

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-000954**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0913**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: 13AW, LD3034A
Procedural	Procedural	Description:	

Reference Description: Base Metal Repair without Prior Approval from the Engineer**Description of Non-Conformance:**

During a random visual inspection of the Orthotropic Box Girder (OBG) Longitudinal Diaphragm, this Caltrans Quality Assurance (QA) Inspector observed the following issue.

-ZPMC personnel performing base metal repair on the Longitudinal Diaphragm (LD) web at W3, panel point 119 +1500 of Segment 13AW without the Engineer's approval.

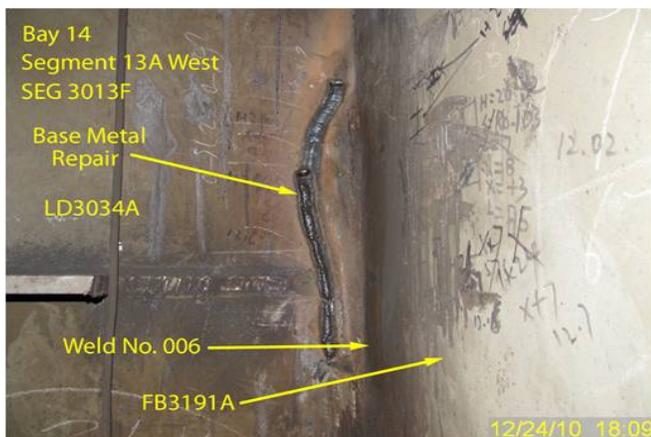
-The Longitudinal Diaphragm is identified as: LD3034A

- Repairs were being performed adjacent to the Vertical web splice identified as LD3034-003 and floor beam to LD weld identified as SEG3013F-006.

-The material utilized is A709 Grade 345 SPCM.

-The welding process used was SMAW.

For further information, please see the attached pictures below.

**Applicable reference:**

Standard Specifications (99) 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

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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: Robert DeArmond

Name of individual from Contractor notified: Ji Cai Tang

Time and method of notification: 1800 hours, 12/24/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 800 hours, 12/26/10, Email

QC Inspector's Name: Li Ping

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Li Ping

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
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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: 27-Dec-2010

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Tara Washington Document Control Assistant
Subject: NCR No. ZPMC-0913

Job Name: SAS Superstructure
Document No: 05.03.06-000910

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

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:** 13

Remarks:

During a random visual inspection of the Orthotropic Box Girder (OBG) Longitudinal Diaphragm, this Caltrans Quality Assurance (QA) Inspector observed the following issue.

- ZPMC personnel performing base metal repair on the Longitudinal Diaphragm (LD) web at W3, panel point 119 +1500 of Segment 13AW without the Engineer’s approval.
- The Longitudinal Diaphragm is identified as: LD3034A
- Repairs were being performed adjacent to the Vertical web splice identified as LD3034-003 and floor beam to LD weld identified as SEG3013F-006.
- The material utilized is A709 Grade 345 SPCM.
- The welding process used was SMAW.

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-0913

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: 05.03.06-000910

Subject: NCR No. ZPMC-0913

Dated: 02-Mar-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000932 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT of the base metal repair to show that the repair was successful.

ZPMC is providing NDT of the base metal repair to show that the repair was successful. The QA and QC departments have been reminded that if they see repairs they must verify that the proper documents on hand before allowing the repair to proceed. The production foreman has been reminded as well that documents on hand are needed before this work should be executed. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000932R00;

Caltrans' comments:

Status: CLO

Date: 02-Mar-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0913 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 02-Mar-2011

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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, China**Report No:** NCR-000954**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0913**Type of problem:**Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:**Bridge No:** 34-0006**Component:** 13AW, LD3034A**Reference Description:** Base Metal Repair without Prior Approval from the Engineer**Description of Non-Conformance:**

During a random visual inspection of the Orthotropic Box Girder (OBG) Longitudinal Diaphragm, this Caltrans Quality Assurance (QA) Inspector observed the following issue.

-ZPMC personnel performing base metal repair on the Longitudinal Diaphragm (LD) web at W3, panel point 119 +1500 of Segment 13AW without the Engineer's approval.

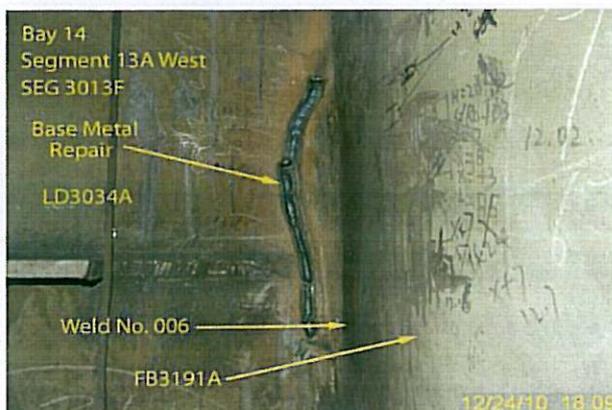
-The Longitudinal Diaphragm is identified as: LD3034A

-Repairs were being performed adjacent to the Vertical web splice identified as LD3034-003 and floor beam to LD weld identified as SEG3013F-006.

-The material utilized is A709 Grade 345 SPCM.

-The welding process used was SMAW.

For further information, please see the attached pictures below.

**Applicable reference:**

Standard Specifications (99) 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

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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-000907**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 02-Mar-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0913**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: 24-Dec-2010**Description of Non-Conformance:**

During a random visual inspection of the Orthotropic Box Girder (OBG) Longitudinal Diaphragm, this Caltrans Quality Assurance (QA) Inspector observed the following issue.

-ZPMC personnel performing base metal repair on the Longitudinal Diaphragm (LD) web at W3, panel point 119 +1500 of Segment 13AW without the Engineer's approval.

-The Longitudinal Diaphragm is identified as: LD3034A

- Repairs were being performed adjacent to the Vertical web splice identified as LD3034-003 and floor beam to LD weld identified as SEG3013F-006.

-The material utilized is A709 Grade 345 SPCM.

-The welding process used was SMAW.

For further information, please see the attached pictures below.

Contractor's proposal to correct the problem:

Contractor will provide the NDT report to prove the repair is successful. Contractor will remind the QC department and the production foreman that proper repair documentation should be on hand prior to any repair works.

Corrective action taken:

Contractor provided the NDT report showing the repair is successful. The QC department and the production foreman was reminded that proper repair documentation should be on hand prior to execution of repair works.

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)

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer