

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 #: 04-0120F4
 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-000965

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Jan-2011

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

NCR #: ZPMC-0924

Type of problem:

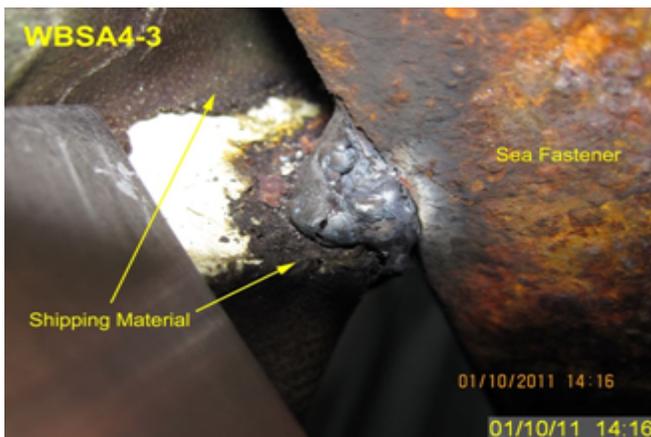
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Tower Walkway support Beam
Procedural	Procedural	Description:	

Reference Description: Unspecified welding of Tower Walkway Support Beam to Sea Fastener

Description of Non-Conformance:

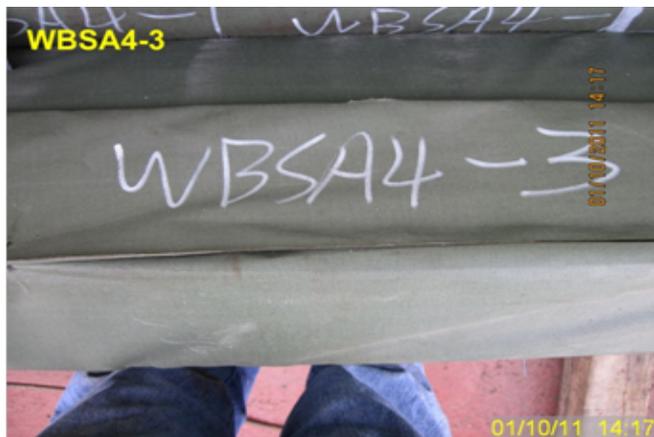
During the Quality Assurance (QA) random visual inspection of Tower Components being loaded on Ship (Zhen Hua vessel #18), this QA Inspector discovered the following issues:

- ZPMC has welded a ship sea fastener to a Walkway Support Beam.
- The approved shop drawings do not specify any welds in these areas.
- The member is identified as WBSA4-3.
- The additional material and welding was not approved by the engineer
- This QA also noted that ZPMC did not appear to have preheated the area welded.
- It appears that ZPMC personnel welded through the shipping material.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

55-1.01 DESCRIPTION: "This work shall consist of constructing steel structures in conformance with the details shown on the plans and as specified in these specifications and the special provisions."

55-2.01 DESCRIPTION: "The various materials shall conform to the requirements in ASTM as listed in the table entitled "Structural Steel Materials" at the end of this Section 55-2.01."

AWS D1.5-2002 Section 6.5.1: "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval".

AWS D1.5-2002 Section 3.3.8 Temporary welds: "Temporary welds shall be subject to the same WPS requirements as final welds." "Temporary welds at other locations shall be shown on the shop drawings." "They shall be removed unless approved by the engineer"

AWS D1.5 (2002), Section 4.2.7: requires the base metal material to be at or above the specified minimum temperature for a distance not less than 75mm in all directions from the point of welding.

Who discovered the problem: James Lumley

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 0900 hrs, email, 01/11/2011

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1025hrs, verbal, 01/11/2011

QC Inspector's Name:

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, 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: 12-Jan-2011

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0924

Job Name: SAS Superstructure
Document No: 05.03.06-000922

Reference Description: Unspecified welding of Tower Walkway Support Beam to Sea Fastener

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:**

Remarks:

During the Quality Assurance (QA) random visual inspection of Tower Components being loaded on Ship (Zhen Hua vessel #18), this QA Inspector discovered the following issues:

- ZPMC has welded a ship sea fastener to a Walkway Support Beam.
- The approved shop drawings do not specify any welds in these areas.
- The member is identified as WBSA4-3.
- The additional material and welding was not approved by the engineer
- This QA also noted that ZPMC did not appear to have preheated the area welded.
- It appears that ZPMC personnel welded through the shipping material.

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 with the appropriate Welding Procedure Specification (WPS). 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-0924

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

NCT

(Continued Page 2 of 2)

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000922

Subject: NCR No. ZPMC-0924

Dated: 13-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000910 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: "ZPMC has removed the tack weld and repaired the surface by grinding and re applied the paint under the supervision of the Department's representative which was acceptable.

"ZPMC has removed the tack weld and repaired the surface by grinding and re applied the paint under the supervision of the Department's representative which was acceptable. In the future to prevent these incidents more supervision of workers on the boat will be provided by ZPMC's QC Department and the department responsible for loading."

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000910R00;

Caltrans' comments:

Status: REJ

Date: 18-Jan-2011

Please provide applicalbe documentation of NDT for the surface repair (grinding) performed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 18-Jan-2011



No. T-186

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2011-01-13

REGARDING: NCR-000965(ZPMC-924)

ZPMC received NCR-000965(ZPMC-924), it mentioned that CT inspectors found ZPMC has tack welded a ship sea fastener to Walkway Support Beam which damage a paint area.

ZPMC take a positive paint repairing work on the component. And now the paint has passed the inspection.

Here we provide relative reports, hope CT could take review and close this NCR.

ATTACHMENT:

NCR-000965(ZPMC-924)

Notice of Inspection T1917

Zhao Jia Neng

2011. 1.13



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: 12-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: 05.03.06-000922

Subject: NCR No. ZPMC-0924

Reference Description: Unspecified welding of Tower Walkway Support Beam to Sea Fastener

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:

Remarks:

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The response for the resolution of this issue is requested within 7 days.

Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0924

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

05.03.06-000922.NCT

NCT

(Continued Page 2 of 2)

File: 05.03.06

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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, P.R. China

Report No: NCR-000965

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Jan-2011

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

NCR #: ZPMC-0924

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

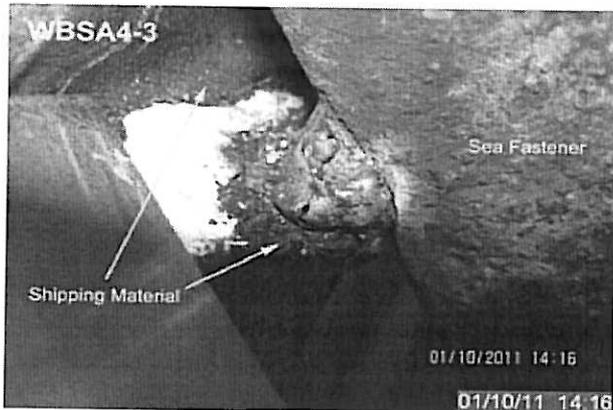
Component: Tower Walkway support Beam

Reference Description: Unspecified welding of Tower Walkway Support Beam to Sea Fastener

Description of Non-Conformance:

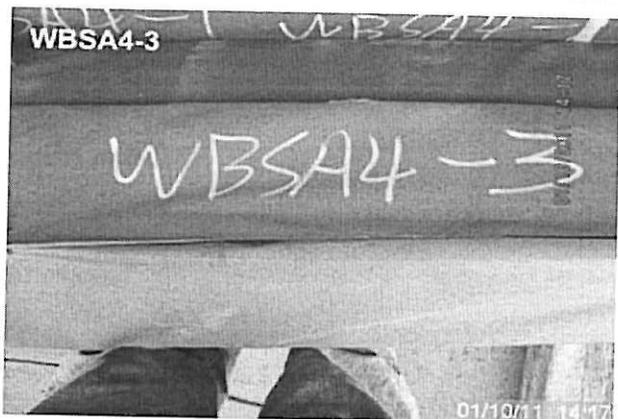
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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AWS D1.5-2002 Section 6.5.1: "The Inspector shall make certain that the size, length, and location of all welds conform to the requirements of this code and to the detail drawings and that no unspecified welds have been added without approval".

AWS D1.5-2002 Section 3.3.8 Temporary welds: "Temporary welds shall be subject to the same WPS requirements as final welds." "Temporary welds at other locations shall be shown on the shop drawings." "They shall be removed unless approved by the engineer"

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Who discovered the problem: James Lumley

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 0900 hrs, email, 01/11/2011

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1025hrs, verbal, 01/11/2011

QC Inspector's Name:

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, who represents the Office of Structural Materials for your project.

Inspected By: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR

Shanghai Zhenhua Heavy Industries
Co., Ltd.

San Francisco-Oakland Bay Bridge

Notice of Inspection



Document No. PR 008 Rev 03

Page 1 of 1

Request Number: T1910-7

The attendance of ABF & CalTrans inspection personnel are requested to carry out inspection of surface preparation and or coating application.

Time: 15:30

Date: 12/01/2011

Location: The shop NO.18

Items offered for inspection

No.	Item description	Code	Total Nos.
1	Tower walkway support beam (weld damaged areas)	WBSA4-3	-
2			

Operations to be Inspected	Item Number							
Degreasing/Cleaning								
Surface Preparation								
Primer Coat Application								
Finish Coat Application								
DFT Check	1							
Adhesion Test								
Residual Chlorides Test								
Others:	1							

Comments:

This area was damaged by weld for sea fastener.
Others means final acceptance inspection prior transport form ZPMC.

Accepted

Inspection requested by: ZPMC

[Signature] 2011. 1. 12

Received by:

[Signature]

ABF:

Date:

12th Jan 2011

Time:

16:28

CalTrans:

[Signature]

Date:

1/13/11

Time:

08:35

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000922

Subject: NCR No. ZPMC-0924

Dated: 20-Jan-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000910 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the MT report after the tack weld was removed to show the base metal is acceptable after grinding, and the paint applied was acceptable.

ZPMC is providing the MT report after the tack weld was removed to show the base metal is acceptable after grinding, and the paint applied was acceptable. Supervision of the loading was increased to prevent other incidents from occurring during loading. Based on this, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000910R01;

Caltrans' comments:

Status: CLO

Date: 20-Jan-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0924 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 20-Jan-2011



No. T-189

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2011-01-20

REGARDING: NCR-000965(ZPMC-924)

ZPMC received NCR-000965(ZPMC-924), it mentioned that CT inspectors found ZPMC has tack welded a ship sea fastener to Walkway Support Beam which damage a paint area.

ZPMC take a positive paint repairing work on the component. And now the paint has passed the inspection.

Here we provide relative reports, hope CT could take review and close this NCR.

ATTACHMENT:

NCR-000965(ZPMC-924)

T787-MT-13245

zhang huali

2011.1.20

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) 649-5483
 (707) 649-5493

Contract #: 04-0120F4
 City: 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-000965

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 10-Jan-2011

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

NCR #: ZPMC-0924

Type of problem:

- Welding Concrete Other
 Welding Curing Procedural
 Joint fit-up Coating Other
 Procedural Procedural Description:

Bridge No: 34-0006

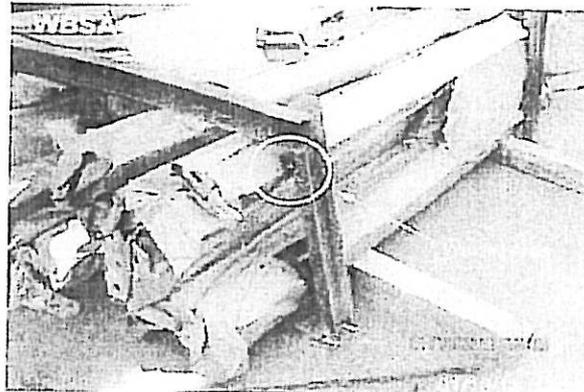
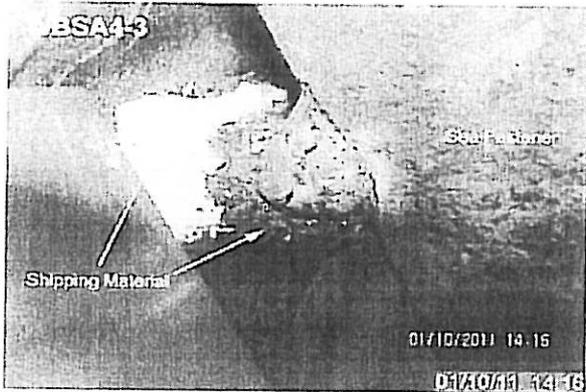
Component: Tower Walkway support Beam

Reference Description: Unspecified welding of Tower Walkway Support Beam to Sea Fastener

Description of Non-Conformance:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 0900 hrs, email, 01/11/2011

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 1025hrs, verbal, 01/11/2011

QC Inspector's Name:

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, who represents the Office of Structural Materials for your project.

Inspected By: Ng, Michael

QA Inspector

Reviewed By: Devey, Jim

SMR

Shanghai Zhenhua Heavy Industries
Co., Ltd.

San Francisco-Oakland Bay Bridge

Notice of Inspection



Document No. PR 008 Rev 03

Page 1 of 1

Request Number: T1910-7

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Time: 15:30

Date: 12/01/2011

Location: The shop NO.18

Items offered for inspection

No.	Item description	Code	Total Nos.
1	Tower walkway support beam (weld damaged areas)	WBSA4-3	-
2			

Operations to be Inspected	Item Number							
Degreasing/Cleaning								
Surface Preparation								
Primer Coat Application								
Finish Coat Application								
DFT Check	1							
Adhesion Test								
Residual Chlorides Test								
Others:	1							

Comments:

This area was damaged by weld for sea fastener.
Others means final acceptance inspection prior transport form ZPMC.

Accepted

Inspection requested by: ZPMC

[Signature] 2011. 1. 12

Received by:

[Signature]

ABF:

Date:

12th Jan 2011

Time:

16:28

CalTrans:

[Signature]

Date:

1/13/11

Time:

08:35

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000896**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 20-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0924**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: 10-Jan-2011**Description of Non-Conformance:**

During the Quality Assurance (QA) random visual inspection of Tower Components being loaded on Ship (Zhen Hua vessel #18), this QA Inspector discovered the following issues:

- ZPMC has welded a ship sea fastener to a Walkway Support Beam.
- The approved shop drawings do not specify any welds in these areas.
- The member is identified as WBSA4-3.
- The additional material and welding was not approved by the engineer
- This QA also noted that ZPMC did not appear to have preheated the area welded.
- It appears that ZPMC personnel welded through the shipping material.

Contractor's proposal to correct the problem:

Contractor will remove the tack weld between sea fasteners to Walkway Support Beams. MT report will be provided to prove the base metal is acceptable. Contractor will inspect paint repaired areas. The loading supervision will increase to prevent the future incidents.

Corrective action taken:

Contractor removed the tack welds between sea fasteners to Walkway beams and ground flush. MT was performed with acceptable MT results. Paint repairs were performed in accordance with the approved PQWP and are acceptable.

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:**

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer