

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, PRC**Report No:** NCR-000151**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Jun-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0142**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Closed Rib Continuity Plates
Procedural	Procedural	Descriptor:	Closed Rib Continuity Plates

Reference Description: Fabricated components that do not conform to working drawings**Description of Non-Conformance:**

The Contractor fabricated components that do not conform to working drawings. Approved shop drawings require a 40-mm complete joint penetration (CJP) weld length at the ends of OBG closed rib continuity plates. The as built condition for the CJP portion is 100 - 110mm. Below is a digital photograph illustrating the as-built condition prior to welding.

**Applicable reference:**

Shop Drawing Standard Details - Plate Sub-Assemblies & Floorbeams, Sheet No. SD14 Detail "14N", approved on 05-20-2008.

Who discovered the problem: Caltrans QA Inspector Greg Bertlesman**Name of individual from Contractor notified:** ABF Representative, Art Peterson**Time and method of notification:** 06-19-2008, verbal notification**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** 0925 hours, verbal, on 06-24-2008

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: ZPMC QC Inspector Sun Wei

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

Inspected By:	Velasco,Abifhram	SMR
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Reviewed By:	Velasco,Abifhram	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: 30-Jun-2008

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

Dear: Mr. Charles Kanapicki

Job Name: SAS Superstructure

Attention: Mr. Dave Williams Consultant

Document No: 05.03.06-000126

Subject: NCR No. ZPMC-0142

Reference Description: Fabricated components that do not conform to working drawings

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:**

Remarks:

The Contractor fabricated components that do not conform to working drawings. Approved shop drawings require a 40-mm complete joint penetration (CJP) weld length at the ends of OBG closed rib continuity plates. The as built condition for the CJP portion is 100 - 110mm.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0142

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, Ching Chao

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000126

Subject: NCR No. ZPMC-0142

Dated: 26-Aug-2008

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000109 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has generated an internal NCR to prevent future occurrences of this nonconformance as well as an RFI that asks for the Engineer to accept the longer CJP weld as-is.

ZPMC inadvertently increased the length of bevel of the CJP weld. ZPMC has generated an internal NCR to prevent future occurrences of this nonconformance as well as an RFI that asks for the Engineer to accept the longer CJP weld as-is. See attached documents.

Submitted by: Kanapicki, Charles

Attachment(s): ABF-NPR-000109R00; ZPMC 142 Attachment.pdf

Caltrans' comments:

Status: CLO

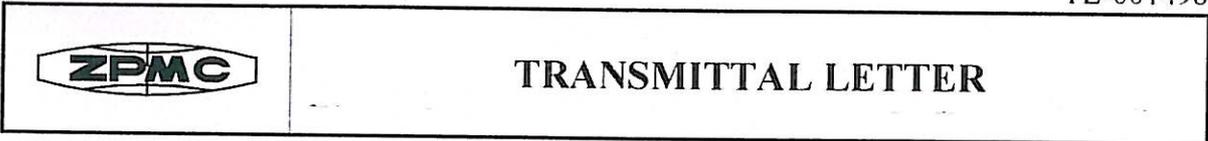
Date: 29-Sep-2008

The proposed resolution is acceptable. The Request for Information (RFI) regarding the length of this CJP weld was approved. The Department concurs that Non-Conformance ZPMC-0142 is closed.

Submitted by: Wright, Doug

Date: 29-Sep-2008

Attachment(s):



PROJECT: SAN FRANCISCO-OAKLAND BAY BRIDGE

DATE: 08/15/2008

TO: RUBY/ ABFJV QA DEPARTMENT

FROM: ZPMC QA DEPARTMENT

SUBJECT: NCR-000151(ZPMC-0142)FOR CLOSURE

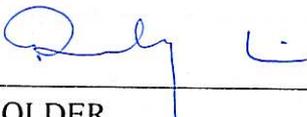
SUBMITTED FOR YOUR APPROVAL.

ENCLOSED WITH THIS TRANSMITTAL IS ONE

- (1) COPY OF LETTER OF RESPONSE WITH NO.B-290FOR CLOSURE.
- (2) COPY OF NCR WITH NUMBER NCR-000151(ZPMC-0142).
- (3) COPY OF INTERNAL NCR NCR-B-081
- (4) COPY OF THE APPROVED RFI ABOUT THE NCR

PLEASE SIGN THIS TRANSMITTAL AND RETURN TO ME.

ACKNOWLEDGEMENT:



 PLAN HOLDER

RECEIVED 15 AUG 2008


 DATE



 COMPANY

 PHONE NO.

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



No. B-290

LETTER OF RESPONSE

TO: American Bridge/Flour JV

DATE: 2008-8-14

REGARDING: NCR-000151 (ZPMC-0142)

With this letter of response, ZPMC requests closure for Caltrans **NCR-000151 (ZPMC-0142)**. ZPMC agrees what describe in the nonconformance report .ZPMC wanted to decrease the weld defects in the end of CJP area, therefore extended the length of referenced 40mm. but with receiving the RFI about the response for acceptance, we consider the **NCR-000151** can be closed.

Please reference attached documentation for acceptance and closure the **NCR-000151**.

ATTACHMENT:

NCR-000151 (ZPMC-0142)

ZPMC internal NCR

The approved RFI about the NCR

zhao shuangbao
2008.8.14



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B
 项目名称: 美国加州海湾大桥
 NCR Number: NCR-B-081
 NCR 编号: NCR-B-081

Item: fabricated components not conform DRW
 名称描述: 施工与图纸不符
 Item Number: _____
 件号: _____
 Drawing Number: _____
 图号: _____

Location: U-rib Shop
 位置: 顶板车间
 Date: 2008-6-21
 日期: 2008-6-21

Description of Nonconformance:
 不符合项状态描述:
 The contractor fabricated components that do not conform to working drawings. Approved shop drawings require a 40mm complete joint penetration(CJP) weld length at the ends of OBG closed rib continuity plates. The as built condition for the CJP portion is 100-110mm. below is a digital photograph illustrating the as-built condition prior to welding.
 ZPMC 在生产过程中没有按照图纸要求进行施工. 批准的图纸上只是要求对 U 肋内侧的筋板端口 40mm 长的范围进行 CJP 烧焊, 而现在车间的实际烧焊情况是有 100-110mm 的范围都进行了 CJP 焊接, 具体见图片所示.
 Work By: Zhang Yan Jun Prepared by: Tu Yuhang Reviewed by QCE: Zhou Shuangbao
 施工方: 准备: 2008.7.9 质量工程师批准: 2008.7.9.
 Drawing Error Material Defect Fabrication Error Other
 图纸错误 材料缺陷 制作错误 其他原因

Disposition: Use as is Repair Reject
 处理措施: 回用 返修 拒收

Recommendation:
 建议 加强现场作业人员的监控与指导, 严格按照图施工.
 Enhance inspection and guidance to the workers and fabricate components that conform to the work drawings.
 Prepared by: Zhang Yan Zhi Approved by QCA: Hu Gang 2008.7.10
 准备 08.7.10 质量经理批准

Reason for Nonconformance:
 不符合原因: 施工队作业时未严格审核图纸.
 The workers didn't review work drawings before fabricating carefully.
 预防措施: 严格按照图施工, 杜绝类似事件再次发生.
 Fabricate components that conform to work drawings to avoid such nonconformance.
 Approved by/批准: Zhang Yan Zhi 08.7.10

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment
 回用或返修的技术依据: 回用, 加强制造过程控制, 附件 无附件
 存, 审核合格图纸, 对相关人员进行培训教育.
 Use as is. Enhance control and inspection during fabrication and provide trainings to relevant workers.
 Reviewed /批准: Tang Yongbo 7/15/08

Verification: Acceptable Unacceptable
 确认: 可接受 2008.8.14 不可接受
 Verified by QCI/质检确认: Sun Miller 08.8.14 Reviewed by QCA/质检主任审核: Hu Gang
 2008.8.14



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

Date: 30-Jun-2008

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

Dear: Mr. Charles Kanapicki
Attention: Mr. Dave Williams Consultant
Subject: NCR No. ZPMC-0142

Job Name: SAS Superstructure
Document No: 05.03.06-000126

Reference Description: Fabricated components that do not conform to working drawings

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- Non-Conformance Resolved.

Material Location: OBG

Lift:

Remarks:

The Contractor fabricated components that do not conform to working drawings. Approved shop drawings require a 40-mm complete joint penetration (CJP) weld length at the ends of OBG closed rib continuity plates. The as built condition for the CJP portion is 100 - 110mm.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance to prevent future occurrences.

Transmitted by: Stanley Ku Sr. Bridge Engineer

Attachments: ZPMC-0142

cc: Rick Morrow, Gary Pursell, Brian Boal, Jason Tom, Ching Chao

File: 05.03.06

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

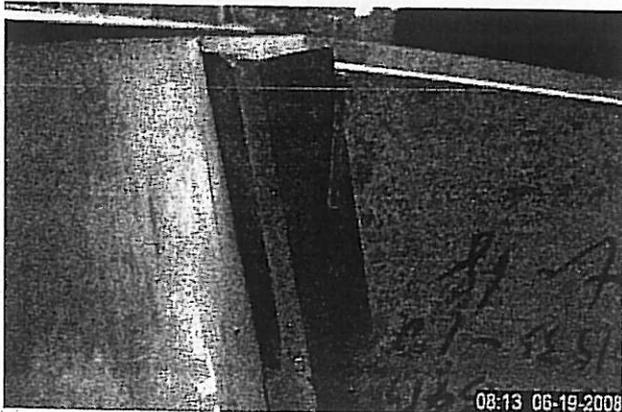
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, PRC**Report No:** NCR-000151**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Jun-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0142**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Closed Rib Continuity PlatesProcedural Procedural Descriptor: Closed Rib Continuity Plates**Reference Description:** Fabricated components that do not conform to working drawings**Description of Non-Conformance:**

The Contractor fabricated components that do not conform to working drawings. Approved shop drawings require a 40-mm complete joint penetration (CJP) weld length at the ends of OBG closed rib continuity plates. The as built condition for the CJP portion is 100 - 110mm. Below is a digital photograph illustrating the as-built condition prior to welding.

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Who discovered the problem: Caltrans QA Inspector Greg Bertlesman**Name of individual from Contractor notified:** ABF Representative, Art Peterson**Time and method of notification:** 06-19-2008, verbal notification**Name of Caltrans Engineer notified:** Stanley Ku**Time and method of notification:** 0925 hours, verbal, on 06-24-2008

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

QC Inspector's Name: ZPMC QC Inspector Sun Wei

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

Comments:

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Inspected By: Velasco, Abifhram

SMR

Reviewed By: Velasco, Abifhram

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, PRC**Report No:** NCS-000081**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 23-Sep-2008**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0142**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: 21-Jun-2008**Description of Non-Conformance:**

The Contractor fabricated components that do not conform to working drawings. Approved shop drawings require a 40-mm complete joint penetration (CJP) weld length at the ends of OBG closed rib continuity plates. The as built condition for the CJP portion is 100 - 110mm. Below is a digital photograph illustrating the as-built condition prior to welding.

Contractor's proposal to correct the problem:

N/A

Corrective action taken:

ZPMC has generated an internal NCR to prevent future occurrences of this nonconformance as well as an RFI that asks for the Engineer to accept the longer CJP weld as-is.

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 Ady Velasco, 011-86-138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Liu, Chengwen

Quality Assurance Inspector

Reviewed By: Velasco, Abifhram

QA Reviewer