

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-000256**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 21-Apr-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0230**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Segment 2AW
Procedural	Procedural	Description:	

Reference Description: Continuity Plate Retrofit, Doubler Plate Fit-Up**Description of Non-Conformance:**

The following issues were found regarding the fit-up of the continuity plate retrofit doubler plates in OBG Segment 2AW:

- 1) The doubler plates were fit up without sufficient depth for the PJP weld.
- 2) Closed rib to diaphragm welds were not ground to 8mm as required for proper fit-up.
- 3) The doubler plates were fit up with excessive gap (3mm) to the diaphragm plate and the closed rib to diaphragm welds.

**Applicable reference:**

RFI 1652 R0

Who discovered the problem: Mark Miller**Name of individual from Contractor notified:** Peter Shaw**Time and method of notification:** 2009/04/21, 14:30, Verbal**Name of Caltrans Engineer notified:** Stanley Ku

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 2009/04/21, 11:00 hours, Verbal

QC Inspector's Name: Wang Lu

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 Skyler Guest, 1500 042 2360, who represents the Office of Structural Materials for your project.

Inspected By:	Guest,Skyler	SMR
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Reviewed By:	Wahbeh,Mazen	SMR
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NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000222

Subject: NCR No. ZPMC-0230

Dated: 20-May-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000226 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ABF is currently in discussions with CT regarding this issue. Documentation of resolution will be provided at a later date.

ABF is currently in discussions with CT regarding this issue. Documentation of resolution will be provided at a later date.

Submitted by:

Attachment(s): ABF-NPR-000226R00

Caltrans' comments:

Status: REJ

Date: 05-Jun-2009

The proposed resolution is not acceptable. Please re-submit the proposed resolution when the issue has been addressed and the work has been performed. The Department will review the Contractor's proposal to close Non-Conformance ZPMC-0230 at that time.

Submitted by: Wright, Doug

Date: 05-Jun-2009

Attachment(s):

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000222

Subject: NCR No. ZPMC-0230

Dated: 03-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000226 **Rev:** 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

ZPMC has responded to this NCR and has attached documents as evidence of completion. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000226R01;

Caltrans' comments:

Status: CLO

Date: 19-Aug-2009

The proposed resolution is acceptable. The Department concurs that the work has been corrected, and Non-Conformance ZPMC-0230 is closed.

Submitted by: Wright, Doug

Date: 19-Aug-2009

Attachment(s):



No. B-427

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-7-30

REGARDING: NCR-000256 (ZPMC-0230)

With this letter of response, ZPMC requests closure for Caltrans **NCR-000256 (ZPMC-0230)**. We agree what describe in the non-conformance report, but we have to point out that we have removed the non-conformance continuity plate at that time and re-install the plate as the require of RFI, the main issue is confirmed the grinding for the fillet surface to tight fit with the additional plate, and make sure the root gap less than 3mm. by the way the re-fit up process and final condition is already verified by ABF and caltrans inspector on site.

Therefore we think the description in the non-conformance report have been repaired and got the notes require, so base on the above explanation. ZPMC applies to close the caltrans's report **NCR-000256 (ZPMC-0230)**.

Please reference attached documentation for acceptance and closure the **NCR-000256 (ZPMC-0230)**.

ATTACHMENT:

NCR-000256 (ZPMC-0230)

ZPMC internal NCR

Zhao Shuangbao

2009. 7. 30



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 编号: NCR-B-147 CNCR-00025673	
Item: Doubler Plate Fit-up 名称描述: 顶板隔的板贴板装配	Item Number: 件号:	Drawing: 图号: 2AW	
Location: 位置: 2AW		Date: 日期: 2009-05-08	

Description of Nonconformance:

The Following issues were found regarding the fit-up of the continuity plate retrofit doubler plates in OBG segment 2AW:

- 1) The doubler plates were fit up without sufficient depth for PJP weld.
- 2) Closed rib to diaphragm welds were not ground to 8mm as required for proper fit up.
- 3) The doubler plates were fit up with excessive gap(3mm) to the diaphragm plate and the closed rib to diaphragm welds.

2AW 在安装顶板隔板的贴板时发现以下问题:

- 1) 安装错误导致 PJP 坡口深度不够
- 2) U 肋与顶板隔板的焊缝安装之前未能按照要求打磨到焊角为 8mm
- 3) 安装后贴板与顶板隔板间隙超过 3mm

Work By: *Zhou Jiafeng* Prepared by: *Wang* Reviewed by QCE: *Zhuoshuangbao*
 施工方: *09.5.15* 准备: *09.5.8* 质量工程师批准:

Drawing Error Material Defect Fabrication Error Other *5.8*
 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:

1. 加强过程控制. 装配过程中 Q 现场管控. 装配后 Q. A/B 报验. 合格后方可.
2. 严格按照要求施工. 装配前焊缝打磨至要求 8mm.
3. 贴板预装配. 保证间隙不超过 3mm.

Prepared by: *Li ziyang* Approved by QCA: _____
 准备 质量经理批准

Reason for Nonconformance:

不符合原因:

1. 顶板、隔板的贴板安装时，PTP坡口深度未达到要求。
2. U肋与顶板、隔板的焊缝安装之前，焊缝未按要求打磨到 8mm。
3. 贴板安装前间隙超过了 3mm。

Prevention of Re-occurrence:

预防措施:

1. 加强过程控制，安装顶板、隔板的贴板前须由QC指导和监督，装配后报经QC和ABF检验合格后再焊接。
 1. Enhance controlling during assembly deck plate, floor beam, and double plate with guiding and supervision by QC and inspection after QC and ABF inspection.
2. 严格按照要求装配，装配前焊缝打磨控制在 8mm。
 2. Perform assembly according to assembly and grind to 8mm.
3. 贴板安装前，间隙保证不超过 3mm。
 3. The gap exceed 3mm before assembly double plate.

Approved by/批准: 

Technical Justification for Use-As-Is/Repair: Attachment Non-attachment

回用或返修的技术依据: 附件 无附件

1. 加强过程控制，在顶板贴板前须由QC指导和监督，装配后报QC、ABF合格后再进行焊接。
 1. Enhance controlling during assembly double plate with guiding and supervision by QC, Accept by QC and ABF inspection before welding.
2. 严格按照要求装配。
 2. Perform assembly according to requirement.

Reviewed/批准: TANG HANYU

Verification: Acceptable Unacceptable
 确认: 可接受 不可接受

1. ZAW的贴板均按工艺要求在停点焊后重新装配。
 2. 报验合格后再进入下道工序。
 3. 加强检验的检查力度。
1. Remove ZAW double plate according to technology requirement and re-assembly;
 2. Enter next procedure before inspection acceptable;
 3. Enhance inspection and supervision.

Verified by QCI/质检确认: Zhang Zhong Reviewed by QCA/质检主任审核: _____



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-Apr-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/Fabrication Manager
Document No: 05.03.06-000222

Subject: NCR No. ZPMC-0230

Reference Description: Continuity Plate Retrofit, Doubler Plate Fit-Up

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: 02

Remarks:

The following issues were found regarding the fit-up of the continuity plate retrofit doubler plates in OBG Segment 2AW:

- 1) The doubler plates were fit up without sufficient depth for the PJP weld.
- 2) Closed rib to diaphragm welds were not ground to 8mm as required for proper fit-up.
- 3) The doubler plates were fit up with excessive gap (3mm) to the diaphragm plate and the closed rib to diaphragm welds.

Please see the attached NCR report #ZPMC-230 for more details.

Action Required and/or Action Taken:

A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

Attachments: ZPMC-0230

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, Doug Wright, Ching C
File: 05.03.06

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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, PRC

Report No: NCR-000256

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 21-Apr-2009

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

NCR #: ZPMC-0230

Type of problem:

Welding **Concrete** **Other**

Welding **Curing** **Procedural** **Bridge No:** 34-0006

Joint fit-up **Coating** **Other** **Component:** OBG Segment 2AW

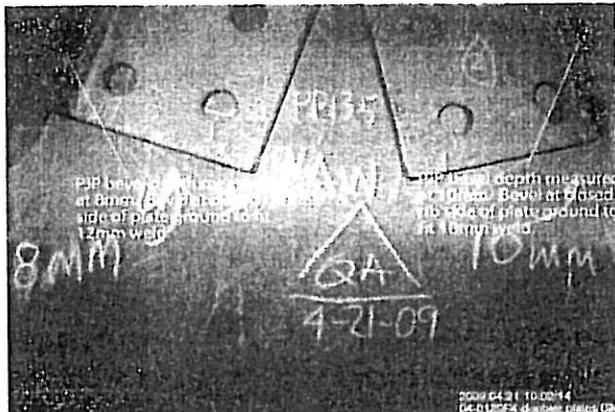
Procedural **Procedural** **Description:**

Reference Description: Continuity Plate Retrofit, Doubler Plate Fit-Up

Description of Non-Conformance:

The following issues were found regarding the fit-up of the continuity plate retrofit doubler plates in OBG Segment 2AW:

- 1) The doubler plates were fit up without sufficient depth for the PJP weld.
- 2) Closed rib to diaphragm welds were not ground to 8mm as required for proper fit-up.
- 3) The doubler plates were fit up with excessive gap (3mm) to the diaphragm plate and the closed rib to diaphragm welds.



Applicable reference:

RFI 1652 R0

Who discovered the problem: Mark Miller

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 2009/04/21, 14:30, Verbal

Name of Caltrans Engineer notified: Stanley Ku

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 2009/04/21, 11:00 hours, Verbal

QC Inspector's Name: Wang Lu

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 Skyler Guest, 1500 042 2360, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

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, PRC**Report No:** NCS-000293**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 26-Aug-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0230**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-Apr-2009**Description of Non-Conformance:**

The following issues were found regarding the fit-up of the continuity plate retrofit doubler plates in OBG Segment 2AW:

- 1) The doubler plates were fit up without sufficient depth for the PJP weld.
- 2) Closed rib to diaphragm welds were not ground to 8mm as required for proper fit-up.
- 3) The doubler plates were fit up with excessive gap (3mm) to the diaphragm plate and the closed rib to diaphragm welds.

Contractor's proposal to correct the problem:

Perform joint survey of doubler plates, and use shims for bolting fit up issues.

Corrective action taken:

Joint survey was performed with CT and ABF. Welds were ground down, root gap issue was addressed, and shims will be used where gap is out of tolerance for bolting.

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

Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer