

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-000582

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 02-Jan-2010

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

NCR #: ZPMC-0555

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 10CE FL3
Procedural	Procedural	Description:	

Reference Description: Perform of heat straightening in Segment 10CE without Engineer's approval

Description of Non-Conformance:

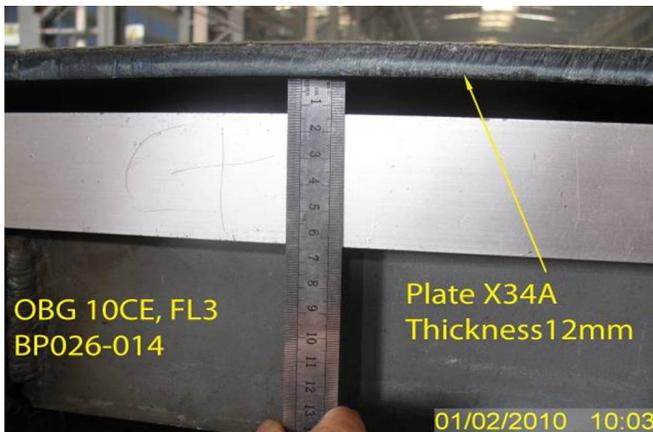
During the Quality Assurance (QA) in-process inspection of the FL3 floor beam bottom plate components, this QA inspector discovered the following issue;

- ZPMC personnel performed heat straightening on OBG segment 10CE, FL3 Bottom Plate without the prior approval of the engineer.

-The Bottom Plate assembly is identified as BP026-014 and the plate is identified as X34A, which measured to be a total of 12.5mm out of straightness in 1000mm.

-ZPMC QC or CWI were not present during the time of the heat straightening process.

-The component is located in fabrication bay 19.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5/2002 Section 3.7.3; Members distorted by welding shall be heat straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the engineer.

Caltrans Special Provisions Section 8-3: "For material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer.

Who discovered the problem: Mike Hasler

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1500 hours, 01-02-2010, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 2300 hours, 01-02-2010, E-mail

QC Inspector's Name: Lv Li Qing

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, (818) 292-0659, 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

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: 03-Jan-2010

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: 05.03.06-000545

Subject: NCR No. ZPMC-0555

Reference Description: Perform of heat straightening in Segment 10CE without 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: OBG **Lift:** 10

Remarks:

During the Quality Assurance (QA) in-process inspection of the FL3 floor beam bottom plate components, this QA inspector discovered the following issue;

- ZPMC personnel performed heat straightening on OBG segment 10CE, FL3 Bottom Plate without the prior approval of the engineer.

-The Bottom Plate assembly is identified as BP026-014 and the plate is identified as X34A, which measured to be a total of 12.5mm out of straightness in 1000mm.

-ZPMC QC or CWI were not present during the time of the heat straightening process.

-The component is located in fabrication bay 19.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. After the HS plan is reviewed and approved notify the engineer prior to starting HS activities. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0555

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: 05.03.06-000545

Subject: NCR No. ZPMC-0555

Dated: 09-Jun-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000680 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: If the distortion was measured in relation to the length of the plate as it should have been, then the heat straightening would not require Engineer approval and NCR would not be required.

Please refer to the Department's letter which states that "flatness checks using a 1 meter straightedge may not be sufficient to determine if the out of flatness tolerances specified in the contract have been exceeded". The use of the 1 meter straight edge results in the distortion exceeding the tolerances and requiring Engineer approval. In this case, if the distortion was measured in relation to the length of the plate as it should have been, then the heat straightening would not require Engineer approval and NCR would not be required. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000680R00;

Caltrans' comments:

Status: REJ

Date: 13-Jun-2010

ZPMC NCR-0555 also notes that QC was not present while the heat straightening was performed. Please address this issue.

Submitted by: Eagen, Sean

Attachment(s):

Date: 13-Jun-2010



No. B-777

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-5-31

REGARDING: NCR-000582(ZPMC-0555) NCR-000601(ZPMC-0574)

The method what inspector used to measure the distortion was incorrect. Refer to department's letter No.05.03.01-000419, as shown in attachment, the amount of distortion allowed for heat straightening without engineering approval is $(6/1000) * L$. L = length of member (mm). As stated in the same letter, 'Flatness checks utilizing a 1 - meter straight edge may not be sufficient to determine if the out of flatness tolerances specified in the contract have been exceeded '. Based on this, the distortion what measured by utilizing 1-meter template couldn't be adopted and the non-conformance could be thought was inexistent. Please consider the withdrawals of these NCRs.

ATTACHMENT:

NCR-000582(ZPMC-0555)

NCR-000601(ZPMC-0574)

Jay W
6/3/10



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: 03-Jan-2010

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-0555

Document No: 05.03.06-000545

Reference Description: Perform of heat straightening in Segment 10CE without Engineer's approval

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- 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: 10

Remarks:

During the Quality Assurance (QA) in-process inspection of the FL3 floor beam bottom plate components, this QA inspector discovered the following issue;

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- The Bottom Plate assembly is identified as BP026-014 and the plate is identified as X34A, which measured to be a total of 12.5mm out of straightness in 1000mm.
- ZPMC QC or CWI were not present during the time of the heat straightening process.
- The component is located in fabrication bay 19.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. After the HS plan is reviewed and approved notify the engineer prior to starting HS activities. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0555

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-000582

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 02-Jan-2010

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

NCR #: ZPMC-0555

Type of problem:Welding Concrete Other Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: Segment 10CE FL3

Procedural Procedural Description:

Reference Description: Perform of heat straightening in Segment 10CE without Engineer's approval

Description of Non-Conformance:

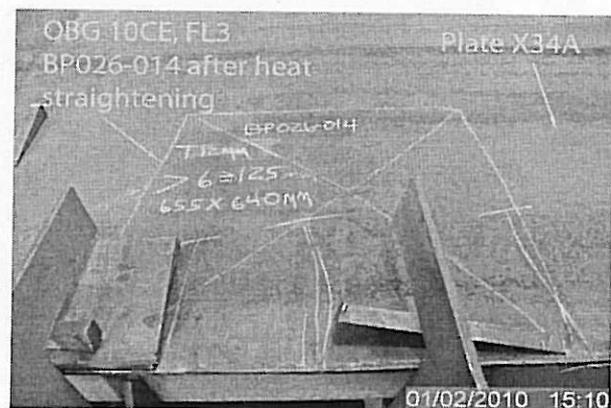
During the Quality Assurance (QA) in-process inspection of the FL3 floor beam bottom plate components, this QA inspector discovered the following issue;

- ZPMC personnel performed heat straightening on OBG segment 10CE, FL3 Bottom Plate without the prior approval of the engineer.

-The Bottom Plate assembly is identified as BP026-014 and the plate is identified as X34A, which measured to be a total of 12.5mm out of straightness in 1000mm.

-ZPMC QC or CWI were not present during the time of the heat straightening process.

-The component is located in fabrication bay 19.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5/2002 Section 3.7.3; Members distorted by welding shall be heat straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the engineer.

Caltrans Special Provisions Section 8-3: "For material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer.

Who discovered the problem: Mike Hasler

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1500 hours, 01-02-2010, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 2300 hours, 01-02-2010, E-mail

QC Inspector's Name: Lv Li Qing

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

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Inspected By: Tsang, Eric

SMR

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: 06-Jan-2010

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: 05.03.06-000564

Subject: NCR No. ZPMC-0574

Reference Description: Contractor performed heat straightening of Bikepath Platform BK7A Plate with 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: Bike Path

Lift: N/A

Remarks:

During the Caltrans Quality Assurance in-process observations of the fabrication of the bike path components in assembly bay 19 this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC heat straightening an area of material distorted by welding without the Engineers approval.
- The bike path segment is identified as BK4.
- The part is identified as BKPL7A.
- The deviation from flat as measured by this QA was 7.5mm per 1000mm.
- Material thickness is 16mm.
- ZPMC QC was not present during the time of the heat straightening process.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Do not perform HS without prior notification of the engineer. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0574

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

File: 05.03.06

DEPARTMENT OF TRANSPORTATION

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Quality Assurance and Source Inspection

Bay Area Branch
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Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4

Cty: 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-000601

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 05-Jan-2010

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

NCR #: ZPMC-0574

Type of problem:Welding Concrete Other Welding Curing Procedural Joint fit-up Coating Other Procedural Procedural Description:

Bridge No: 34-0006

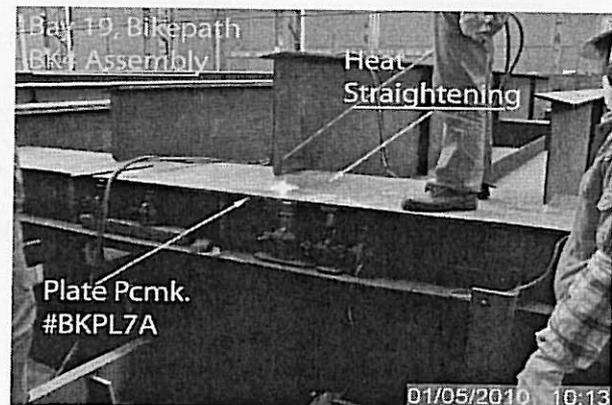
Component: Bikepath BK4 Assembly

Reference Description: Contractor performed heat straightening of Bikepath Platform BK7A Plate with Engineer's approval

Description of Non-Conformance:

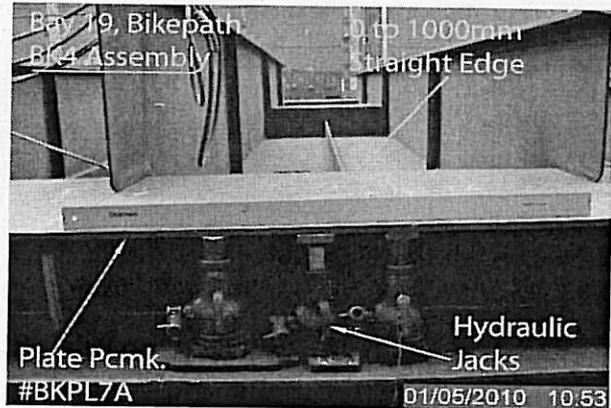
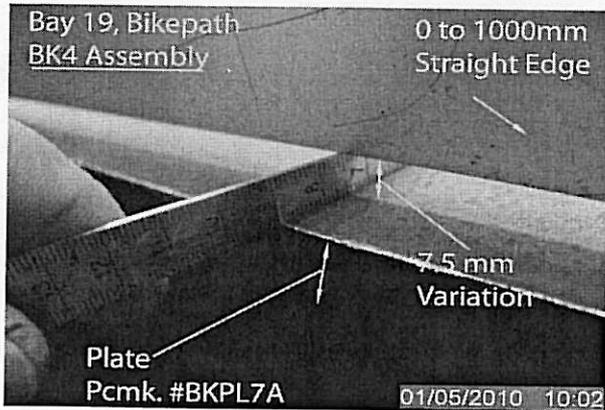
During the Caltrans Quality Assurance in-process observations of the fabrication of the bike path components in assembly bay 19 this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC heat straightening an area of material distorted by welding without the Engineers approval.
- The bike path segment is identified as BK4.
- The part is identified as BKPL7A.
- The deviation from flat as measured by this QA was 7.5mm per 1000mm.
- Material thickness is 16mm.
- ZPMC QC was not present during the time of the heat straightening process.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5/2002 Section 3.7.3: Members distorted by welding shall be heat straightened by mechanical means or by carefully supervised application of a limited amount of localized heat as approved by the engineer.

Caltrans Special Provisions Section 8-3: For material less than or equal to 16 mm thick, the Contractor shall not heat straighten members more than 6 in 1000 without prior approval of the Engineer.

Who discovered the problem: Mike Hasler

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 1/5/2010, 10:30; Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 7:00_01-06-10_Verbal

QC Inspector's Name: Zhou Cheng

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: Sinevod,Serge

ASMR

Reviewed By: Wahbeh,Mazen

SMR

NCR PROPOSED RESOLUTION

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

Dated: 21-Jun-2010

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

Attention: Pursell, Gary
Resident Engineer

Job Name: SAS Superstructure

Document No.: ABF-NPR-000680 Rev: 01

Ref: 05.03.06-000545

Subject: NCR No. ZPMC-0555

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has written and internal NCR to address the absence of the QC inspector. ABFJV is meeting with ZPMC's QA manager to discuss this issue with him so he is aware of this issue as well.

ZPMC has written and internal NCR to address the absence of the QC inspector. ABFJV is meeting with ZPMC's QA manager to discuss this issue with him so he is aware of this issue as well. ZPMC requests closure of this NCR based on these actions and previously submitted comments.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000680R01

Caltrans' comments:

Status: CLO

Date: 23-Jun-2010

This proposed resolution is acceptable. The Department concurs that Non-Conformance ZPMC-0555 is closed.

Submitted by: Eagen, Sean

Date: 23-Jun-2010

Attachment(s):

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-000688**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 22-Jun-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0555**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: 02-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) in-process inspection of the FL3 floor beam bottom plate components, this QA inspector discovered the following issue;

- ZPMC personnel performed heat straightening on OBG segment 10CE, FL3 Bottom Plate without the prior approval of the engineer.

-The Bottom Plate assembly is identified as BP026-014 and the plate is identified as X34A, which measured to be a total of 12.5mm out of straightness in 1000mm.

-ZPMC QC or CWI were not present during the time of the heat straightening process.

-The component is located in fabrication bay 19.

Contractor's proposal to correct the problem:

Meet with ZPMC's QA manager to reinforce the importance of following procedures in accordance with the Contract requirements.

Corrective action taken:

ZPMC issued an internal NCR in regards to this matter and meetings are scheduled between ABF and ZPMC's QA department to ensure that they are aware of this issue and the Contract requirements pertaining to heat straightening.

Did corrective action require Engineer's approval? Yes No

If so, name of Engineer providing approval:

Date:

Is Engineer's approval attached?

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Yes No

Comments:

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