

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 #: 10.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Muroan Japan**Report No:** NCR-000144**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 05-Jun-2008**Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0003**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: West Deviation Saddle W2E1
Procedural	Procedural	Descriptor: Welding Report submittal	

Reference Description: Special Provisions**Description of Non-Conformance:**

Welding of W2E1 grillage started on May 14, 2008. At this time, no welding reports have been submitted.

Applicable reference:

Special Provisions, Section 8 3. WELDING, WELDING QUALITY CONTROL, page 154

The following items shall be included in a Welding Report that is to be submitted to the Engineer within 10 days following the performance of any welding:

- A. Reports of all visual weld inspections and NDT.
- B. Radiographs and radiographic reports, and other required NDT reports.
- C. Documentation that the Contractor has evaluated all radiographs and other nondestructive tests and corrected all rejectable deficiencies, and all repaired welds have been reexamined by the required NDT and found acceptable.
- D. Reports of each incident of heat straightening
- E. Daily production log.
- F. Summarized log listing the rejected lengths of weld by welder, position, process, joint configuration, and piece number.

Who discovered the problem: Ron Brasel**Name of individual from Contractor notified:** Jim Bowers**Time and method of notification:** 19:00 June 5, 2008 by telephone**Name of Caltrans Engineer notified:** Warren Collins**Time and method of notification:** Email on June 5, 2008**QC Inspector's Name:****Was QC Inspector aware of the problem:**

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Yes No

Contractor's proposal to correct the problem:

Not available at this time.

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 Venkatesh Iyer,(510) 808-4542, who represents the Office of Structural Materials for your project.

Inspected By:	Brasel,Ron	SMR
Reviewed By:	Iyer,Venkatesh	SMR



DEPARTMENT OF TRANSPORTATION
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 Enterprises, a JV
375 Burma Road
Oakland CA 94607

Date: 16-Feb-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000036

Subject: NCR No. ABF-0003

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

Non-Conformance with quality control procedures. Please take appropriate corrective action. Recurrence may require further administrative action.

Non-Conformance with quality control. Records indicate that this is a recurring issue and constitutes a systematic problem in quality control. Within fourteen (14) days, please submit a plan to correct the deficiency.

Material or workmanship is not in compliance with contract requirements.

Enclosed please find the following items:

NCR No: ABF-0003

Remarks:

Please see attachment for details.

Transmitted by: Ching Chao

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods, Doug Coe, Jason Tom, Dave Williams, Contract Files, Kannu Balan, Chin

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000036

Subject: NCR No. ABF-0003

Dated: 24-Apr-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000027 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC QC has instructed the NDT technician to properly mark areas tested

Please see the attached response from ZPMC. ABFJV has reviewed and concurs with this response and considers this issue resolved. ABFJV believes, based on our understanding of the NCT process that this NCR was issued closed as the top (first) box on the NCT was checked. Please confirm.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000027R00;

Caltrans' comments:

Status: CLO

Date: 17-Feb-2009

Per State Letter 05.03.01-003087 dated December 8, 2008, the 77m and 89m Tower Section Mock-ups were successfully completed. The Department concurs that Non-Conformance ABF-0003 is closed.

As noted in ABF-CAL-LTR-000758, the Department understands that the appropriate fabrication plans will be modified in accordance with Special Provision Section 10-1.59, "Steel Structures," subsection "Working Drawings" through the FCN process.

Submitted by: Wright, Doug

Attachment(s):

Date: 17-Feb-2009

NCT 30

TL-000788R1



TRANSMITTAL LETTER

PROJECT: SAN FRANCISCO OAKLAND BAY BRIDGE

DATE: 03/19/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR(NCR-000067) FOR CLOSURE / ABF 003

OK 4/23/08

SUBMITTED FOR YOUR APPROVAL AND SUBMITTAL TO CALTRANS.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

(1) COPY OF LETTER OF RESPONSE WITH NO.CT-97 FOR CLOSURE.

(2) COPY OF NCR WITH NUMBER NCR-000067. / ABF 003

OK 4/23/08

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:

Ruby L.

PLAN HOLDER

3/19/08

DATE

ABF JV

COMPANY

PHONE NO.

PLAN NUMBER: N/A

#R787-QCP-102



No. CT-97

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2007-2 -26

REGARDING: NCR-000067 (AB/F-0003)

ZPMC received CT NCR-000067 on 21-Feb-2008, it mentioned ZPMC covered complete joint penetration groove welds prior to being accepted by nondestructive testing and ZPMC was not able to provide QC reports which documented the ultrasonic testing of the enclosed welds. Actually, the ultrasonic testing had been done on these joints list prior to welding the corner stiffener plate into place, but the ultrasonic testing hadn't been finished for that time. The ZPMC UT technician forgot to mark the weld as UT OK. That made the CT inspector confused. But the NDT technician has been told mark the UT area tested from now on.

ZPMC requests Caltrans can withdraw or close NCR-000067 (AB/F-0003).

ATTACHMENT:

NCR-000067 (AB/F-0003)

Lu Jianhua
02/28/08

REVIEWED
J. [Signature]
ABF QEM
10 APRIL 08



DEPARTMENT OF TRANSPORTATION
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 Enterprises, a JV
375 Burma Road
Oakland CA 94607

Date: 16-Feb-2008

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

Attention: Dave Williams Consultant

Job Name: SAS Superstructure

Document No: 05.03.06-000036

Subject: NCR No. ABF-0003

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

- Non-Conformance with quality control procedures. Please take appropriate corrective action. Recurrence may require further administrative action.
- Non-Conformance with quality control. Records indicate that this is a recurring issue and constitutes a systematic problem in quality control. Within fourteen (14) days, please submit a plan to correct the deficiency.
- Material or workmanship is not in compliance with contract requirements.

Enclosed please find the following items:

NCR No: ABF-0003

Remarks:

Please see attachment for details.

Transmitted by: Ching Chao

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Mark Woods, Doug Coe, Jason Tom, Dave Williams, Contract Files, Kannu Balan, Chin

File: 05.03.06

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT**

Location: Changxing Island, Shanghai, PRC

Report No: NCR-000067

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 12-Feb-2008

Submitting Contractor: American Bridge/Fluor Enterprises, a JV

NCR #: ABF-0003

Type of problem:

Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: 89 meter mockup
 Procedural Procedural Description: Tower Skin CJP weld NDT

Description of Non-Conformance:

ABF allowed ZPMC to cover complete joint penetration (CJP) groove welds prior to being accepted by non destructive testing. ZPMC welded two corner stiffener plates over skin plate corner CJP at skin plate B to C and at skin plate C to D. ABF/ZPMC was not able to provide QC reports which documented the ultrasonic testing of the enclosed welds. AWS D1.5-2002 Paragraph 6.20.2 requires the Contractor provide documentation of NDT testing before acceptance by the Engineer. The Contractor will not be able to comply after the welds are covered.

Applicable reference:

AWS D1.5-2002 Section 6, Paragraph 6.20.2 that states "Before a weld subject to ultrasonic testing by the contractor for the Engineer is accepted, all report forms pertaining to the weld, including any that show unacceptable quality prior to repair, shall be submitted to the QA Inspector."

Who discovered the problem: Joe Lanz, Quality Assurance Inspector

Name of individual from Contractor notified:

Time and method of notification:

Name of Caltrans Engineer notified: Ching Chao, Structure Representative

Time and method of notification: 2/15/08;1630, Verbal

QC Inspector's Name: Xue Hai Rang, Quality Control Inspector

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.

Inspected By: Wahbeh, Mazen

Quality Assurance Inspector

QUALITY ASSURANCE – NON-CONFORMANCE REPORT

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Reviewed By: Wahbeh, Mazen

QA Reviewer

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Muroan Japan**Report No:** NCS-000193**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** American Bridge/Fluor Enterprises, a JV**NCR #:** ABF-0003**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-Jun-2008**Description of Non-Conformance:**

Welding of W2E1 grillage started on May 14, 2008. At this time, no welding reports have been submitted.

Contractor's proposal to correct the problem:

Not available at this time.

Corrective action taken:

Welding reports have been submitted and continue to be submitted on a weekly basis.

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

Inspected By: Choy,Nina

Quality Assurance Inspector

Reviewed By: Choy,Nina

QA Reviewer