

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-000952**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0911**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 14E East Anchorage Vertical SA Plates
Procedural	Procedural	Description:	

Reference Description: Cuts Made on Lift 14E East Anchorage (SA) Vertical Plates Not Shown on Approved Shop Drawings

Description of Non-Conformance:

During the Quality Assurance (QA) random in-process observations of the fabrication of OBG segment 14E in fabrication Bay 14, this Caltrans QA Inspector observed the following issue:

- ZPMC personnel cut out the leading edge of the Vertical Shear Plate Sub-Assemblies (Web) in a total of nine (9) locations to facilitate fit up at the Panel Point 125 Floorbeam (FB3262A) slotted flange connection.
- Following the removal of the Shear Plate web material, ZPMC personnel have masked the roughly free hand cut area by welding it to the flange plate.
- The Vertical Shear Plate sub-assemblies are identified as SA3357A, SA3358A, SA3359A, SA3360A, SA3361A, SA3362A, SA3363A, SA3364A and SA3365A and are designated on the contract drawings as Seismic Performance Critical Members (SPCM).
- Maximum dimension of the Vertical Shear Plate web removal was 20mm deep and 40mm in length.
- Segment 14E is in the OBG Fabrication Bay 14.

See attached photographs for additional detail.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Contract Approved Shop Drawings: SA3357A, SA3358A, SA3359A, SA3360A, SA3361A, SA3362A, SA3363A, SA3364A and SA3365A

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."

AWS D1.5 2002; Section 3.2.2 "In all thermal cutting, the cutting flame shall be so adjusted and manipulated as to avoid cutting beyond (inside) the prescribed lines."

Who discovered the problem: Rodney Patterson
Name of individual from Contractor notified: Li Man Kit
Time and method of notification: 0930 Hrs, 12/23/10, Verbal
Name of Caltrans Engineer notified: Stanley Ku
Time and method of notification: 1515 Hrs, 12/23/10, Verbal
QC Inspector's Name: Mr. Geng Wei
Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000908

Subject: NCR No. ZPMC-0911

Dated: 24-May-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000956 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

ZPMC has completed the work per the RFI, based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000956R00;

Caltrans' comments:

Status: CLO

Date: 25-May-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0911 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 25-May-2011



TRANSMITTAL LETTER

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

DATE:2011-05-24

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: OBG NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

(01) LR: No. B-998

(02) NCR-000952(ZPMC-0911)

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER: Jare

DATE: RECEIVED 24 MAY 2011
14:42

COMPANY: 

PHONE NO. _____

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



No. B-998

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-05-24

REGARDING: NCR-000952(ZPMC-0911)

During the installation of EB anchorage shear plates, ZPMC had to cut a portion of the leading edge. As discussed with engineer, the proposal to taper the cutout with 1:10 transition and grind smooth the cut surface was accepted. All the remedial work as required has been completed. Based on this, ZPMC is requested closure of this NCR.

ATTACHMENT:

NCR-000952(ZPMC-0911)

Confirmed e-mail from department engineer

Handwritten signature

5/24/11

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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-000952

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Dec-2010

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

NCR #: ZPMC-0911

Type of problem:

Welding Concrete Other

Welding Curing Procedural **Bridge No:** 34-0006

Joint fit-up Coating Other **Component:** Lift 14E East Anchorage Vertical SA Plates

Procedural Procedural **Description:**

Reference Description: Cuts Made on Lift 14E East Anchorage (SA) Vertical Plates Not Shown on
 Approved Shop Drawings

Description of Non-Conformance:

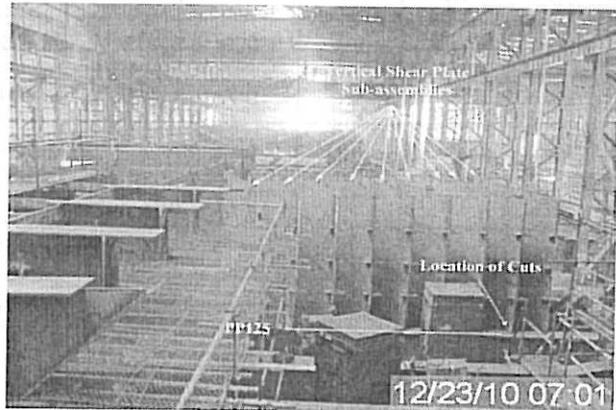
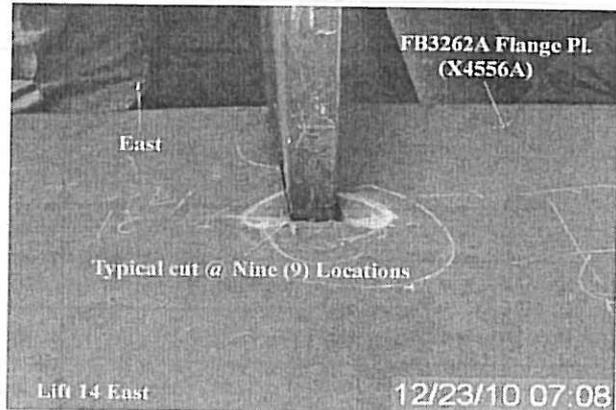
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- Maximum dimension of the Vertical Shear Plate web removal was 20mm deep and 40mm in length.
- Segment 14E is in the OBG Fabrication Bay 14.

See attached photographs for additional detail.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Contract Approved Shop Drawings: SA3357A, SA3358A, SA3359A, SA3360A, SA3361A, SA3362A, SA3363A, SA3364A and SA3365A

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."

AWS D1.5 2002; Section 3.2.2 "In all thermal cutting, the cutting flame shall be so adjusted and manipulated as to avoid cutting beyond (inside) the prescribed lines."

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QC Inspector's Name: Mr. Geng Wei
Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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

Fw: ZPMC-0911

发件人: 张伟 <zhangwei_zj@zpmc.net>
收件人: Lay Tao <taolei@zpmc.com>
日期: 2011-5-20 15:00:47

张伟
2011-05-20

发件人: Steve Lawton
发送时间: 2011-05-13 16:25:37
收件人: 张伟
抄送:
主题: ZPMC-0911

Mr. Zhangwei

Below is a TC-RFI from last year. To respond to this NCR, attach the below emails between Aaron Prchlik and Gang Jiao to your cover letter saying that the remedial work as required per the TC-RFI has been completed.

Steve

From: Aaron Prchlik [mailto:aaron_prchlik@dot.ca.gov]
Sent: Friday, December 24, 2010 6:05 PM
To: Gang Jiao
Cc: 'Chris Havel'; 'Gene Rosamilia'; 'Joshua Ishibashi'; 'Roman Granados'; 'Sean Wichman'; 'zhu yin'
Subject: Re: Emailing: IMG_5528.jpg

Gang,

Your proposal is acceptable.

Aaron Prchlik
Assistant Structure Representative
Caltrans Toll Bridge Construction
(510) 867-6171 Mobile
Aaron_Prchlik@dot.ca.gov

Gang Jiao <gjiao@cn.abfjv.com>

12/24/2010 03:21 PM

To 'Aaron Prchlik' <aaron_prchlik@dot.ca.gov>
cc 'Chris Havel' <chris_havel@dot.ca.gov>, 'Roman Granados' <roman_granados@dot.ca.gov>, 'Sean Wichman' <swichman@cn.abfjv.com>, 'Gene Rosamilia' <grosamilia@cn.abfjv.com>, 'zhu yin' <zyin@cn.abfjv.com>, 'Joshua Ishibashi' <jishibashi@cn.abfjv.com>
Subject Emailing: IMG_5528.jpg

Aaron,

During the installation of EB anchorage shear plates, ZPMC had to cut a portion of the leading edge to clear the interference with PP125 FB flange. Please confirm if it is acceptable to taper the cutout with 1:10 transition and grind smooth the cut surface. No weld repair will be needed.

Regards,

Gang Jiao
ABFJV

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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-000971**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-May-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0911**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: 23-Dec-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random in-process observations of the fabrication of OBG segment 14E in fabrication Bay 14, this Caltrans QA Inspector observed the following issue:

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- Segment 14E is in the OBG Fabrication Bay 14.

See attached photographs for additional detail.

Contractor's proposal to correct the problem:

Contractor to carry out the retrofit work as per the TC-RFI which has been accepted.

Corrective action taken:

ZPMC completed the retrofit as required in the TC-RFI and has been inspected and accepted by QA.

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
