

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, China

Report No: NCR-000976

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 22-Jan-2011

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

NCR #: ZPMC-0935

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Lift 13AW Weld# DP3118-001-052
Procedural	Procedural	Description:	

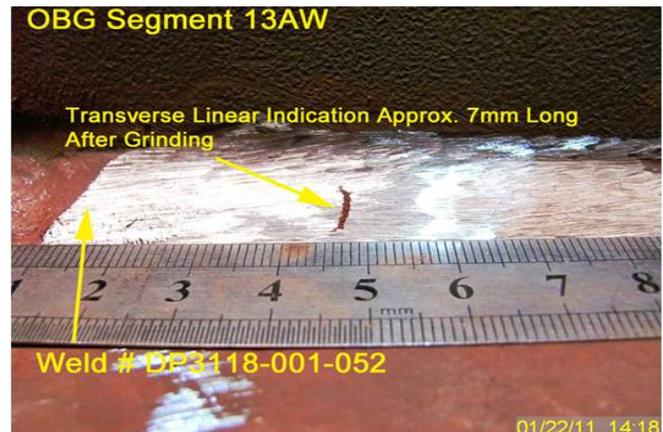
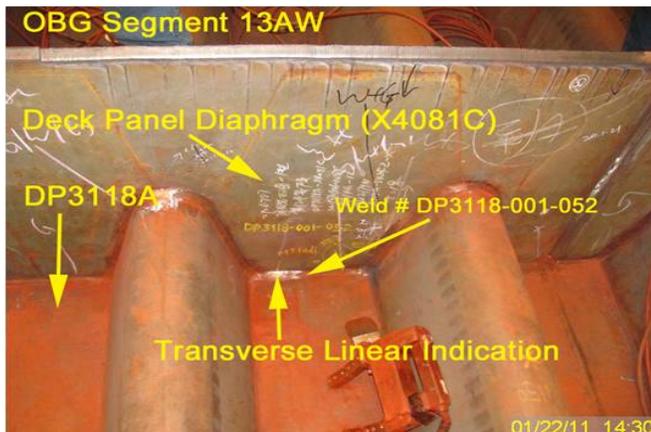
Reference Description: Transverse Crack Discovered by QA on Lift 13AW Deck Panel Weld # DP3118-001-052

Description of Non-Conformance:

During random Quality Assurance Magnetic Particle Testing (MT) review of welds located on Deck Panel of the OBG Segment 13AW, this Caltrans (CT) Quality Assurance Inspector (QA) discovered the following issue:

- One (1) Transverse crack measuring approximately 7 mm in length.
- The indication is clearly marked on the material near the weld.
- The weld is identified as DP3118-001-052.
- Weld is an 8mm Fillet Weld joining the Deck Panel Diaphragm To Deck Plate.
- Deck Panel Diaphragm is identified as X4081C (SPCM)
- Deck Plate is identified as DP3118A/PL3314A (SPCM).
- The weld is designated as Seismic Performance Critical Material (SPCM).
- OBG segment 13AW is located inside OBG Bay 14.
- ZPMC Quality Control Personnel have performed 100% Magnetic Particle Testing of these welds.

For further information, see the attached pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 - "Welds that are subject to RT or MT in addition to visual inspection shall have no cracks..."

AWS D1.5 (02) Figure 6.8 – Specifies the maximum length of discontinuity allowed in an 8mm weld is approximately 3mm.

Who discovered the problem: Vikram Singh

Name of individual from Contractor notified: Mr. C.K. Chan

Time and method of notification: 1400 hours_01/22/11_Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 09:00_1/24/11_Email

QC Inspector's Name: Zhang Wei

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.

Inspected By:	Devey,Jim	SMR
Reviewed By:	Wahbeh,Mazen	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: 24-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: 05.03.06-000933

Subject: NCR No. ZPMC-0935

Reference Description: Transverse Crack Discovered by QA on Lift 13AW Deck Panel Weld # DP3118-001-052

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 random Quality Assurance Magnetic Particle Testing (MT) review of welds located on Deck Panel of the OBG Segment 13AW, this Caltrans (CT) Quality Assurance Inspector (QA) discovered the following issue:
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 - The weld is designated as Seismic Performance Critical Material (SPCM).
 - OBG segment 13AW is located inside OBG Bay 14.
 - ZPMC Quality Control Personnel have performed 100% Magnetic Particle Testing 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-0935

NCT

(*Continued Page 2 of 2*)

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: 05.03.06-000933

Subject: NCR No. ZPMC-0935

Dated: 23-Feb-2011

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000922 Rev: 00

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 as well as all inspector 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-000922R00;

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-0935 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 23-Feb-2011



TRANSMITTAL LETTER

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-974

(02) NCR-000976(ZPMC-0935)

B787-MT-34937 R1

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT

PLAN HOLDER:

Rosemary

COMPANY:



DATE:

8:43

RECEIVED 22 FEB 2011

PHONE NO.

PLAN NUMBER:N/A

#R787-QCP-102



No. B-974

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2011-2-21

REGARDING: NCR-000976(ZPMC-0935)

ZPMC acknowledged this problem and has issued an internal NCR. This indication has been removed, repaired and re-tested to be acceptable. ZPMC is providing the NDT record and is requesting closure of this NCR.

ATTACHMENT:

NCR-000976(ZPMC-0935)

B787-MT-34937 R1

Zhang Wei
2/21/11



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
375 BURMA ROAD
OAKLAND CA 95607

Date: 24-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: 05.03.06-000933

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Attachments: ZPMC-0935

NCT

(Continued Page 2 of 2)

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

File: 05.03.06

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, China

Report No: NCR-000976

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 22-Jan-2011

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

NCR #: ZPMC-0935

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

Bridge No: 34-0006

Component: Lift 13AW Weld# DP3118-001-052

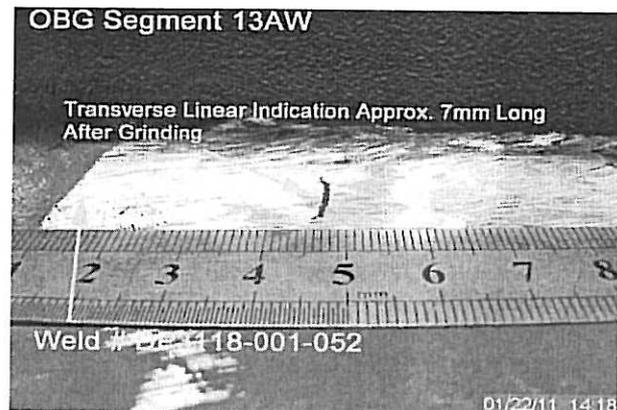
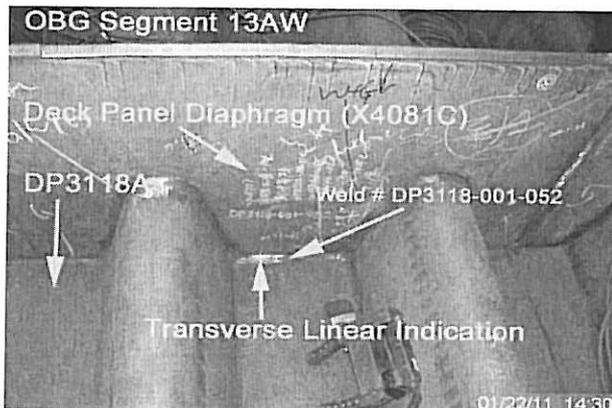
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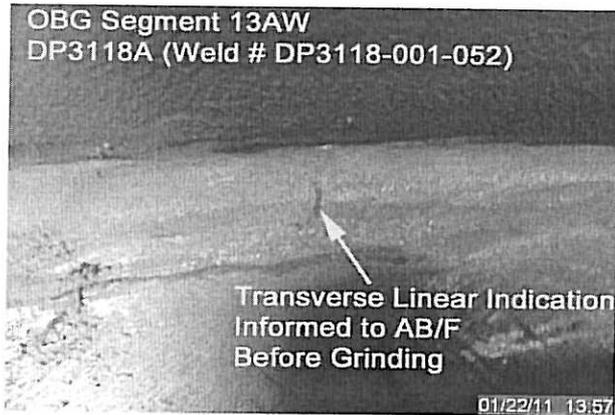
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



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Time and method of notification: 1400 hours_01/22/11_Verbal

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 09:00_1/24/11_Email

QC Inspector's Name: Zhang Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

NA

Comments:

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Inspected By: Devey,Jim

SMR

Reviewed By: 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, China**Report No:** NCS-000911**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Feb-2011**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0935**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: 22-Jan-2011**Description of Non-Conformance:**

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For further information, see the attached pictures below.

Contractor's proposal to correct the problem:

Contractor will repair the indication noted in the NCR and will provide the NDT report to prove the weld is acceptable after repairing. Contractor will monitor the inspector's performance. Disciplinary action will be taken if he misses indication continuously.

Corrective action taken:

Contractor removed the weld indication. NDT report was provided showing the welds are acceptable. The inspector's performance was being monitored.

Did corrective action require Engineer's approval? **Yes** **No**

If so, name of Engineer providing approval:**Date:****Is Engineer's approval attached?**

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(*Continued Page 2 of 2*)

Yes No

Comments:

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Inspected By:	Ng,Michael	Quality Assurance Inspector
Reviewed By:	Wahbeh,Mazen	QA Reviewer
