

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



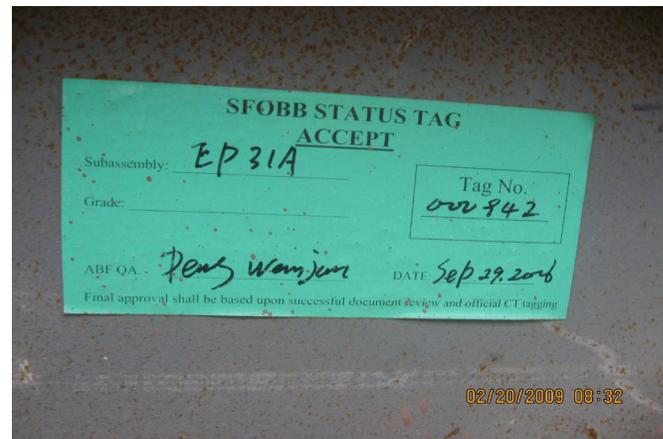
Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.25B**QUALITY ASSURANCE -- NON-CONFORMANCE REPORT****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCR-000232**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Feb-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0207**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> Edge Plate EP31A
<b>Procedural</b>	<b>Procedural</b>	<b>Description:</b>	Handling welded and inspected materials

**Reference Description:** Handling of Edge Plate 31A**Description of Non-Conformance:**

This Quality Assurance Inspector (QA) observed ZPMC personnel improperly handling this ABF green tagged segment sub-assembly, EP31A (see attached photos).

**Applicable reference:**

Standard Specifications (1999) Section 6: "The materials furnished and used shall be new, except as may be provided elsewhere in these specifications, on the plans or in the special provisions. The materials shall be manufactured, handled and used in a workmanlike manner to ensure completed work in accordance with the plans and specifications."

Standard Specifications (1999) Section 55: "In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping or overstressing the pieces. All pieces bent or otherwise injured will be rejected."

**Who discovered the problem:** James Lumley

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

( Continued Page 2 of 2 )

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**Name of individual from Contractor notified:** Peter Shaw

**Time and method of notification:** 11:00 - 2/19/09 - verbal

**Name of Caltrans Engineer notified:** Stanley Ku, Construction Senior

**Time and method of notification:** 13:30 - 2/19/09 - verbal

**QC Inspector's Name:** N/A

**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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Tsang, Eric	SMR
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<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:** 04-Mar-2009

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

**Dear:** Mr. Charles Kanapicki

**Job Name:** SAS Superstructure

**Attention:** Mr. Thomas Nilsson Project Manager - OBG

**Document No:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Reference Description:** Handling of Edge Plate 31A

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:**

ZPMC personnel improperly handling ABF green tagged segment sub-assembly, EP31A, during transportation.

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

Please propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

**Transmitted by:** Stanley Ku Sr. Bridge Engineer

**Attachments:** ZPMC-0207

**cc:** Rick Morrow, Gary Pursell, Brian Boal, Jason Tom

**File:** 05.03.06

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Dated:** 11-Mar-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000204 Rev: 00

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### Contractor's Proposed Resolution:

**Reference Resolution:** ABFJV has conducted documented training with ZPMC CWI's and MT inspectors to recognize and prevent improper storage and handling.

ABFJV has notified ZPMC of improper handling and storage and has generated internal NCR's. ABFJV has conducted documented training with ZPMC CWI's and MT inspectors to recognize and prevent improper storage and handling. This NCR was presented during the training session. With the attached data, ZPMC request closure of this NCR.

### Submitted by:

**Attachment(s):** ABF-NPR-000204R00;

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### Caltrans' comments:

**Status:** AAP

**Date:** 13-Apr-2009

The response is acceptable, but the Non-Conformance is not closed.

Please provide documentation of 100% MT of the welds on stiffeners T-3, T-4, and the plate stiffeners between T-3 and T-4 of edge panel EP-31A. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0207 at that time.

**Submitted by:** Wright, Doug

**Date:** 13-Apr-2009

**Attachment(s):**



# Tool Box Training Agenda

**Subject:** CWI responsibilities

**Reason for Training:** Several NCR's relating to CWI responsibility, where it appears the CWI is not completely aware of all duties expected of a CWI

**Reference:** NCR's, ZPMC-0123, ZPMC-0145, ZPMC-0162, ZPMC-0202, ZPMC-0204, ZPMC-0205

1. **AWS D1.5-2002 Section 6 Responsibilities of QC Inspector**
  - a. 6.2 Inspection of Materials
  - b. 6.3 Inspection of WPS Qualification and Equipment
  - c. 6.4 Inspection of Welder, Welding Operator and Tack Welder Qualifications
  - d. 6.5 Inspection of Work and Records
2. **Time of Inspection**
  - a. Fit-up
  - b. inprocess
  - c. Final
3. **AWS D1.5-02 Section 3**
  - a. 3.2 Preparation of Base Material
  - b. 3.3 Assembly
  - c. 3.4 Control of Distortion and Shrinkage
  - d. 3.6 Weld Profiles
  - e. 3.7 Repairs



# Tool Box Training Agenda

**Subject:** MT of welds

**Reason for Training:** Several CT NCR's relating to welds accepted by MT by ZPMC then later found to be unacceptable by CT QA inspection.

**Reference:** CT NCR's ZPMC-0203, ZPMC-0204, ZPMC-0034, ZPMC-0035, ZPMC-0077, ZPMC-0191, ZPMC-0192, ZPMC-0194,

1. **MT Techniques**
  - a. Equipment
  - b. Pie Gage
  - c. Powder
  
2. **Inspection Techniques**
  - a. Lighting
  - b. Position of body (distance of eyes to the weld surface)
  - c. Speed
  - d. Amount of Powder
  
3. **Inspection Criteria**
  - a. ZPMC Inspection procedures
  - b. Relevant Versus Non Relevant indications

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Dated:** 26-Oct-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000204 Rev: 01

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC has submitted documentation of NDT which shows the welds potentially affected are acceptable. The documentation is available on the electronic database. ZPMC requests closure of the NCR.

ZPMC has submitted documentation of NDT which shows the welds potentially affected are acceptable. The documentation is available on the electronic database. ZPMC requests closure of the NCR.

### Submitted by:

**Attachment(s):** ABF-NPR-000204R01

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### Caltrans' comments:

**Status:** AAP

**Date:** 11-Nov-2009

The related welds were not found in the QA database by the Engineer. Please notify the Engineer when all required information is uploaded to the database before requesting closure of the NCR.

**Submitted by:** Chao, Ching

**Date:** 11-Nov-2009

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Dated:** 30-Dec-2009

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000204 Rev: 02

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**Contractor's Proposed Resolution:**

**Reference Resolution:** As requested by CT, ZPMC has located and identified the welds within the QA data base. See attached. ZPMC requests closure of this NCR.

As requested by CT, ZPMC has located and identified the welds within the QA data base. See attached.

ZPMC requests closure of this NCR.

**Submitted by:** Lawton, Steve

**Attachment(s):** ABF-NPR-000204R02;

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**Caltrans' comments:**

**Status:** REJ

**Date:** 30-Dec-2009

The data base shows the 68 welds to be "in progress". Re submit when welds are complete.

**Submitted by:** Howe, Bill

**Attachment(s):**

**Date:** 30-Dec-2009



No. B-536

## LETTER OF RESPONSE

**TO: American Bridge/Flour**

**DATE: 2009-12-30**

**REGARDING: NCR-000232(ZPMC-0207)**

With this letter of response, ZPMC requests closure for CALTRANS NCR-000232(ZPMC-0207) what mentioned that QA observed improper handling of Edge Plate 31A.

ZPMC has submitted related NDT documentation for engineer's review. According to Engineer's comment in ABF-NPR-000204 R1, engineer can't find related welds in QA database.

So ZPMC provides NPR & related welds' search result from ABF's database, hoping CALTRANS could take a review and consider close this NCR.

**ATTACHMENT:**

ABF-NPR-000204 R1

NCR-000232 (ZPMC-0207)

SEARCH RESULT FORM ABF DATABASE

*Jun W*

*12/30/09*



**AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV**

P.O. BOX 23223 Oakland, CA 94623  
Phone (510) 419-0120 / Fax (510) 839-0666

**NCR PROPOSED RESOLUTION**

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

Dated: 26-Oct-2009

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

Attention: Pursell, Gary  
Resident Engineer

Job Name: SAS Superstructure

Ref: 05.03.06-000200

Document No.: ABF-NPR-000204 Rev: 01

Subject: NCR No. ZPMC-0207

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**Contractor's Proposed Resolution:**

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ZPMC has submitted documentation of NDT which shows the welds potentially affected are acceptable. The documentation is available on the electronic database. ZPMC requests closure of the NCR.

Submitted by:

Attachment(s): ABF-NPR-000204R01

---

**Caltrans' comments:**

Status: AAP

Date: 11-Nov-2009

The related welds were not found in the QA database by the Engineer. Please notify the Engineer when all required information is uploaded to the database before requesting closure of the NCR.

Submitted by: Chao, Ching

Date: 11-Nov-2009

Attachment(s):



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:** 04-Mar-2009

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

**Dear:** Mr. Charles Kanapicki

**Job Name:** SAS Superstructure

**Attention:** Mr. Thomas Nilsson Project Manager - OBG

**Document No:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Reference Description:** Handling of Edge Plate 31A

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

Please propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences.

**Transmitted by:** Stanley Ku Sr. Bridge Engineer

**Attachments:** ZPMC-0207

**cc:** Rick Morrow, Gary Pursell, Brian Boal, Jason Tom

**File:** 05.03.06

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

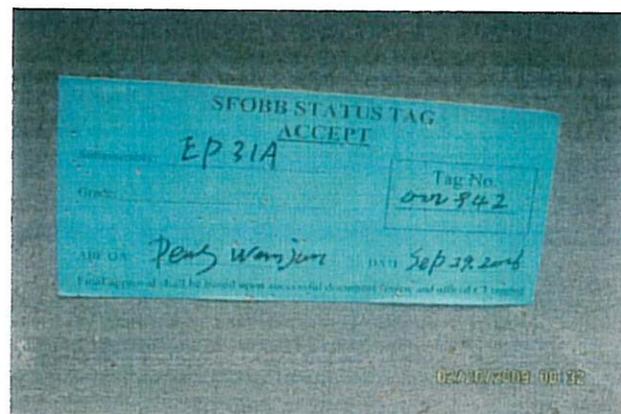
Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(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, P.R. China**Report No:** NCR-000232**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 18-Feb-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0207**Type of problem:**Welding  Concrete  Other Welding  Curing  Procedural  **Bridge No:** 34-0006Joint fit-up  Coating  Other  **Component:** Edge Plate EP31AProcedural  **Description:** Handling welded and inspected materials**Reference Description:** Handling of Edge Plate 31A**Description of Non-Conformance:**

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**Who discovered the problem:** James Lumley

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## QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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( Continued Page 2 of 2 )

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**Name of individual from Contractor notified:** Peter Shaw

**Time and method of notification:** 11:00 - 2/19/09 - verbal

**Name of Caltrans Engineer notified:** Stanley Ku, Construction Senior

**Time and method of notification:** 13:30 - 2/19/09 - verbal

**QC Inspector's Name:** N/A

**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, +(86) 134.7247.7571, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Tsang, Eric	SMR
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<b>Reviewed By:</b>	Wahbeh, Mazen	SMR
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Home | Reports | Logs | Preferences | Logout |



Welcome: DWENLING Report # / Weld ID

Site Map

## Weld Data Log

Weld ID

Report Number

Originator

SubAssembly EP31

Weld Map Number

Weld Type

Find Blanks: 

Search

Total WDLs: 68  
 Total CJP: 28 Total PJP: 0 Total Fillet: 40 Total Other: 0

Report Number	Weld ID	SubAssembly	Originator	Origination Date	Status
WDL0066158	EP031-001-055	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066159	EP031-001-056	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066160	EP031-001-057	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066161	EP031-001-058	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066162	EP031-001-059	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066163	EP031-001-060	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066164	EP031-001-061	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066165	EP031-001-062	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066166	EP031-001-063	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066167	EP031-001-064	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066168	EP031-001-065	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066169	EP031-001-066	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066170	EP031-001-067	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066171	EP031-001-068	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066172	EP031-001-001	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066173	EP031-001-002	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066174	EP031-001-003	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066175	EP031-001-004	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066176	EP031-001-005	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066177	EP031-001-006	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066178	EP031-001-007	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066179	EP031-001-008	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066180	EP031-001-009	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066181	EP031-001-010	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066182	EP031-001-011	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066183	EP031-001-012	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066184	EP031-001-013	EP31	Jeff Evans	03/02/2009	In Progre
WDL0066185	EP031-001-014	EP31	Jeff Evans	03/02/2009	In Progre
WDL0058595	EP031-001-015	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058604	EP031-001-016	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058610	EP031-001-017	EP31	Tai Yunxia	02/25/2009	In Progre

WDL0058616	EP031-001-018	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058630	EP031-001-019	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058633	EP031-001-020	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058701	EP031-001-034	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058706	EP031-001-035	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058711	EP031-001-036	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058716	EP031-001-037	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058721	EP031-001-038	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058728	EP031-001-039	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058735	EP031-001-040	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058740	EP031-001-041	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058746	EP031-001-042	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058752	EP031-001-043	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058758	EP031-001-044	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058639	EP031-001-021	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058643	EP031-001-022	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058647	EP031-001-023	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058651	EP031-001-024	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058655	EP031-001-025	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058660	EP031-001-026	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058665	EP031-001-027	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058669	EP031-001-028	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058673	EP031-001-029	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058679	EP031-001-030	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058684	EP031-001-031	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058691	EP031-001-032	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058696	EP031-001-033	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058763	EP031-001-045	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058768	EP031-001-046	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058773	EP031-001-047	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058776	EP031-001-048	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058780	EP031-001-049	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058783	EP031-001-050	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058787	EP031-001-051	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058794	EP031-001-052	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058798	EP031-001-053	EP31	Tai Yunxia	02/25/2009	In Progre
WDL0058803	EP031-001-054	EP31	Tai Yunxia	02/25/2009	In Progre

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Dated:** 08-Feb-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000204 **Rev:** 03

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**Contractor's Proposed Resolution:**

**Reference Resolution:** Please refer to the electronic database, all 68 welds have been "Accepted". ZPMC request closure of this NCR.  
Please refer to the electronic database, all 68 welds have been "Accepted". ZPMC request closure of this NCR.

**Submitted by:** Ishibashi, Joshua  
**Attachment(s):** ABF-NPR-000204R03

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**Caltrans' comments:**

**Status:** REJ

**Date:** 09-Feb-2010

Provide acceptance sheets for verification.

**Submitted by:** Howe, Bill  
**Attachment(s):**

**Date:** 09-Feb-2010

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Dated:** 16-Feb-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000204 **Rev:** 04

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### Contractor's Proposed Resolution:

**Reference Resolution:** The verification sheets that CT requests do not exist. Verification can be accomplished by viewing the completed accepted welds on the online database. Based on this ZPMC request for closure of this NCR.

The verification sheets that CT requests do not exist. Verification can be accomplished by viewing the completed accepted welds on the online database. Based on this ZPMC request for closure of this NCR.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000204R04

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### Caltrans' comments:

**Status:** REJ

**Date:** 16-Feb-2010

Search the online data base for the relevant information and submit for review.

**Submitted by:** Howe, Bill

**Date:** 16-Feb-2010

**Attachment(s):**

## NCR PROPOSED RESOLUTION

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

**Attention:** Pursell, Gary  
Resident Engineer

**Ref:** 05.03.06-000200

**Subject:** NCR No. ZPMC-0207

**Dated:** 04-Mar-2010

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

**Job Name:** SAS Superstructure

**Document No.:** ABF-NPR-000204 Rev: 05

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### Contractor's Proposed Resolution:

**Reference Resolution:** ZPMC is providing the relevant information regarding the acceptability of EP31A for review. The documentation shows that the welds have been accepted on EP31A.

ZPMC is providing the relevant information regarding the acceptability of EP31A for review. The documentation shows that the welds have been accepted on EP31A. Based on this ZPMC requests that shi NCR be closed.

**Submitted by:** Ishibashi, Joshua

**Attachment(s):** ABF-NPR-000204R05;

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### Caltrans' comments:

**Status:** CLO

**Date:** 07-Mar-2010

The documentation received is sufficient to close this NCR.

**Submitted by:** Howe, Bill

**Date:** 07-Mar-2010

**Attachment(s):**

Welcome: Jianhua Lu

Report # / Weld ID

Site Map

## Weld Data Log

Weld ID  Report Number   
 Originator  SubAssembly   
 Weld Map Number  Weld Type  Find Blanks:   
 Status

Search

Create New

Total WDLs: 68

Total CJP: 28 Total PJP: 0 Total Fillet: 40 Total Plug: 0 Total Other: 0

Report Number	Weld ID	SubAssembly	Originator	Origination Date	Status
WDL0066172	EP031-001-001	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066173	EP031-001-002	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066174	EP031-001-003	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066175	EP031-001-004	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066176	EP031-001-005	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066177	EP031-001-006	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066178	EP031-001-007	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066179	EP031-001-008	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066180	EP031-001-009	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066181	EP031-001-010	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066182	EP031-001-011	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066183	EP031-001-012	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066184	EP031-001-013	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0066185	EP031-001-014	EP31A	Jeff Evans	03/02/2009	Accepted
WDL0058595	EP031-001-015	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058604	EP031-001-016	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058610	EP031-001-017	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058616	EP031-001-018	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058630	EP031-001-019	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058633	EP031-001-020	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058639	EP031-001-021	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058643	EP031-001-022	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058647	EP031-001-023	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058651	EP031-001-024	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058655	EP031-001-025	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058660	EP031-001-026	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058665	EP031-001-027	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058669	EP031-001-028	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058673	EP031-001-029	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058679	EP031-001-030	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058684	EP031-001-031	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058691	EP031-001-032	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058696	EP031-001-033	EP31A	Tai Yunxia	02/25/2009	Accepted
WDL0058701	EP031-001-034	EP31A	Tai Yunxia	02/25/2009	Accepted

<b>WDL0058706</b>	EP031-001-035	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058711</b>	EP031-001-036	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058716</b>	EP031-001-037	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058721</b>	EP031-001-038	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058728</b>	EP031-001-039	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058735</b>	EP031-001-040	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058740</b>	EP031-001-041	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058746</b>	EP031-001-042	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058752</b>	EP031-001-043	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058758</b>	EP031-001-044	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058763</b>	EP031-001-045	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058768</b>	EP031-001-046	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058773</b>	EP031-001-047	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058776</b>	EP031-001-048	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058780</b>	EP031-001-049	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058783</b>	EP031-001-050	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058787</b>	EP031-001-051	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058794</b>	EP031-001-052	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058798</b>	EP031-001-053	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0058803</b>	EP031-001-054	EP31A	Tai Yunxia	02/25/2009	Accepted
<b>WDL0066158</b>	EP031-001-055	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066159</b>	EP031-001-056	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066160</b>	EP031-001-057	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066161</b>	EP031-001-058	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066162</b>	EP031-001-059	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066163</b>	EP031-001-060	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066164</b>	EP031-001-061	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066165</b>	EP031-001-062	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066166</b>	EP031-001-063	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066167</b>	EP031-001-064	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066168</b>	EP031-001-065	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066169</b>	EP031-001-066	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066170</b>	EP031-001-067	EP31A	Jeff Evans	03/02/2009	Accepted
<b>WDL0066171</b>	EP031-001-068	EP31A	Jeff Evans	03/02/2009	Accepted



**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-000504**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0207**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>Descriptor:</b>	

**Date the Non-Conformance Report was written:** 18-Feb-2009**Description of Non-Conformance:**

This Quality Assurance Inspector (QA) observed ZPMC personnel improperly handling this ABF green tagged segment sub-assembly, EP31A (see attached photos).

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

Perform required NDT in order to verify all welds on EP31A are in conformance with Contract requirements.

**Corrective action taken:**

Contractor has performed Magnetic Particle Testing (MT) of all welds on EP31A. The data base reflects that all 68 welds are in conformance with Contract requirements.

**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 Jim Simonis 152. 1675.3703, who represents the Office of Structural Materials for your project.

**Inspected By:** Simonis, Jim

Quality Assurance Inspector

**Reviewed By:** Wahbeh, Mazen

QA Reviewer