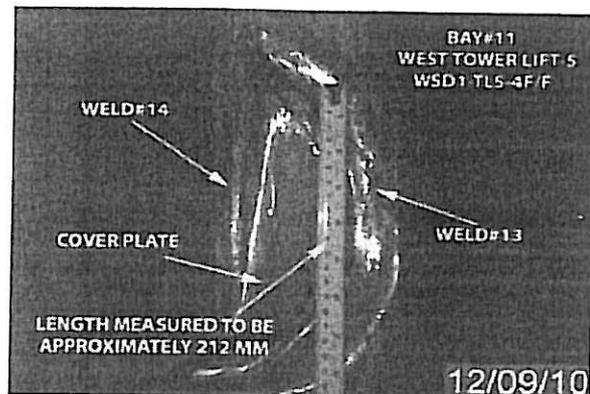
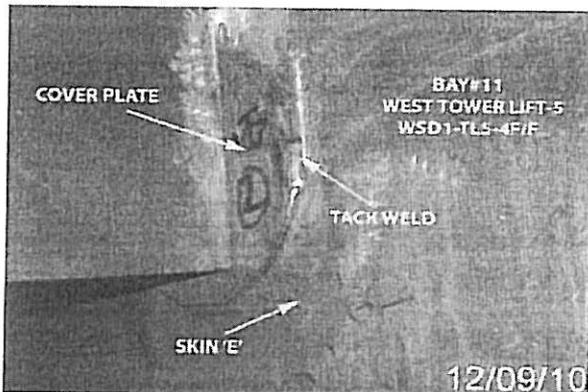
Component: West Tower Cover Plates

Reference Description: West Tower Cover Plates Re-installed without following Approved Shop Drawing

Description of Non-Conformance:

During the Caltrans Quality Assurance (QA) in-process observation on West tower lift-5 Cover plate, this QA Inspector discovered the following issue:

- ZPMC fabrication personnel removed 2 cover plates involving a total four (4) Non-SPCM fillet welds without notifying the Engineer.
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- As per the shop drawing the required length of the cover plate is 151.4 mm. The length measured was approximately 212 mm.
- Welds are fillet welds joining cover plate to skin 'E'.
- The weld designations are WSD1-TL5-4F/F#13; 14; 15; 16.
- This component located at fabrication Bay#11.
- NCR ZPMC-827 had been issued on 10/19/2010 for the two non-conforming cover plates that were removed. Response to this NCR is still outstanding today.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5 2002 Section 3.7.5: "The Engineer shall be notified before improperly fitted and welded members are cut apart".

Approved Shop Drawing: "WSD1-TL5-4F-F".

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Bi Dewei

Time and method of notification: 1000 hours, 12/09/10, Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 1000 hours, 12/10/10, Verbal

QC Inspector's Name: Mr. Sun Zi Wang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

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: Ng,Michael

QA Inspector

Reviewed By: Devey,Jim

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 T787-MT-12200 DATE日期 2010.12.12 PAGE OF页码 1/1 Revision No: 0

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

DRAWING NO. NSD1-TL5-4E/F CALTRANS CONTRACT NO.: 04-0120F4
 图号: THE FIFTH LIFTING TOWER(W) 加州工程编号

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
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EQUIPMENT 设备 MT YOKE	MANUFACTURER 制造商 PARKER	MODEL NO. 样式编号 da400S	SERIAL NO. 连续编号 17371
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MAGNETIZING METHOD 磁化方法	Continuous magnetic yoke 磁轭式连续法	CURRENT 电流	AC
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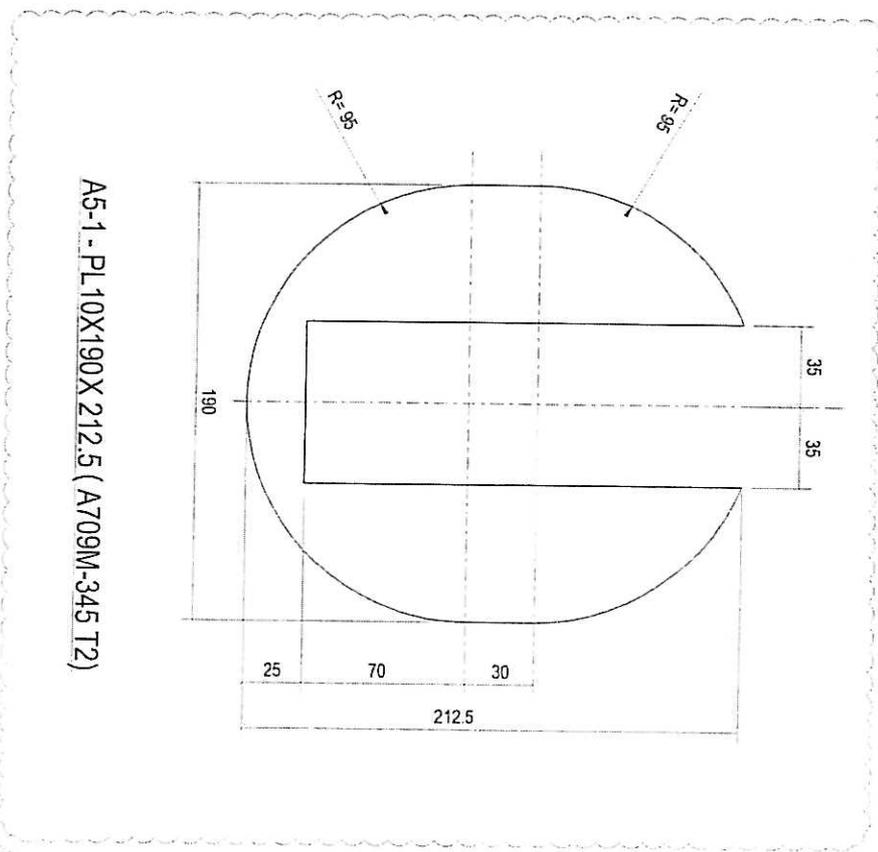
PARTICLE TYPE 磁粉类型	Dry magnet powder 干磁粉	YOKE SPACING 磁轭间距	70~150mm
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MATERIAL TO BE EXAMINED 检测材料	<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造	Material & thickness 母材,厚度	A709M-HPS-485WT2-Z /A709M-345T2 10/70/90 mm
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WELDING PROCESS 焊接方法	SMAW	TYPE OF JOINT 焊缝类型	T-JOINT
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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			
WSD1-TL5-2F-F-13				ACC.		100%MT
WSD1-TL5-2F-F-14				ACC.		100%MT
WSD1-TL5-2F-F-15				ACC.		100%MT
WSD1-TL5-2F-F-16				ACC.		100%MT
BLANK						

EXAMINED BY主探 Fu Zhi Qiang <i>Fu Zhi Qiang</i>	REVIEWED BY 审核 <i>Wang Mei</i>
LEVEL - II SIGN 签名 / DATE日期 <i>2010.12.12</i>	LEVEL-II SIGN / DATE日期 <i>2010.12.12</i>
质量经理 / QCM <i>Liu Jianhua</i>	用户CUSTOMER
签字 SIGN / 日期 DATE <i>2010.12.12</i>	签字 SIGN / 日期 DATE



A5-1 - PL 10X190X 212.5 (A709M-345 T2)

REF DWG : 605-612/1204

BILL OF MATERIALS						SHIP BILL		BILL ORDER	
NO	SHAPE	LENGTH mm	MARK	WEIGHT	REMARKS	NO	ITEM		
0			A5-1	12.8					
0	PL 10X190	212.5	A5-1	12.8					
ALL MATERIAL TO BE A709M GR 345 12 UN									

APPROVED
 APPROVED AS NOTED
 RETURNED FOR CORRECTION
 TYPED INSTRUMENTAL AND RECOMMENDATIONS BY
 THE ARCHITECT AND CONTRACTOR
 THE ARCHITECT'S SIGNATURE AND SEAL
 APPROVAL OF THE ARCHITECT IS A NECESSARY CONDITION FOR THE STATE OF CALIFORNIA
 TO ISSUE A PERMIT TO CONSTRUCT. THE ARCHITECT'S SIGNATURE AND SEAL MUST BE
 PLACED ON ALL INSTRUMENTS AND RECOMMENDATIONS. THE ARCHITECT'S SIGNATURE AND
 SEAL MUST BE PLACED ON ALL INSTRUMENTS AND RECOMMENDATIONS. THE ARCHITECT'S
 SIGNATURE AND SEAL MUST BE PLACED ON ALL INSTRUMENTS AND RECOMMENDATIONS.
Bonny Kay DEC 21 2010
 REGISTERED ARCHITECT
 No. 11111

NO.	DATE	REVISIONS	BY
2	12/22/10	ISSUE ACCORDING TO COMMENTS BY FABRICATOR RE: UCCFY ACCORDING TO COMMENTS BY FABRICATOR RE: UCCFY	CJ
1	08/27/10	ISSUE ACCORDING TO COMMENTS BY FABRICATOR RE: UCCFY	CJ
0			BR

ZPMC
 SAN FRANCISCO OAKLAND BAY BRIDGE EAST SPAN SELF-ANCHORED SUSPENSION SPAN
 ROUTE 80 EAST OF YERBA BUENA ISLAND DISTRICT 04, SF COUNTY, CA
 BRIDGE Nos.: 30-0004, PA B 2, NP 13.2 & 34-0008 PA B 7, NP 13.9
 STATE OF CALIFORNIA DEPT. OF TRANSPORTATION CONTRACT NO. 04-1205-1
 ENGINEER: CALTRANS --- T.Y. LIN/MOFFATT & NICHOL, JV
 CONTRACTOR: AMERICAN BRIDGE/FUJINO ENTERPRISES, JV
 MISCELLANEOUS PL

DRAWN	LJ	DATE	04/12/08	SCALE	
CHECKED	LJV	DATE	08/12/08	SCALE	A5-1

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000893

Subject: NCR No. ZPMC-0897

Dated: 04-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000890 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: "Per the previously Caltrans' response, ZPMC is provided the requested NDT reports. Based on this ZPMC requests closure of this NCR."

"Per the previously Caltrans' response, ZPMC is provided the requested NDT reports. Based on this ZPMC requests closure of this NCR."

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000890R01;

Caltrans' comments:

Status: CLO

Date: 04-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0897 is closed.

Submitted by: Eagen, Sean

Date: 04-Jan-2011

Attachment(s):



TRANSMITTAL LETTER

PROJECT: S.F.O.B.B.

DATE:2011-01-04

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: TOWER NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

(01) LR: No. T-184

(02) NCR-000936(ZPMC-0897)

T787-MT-12200

ABF-NPR-000890 R0

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

Rosemary

COMPANY:  **FLUOR**

DATE: 10:08
RECEIVED 04 JAN 2011

PHONE NO.

PLAN NUMBER:N/A
#R787-QCP-102



No. T-184

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2011-01-04

REGARDING: NCR-000936(ZPMC-0897)

ZPMC received NCR-000936(ZPMC-0897), it mentioned that CT inspectors found ZPMC used incorrect dimension component without prior approval by Engineer.

According to ABF-NPR-000890, here, we provide revised reports, hope CT could take review and close this NCR.

ATTACHMENT:

NCR-000936(ZPMC-0897)

T787-MT-12200

ABF-NPR-000890 R0

Zhang Wanda

2011.01.04

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-000936

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Dec-2010

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

NCR #: ZPMC-0897

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: West Tower Cover Plates

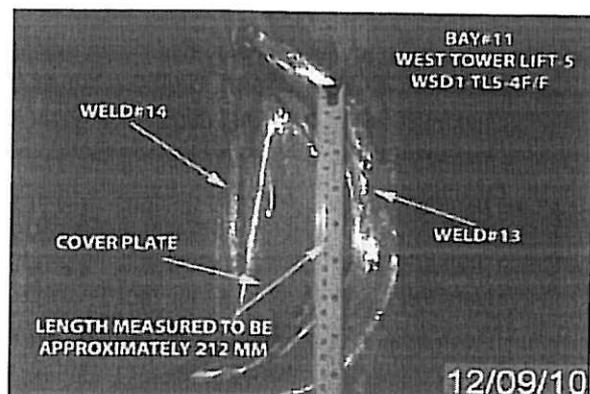
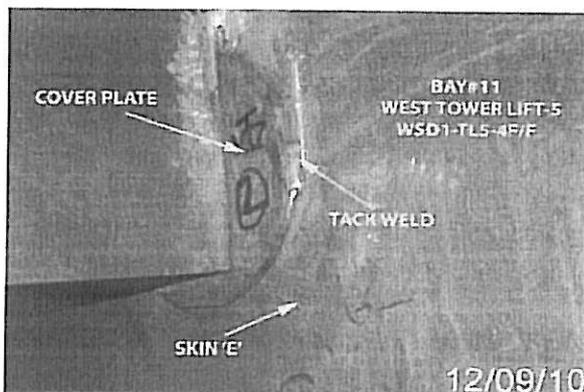
Procedural Procedural Description:

Reference Description: West Tower Cover Plates Re-installed without following Approved Shop Drawing

Description of Non-Conformance:

During the Caltrans Quality Assurance (QA) in-process observation on West tower lift-5 Cover plate, this QA Inspector discovered the following issue:

- ZPMC fabrication personnel removed 2 cover plates involving a total four (4) Non-SPCM fillet welds without notifying the Engineer.
- ZPMC re-welded with new cover plates, where the dimensions of the cover plates do not comply with the approved drawings.
- As per the shop drawing the required length of the cover plate is 151.4 mm. The length measured was approximately 212 mm.
- Welds are fillet welds joining cover plate to skin 'E'.
- The weld designations are WSD1-TL5-4F/F#13; 14; 15; 16.
- This component located at fabrication Bay#11.
- NCR ZPMC-827 had been issued on 10/19/2010 for the two non-conforming cover plates that were removed. Response to this NCR is still outstanding today.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5 2002 Section 3.7.5: "The Engineer shall be notified before improperly fitted and welded members are cut apart".

Approved Shop Drawing: "WSD1-TL5-4F-F".

Who discovered the problem: Naddi Sandeep Kumar

Name of individual from Contractor notified: Bi Dewei

Time and method of notification: 1000 hours, 12/09/10, Verbal

Name of Caltrans Engineer notified: Jim Reid

Time and method of notification: 1000 hours, 12/10/10, Verbal

QC Inspector's Name: Mr. Sun Zi Wang

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

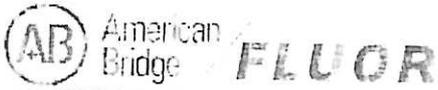
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR



AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 20223 Oakland, CA 94623
Phone (510) 419-0120 / Fax (510) 839-0606

NCR PROPOSED RESOLUTION

To: CALTRANS - SAS Superstructure
333 Burma Road
Oakland CA 94607
Attention: Siegenthaler, Peter
Resident Engineer
Ref: 05.03.06-000893
Subject: NCR No. ZPMC-0897

Dated: 27-Dec-2010
Contract No.: 04-0120F4
04-SF-80-13.2 / 13.9
Job Name: SAS Superstructure
Document No.: ABF-NPR-000890 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:
See ZPMC's comments.

Submitted by: Ishibashi, Joshua
Attachment(s): ABF-NPR-000890R00;

Caltrans' comments:

Status: AAP
Date: 28-Dec-2010

This proposed resolution is accepted with action pending. This NCR will be considered closed once the proper NDT documentation is submitted and reviewed. The NDT documentation submitted with the current NPR was for Weld IDs WSD1-TL5-2F/F-13, -14, -15, and -16. The weld IDs associated with this NCR are Weld IDs WSD1-TL5-4F/F-13, -14, -15, and -16.

Submitted by: Eagen, Sean
Attachment(s):

Date: 28-Dec-2010



DEPARTMENT OF TRANSPORTATION

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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-000885**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0897**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: 10-Dec-2010**Description of Non-Conformance:**

During the Caltrans Quality Assurance (QA) in-process observation on West tower lift-5 Cover plate, this QA Inspector discovered the following issue:

- ZPMC fabrication personnel removed 2 cover plates involving a total four (4) Non-SPCM fillet welds without notifying the Engineer .
- ZPMC re-welded with new cover plates, where the dimensions of the cover plates do not comply with the approved drawings.
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- The weld designations are WSD1-TL5-4F/F#13; 14; 15; 16.
- This component located at fabrication Bay#11.
- NCR ZPMC-827 had been issued on 10/19/2010 for the two non-conforming cover plates that were removed. Response to this NCR is still outstanding today.

Contractor's proposal to correct the problem:

Contractor will submit revised shop drawing as per the as built for Engineer's approval. Ensure in future to communicate with CT before any modification works are performed.

Corrective action taken:

Contractor has revised the shop drawing and submitted for Engineer's approval. The revised drawing has been accepted and the cover plate left as- built.

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:

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 Wahbeh, Mazen 818-292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer
