

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, P.R. China**Report No:** NCR-000506**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0479**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG CB8 Side and Bottom Panel
Procedural	Procedural	Description:	

Reference Description: SPCM base material repair on CB8 performed without prior Engineer's approval**Description of Non-Conformance:**

This Quality Assurance (QA) inspector observed ZPMC personnel performing base metal weld repairs on material designated as SPCM on the approved shop drawings without prior Engineer's approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as Orthotropic Box Girder (OBG) crossbeam CB8. The Seismic Performance Critical Member (SPCM) panels affected are identified as side panel SP202A and bottom panel BP204A.

**Applicable reference:**

1. AWS D1.5 2002 section 3.3.7.3 "Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair.

2. AWS D1.5 2002 section 3.7.4 "Prior approval of the Engineer shall be obtained for repairs to base metal..."

Who discovered the problem: Steve Hall

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Kelvin Chueng

Time and method of notification: 1430 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1530 hours, Verbal

QC Inspector's Name: Zhang Wei

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: 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: 11-Dec-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: 05.03.06-000469

Subject: NCR No. ZPMC-0479

Reference Description: SPCM base material repair on CB8 performed without prior Engineer's approval

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:** 08

Remarks:

This Quality Assurance (QA) inspector observed ZPMC personnel performing base metal weld repairs on material designated as SPCM on the approved shop drawings without prior Engineer's approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as Orthotropic Box Girder (OBG) crossbeam CB8. The Seismic Performance Critical Member (SPCM) panels affected are identified as side panel SP202A and bottom panel BP204A.

Action Required and/or Action Taken:

Submit a repair plan to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0479

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000469

Subject: NCR No. ZPMC-0479

Dated: 25-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000543 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC will provide explanation of measures that they took to correct the issue. In addition, the repair report and NDT documentation will be provided to show the SPCM material was not damaged.

ZPMC will provide explanation of measures that they took to correct the issue documented in the NCR. In addition, the repair report and NDT documentation will be provided to show the SPCM material was not damaged. Based on this ZPMC requests that this course of action be approved with action pending. When documents become available ZPMC will request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000543R00

Caltrans' comments:

Status: AAP

Date: 26-Jan-2010

The proposed resolution provided by the contractor is accepted. The NCR will be closed once the required preventative measures are taken and repair documentation are submitted for the Engineer's review and acceptance.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010

NCR PROPOSED RESOLUTION

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

Dated: 20-Apr-2010

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Ref: 05.03.06-000469

Document No.: ABF-NPR-000543 **Rev:** 01

Subject: NCR No. ZPMC-0479

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT documentation that base metal repairs observed are acceptable. Based on this ZPMC request closure of this NCR.

ZPMC is providing NDT documentation that base metal repairs observed are acceptable. Based on this ZPMC request closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000543R01;

Caltrans' comments:

Status: REJ

Date: 25-Apr-2010

The NCR shows that the base metal repairs were performed prior to the NCR being written in November 2009 while CWR was approved long after this in March of 2010. Additionally, the MT report for the excavation is dated the same as the MT report for after welding. This conflicts with the SPCM material requirements of AWS D1.5 Section 12.16.4, which requires welds to cool for a period of 24 hours prior to inspection.

Submitted by: Eagen, Sean

Date: 25-Apr-2010

Attachment(s):



No. B-732

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-4-20

REGARDING: NCR-000506(ZPMC-0479) NCR-000537(ZPMC-0510)

ZPMC is providing the NDT records what show these base metal repair are now acceptable. The repair procedure please look at B-CWR 1236. Based on this, ZPMC is requesting closure of these NCRs.

ATTACHMENT:

NCR-000506(ZPMC-0479)

NCR-000537(ZPMC-0510)

B787-MT-20791

B787-MT-20792

[Handwritten signature]
4/20/10



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: 11-Dec-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: 05.03.06-000469

Subject: NCR No. ZPMC-0479

Reference Description: SPCM base material repair on CB8 performed without prior Engineer's approval

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: 08

Remarks:

This Quality Assurance (QA) inspector observed ZPMC personnel performing base metal weld repairs on material designated as SPCM on the approved shop drawings without prior Engineer's approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as Orthotropic Box Girder (OBG) crossbeam CB8. The Seismic Performance Critical Member (SPCM) panels affected are identified as side panel SP202A and bottom panel BP204A.

Action Required and/or Action Taken:

Submit a repair plan to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0479

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

File: 05.03.06

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

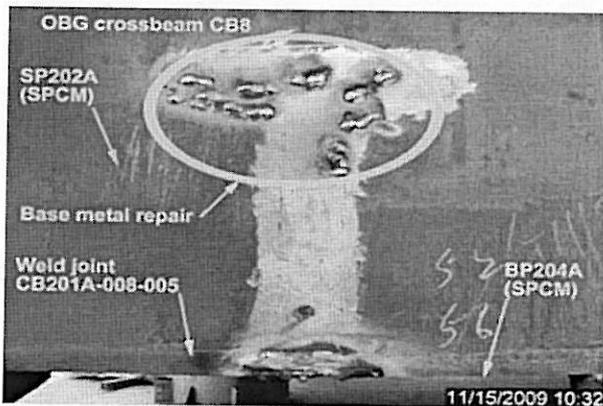
Quality Assurance and Source Inspection



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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-000506**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 15-Nov-2009**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0479**Type of problem:**Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: OBG CB8 Side and Bottom PanelProcedural Procedural Description:**Reference Description:** SPCM base material repair on CB8 performed without prior Engineer's approval**Description of Non-Conformance:**

This Quality Assurance (QA) inspector observed ZPMC personnel performing base metal weld repairs on material designated as SPCM on the approved shop drawings without prior Engineer's approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as Orthotropic Box Girder (OBG) crossbeam CB8. The Seismic Performance Critical Member (SPCM) panels affected are identified as side panel SP202A and bottom panel BP204A.

**Applicable reference:**

1. AWS D1.5 2002 section 3.3.7.3 "Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair.
2. AWS D1.5 2002 section 3.7.4 "Prior approval of the Engineer shall be obtained for repairs to base metal..."

Who discovered the problem: Steve Hall

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Kelvin Chueng

Time and method of notification: 1430 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1530 hours, Verbal

QC Inspector's Name: Zhang Wei

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: 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: 24-Dec-2009

Contract No: 04-0120F4

04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0510

Job Name: SAS Superstructure

Document No: 05.03.06-000498

Reference Description: Base Metal Repair without Engineer's Approval, Side Panel SP205A, Crossbeam CB8

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: 08

Remarks:

During a random visual inspection of the Orthotropic Box Girder (OBG) Crossbeam CB8, the Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel performing un-approved Seismic Performance Critical Member (SPCM) base metal repairs on the Side Panel (SP) of Crossbeam CB8 without the Engineer's approval.

-The BP was identified as: BP205A

-The SP was identified as: SP205A

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe

Attachments: ZPMC-0510

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

File: 05.03.06

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 DIVISION OF ENGINEERING SERVICES
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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, P.R. China

Report No: NCR-000537

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Dec-2009

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

NCR #: ZPMC-0510

Type of problem:

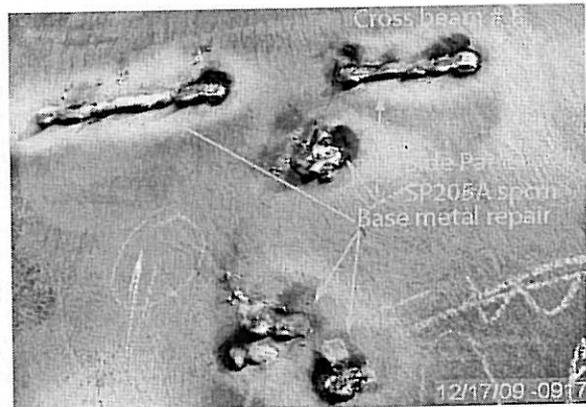
- Welding Concrete Other
 Welding Curing Procedural **Bridge No:** 34-0006
 Joint fit-up Coating Other **Component:** Crossbeam CB8
 Procedural Procedural **Description:**

Reference Description: Base Metal Repair without Engineer's Approval, Side Panel SP205A, Crossbeam CB8

Description of Non-Conformance:

During a random visual inspection of the Orthotropic Box Girder (OBG) Crossbeam CB8, the Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel performing un-approved Seismic Performance Critical Member (SPCM) base metal repairs on the Side Panel (SP) of Crossbeam CB8 without the Engineer's approval.

- The BP was identified as: BP205A
- The SP was identified as: SP205A
- The weld number between the SP and BP is identified as: CB202A-008-017
- The material utilized is A709 Grade 345 SPCM.
- The welding process used was SMAW.



Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Standard Specifications (99) section 8-3.01: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair."

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Dhanasingh Sukanthan
Name of individual from Contractor notified: Kevin Chen
Time and method of notification: 0920 hours, 12-17-09, Verbal
Name of Caltrans Engineer notified: Bill Howe
Time and method of notification: 1100 hours, 12-18-09, Verbal
QC Inspector's Name: Liu Chuan Gang
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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Guest, Skyler	SMR
Reviewed By:	Wahbeh, Mazen	SMR

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000469

Subject: NCR No. ZPMC-0479

Dated: 01-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000543 Rev: 02

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT records which show that the testing was performed after the required waiting period and the results are acceptable. Based on this ZPMC requests closure of this NCR.

ZPMC is providing NDT records which show that the testing was performed after the required waiting period and the results are acceptable. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000543R02;

Caltrans' comments:

Status: CLO

Date: 03-Jun-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0479 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 03-Jun-2010



No. B-774

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-5-27

REGARDING: NCR-000506(ZPMC-0479) NCR-000537(ZPMC-0510)

ZPMC is providing the NDT record what shows the repair areas were tested to be acceptable after the required cool period in AWS D1.5. Based on this, ZPMC is requesting closures of these NCRs.

ATTACHMENT:

NCR-000506(ZPMC-0479)

NCR-000537(ZPMC-0510)

B787-MT-23503

A handwritten signature in blue ink, appearing to be "Jing" followed by a flourish.

5/27/10



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: 11-Dec-2009

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

Dear: Mr. Charles Kanapicki

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure

Subject: NCR No. ZPMC-0479

Document No: 05.03.06-000469

Reference Description: SPCM base material repair on CB8 performed without prior Engineer's approval

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: 08

Remarks:

This Quality Assurance (QA) inspector observed ZPMC personnel performing base metal weld repairs on material designated as SPCM on the approved shop drawings without prior Engineer's approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as Orthotropic Box Girder (OBG) crossbeam CB8. The Seismic Performance Critical Member (SPCM) panels affected are identified as side panel SP202A and bottom panel BP204A.

Action Required and/or Action Taken:

Submit a repair plan to the engineer for approval.

Transmitted by: Bill Howe

Attachments: ZPMC-0479

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

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-000506

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 15-Nov-2009

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

NCR #: ZPMC-0479

Type of problem:

Welding Concrete Other

Welding Curing Procedural

Joint fit-up Coating Other

Procedural Procedural Description:

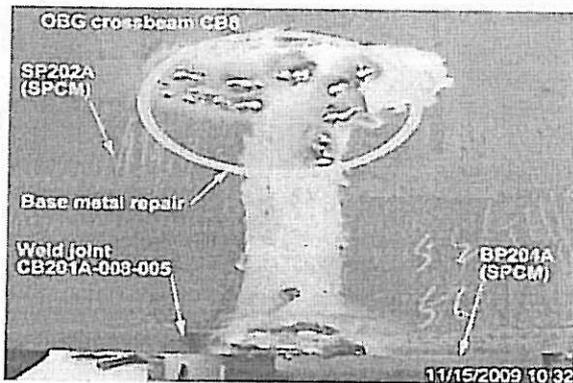
Bridge No: 34-0006

Component: OBG CB8 Side and Bottom Panel

Reference Description: SPCM base material repair on CB8 performed without prior Engineer's approval

Description of Non-Conformance:

This Quality Assurance (QA) inspector observed ZPMC personnel performing base metal weld repairs on material designated as SPCM on the approved shop drawings without prior Engineer's approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as Orthotropic Box Girder (OBG) crossbeam CB8. The Seismic Performance Critical Member (SPCM) panels affected are identified as side panel SP202A and bottom panel BP204A.



Applicable reference:

1. AWS D1.5 2002 section 3.3.7.3 "Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair.

2. AWS D1.5 2002 section 3.7.4 "Prior approval of the Engineer shall be obtained for repairs to base metal..."

Who discovered the problem: Steve Hall

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Name of individual from Contractor notified: Kelvin Chueng

Time and method of notification: 1430 hours, Verbal

Name of Caltrans Engineer notified: Ching Chao and Bill Howe

Time and method of notification: 1530 hours, Verbal

QC Inspector's Name: Zhang Wei

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: 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: 24-Dec-2009

Contract No: 04-0120F4

04-SF-80-13.2 / 13.9

Dear: Mr. Charles Kanapicki
Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Job Name: SAS Superstructure

Document No: 05.03.06-000498

Subject: NCR No. ZPMC-0510

Reference Description: Base Metal Repair without Engineer's Approval, Side Panel SP205A, Crossbeam CB8

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: 08

Remarks:

During a random visual inspection of the Orthotropic Box Girder (OBG) Crossbeam CB8, the Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel performing un-approved Seismic Performance Critical Member (SPCM) base metal repairs on the Side Panel (SP) of Crossbeam CB8 without the Engineer's approval.

-The BP was identified as: BP205A

-The SP was identified as: SP205A

Action Required and/or Action Taken:

Submit a repair procedure to the engineer for approval. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe

Attachments: ZPMC-0510

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

File: 05.03.06

DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection



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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, P.R. China

Report No: NCR-000537

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 17-Dec-2009

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

NCR #: ZPMC-0510

Type of problem:

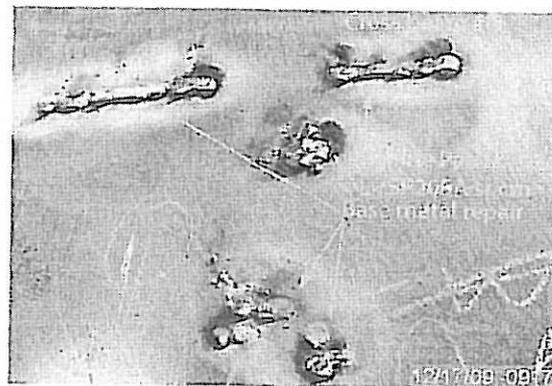
Welding Concrete Other
Welding Curing Procedural Bridge No: 34-0006
Joint fit-up Coating Other Component: Crossbeam CB8
Procedural Procedural Description:

Reference Description: Base Metal Repair without Engineer's Approval, Side Panel SP205A, Crossbeam CB8

Description of Non-Conformance:

During a random visual inspection of the Orthotropic Box Girder (OBG) Crossbeam CB8, the Caltrans Quality Assurance (QA) Inspector observed ZPMC personnel performing un-approved Seismic Performance Critical Member (SPCM) base metal repairs on the Side Panel (SP) of Crossbeam CB8 without the Engineer's approval.

- The BP was identified as: BP205A
- The SP was identified as: SP205A
- The weld number between the SP and BP is identified as: CB202A-008-017
- The material utilized is A709 Grade 345 SPCM.
- The welding process used was SMAW.



Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Standard Specifications (99) section 8-3.01: "The Engineer shall be notified immediately in writing when welding problems, deficiencies, base metal repairs, or any other type of repairs not submitted in the WQCP are discovered and also of the proposed repair procedures to correct them. For requests to perform repairs, The contractor shall include an engineering evaluation of the proposed repair."

ZPMC Welding Quality Control Plan, Section 9.2.1.2: "Prior approval of the Engineer shall be obtained for repairs to base metal other than what was identified in Section 9.2.1.1 of this manual and the repair of all other cracks."

AWS D1.5/2002, Section 3.7.4: "Prior approval of the Engineer shall be obtained for repairs to base metal."

Who discovered the problem: Dhanasingh Sukanthan
Name of individual from Contractor notified: Kevin Chen
Time and method of notification: 0920 hours, 12-17-09, Verbal
Name of Caltrans Engineer notified: Bill Howe
Time and method of notification: 1100 hours, 12-18-09, Verbal
QC Inspector's Name: Liu Chuan Gang
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 Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Guest, Skyler	SMR
Reviewed By: Wahbeh, Mazen	SMR

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
 690 Walnut Ave. St. 150
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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-000650**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0479**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: 15-Nov-2009**Description of Non-Conformance:**

This Quality Assurance (QA) inspector observed ZPMC personnel performing base metal weld repairs on material designated as SPCM on the approved shop drawings without prior Engineer's approval. The areas being repaired were damaged while removing temporary lifting lug welds at the corners of this crossbeam. The component is identified as Orthotropic Box Girder (OBG) crossbeam CB8. The Seismic Performance Critical Member (SPCM) panels affected are identified as side panel SP202A and bottom panel BP204A.

Contractor's proposal to correct the problem:

Perform NDT required to verify weld quality.

Corrective action taken:

Contractor submitted NDT documentation verifying the repaired areas are in conformance with Contract weld quality requirements.

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