

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
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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, P.R. China**Report No:** NCR-000433**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Sep-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0407**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Lift 1E: 1AE to 1BE Segment Splice
Procedural	Procedural	Description: Access Issue and Removing of UT Test Result	

Reference Description: The contractor failed to provide access for QA inspection and removed QA UT test results

Description of Non-Conformance:

ZPMC failed to provide access to document the quality of the work associated with transverse splice weld between the bottom panel of Segment 1AE and 1BE. Additionally, a ZPMC Production Supervisor acted in an improper manner by removing test result markings and preventing Caltrans Quality Assurance (QA) from recording test results. Based upon information relayed from the recent Project Management meetings, the transverse splice welds in OBG Lifts 1E, 1W, 2E and 2W require additional Ultrasonic Testing (UT) to identify potential transverse indications for evaluation and consideration by the Engineer. QA personnel attempted to commence UT of the bottom panel transverse splice weld in Lift 1E to develop protocol and procedures for joint testing between ABF and Caltrans. QA personnel attempted to conduct UT on the bottom panel splice between 1AE and 1BE in Lift 1E at 1400. The weld was determined to need cleaning to remove heavy corrosion. QA requested assistance from ABF and ZPMC, however ZPMC QC indicated that ZPMC would not provide assistance with this endeavor due to ZPMC management's position on the issue. QA personnel later acquired a power wire brush and cleaned the subject weld at approximately 1700 to facilitate UT, which commenced at 1730. A ZPMC Production Supervisor arrived at the test location at 1815 and insisted the termination of further testing. QA personnel were in the process of evaluating indications when the individual began impeding the testing by wiping the couplant from the test area and shouting "No UT". The testing stopped and QA personnel began transferring test information from the work location to paper when the ZPMC Production individual commenced removing the markings placed on the weld. The individual would not allow QA to transfer the information or photograph the test area in order to capture the test information. QA personnel departed the location at 1835 without completing the documentation of the testing performed.

Applicable reference:

A.) Standard Specifications: July 1999, Section 5-1.08 "Inspection"

The Engineer shall, at all times, have safe access to the work during its construction, and shall be furnished with every reasonable facility for ascertaining that the materials and the workmanship are in accordance with the requirements and intentions of these specifications, the special provisions, and the plans. All work done

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

and materials furnished shall be subject to the Engineer's inspection.

B.) Standard Specifications: July 1999, Section 5-1.12 "Character of Workers"

If any subcontractor or person employed by the Contractor shall appear to the Engineer to be incompetent or act in a disorderly or improper manner, they shall be discharged on the request of the Engineer, and that person shall not again be employed on the work.

C.) Special Provisions, Section 8-3.01 "Welding" General

The Engineer shall, at all times, have safe access to the work during construction, and shall be furnished with every reasonable facility to photograph, video, or otherwise document that the material and workmanship are in accordance with the requirements of these special provisions and plans.

Who discovered the problem: John Kinsey

Name of individual from Contractor notified: Steve Lawton

Time and method of notification: 1000 hours, verbal

Name of Caltrans Engineer notified: Doug Coe

Time and method of notification: 0800 hours, verbal

QC Inspector's Name: Wang Lu

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.

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	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: 29-Sep-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: 05.03.06-000396

Subject: NCR No. ZPMC-0407

Reference Description: The contractor failed to provide access for QA inspection and removed QA UT test results

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:** 01

Remarks:

ZPMC failed to provide access to document the quality of the work associated with transverse splice weld between the bottom panel of Segment 1AE and 1BE. Additionally, a ZPMC Production Supervisor acted in an improper manner by removing test result markings and preventing Caltrans Quality Assurance (QA) from recording test results. Based upon information relayed from the recent Project Management meetings, the transverse splice welds in OBG Lifts 1E, 1W, 2E and 2W require additional Ultrasonic Testing (UT) to identify potential transverse indications for evaluation and consideration by the Engineer. QA personnel attempted to commence UT of the bottom panel transverse splice weld in Lift 1E to develop protocol and procedures for joint testing between ABF and Caltrans. QA personnel attempted to conduct UT on the bottom panel splice between 1AE and 1BE in Lift 1E at 1400. The weld was determined to need cleaning to remove heavy corrosion. QA requested assistance from ABF and ZPMC, however ZPMC QC indicated that ZPMC would not provided assistance with this endeavor due to ZPMC management’s position on the issue. QA personnel later acquired a power wire brush and cleaned the subject weld at approximately 1700 to facilitate UT, which commenced at 1730. A ZPMC Production Supervisor arrived at the test location at 1815 and insisted the termination of further testing. QA personnel were in the process of evaluating indications when the individual began impeding the testing by wiping the couplant from the test area and shouting “No UT”. The testing stopped and QA personnel began transferring test information from the work location to paper when the ZPMC Production individual commenced removing the markings placed on the weld. The individual would not allow QA to transfer the information or photograph the test area in order to capture the test information. QA personnel departed the location at 1835 without completing the documentation of the testing performed.

Please see the attached NCR No. ZPMC-407 for details.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. A response for the resolution of this issue is expected within 14 days.

Transmitted by: Ching Chao

NCT

(Continued Page 2 of 2)

Attachments: ZPMC-0407

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000396

Subject: NCR No. ZPMC-0407

Dated: 17-Nov-2009

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000421 **Rev:** 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC management agrees this type of behaviour is unacceptable and have taken measures of notifying QA and production personnel of the QA verification requirements.

ABF has investigated this incident and have notified ZPMC that this type of behavior is unacceptable per the contract as access must be provided to the engineer. However, ABF had previously set up an inspection scheduling protocol to notify ZPMC of ABF/CT inspection. For this particular incident, ABF was not notified by nor was ZPMC notified that CT would be performing this inspection. Again ABF has discussed this incident with ZPMC Management, ZPMC management agrees this type of behaviour is unacceptable and have taken measures of notifying QA and production personnel of the QA verification requirements. Since this incident, the scheduled inspection notification process has been a success as all of the joints requiring verification/ overchecks have been completed without this type of incident recurring. Based on this ZPMC requests closure of this NCR.

Submitted by:

Attachment(s): ABF-NPR-000421R00

Caltrans' comments:

Status: CLO

Date: 30-Nov-2009

The resolution submitted by the contractor is considered acceptable.

Submitted by: Chao, Ching

Date: 30-Nov-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, P.R. China**Report No:** NCS-000408**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 25-Dec-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0407**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: 27-Sep-2009**Description of Non-Conformance:**

ZPMC failed to provide access to document the quality of the work associated with transverse splice weld between the bottom panel of Segment 1AE and 1BE. Additionally, a ZPMC Production Supervisor acted in an improper manner by removing test result markings and preventing Caltrans Quality Assurance (QA) from recording test results. Based upon information relayed from the recent Project Management meetings, the transverse splice welds in OBG Lifts 1E, 1W, 2E and 2W require additional Ultrasonic Testing (UT) to identify potential transverse indications for evaluation and consideration by the Engineer. QA personnel attempted to commence UT of the bottom panel transverse splice weld in Lift 1E to develop protocol and procedures for joint testing between ABF and Caltrans. QA personnel attempted to conduct UT on the bottom panel splice between 1AE and 1BE in Lift 1E at 1400. The weld was determined to need cleaning to remove heavy corrosion. QA requested assistance from ABF and ZPMC, however ZPMC QC indicated that ZPMC would not provide assistance with this endeavor due to ZPMC management's position on the issue. QA personnel later acquired a power wire brush and cleaned the subject weld at approximately 1700 to facilitate UT, which commenced at 1730. A ZPMC Production Supervisor arrived at the test location at 1815 and insisted the termination of further testing. QA personnel were in the process of evaluating indications when the individual began impeding the testing by wiping the couplant from the test area and shouting "No UT". The testing stopped and QA personnel began transferring test information from the work location to paper when the ZPMC Production individual commenced removing the markings placed on the weld. The individual would not allow QA to transfer the information or photograph the test area in order to capture the test information. QA personnel departed the location at 1835 without completing the documentation of the testing performed.

Contractor's proposal to correct the problem:

ABF has investigated this incident and have notified ZPMC that this type of behavior is unacceptable per the contract as access must be provided to the engineer.

Corrective action taken:

ZPMC management agrees this type of behavior is unacceptable and have taken measures of notifying QA and production personnel of the QA verification requirements.

