

**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-000948**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0907**Type of problem:**

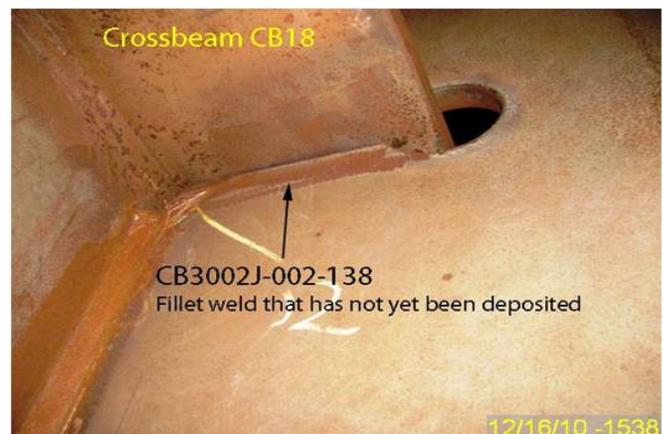
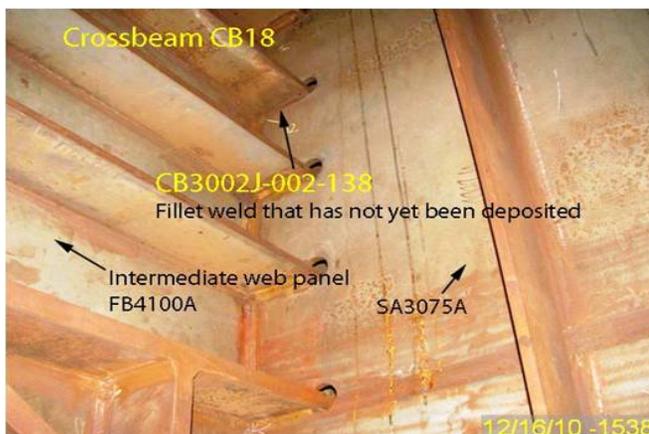
<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Crossbeam 18, CB3002J-002-138
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** QA Discovered Missing Weld already accepted by QC's VT Report on CB18**Description of Non-Conformance:**

During Caltrans Quality Assurance (QA) Visual Testing (VT) verification of welds located on OBG Crossbeam identified as CB18, this QA discovered the following issue:

- ZPMC Quality Control (QC) inspectors have issued a report stating that they had visually tested and accepted a fillet weld where the fillet appears to be missing.
- VT report identified as B-VT-87758, documents that this weld was visually tested and accepted.
- The weld is identified as CB3002J-002-138.
- This weld is a fillet weld joining Floor Beam (FB4100A) to the I-rib stiffeners (X3726E) and the interior Diaphragm identified as SA3075A.
- CB18 is currently located outside the north end of Bay 18.

The notice of witness Inspection Number (NWIT) is 07782. This weld joint is within an area that has been previously tested and accepted by ZPMC Quality Control (QC) personal. As per contract documents ZPMC is required to perform 100% visual testing (VT) of this weld.



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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Applicable reference:**

AWS D1.5-2002 Section 6.26.1: "All welds shall be visually inspected."

AWS D1.5-2002 Section 6.5.1: "The Inspector shall make certain that the size, length, and the location of all welds conform to the requirements of this code and to the detail drawings."

8-3.01 WELDING GENERAL; "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".

**Who discovered the problem:** D. Sukanthan

**Name of individual from Contractor notified:** Steve Lawton

**Time and method of notification:** 0830 hours, 12-17-10, Email

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 1030 hours, 12-17-10 Email

**QC Inspector's Name:** Huang Min

**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.

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<b>Inspected By:</b>	Devey,Jim	SMR
<b>Reviewed By:</b>	Wahbeh,Mazen	SMR

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**DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge**  
666 Feng Bin Road Room 708, Changxing Island  
Shanghai 201913 PR China  
Tel: 021-56856666 ext 207061 Fax:

## NON-CONFORMANCE REPORT TRANSMITTAL

**To:** AMERICAN BRIDGE/FLUOR, A JV  
375 BURMA ROAD  
OAKLAND CA 95607

**Date:** 16-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:** 05.03.06-000905

**Subject:** NCR No. ZPMC-0907

**Reference Description:** QA Discovered Missing Weld already accepted by QC's VT Report on CB18

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 Caltrans Quality Assurance (QA) Visual Testing (VT) verification of welds located on OBG Crossbeam identified as CB18, this QA discovered the following issue:

- ZPMC Quality Control (QC) inspectors have issued a report stating that they had visually tested and accepted a fillet weld where the fillet appears to be missing.
- VT report identified as B-VT-87758, documents that this weld was visually tested and accepted.
- The weld is identified as CB3002J-002-138.
- This weld is a fillet weld joining Floor Beam (FB4100A) to the I-rib stiffeners (X3726E) and the interior Diaphragm identified as SA3075A.
- CB18 is currently located outside the north end of Bay 18.

The notice of witness Inspection Number (NWIT) is 07782. This weld joint is within an area that has been previously tested and accepted by ZPMC Quality Control (QC) personal. As per contract documents ZPMC is required to perform 100% visual testing (VT) of this weld.

### 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:** Ching Chao

**Attachments:** ZPMC-0907

**cc:** Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Laraine Woo, 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:** 05.03.06-000905

**Subject:** NCR No. ZPMC-0907

**Dated:** 24-Feb-2011

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000929 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC has completed the weld and is providing the VT report to show that it is in fact present in accordance with the code and made certain that the size, length, and the location of all welds.

ZPMC has completed the weld and is providing the VT report to show that it is in fact present in accordance with the code and made certain that the size, length, and the location of all welds conform to the requirements. ZPMC QA has been reminded to check with their Production counterparts before issuing a inspection request to prevent this from occurring again. Based on this, ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000929R00;

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### Caltrans' comments:

**Status:** CLO

**Date:** 27-Feb-2011

The weld that was missed by QC has since been welded and the QC VT record (dated Feb 21, 2011) has been provided. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0907 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 27-Feb-2011

**DEPARTMENT OF TRANSPORTATION**

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Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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, China**Report No:** NCR-000948**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0907**Type of problem:**

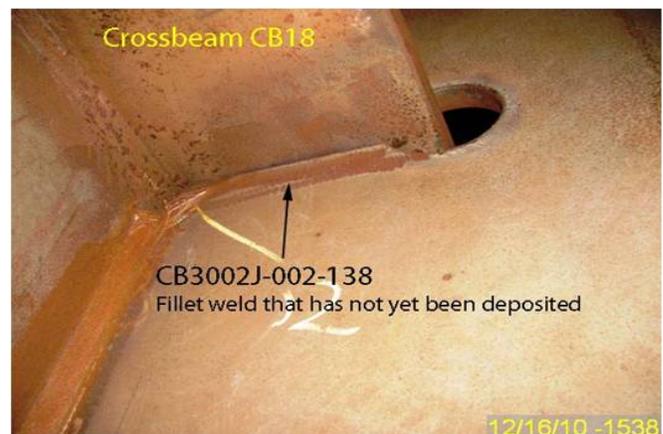
<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b> Crossbeam 18, CB3002J-002-138
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** QA Discovered Missing Weld already accepted by QC's VT Report on CB18**Description of Non-Conformance:**

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Applicable reference:**

AWS D1.5-2002 Section 6.26.1: "All welds shall be visually inspected."

AWS D1.5-2002 Section 6.5.1: "The Inspector shall make certain that the size, length, and the location of all welds conform to the requirements of this code and to the detail drawings."

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**Name of individual from Contractor notified:** Steve Lawton

**Time and method of notification:** 0830 hours, 12-17-10, Email

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 1030 hours, 12-17-10 Email

**QC Inspector's Name:** Huang Min

**Was QC Inspector aware of the problem:** Yes No

**Contractor's proposal to correct the problem:**

NA

**Comments:**

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<b>Inspected By:</b>	Devey,Jim	SMR
<b>Reviewed By:</b>	Wahbeh,Mazen	SMR

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DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge  
666 Feng Bin Road Room 708, Changxing Island  
Shanghai 201913 PR China  
Tel: 021-56856666 ext 207061 Fax:

## NON-CONFORMANCE REPORT TRANSMITTAL

**To:** AMERICAN BRIDGE/FLUOR, A JV  
375 BURMA ROAD  
OAKLAND CA 95607

**Date:** 16-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:** 05.03.06-000905

**Subject:** NCR No. ZPMC-0907

**Reference Description:** QA Discovered Missing Weld already accepted by QC's VT Report on CB18

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- 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 Caltrans Quality Assurance (QA) Visual Testing (VT) verification of welds located on OBG Crossbeam identified as CB18, this QA discovered the following issue:

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-The weld is identified as CB3002J-002-138.

-This weld is a fillet weld joining Floor Beam (FB4100A) to the I-rib stiffeners (X3726E) and the interior Diaphragm identified as SA3075A.

-CB18 is currently located outside the north end of Bay 18.

The notice of witness Inspection Number (NWIT) is 07782. This weld joint is within an area that has been previously tested and accepted by ZPMC Quality Control (QC) personal. As per contract documents ZPMC is required to perform 100% visual testing (VT) of this weld.

### 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:** Ching Chao

**Attachments:** ZPMC-0907

**cc:** Peter Siegenthaler, Stanley Ku, Contract Files, Ching Chao, Laraine Woo, Bill Casey

**File:** 05.03.06

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Time and method of notification:** 0830 hours, 12-17-10, Email

**Name of Caltrans Engineer notified:** Ching Chao

**Time and method of notification:** 1030 hours, 12-17-10 Email

**QC Inspector's Name:** Huang Min

**Was QC Inspector aware of the problem:**  Yes  No

**Contractor's proposal to correct the problem:**

NA

**Comments:**

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<b>Inspected By:</b>	Devey,Jim	SMR
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<b>Reviewed By:</b>	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-000908**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Feb-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0907**Type of problem:**

<b>Welding</b>	<b>Concrete</b>	<b>Other</b>	
<b>Welding</b>	<b>Curing</b>	<b>Procedural</b>	<b>Bridge No:</b> 34-0006
<b>Joint fit-up</b>	<b>Coating</b>	<b>Other</b>	<b>Component:</b>
<b>Procedural</b>	<b>Procedural</b>	<b>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 16-Dec-2010**Description of Non-Conformance:**

During Caltrans Quality Assurance (QA) Visual Testing (VT) verification of welds located on OBG Crossbeam identified as CB18, this QA discovered the following issue:

-ZPMC Quality Control (QC) inspectors have issued a report stating that they had visually tested and accepted a fillet weld where the fillet appears to be missing.

-VT report identified as B-VT-87758, documents that this weld was visually tested and accepted.

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The notice of witness Inspection Number (NWIT) is 07782. This weld joint is within an area that has been previously tested and accepted by ZPMC Quality Control (QC) personal. As per contract documents ZPMC is required to perform 100% visual testing (VT) of this weld.

**Contractor's proposal to correct the problem:**

Contractor to complete the weld, and provide the VT report to show that it is in fact present in accordance with the code and make certain that the size, length, and the location of all welds conform to the requirements.

ZPMC QC will be reminded to check with their Production team before issuing inspection request.

**Corrective action taken:**

Contractor completed the missing weld and provided the VT report showing the weld was present as per Code and conformed to the requirement. Contractor's QC was reminded to check with the Production team before issuing notification for inspection.

**Did corrective action require Engineer's approval?**

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**Yes    No**

**If so, name of Engineer providing approval:**

**Date:**

**Is Engineer's approval attached?**                      **Yes    No**

**Comments:**

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**Inspected By:**    Ng,Michael

Quality Assurance Inspector

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**Reviewed By:**    Wahbeh,Mazen

QA Reviewer