

**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-000972**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 19-Jan-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0931**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> Lift 14W, SEG3020Q-058, SEG3020K-026
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	

**Reference Description:** Missed Class "A" (UT) Indications on Lift 14W weld numbers SEG3020Q-058 and SEG3020K-026 discovered by QA

**Description of Non-Conformance:**

During the Quality Assurance Ultrasonic Testing (UT) verification of welds located on OBG lift 14 West, this Quality Assurance (QA) Inspector discovered the following issues:

- One Class "A" longitudinal indication measuring approximately 20mm in length.
- The depth of the indication is 21mm from face A.
- The db rating is +4.
- The material thickness is 30mm.
- The weld is identified as: SEG3020Q-058.
- The Weld is a Complete Joint Penetration (CJP), Tee-joint, joining the Floorbeam (FB3320A) to the Longitudinal Diaphragm (LD3049A) at Panel Point (PP126).
- The "Y" location of the indication is 1575mm from the top end of the weld as shown in the attached photograph.
- The indication is clearly marked on the component.
- The material is identified as Seismic Performance Critical Member (SPCM) and the weld is identified as Fracture Critical Weld (FCW).
- The member is located in Bay 14.
  
- One Class "A" longitudinal indication measuring approximately 20mm in length.
- The depth of the indication is 23mm from face A.
- The db rating is +6.
- The material thickness is 25mm.
- The weld is identified as: SEG3020K-026.
- The Weld is a Complete Joint Penetration (CJP), Tee-joint, joining the Floor Beam Sub Assembly (SA3410A) to the Bottom Plate (BP3092A) at Panel point (PP127.3).

# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 3 )

- The “Y” location of the indication is 450mm from the Longitudinal Diaphragm (LD3050A) as shown in the attached photograph.
- The indication is clearly marked on the component.
- The material is identified as Seismic Performance Critical Member (SPCM) and the weld is identified as Fracture Critical Weld (FCW).
- The member is located in Bay 14.

The Notice of Witness Inspection Number (NWIT) is 08220. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform 100% UT inspection of these welds. Attached photographs provide additional location details.



## Applicable reference:

AWS D1.5-02 Section 6.6.2 “The Contractor shall be responsible for visual inspection and NDT described in 6.7 necessary correction of all deficiencies in materials and workmanship in conformance with the requirements of Clause 3 and 6.26 and as specified elsewhere in the contract documents.”

AWS D1.5-02 Table 6.3 “Specifies a class A indication for material thicknesses greater than 20mm through 38mm as having a db rating of +8 and lower.”

**Who discovered the problem:** Umesh D. Gaikwad

**Name of individual from Contractor notified:** Li Man Kit

**Time and method of notification:** 15:30, 01/19/11, Verbal

**Name of Caltrans Engineer notified:** Sean Eagen

**Time and method of notification:** 14:00, 01/20/11, Email

**QC Inspector's Name:** Wang Lu

**Was QC Inspector aware of the problem:** 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.

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# QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 3 of 3 )

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<b>Inspected By:</b>	Devey,Jim	SMR
<b>Reviewed By:</b>	Wahbeh,Mazen	SMR

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**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:** 20-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:** 05.03.06-000929

**Subject:** NCR No. ZPMC-0931

**Reference Description:** Missed Class "A" (UT) Indications on Lift 14W weld numbers SEG3020Q-058 and SEG3020K-026 discovered by QA

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:** 14

**Remarks:**

During the Quality Assurance Ultrasonic Testing (UT) verification of welds located on OBG lift 14 West, this Quality Assurance (QA) Inspector discovered the following issues:

- One Class "A" longitudinal indication measuring approximately 20mm in length.
- The depth of the indication is 21mm from face A.
- The db rating is +4.
- The material thickness is 30mm.
- The weld is identified as: SEG3020Q-058.
- The Weld is a Complete Joint Penetration (CJP), Tee-joint, joining the Floorbeam (FB3320A) to the Longitudinal Diaphragm (LD3049A) at Panel Point (PP126).
- The "Y" location of the indication is 1575mm from the top end of the weld as shown in the attached photograph.
- The indication is clearly marked on the component.
- The material is identified as Seismic Performance Critical Member (SPCM) and the weld is identified as Fracture Critical Weld (FCW).
- The member is located in Bay 14.
- One Class "A" longitudinal indication measuring approximately 20mm in length.
- The depth of the indication is 23mm from face A.
- The db rating is +6.
- The material thickness is 25mm.
- The weld is identified as: SEG3020K-026.
- The Weld is a Complete Joint Penetration (CJP), Tee-joint, joining the Floor Beam Sub Assembly (SA3410A) to the Bottom Plate (BP3092A) at Panel point (PP127.3).
- The "Y" location of the indication is 450mm from the Longitudinal Diaphragm (LD3050A) as shown in the attached photograph.
- The indication is clearly marked on the component.

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# NCT

( Continued Page 2 of 2 )

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-The material is identified as Seismic Performance Critical Member (SPCM) and the weld is identified as Fracture Critical Weld (FCW).

-The member is located in Bay 14.

The Notice of Witness Inspection Number (NWIT) is 08220. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of these welds.

## **Action Required and/or Action Taken:**

Propose a resolution for this non-conformance and provide documentation that the deficiency has been brought into compliance with the contract requirements. Propose a resolution that addresses the apparent failure of Quality Control to identify the indication. Additionally, 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-0931

**cc:**    Rick Morrow, 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:** 05.03.06-000929

**Subject:** NCR No. ZPMC-0931

**Dated:** 01-Apr-2011

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000942 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC has repaired the indication noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed.

ZPMC has repaired the indication noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed.

ABFJV has noted which inspector was responsible for this missed indication and is monitoring his performance, if he continues to miss indications disciplinary action will be undertaken. Based on these actions, ZPMC requests closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000942R00;

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### Caltrans' comments:

**Status:** CLO

**Date:** 03-Apr-2011

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0931 is closed.

**Submitted by:** Eagen, Sean

**Attachment(s):**

**Date:** 03-Apr-2011



TRANSMITTAL LETTER

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

DATE:2011-04-01

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-986
- (02) NCR-000972(ZPMC-0931)  
B787-UT-18525 R2  
B787-UT-19438 R3

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

*Rosemary*

COMPANY:



DATE: 16:00  
RECEIVED 01 APR 2011

PHONE NO.

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



No. B-986

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2011-04-01**

**REGARDING: NCR-000972(ZPMC-0931)**

ZPMC acknowledged this problem and has issued an internal NCR. ZPMC has repaired the indications noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed. Based on these actions, ZPMC requests closure of this NCR.

**ATTACHMENT:**

NCR-000972(ZPMC-0931)

B787-UT-18525 R2

B787-UT-19438 R3

*Zhang Wei.*  
*4/1/11*



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 Date: 20-Jan-2011  
 375 BURMA ROAD  
 OAKLAND CA 95607 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: 05.03.06-000929  
 Subject: NCR No. ZPMC-0931

**Reference Description:** Missed Class "A" (UT) Indications on Lift 14W weld numbers SEG3020Q-058 and SEG3020K-026 discovered by QA  
 The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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15.04  
 05.03.06-000929,NCT

Received  
 NCT-000929 20 Jan 11 Page 1 of 2

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## NCT

( Continued Page 2 of 2 )

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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-0931

**cc:** Rick Morrow, Peter Siegenthaler, Stanley Ku, Brian Boal, Contract Files, Ching Chao, Bill Casey

**File:** 05.03.06

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) 649-6453  
(707) 649-6493

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-000972

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

**Date:** 19-Jan-2011

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

**NCR #:** ZPMC-0931

**Type of problem:**

Welding  Concrete  Other

Welding  Curing  Procedural  Bridge No: 34-0006

Joint fit-up  Coating  Other  Component: Lift 14W, SEG3020Q-058, SEG3020K-026

Procedural  Procedural  Description:

**Reference Description:** Missed Class "A" (UT) Indications on Lift 14W weld numbers SEG3020Q-058 and SEG3020K-026 discovered by QA

**Description of Non-Conformance:**

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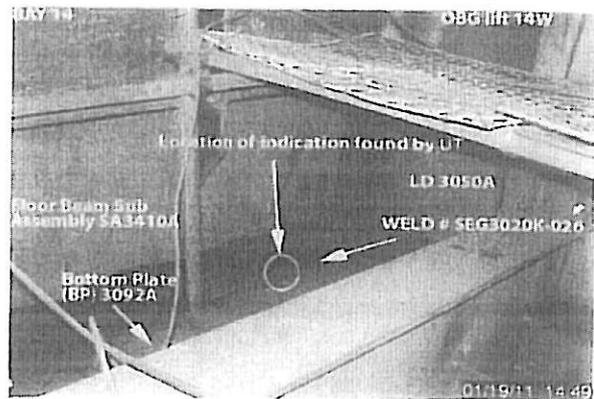
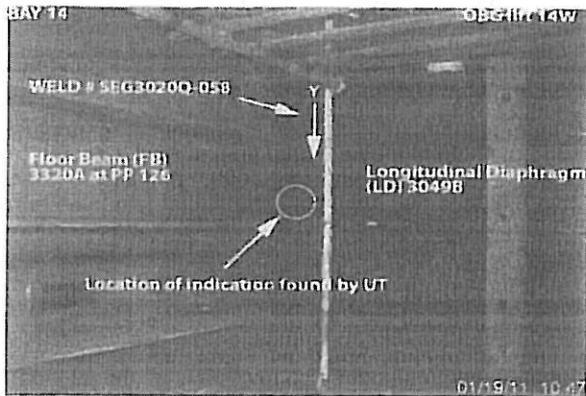
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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)

- The "Y" location of the indication is 450mm from the Longitudinal Diaphragm (LD3050A) as shown in the attached photograph.
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### Applicable reference:

AWS D1.5-02 Section 6.6.2 "The Contractor shall be responsible for visual inspection and NDT described in 6.7 necessary correction of all deficiencies in materials and workmanship in conformance with the requirements of Clause 3 and 6.26 and as specified elsewhere in the contract documents."

AWS D1.5-02 Table 6.3 "Specifies a class A indication for material thicknesses greater than 20mm through 38mm as having a db rating of +8 and lower."

Who discovered the problem: Umesh D. Gaikwad

Name of individual from Contractor notified: Li Man Kit

Time and method of notification: 15:30, 01/19/11, Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 14:00, 01/20/11, Email

QC Inspector's Name: Wang Lu

Was QC Inspector aware of the problem:  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.

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 3 of 3 )

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**Inspected By:** Devey, Jim

SMR

**Reviewed By:** Wahbeh, Mazen

SMR





# REPORT OF ULTRASONIC EXAMINATION

## UT探伤报告

REPORT NO. 报告编号 B787-UT-19438R3      DATE 2011.03.20      PAGE 1 OF 1      Revision No: 0

PROJECT NO.: 工程编号 ZP06-787      CONTRACTOR: CALTRANS

ITEMS NAME: 14W LONGITUDINAL DIAPHRAGM AND FLOOR BEAM      DRAWING NO.: SEG3020      CALTRANS CONTRACT NO.: 04-0120F4  
 部件名称      图号      加州工程编号

REFERENCING CODE 参考规范 AWS D1.5-2002      ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002(Table 6.3)      PROCEDURE NO. 程序编号 ZPQC-UT-01

WELDING PROCESS 焊接方法 SMAW      JOINT TYPE 焊缝类型 T-JOINT      CALIBRATION DUE DATE 仪器校正有效期 Dec. 28<sup>ST</sup>, 2011

EQUIPMENT 设备 UT SCOPE      MANUFACTURER 制造商 OLYMPUS      MODEL NO. 样式编号 EPOCH-4B      SERIAL NO. 序列编号 081610708

CALIBRATION BLOCK 试块 AWS IIW BLOCK TYPE II      COUPLANT 耦合剂 C.M.C      MATERIAL/THICKNESS 材料厚度 A709M-345T2/F2 30/25mm

### TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
AMERICA	70°	2.25MHz	0.75in×0.625in				
Reference Level 参考灵敏度						20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5      0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS 分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SEG3020Q-058	1R2	69				37								ACC.	100%

AFTER B-CWR2620REV2

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EXAMINED BY 主探 king Tim      DATE 11.3.20      REVIEWED BY 审核 Tang Jinyan

LEVEL - II SIGN / DATE      LEVEL - II SIGN / DATE 2011. 03.20

质量经理 / QCM [Signature]      用户 CUSTOMER

签字 SIGN / 日期 DATE      签字 SIGN / 日期 DATE

**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, China**Report No:** NCS-000961**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 04-Apr-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0931**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>Description:</b>	

**Date the Non-Conformance Report was written:** 19-Jan-2011**Description of Non-Conformance:**

During the Quality Assurance Ultrasonic Testing (UT) verification of welds located on OBG lift 14 West, this Quality Assurance (QA) Inspector discovered the following issues:

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- The "Y" location of the indication is 450mm from the Longitudinal Diaphragm (LD3050A) as shown in the

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## QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

( Continued Page 2 of 2 )

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attached photograph.

-The indication is clearly marked on the component.

-The material is identified as Seismic Performance Critical Member (SPCM) and the weld is identified as Fracture Critical Weld (FCW).

-The member is located in Bay 14.

The Notice of Witness Inspection Number (NWIT) is 08220. The indication is located inside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% UT inspection of these welds. Attached photographs provide additional location details.

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

Contractor will repair the welds, and provide the NDT report to prove the weld is acceptable. Contractor will identify and monitor the inspector responsible. Disciplinary action will be undertaken if the inspector continues missing indications.

**Corrective action taken:**

Contractor repaired the indications. NDT report was provided which shows the welds are acceptable. Contractor identified the inspector responsible and his performance is being monitored

**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:**    Wahbeh,Mazen

QA Reviewer

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