

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, P.R. China **Report No:** NCR-000308
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 08-Jun-2009
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0282

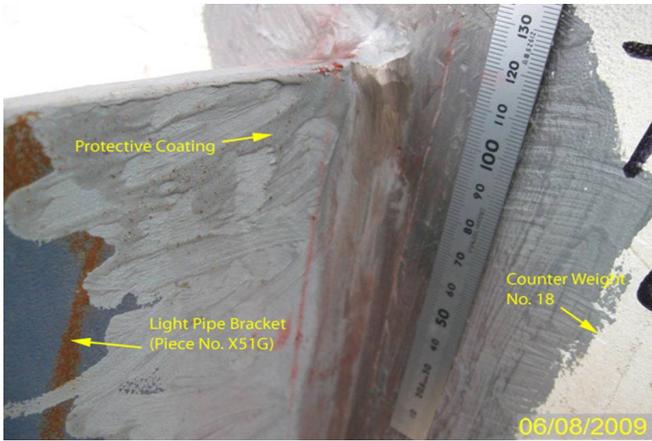
Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Counterweight CW018, Segment 2BW
Procedural	Procedural	Description:	

Reference Description: Improper Surface Preparation Prior to MT, CW018, Segment 2BW

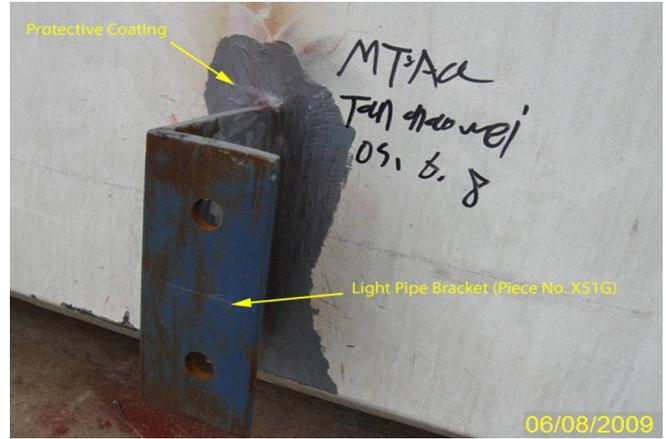
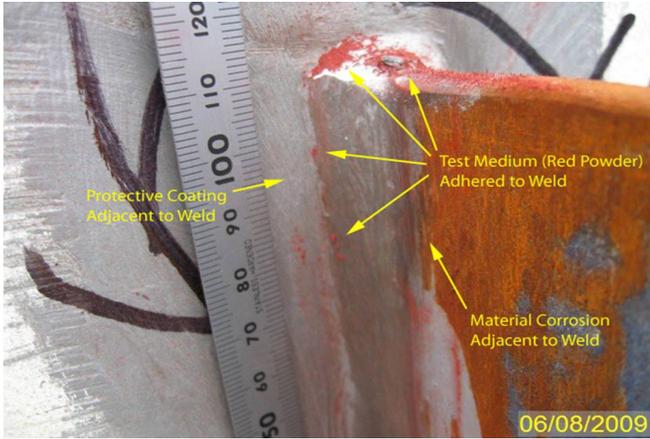
Description of Non-Conformance:

Caltrans Quality Assurance (QA) Inspector observed magnetic particle testing (MT) that had been performed on light pipe brackets on Counterweight CW018 (OBG Segment 2BW). The MT was performed through protective coating and/or rust and was accepted by ZPMC Quality Control (QC) MT technicians.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002 Section 6.7.6.3: "Prior to MT, the surface shall be examined, and any adjacent area within at least 25 mm [1 in.] of the surface to be tested, shall be dry and free of contaminants such as oil, grease, loose rust, loose sand, loose scale, lint, thick paint, welding flux, and weld spatter."

Who discovered the problem: Rory O'Kane

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 16:45, 06-08-09, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 14:00, 06-10-09, Verbal

QC Inspector's Name: Shen Xuejun

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, (86) 1500.042.2360, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

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: 14-Jun-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: 05.03.06-000267

Subject: NCR No. ZPMC-0282

Reference Description: Improper Surface Preparation Prior to MT, CW018, Segment 2BW

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: Xbeam **Lift:** 02

Remarks:

Caltrans Quality Assurance (QA) Inspector observed magnetic particle testing (MT) that had been performed on light pipe brackets on Counterweight CW018 (OBG Segment 2BW). The MT was performed through protective coating and/or rust and was accepted by ZPMC Quality Control (QC) MT technicians.
See NCR report No. ZPMC-282 for details.

Action Required and/or Action Taken:

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

Transmitted by: Ching Chao

Attachments: ZPMC-0282

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, Doug Coe, Jason Tom, Contract Files, 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: 05.03.06-000267

Subject: NCR No. ZPMC-0282

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000302 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has written an internal NCR providing corrective and preventive actions to be taken as well as provided all relative inspection documents. ZPMC requests closure of this NCR.

ZPMC has written an internal NCR providing corrective and preventive actions to be taken as well as provided all relative inspection documents. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000302R00;

Caltrans' comments:

Status: CLO

Date: 31-Aug-2009

The proposed resolution is acceptable. The areas in question have been accepted by MT as shown in the attached documents. The Department concurs that Non-Conformance ZPMC-0282 is closed.

Submitted by: Wright, Doug

Date: 31-Aug-2009

Attachment(s):



No. B-45

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2009-8-19

REGARDING: NCR-000308 (ZPMC-282)

With this letter of response, ZPMC requests closure for Caltrans NCR-000308 (ZPMC-282). We should clarify here that the ZPMC were performing the MT inspection after the complete removed the surface primer coating, but after that the worker privately paint the primer again prior the request of caltrans' final MT verification. Therefore we have ground the areas to complete remove the paint again for the inspector's MT and got the green tag (05672) after the complete checking.

so base on the above explanation and attached documentations, ZPMC applies to close the caltrans's report NCR-000308 (ZPMC-282).

Please reference attached document for acceptance and closure the NCR-000308 (ZPMC-282).

ATTACHMENT:

NCR-000308 (ZPMC-282)

ZPMC internal NCR

The final VT/MT inspection reports

zhao shuangbao

2009.8.19



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-186
 (NCR-000308)

Item: Improper Surface Preparation
 Prior to MT
 名称描述: MT 前表面处理不合理

Item Number:
 件号: N/A

Drawing:
 图号: CW018

Location: OBG Trial assembly
 位置: OBG 外场

Date:
 日期: 2009-06-19

Description of Nonconformance:
 不符合项状态描述:

Caltrans Inspector observed magnetic particle testing that had been performed on light pipe brackets on Counterweight CW18 (OBG Segment 2BW). The MT was performed through protective coating and/or rust and was accepted by ZPMC QC MT technicians.

加州检验员发现配重块 CW18 (2BW 箱体) 的管状支撑已经完成了 MT。MT 完成时, 表面存在油漆和铁锈等污染物, 但是 ZPMC MT 人员已经完成并接受了 MT。

参考标准: AWS D1.5 章节 6.7.6.3 “MT 之前, 必须检验表面, 至少被检表面邻近 25mm 区域内必须干燥, 并且无诸如油、润滑脂、铁锈、砂粒、氧化皮、棉线头、厚漆层、焊接飞溅等污染物”。

Work By: Li Linying Prepared by: Li Linying Reviewed by QCE: Zhao Shuangpan
 施工方: 2009.06.19 准备: 6/19/09 质量工程师批准:
 Drawing Error / 图纸错误 Material Defect / 材料缺陷 Fabrication Error / 制作错误 Other / 其他原因 6-19

Disposition: Use as is / 回用 Repair / 返修 Reject / 拒收

Recommendation:
 建议: 去除油漆铁锈后重新检验. Remove protective coating and rust, then re-inspection.

Prepared by: Li Linying Approved by QCA: _____
 准备 2009.06.19 质量经理批准

Reason for Nonconformance:
 不符合原因: 检测表面未清理干净. Didn't clean inspection surface completely

预防措施: 加强教育培训. Enhance education and training.
 Approved by/批准: Li Linying 2009.06.19

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

Reviewed /批准: _____

Verification: Acceptable / 可接受 Unacceptable / 不可接受
 确认:

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

DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge
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Shanghai 201913 PR China
Tel: 021-56856666 ext 207061 Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

To: AMERICAN BRIDGE/FLUOR, A JV Date: 14-Jun-2009
375 BURMA ROAD
OAKLAND CA 95607 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: 05.03.06-000267
Subject: NCR No. ZPMC-0282

Reference Description: Improper Surface Preparation Prior to MT, CW018, Segment 2BW

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- Non-Conformance Resolved.

Material Location: Xbeam

Lift: 02

Remarks:

Caltrans Quality Assurance (QA) Inspector observed magnetic particle testing (MT) that had been performed on light pipe brackets on Counterweight CW018 (OBG Segment 2BW). The MT was performed through protective coating and/or rust and was accepted by ZPMC Quality Control (QC) MT technicians.

See NCR report No. ZPMC-282 for details.

Action Required and/or Action Taken:

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

Transmitted by: Ching Chao

Attachments: ZPMC-0282

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

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Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000308

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 08-Jun-2009

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

NCR #: ZPMC-0282

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

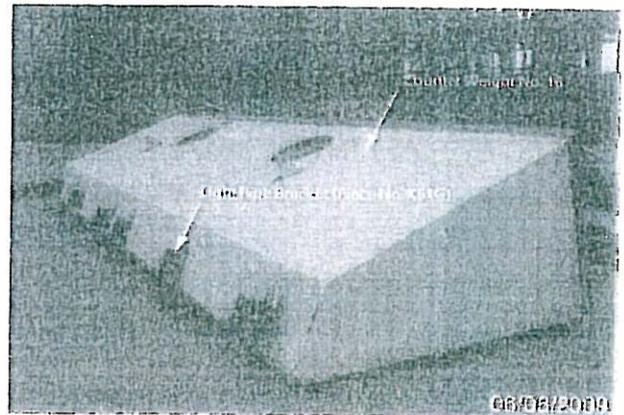
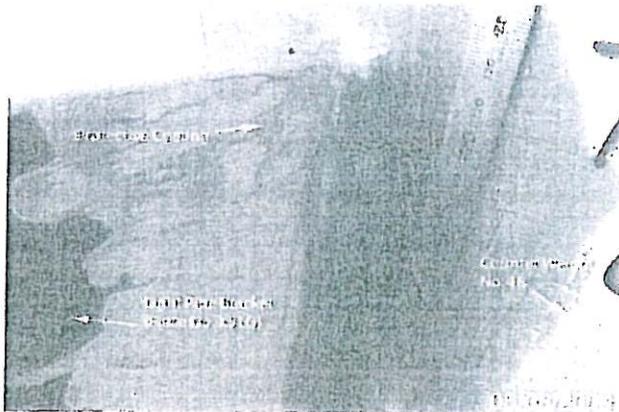
Component: Counterweight CW018, Segment 2BW

Procedural Procedural Description:

Reference Description: Improper Surface Preparation Prior to MT, CW018, Segment 2BW

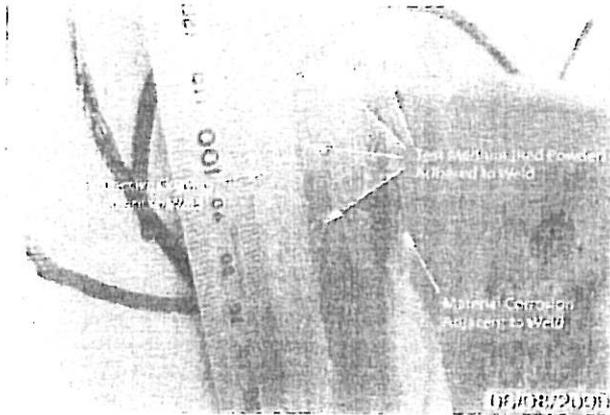
Description of Non-Conformance:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002 Section 6.7.6.3: "Prior to MT, the surface shall be examined, and any adjacent area within at least 25 mm [1 in.] of the surface to be tested, shall be dry and free of contaminants such as oil, grease, loose rust, loose sand, loose scale, lint, thick paint, welding flux, and weld spatter."

Who discovered the problem: Rory O'Kane

Name of individual from Contractor notified: Kevin Chen

Time and method of notification: 16:45, 06-08-09, Verbal

Name of Caltrans Engineer notified: Stanley Ku

Time and method of notification: 14:00, 06-10-09, Verbal

QC Inspector's Name: Shen Xuejun

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, (86) 1500.042.2360, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler

SMR

Reviewed By: Wabbeh, Mazen

SMR



REPORT OF MAGNETIC PARTICLE EXAMINATION

磁粉检测报告

REPORT NO. 报告编号 B787-MT-13006		DATE日期 2009.06.15		PAGE OF页码 1/1		Revision No: 0			
PROJECT NO. 工程编号: ZP06-787			CONTRACTOR: 用户: CALTRANS						
DRAWING NO. 图号: CW001 OBG COUNTERWEIGHT BOX			CALTRANS CONTRACT NO.: 加州工程编号 04-0120F4						
REFERENCING CODE 参考规范编码 AWS D1.5-2002		ACCEPTANCE STANDARD 接受标准 AWS D1.5-2002		PROCEDURE NO. 程序编号 ZPQC-MT-01		CALIBRATION DUE DATE 仪器校正有效期 Dec. 28 ST , 2009			
EQUIPMENT 设备 MT YOKE		MANUFACTURER 制造商 PARKER		MODEL NO. 样式编号 B310S		SERIAL NO. 连续编号 5395 5617 5620			
MAGNETIZING METHOD 磁化方法		Continuous magnetic yoke 磁轭式连续法		CURRENT 电流		AC			
PARTICLE TYPE 磁粉类型		Dry magnet powder 干磁粉		YOKE SPACING 磁轭间距		70~150mm			
MATERIAL TO BE EXAMINED 检测材料		<input checked="" type="checkbox"/> WELDING 焊接件 <input type="checkbox"/> CASTING 铸件 <input type="checkbox"/> FORGING 锻造		Material & thickness 母材,厚度		A709M-345T2-X 10/9.5mm			
WELDING PROCESS 焊接方法			SMAW		TYPE OF JOINT 焊缝类型			T-JOINT	
WELD I.D. 焊缝编号	DISCONTINUITY不连续性			ACCEPT 接受	REJECT 拒收	REMARKS 备注			
	INDICATION 指示	TYPE 类型	LENGTH IN mm 长度						
CW001-PP042-127						*			
CW001-PP042-128				ACC.		100%MT			
CW001-PP042-129				ACC.		100%MT			
CW001-PP042-130						*			
CW001-PP042-131						*			
CW001-PP042-132						*			
CW001-PP042-133						*			
* CW001-PP042-128、CW001-PP046-129were MT inspection and ACC, which is the result of required 25% MT. * CW001-PP042-128、CW001-PP046-129焊缝经MT检测合格，累积检测长度已经达到了此批要求的25%检测长度。									
BLANK									
EXAMINED BY主探 Tan Chaowei <i>Tan Chaowei</i>				REVIEWED BY 审核 <i>Sui Wei</i>					
LEVEL - II SIGN 签名 / DATE日期 质量经理 / QCM <i>[Signature]</i> 签字 SIGN / 日期 DATE 6.15				LEVEL-II SIGN / DATE日期 用户CUSTOMER 签字 SIGN / 日期 DATE					

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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, P.R. China**Report No:** NCS-000245**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:****Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0282**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: 08-Jun-2009**Description of Non-Conformance:**

Caltrans Quality Assurance (QA) Inspector observed magnetic particle testing (MT) that had been performed on light pipe brackets on Counterweight CW018 (OBG Segment 2BW). The MT was performed through protective coating and/or rust and was accepted by ZPMC Quality Control (QC) MT technicians.

Contractor's proposal to correct the problem:

Contractor has acknowledged that this item must be addressed, and the item was added to the Master Punchlist.

Corrective action taken:

Work was completed and item was cleared on Master Punchlist by Caltrans on 8-7-09. Submittal of documentation by Contractor being tracked on Documentation Punchlist.

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