

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-000353**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 16-Jul-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0327**Type of problem:**

| | | |
|---------------------|-------------------|---------------------|
| Welding | Concrete | Other |
| Welding | Curing | Procedural |
| Joint fit-up | Coating | Other |
| Procedural | Procedural | Description: |

Bridge No: 34-0006**Component:** Side Panels SP623B, SP626A & SP626B**Reference Description:** Cope Holes**Description of Non-Conformance:**

During random visual inspection, Caltrans Quality Assurance (QA) Inspector observed Weld Access Holes, which were removed via thermal cutting, were not finished in accordance with Section 3.2.5 of AWS D1.5. The components observed were located on Side Panels SP623B, SP626A, and SP 626B (currently located in Bay 14). These components were previously inspected and accepted by ZPMC personnel.

See attached photos for details:

**Applicable reference:**

AWS D1.5 / 2002 – Section 3.2.5: “Radii of beam copes and weld access holes shall provide a smooth transition, free of notches or cutting past the points of tangency between adjacent surfaces.”

Who discovered the problem: Rory O’Kane**Name of individual from Contractor notified:** Peter Shaw**Time and method of notification:** 15:20 hours, Email**Name of Caltrans Engineer notified:** Bill Howe

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Time and method of notification: 16:30 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 Mazen Wahbeh,(818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Simonis,Jim

QA Inspector

Reviewed By: Wahbeh,Mazen

SMR



DEPARTMENT OF TRANSPORTATION - District 4 Toll Bridge

333 Burma Road
Oakland CA 94607
Tel: Fax:

NON-CONFORMANCE REPORT TRANSMITTAL

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

Date: 05-Aug-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: 05.03.06-000330

Subject: NCR No. ZPMC-0327

Reference Description: Cope Holes

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:** 12

Remarks:

During random visual inspection, Caltrans Quality Assurance (QA) Inspector observed Weld Access Holes, which were removed via thermal cutting, were not finished in accordance with Section 3.2.5 of AWS D1.5. The components observed were located on Side Panels SP623B, SP626A, and SP 626B (currently located in Bay 14). These components were previously inspected and accepted by ZPMC personnel.

Action Required and/or Action Taken:

Finish in accordance with AWS D1.5.

Transmitted by: Bill Howe

Attachments: ZPMC-0327

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, 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: 05.03.06-000330

Subject: NCR No. ZPMC-0327

Dated: 24-Aug-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000325 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC completes this work in segment assembly. Final inspection will be performed and documented as such during final VT inspection prior to blasting.

ZPMC has informed ABF that the cope holes are not final inspected and therefore are considered in process. ZPMC completes this work in segment assembly. Final inspection will be performed and documented as such during final VT inspection prior to blasting. ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000325R00

Caltrans' comments:

Status: CLO

Date: 28-Aug-2009

The proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0327 is closed.

Submitted by: Wright, Doug

Date: 28-Aug-2009

Attachment(s):

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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-000361**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0327**Type of problem:**

| | | | |
|---------------------|-------------------|---------------------|---------------------------|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: |
| Procedural | Procedural | Description: | |

Date the Non-Conformance Report was written: 16-Jul-2009**Description of Non-Conformance:**

During random visual inspection, Caltrans Quality Assurance (QA) Inspector observed Weld Access Holes, which were removed via thermal cutting, were not finished in accordance with Section 3.2.5 of AWS D1.5. The components observed were located on Side Panels SP623B, SP626A, and SP 626B (currently located in Bay 14). These components were previously inspected and accepted by ZPMC personnel.

See attached photos for details:

Contractor's proposal to correct the problem:

Perform cope hole inspection / repair during segment assembly stage.

Corrective action taken:

NCR was written while work was in process. ABF ensures that ZPMC will address the issue during segment assembly stage.

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.

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| Inspected By: Simonis, Jim | Quality Assurance Inspector |
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| Reviewed By: Wahbeh, Mazen | QA Reviewer |
|-----------------------------------|-------------|