

**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

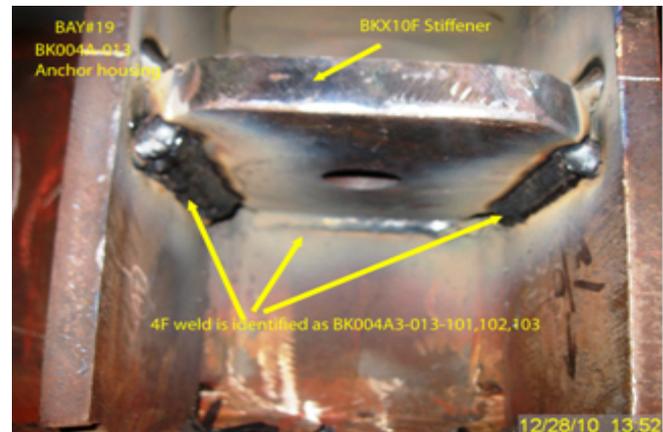
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000960**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 28-Dec-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0919**Type of problem:****Welding****Concrete****Other****Welding****Curing****Procedural****Bridge No:** 34-0006**Joint fit-up****Coating****Other****Component:** Bikepath BK004A-013**Procedural****Procedural****Description:**

**Reference Description:** ZPMC welder performed welding in a position which he is not qualified to weld (Bikepath BK004A-013)

**Description of Non-Conformance:**

During the Quality Assurance (QA) random observation of the fabrication of OBG Bike path BK004A-013, this QA Inspector discovered the following issue:

- ZPMC welder ID#062752 performed welding in a position in which he is not qualified according to his welder card.
- The welder is qualified to the 3G (FCAW) position.
- The welder was observed by this QA welding in the 4F position.
- There are three fillet weld joints completed by this welder in the 4F position.
- The welds are identified as BK004A3-013-101,102 and 103.
- The welds are fillet welds joint connecting the stiffener BKX10F to 25mm stiffener plate BKX11 and stiffener BKSA1A (Anchor Housing assembly).
- OBG Bike path is located inside bay 19.



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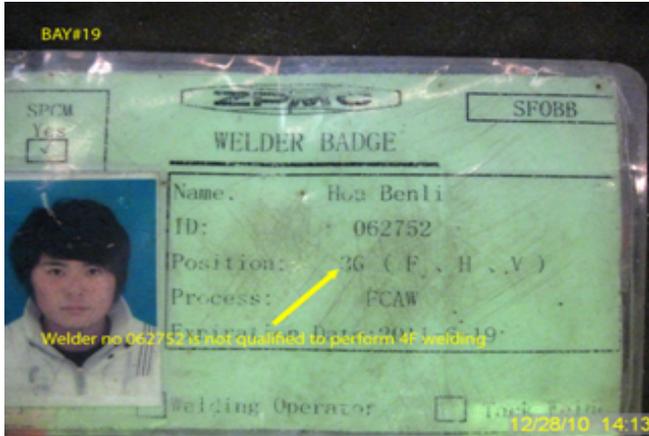
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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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### Applicable reference:

AWS D1.5-2002, Table 5.6, Welder Qualification-Type and Position Limitations Specifies a welder tested in the 3G position is qualified to weld in the 1G,2G,3G and 1F,2F,3F positions only.

Standard Specifications July 1999, 55-3.17 WELDING

•?Welding, welder qualification and inspection of welding shall conform to the requirements in these specifications, ANSI/AASHTO/AWS D1.5 and the special provisions.

**Who discovered the problem:** Chandra Sudalaimuthu

**Name of individual from Contractor notified:** Peng wen jun

**Time and method of notification:** 1400 hours, 12/28/10, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 1530 hours, 12/29/10, Verbal

**QC Inspector's Name:** Guo xing hui

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

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**Inspected By:** Tsang, Eric SMR

**Reviewed By:** Wahbeh, Mazen SMR

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## NCR PROPOSED RESOLUTION

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

**Attention:** Siegenthaler, Peter  
Resident Engineer

**Ref:** 05.03.06-000917

**Subject:** NCR No. ZPMC-0919

**Dated:** 23-Feb-2011

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000925 **Rev:** 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC has removed the plate and welds, this plate was not on the drawing so ZPMC is providing NDT of the base metal where the plate and welds were removed.

ZPMC has removed the plate and welds, this plate was not on the drawing so ZPMC is providing NDT of the base metal where the plate and welds were removed. Based on this ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000925R00;

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### Caltrans' comments:

**Status:** CLO

**Date:** 23-Feb-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0919 is closed.

**Submitted by:** Eagen, Sean

**Date:** 23-Feb-2011

**Attachment(s):**



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

DATE:2011-02-22

TO: ROSEMARY/ABF JV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: OBG NCR

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS

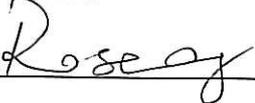
ENCLOSED WITH THIS TRANSMITTAL IS ONE COPY OF

- (01) LR: No. B-976
- (02) NCR-000960(ZPMC-0919)  
B787-MT-35575

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:


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COMPANY:



DATE: <sup>16:15</sup>  
 RECEIVED 22 FEB 2011  


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PHONE NO.

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



No. B-976

## LETTER OF RESPONSE

**TO:** American Bridge/Flour

**DATE:** 2011-2-22

**REGARDING:** NCR-000960(ZPMC-0919)

ZPMC acknowledged this problem and has written an internal NCR. The unsatisfied welds have been removed and were repaired with CWR report after doing NDT on removal area. As the area no NDT request after welding, ZPMC is just providing the NDT record of base metal for Engineer to review and is expecting the closure of this NCR.

**ATTACHMENT:**

NCR-000960(ZPMC-0919)

B787-MT-35575

*Zhangwei*  
*2/21/11*



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:** 30-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:** 05.03.06-000917  
**Subject:** NCR No. ZPMC-0919

**Reference Description:** ZPMC welder performed welding in a position which he is not qualified to weld (Bikepath BK004A-013)

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:** Bike Path **Lift:**

### Remarks:

During the Quality Assurance (QA) random observation of the fabrication of OBG Bike path BK004A-013, this QA Inspector discovered the following issue:

- ZPMC welder ID#062752 performed welding in a position in which he is not qualified according to his welder card.
- The welder is qualified to the 3G (FCAW) position.
- The welder was observed by this QA welding in the 4F position.
- There are three fillet weld joints completed by this welder in the 4F position.
- The welds are identified as BK004A3-013-101,012 and 103.
- The welds are fillet welds joint connecting the stiffener BKX10F to 25mm stiffener plate BKX11 and stiffener BKSA1A (Anchor Housing assembly).
- OBG Bike path is located inside bay 19.

### 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 the issue is expected within 7 days.

**Transmitted by:** Laraine Woo Transportation Engineer

**Attachments:** ZPMC-0919

**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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 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-000960

**Prime Contractor:** American Bridge/Fluor Enterprises, a JV

**Date:** 28-Dec-2010

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

**NCR #:** ZPMC-0919

**Type of problem:**

Welding  Concrete  Other

Welding  Curing  Procedural

Joint fit-up  Coating  Other

Procedural  Procedural  Description:

**Bridge No:** 34-0006

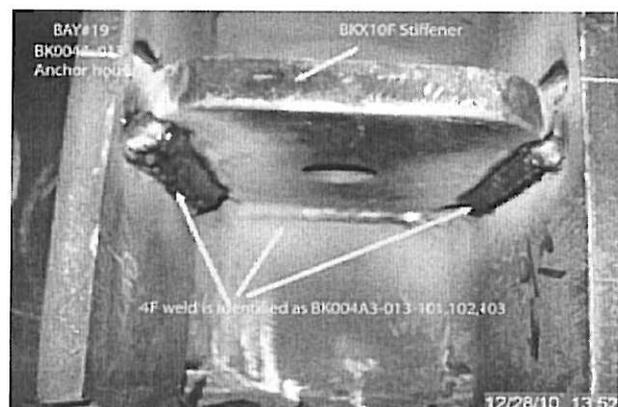
**Component:** Bikepath BK004A-013

**Reference Description:** ZPMC welder performed welding in a position which he is not qualified to weld (Bikepath BK004A-013)

**Description of Non-Conformance:**

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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(Continued Page 2 of 2)

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**Time and method of notification:** 1400 hours, 12/28/10, Verbal

**Name of Caltrans Engineer notified:** Laraine Woo

**Time and method of notification:** 1530 hours, 12/29/10, Verbal

**QC Inspector's Name:** Guo xing hui

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

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

**Comments:**

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<b>Inspected By:</b> Tsang, Eric	SMR
<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, P.R. China**Report No:** NCS-000914**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Feb-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0919**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:** 28-Dec-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) random observation of the fabrication of OBG Bike path BK004A-013, this QA Inspector discovered the following issue:

-ZPMC welder ID#062752 performed welding in a position in which he is not qualified according to his welder card.

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-The welds are fillet welds joint connecting the stiffener BKX10F to 25mm stiffener plate BKX11 and stiffener BKSA1A (Anchor Housing assembly).

-OBG Bike path is located inside bay 19.

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

Contractor will remove the non-conforming welds, and submit the Critical Welding Report. As this plate is not on the drawing Contractor will perform NDT on the base metal where the plate has been removed. Contractor will issue an internal NCR to the QC personnel involved.

**Corrective action taken:**

Contractor removed the welds, and repaired as Critical Welding Repair to the approved procedure. NDT report has been provided proving the base metal is acceptable after repair. ZPMC issued an internal NCR to the QC personnel.

**Did corrective action require Engineer's approval?** Yes No**If so, name of Engineer providing approval:****Date:****Is Engineer's approval attached?**

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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**Yes    No**

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<b>Inspected By:</b>	Ng,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Wahbeh,Mazen	QA Reviewer

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