

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-000472

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 07-Oct-2009

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

NCR #: ZPMC-0445

Type of problem:

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

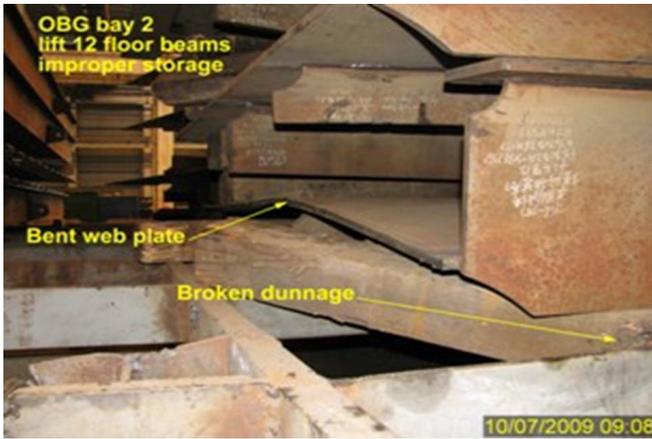
Bridge No: 34-0006

Component: Numerous Lift 12 Floor Beam Components

Reference Description: Improper storage of fabricated Floor Beam components in Lift 12

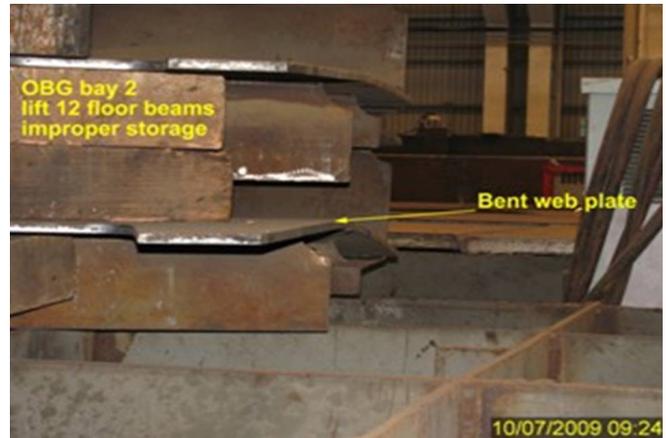
Description of Non-Conformance:

This Quality Assurance Inspector (QA) observed Lift 12 Floor Beam components were bent and warped due to improper handling and/or storage. These Floor Beam components are fabricated and stored in OBG sub-assembly Bay 2.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



Applicable reference:

Caltrans Standard Specifications 1999:

- 1) Section 6-1.3; Articles or materials to be incorporated in the work shall be stored in such a manner as to ensure the preservation of their quality and fitness for the work, and to facilitate inspection.
- 2) Section 55-1.04; 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.
- 3) Section 55-3.09; Finish members shall be true to line and free from twists, bends and open joints.

Who discovered the problem: Steve Hall

Name of individual from Contractor notified: Wen Wen Bin

Time and method of notification: 1000 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1430 hours, Email

QC Inspector's Name: Chen Xi

Was QC Inspector aware of the problem:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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:	Carreon,Albert	Lead Reviewer/Task Leader
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: 12-Nov-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: 05.03.06-000435

Subject: NCR No. ZPMC-0445

Reference Description: Improper storage of fabricated Floor Beam components in Lift 12

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:

This Quality Assurance Inspector (QA) observed Lift 12 Floor Beam components were bent and warped due to improper handling and/or storage. These Floor Beam components are fabricated and stored in OBG sub-assembly Bay 2.

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval prior to installing these bent and warped components into the work. Correct the storage procedure that lead to the bent and warped components.

Transmitted by: Bill Howe

Attachments: ZPMC-0445

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: 05.03.06-000435

Subject: NCR No. ZPMC-0445

Dated: 11-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000473 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF has notified ZPMC QA department to discuss handling practices with production to improve handling and storage practices to prevent damage as shown in this NCR.

ABF has notified ZPMC QA department to discuss handling practices with production to improve handling and storage practices to prevent damage as shown in this NCR. ZPMC will re-stack and or organize these Floor beams as required to prevent damage. ZPMC QA will conduct a documented training session with the material handling personnel as well as production personnel in each workshop of proper handling and storage practices.

Submitted by: Lawton, Steve

Attachment(s): ABF-NPR-000473R00

Caltrans' comments:

Status: REJ

Date: 13-Jan-2010

Since this NCR was written in October for specific elements, proposing discussions to improve handling and then restack is not acceptable. Provide status of these particular floor beams.

Submitted by: Howe, Bill

Attachment(s):

Date: 13-Jan-2010

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000435

Subject: NCR No. ZPMC-0445

Dated: 08-Feb-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000473 Rev: 01

Contractor's Proposed Resolution:

Reference Resolution: ZPMC QA has conducting training with the production and transportation departments to ensure that good handling and storage practices are followed. Attached is an attendance roster.

Specific floorbeam identification numbers were not listed in Caltrans' non conformance report, therefore it is not possible to provide status of the floorbeams per Caltrans' comments to ABF-NPR-000473R0. ZPMC QA has conducting training with the production and transportation departments to ensure that good handling and storage practices are followed. Attached is an attendance roster from the ZPMC meeting. ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000473R01;

Caltrans' comments:

Status: CLO

Date: 08-Feb-2010

Training verification is sufficient to close this NCR.

Submitted by: Howe, Bill

Date: 08-Feb-2010

Attachment(s):

会议签到单

会议时间：2009.10.24

会议地点：钢构三部办公室 **ZPMC Department 3**

会议主题：关于美国钢桥产品及构件摆放不正规的会议 **Storage and handling of components on the American Bridge Project**

与会人员（签到）：

生产：

Production

张卫 李卫 李卫 李卫 李卫
李卫 李卫 李卫 李卫 李卫
李卫 李卫 李卫 李卫 李卫

起运：

李卫

施工队：

Transportation

李卫 李卫
李卫 李卫

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-000505**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 09-Feb-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0445**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: 07-Oct-2009**Description of Non-Conformance:**

This Quality Assurance Inspector (QA) observed Lift 12 Floor Beam components were bent and warped due to improper handling and/or storage. These Floor Beam components are fabricated and stored in OBG sub-assembly Bay 2.

Contractor's proposal to correct the problem:

Provide training to ZPMC personnel in regards to proper storage and handling practices.

Corrective action taken:

All Lift 12 Floor Beam sub-assemblies have been moved to Bays 13 and 14. The Contractor submitted a training session roster as verification of ABF addressing storage and handling issues internally with ZPMC. No documentation was submitted in regards to the current condition of the Floor Beam sub-assemblies as no piece marks were listed in the NCR. Dimensional inspections will continue throughout the Segment Assembly phase.

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