

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-000628**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 12-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0601**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 8CW Bottom Panel to Floor Beam
Procedural	Procedural	Description: Missed MT indication by QC	

Reference Description: One Longitudinal Linear Indication discovered in Segment 8CW after ZPMC NDT testing and acceptance

Description of Non-Conformance:

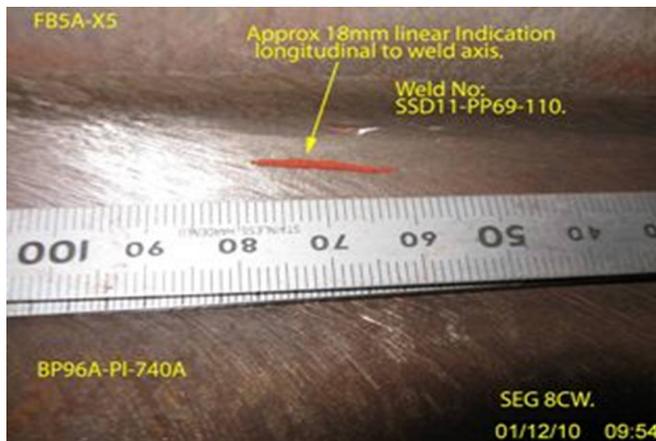
During the Quality Assurance(QA) Magnetic Particle Testing (MT) review of welds on OBG Segment 8CW, this QA Inspector discovered the following issue:

- One (1) linear indication longitudinal to the weld axis measuring approximately 18mm in length.
- The Y location is approximately 120mm from the left end of the weld.
- The indication is clearly marked on the material near the weld.
- The weld is identified as: SSD11-PP69-110.
- The weld is a fillet weld joining the Bottom Panel BP96A-PL-740A & Floor Beam FB5A-X5.
- This material is designated as Seismic Performance Critical Member (SPCM).
- Segment 8CW is located in Outside Yard.

The Notice of Witness Inspection Number (NWIT) is 005037. The indication is located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform Twenty Five (25) percent MT inspection of this weld.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

Special Provisions Section 8.3 – “Quality Control (QC) shall be the responsibility of the Contractor. As a minimum, the Contractor shall perform inspection and testing of each weld joint prior to welding, during welding, and after welding as specified in this section and to ensure that materials and workmanship conform to the requirements of the contract documents.”

AWS D1.5 (02) Section 6.26.2 – “Welds that are subject to MT in addition to visual inspection shall have no cracks.”

Who discovered the problem: Shailesh V. Wadkar

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 1000 hours, 01-12-10, Verbal

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 1330 hours, 01-12-10, Verbal

QC Inspector's Name: Zhong 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: 13-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: 05.03.06-000591

Subject: NCR No. ZPMC-0601

Reference Description: One Longitudinal Linear Indication discovered in Segment 8CW after ZPMC NDT testing and acceptance

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:** 08

Remarks:

During the Quality Assurance(QA) Magnetic Particle Testing (MT) review of welds on OBG Segment 8CW, this QA Inspector discovered the following issue:

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- This material is designated as Seismic Performance Critical Member (SPCM).
- Segment 8CW is located in Outside Yard.

The Notice of Witness Inspection Number (NWIT) is 005037. The indication is located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform Twenty Five (25) percent MT inspection of this weld.

Action Required and/or Action Taken:

Propose a resolution for the identified non-conformance with revised procedures to prevent future occurrences. Provide training and equipment to the ZPMC MT technician so that these indications are found and provide evidence of such training to the engineer. A response for the resolution of this issue is expected within 7 days.

Transmitted by: Bill Howe Sr. Transportation Engineer

Attachments: ZPMC-0601

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

NCT

(Continued Page 2 of 2)

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000591

Subject: NCR No. ZPMC-0601

Dated: 22-Jan-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000533 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ABF is submitting NDT documentation to show that welds with missed indications are acceptable after repair. Per discussion in China with representatives of the Department, ABF is submitting NDT documentation to show that welds with missed indications are acceptable after repair. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000533R00;

Caltrans' comments:

Status: CLO

Date: 26-Jan-2010

The documentation submitted by the contractor has been reviewed by the Engineer and is found to be acceptable. Based on the discussion in China with the contractor's representatives, other weld repair reports from ZPMC shall be included in the QA Data Base when available.

Submitted by: Chao, Ching

Attachment(s):

Date: 26-Jan-2010

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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-000489**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Jan-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0601**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: 12-Jan-2010**Description of Non-Conformance:**

During the Quality Assurance(QA) Magnetic Particle Testing (MT) review of welds on OBG Segment 8CW, this QA Inspector discovered the following issue:

- One (1) linear indication longitudinal to the weld axis measuring approximately 18mm in length.
- The Y location is approximately 120mm from the left end of the weld.
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- The weld is identified as: SSD11-PP69-110.
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The Notice of Witness Inspection Number (NWIT) is 005037. The indication is located outside the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform Twenty Five (25) percent MT inspection of this weld.

Contractor's proposal to correct the problem:

Repair indication and perform required NDT.

Corrective action taken:

ABF submitted internal NDT documentation verifying the weld is now in conformance with Contract specifications. Per Team China discussions, documentation from ZPMC verifying the repairs were made and NDT was performed by ZPMC technicians will be submitted at a later date and added to the Data Base.

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

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Yes No

Comments:

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