

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-000964**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 05-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0923**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Facades
Procedural	Procedural	Description:	

Reference Description: Lift 4 131m and 139m Facades connecting from West and North Shafts**Description of Non-Conformance:**

During random in-process visual inspection of Tower sub-assemblies (Facades), Caltrans Quality Assurance (QA) Inspector discovered the following issue:

- Facades have been accepted by CT after paint inspection in the Paint Shop.
- Paint damaged during transportation from Paint Shop to Ship Zhenhua #18 for Tower Shipment 4. Protective softeners were found detached/damaged.
- The façades are identified as ND1-SPSA4-336-131m, ND1-SPSA4-335-139m.

**Applicable reference:**

Special Provisions Section 10-1.69- Clean and Paint Structural Steel, Handling, Storage, and Erection: Due care shall be exercised in handling the steel in the shop, during shipping, during erection, and during subsequent construction of the bridge. The steel shall be insulated from the binding chains by softeners approved by the Engineer. Hooks and slings used to hoist steel shall be padded. Diaphragms and similar pieces shall be spaced in such a way that no rubbing that may damage the coatings will occur during shipment. The steel shall be placed on pallets at the jobsite or by other means approved by the Engineer, so that it does not

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

rest on the dirt, so that water pockets are not formed, and so that components do not fall or rest on each other.

Who discovered the problem: James Lumley

Name of individual from Contractor notified: Don Walton

Time and method of notification: 0930 hours, 01/05/11, Telephone

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0900 hours, 01/06/11, Verbal

QC Inspector's Name: Quin & Zhang Wei

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
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: 06-Jan-2011

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: 05.03.06-000921

Subject: NCR No. ZPMC-0923

Reference Description: Lift 4 131m and 139m Facades connecting from West and North Shafts

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:** 04

Remarks:

- During random in-process visual inspection of Tower sub-assemblies (Facades), Caltrans Quality Assurance (QA) Inspector discovered the following issue:
- Facades have been accepted by CT after paint inspection in the Paint Shop.
 - Paint damaged during transportation from Paint Shop to Ship Zhenhua #18 for Tower Shipment 4. Protective softeners were found detached/damaged.
 - The façades are identified as ND1-SPSA4-336-131m, ND1-SPSA4-335-139m.

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. 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.

Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0923

cc: Rick Morrow, Peter Siegenthaler, Brian Boal, Mark Woods, 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: 05.03.06-000921

Subject: NCR No. ZPMC-0923

Dated: 18-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000914 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution:

ZPMC-0923
Please see ZPMC's comments

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000914R00;

Caltrans' comments:

Status: CLO

Date: 18-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0923 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 18-Jan-2011



No. T-188

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2011-01-16

REGARDING: NCR-000964(ZPMC-923)

ZPMC received NCR-000964(ZPMC-923), it mentioned that CT inspectors found paint was damaged during transportation.

Once got this information, ZPMC took positive action immediately and effective paint repairing work was carried out on the component. And now the paint has passed the inspection on site.

So we hope CT could take review and close this NCR.

ATTACHMENT:

NCR-000964(ZPMC-923)

Zhang

2011.1.16

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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, P.R. China

Report No: NCR-000964

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 05-Jan-2011

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

NCR #: ZPMC-0923

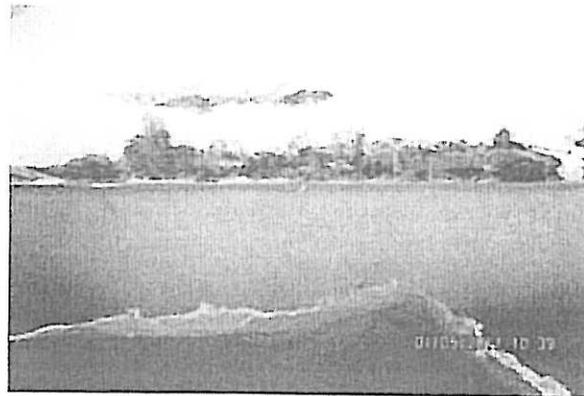
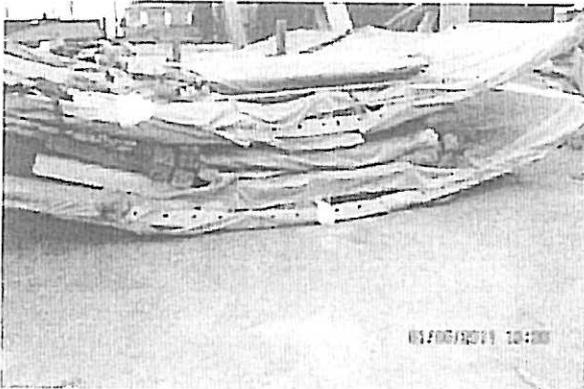
Type of problem:Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: FacadesProcedural Procedural Description:

Reference Description: Lift 4 131m and 139m Facades connecting from West and North Shafts

Description of Non-Conformance:

During random in-process visual inspection of Tower sub-assemblies (Facades), Caltrans Quality Assurance (QA) Inspector discovered the following issue:

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**Applicable reference:**

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

rest on the dirt, so that water pockets are not formed, and so that components do not fall or rest on each other.

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Name of individual from Contractor notified: Don Walton

Time and method of notification: 0930 hours, 01/05/11, Telephone

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 0900 hours, 01/06/11, Verbal

QC Inspector's Name: Quin & Zhang Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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Inspected By: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR



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NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 06-Jan-2011

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: 05.03.06-000921

Subject: NCR No. ZPMC-0923

Reference Description: Lift 4 131m and 139m Facades connecting from West and North Shafts

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- Recurring QC issue that constitutes a systematic problem in quality control.
- Non-Conformance Resolved.

Material Location: Tower Lift: 04

Remarks:

During random in-process visual inspection of Tower sub-assemblies (Facades), Caltrans Quality Assurance (QA) Inspector discovered the following issue:

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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. 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.

Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0923

cc: Rick Morrow, Peter Siegenthaler, Brian Boal, Mark Woods, Contract Files, Ching Chao, Bill Casey

File: 05.03.06

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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-000890**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0923**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: 05-Jan-2011**Description of Non-Conformance:**

During random in-process visual inspection of Tower sub-assemblies (Facades), Caltrans Quality Assurance (QA) Inspector discovered the following issue:

- Facades have been accepted by CT after paint inspection in the Paint Shop.
- Paint damaged during transportation from Paint Shop to Ship Zhenhua #18 for Tower Shipment 4. Protective softeners were found detached/damaged.
- The façades are identified as ND1-SPSA4-336-131m, ND1-SPSA4-335-139m.

Contractor's proposal to correct the problem:

Contractor proposes to repair the paint on the damaged areas. Contractor will ask for inspection after the paint repaired.

Corrective action taken:

Contractor repaired the paint damaged areas. QA Inspection was performed, and accepted.

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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Inspected By: Ng, Michael

Quality Assurance Inspector

Reviewed By: Devey, Jim

QA Reviewer