

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 #: 50.25B

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000647

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Jan-2010

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

NCR #: ZPMC-0619

Type of problem:

Welding

Concrete

Other

Welding

Curing

Procedural

Bridge No: 34-0006

Joint fit-up

Coating

Other

Component: OBG Segment 6CW

Procedural

Procedural

Description: Partial Height Crossbeam Diaphragm, Piece Mark X27

Reference Description: ZPMC cut WT stiffener in Partial Height Crossbeam Diaphragm located at PP 46

Description of Non-Conformance:

During random in-process inspection of Orthotropic Box Girder (OBG) Segment 6CW, this Quality Assurance Inspector (QA) discovered the following issues:

-ZPMC appears to have deviated from the design specified on the approved drawings without the Engineers approval.

- The member is identified as a partial height cross beam diaphragm.

-ZPMC has cut the flange from the web of WT stiffener identified as X27C.

-The stiffener is located on the FL3 floor beam at Panel Point 46.

-The cut measured approximately 160mm in length, perpendicular to Complete Joint Penetration (CJP) weld identified as SSD025-045-171.

-This area will require the addition of a weld that is not designated on the approved shop drawings.

-The material is A709 Grade 345 Non Seismic Performance Critical Member (Non SPCM).

OBG segment 6CW is located in the Trial assembly area.

For further information, please see the pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

AWS D1.5/2002, Section 6.5.1: "The Inspector shall make certain that the size, length and location of all welds conform to the requirements of this code and the detail drawings and that no unspecified welds have been added without approval."

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

Who discovered the problem: Dhanasingh Sukanthan

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 11:00 / 01-23-10 / e-mail

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 18:00 / 01-23-10 / e-mail

QC Inspector's Name: Mr. 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,(818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Simonis,Jim	QA Inspector
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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: 24-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: 05.03.06-000610

Subject: NCR No. ZPMC-0619

Reference Description: ZPMC cut WT stifener in Partial Hieght Crossbeam Diaphragm located at PP 46

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:** 06

Remarks:

During random in-process inspection of Orthotropic Box Girder (OBG) Segment 6CW, this Quality Assurance Inspector (QA) discovered the following issues:

- ZPMC appears to have deviated from the design specified on the approved drawings without the Engineers approval.
- The member is identified as a partial height cross beam diaphragm.
- ZPMC has cut the flange from the web of WT stiffener identified as X27C.
- The stiffener is located on the FL3 floor beam at Panel Point 46.
- The cut measured approximately 160mm in length, perpendicular to Complete Joint Penetration (CJP) weld identified as SSD025-045-171.
- This area will require the addition of a weld that is not designated on the approved shop drawings.
- The material is A709 Grade 345 Non Seismic Performance Critical Member (Non SPCM).

OBG segment 6CW is located in the Trial assembly area.
 For further information, please see the pictures below.
 Please attached NCR ZPMC-619 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

Attachments: ZPMC-0619

cc: Rick Morrow, Gary Pursell, Peter Siegenthaler, Stanley Ku, Brian Boal, 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: 05.03.06-000610

Subject: NCR No. ZPMC-0619

Dated: 16-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000619 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing the NDT records which show that the base metal is acceptable after repair. Based on this ZPMC requests closure of this NCR.

ZPMC has written an internal NCR for this incident to ensure that the Production department understand that performing base metal repairs without Engineer approval is not acceptable. ZPMC is providing the NDT records which show that the base metal is acceptable after repair. Based on this ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000619R00;

Caltrans' comments:

Status: CLO

Date: 05-Apr-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0619 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 05-Apr-2010



No. B-682

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-16

REGARDING: NCR-000647(ZPMC-0619)

ZPMC acknowledged this problem and has issued internal NCR. The flange was cut to adjust the misalignment with the lower floor beam. ZPMC has repaired the base metal and is providing the NDT records show the repaired area is acceptable. After verification by CT's representative, this issue has been removed from punchlist. ZPMC QA has instructed production department to notify Engineer prior to perform any cutting to base metal. Based on this, ZPMC is requesting this NCR to be closed.

ATTACHMENT:

NCR-000647(ZPMC-0619)

B787-UT-11508

B787-MT-20683

A handwritten signature in black ink, appearing to be 'J. W.' or similar, written in a cursive style.

3/16/10



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: 24-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: 05.03.06-000610

Subject: NCR No. ZPMC-0619

Reference Description: ZPMC cut WT stiffener in Partial Height Crossbeam Diaphragm located at PP 46

The attached Non-Conformance Report describes an occurrence where the contractor did not comply with a requirement of the contract document as indicated below:

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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: 06

Remarks:

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- The material is A709 Grade 345 Non Seismic Performance Critical Member (Non SPCM).

OBG segment 6CW is located in the Trial assembly area.

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Transmitted by: Ching Chao

Attachments: ZPMC-0619

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

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

Location: Changxing Island, Shanghai, P.R. China

Report No: NCR-000647

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Jan-2010

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

NCR #: ZPMC-0619

Type of problem:Welding Concrete Other Welding Curing Procedural

Bridge No: 34-0006

Joint fit-up Coating Other

Component: OBG Segment 6CW

Procedural Procedural Description: Partial Height Crossbeam Diaphragm, Piece Mark X27

Reference Description: ZPMC cut WT stiffener in Partial Height Crossbeam Diaphragm located at PP 46

Description of Non-Conformance:

During random in-process inspection of Orthotropic Box Girder (OBG) Segment 6CW, this Quality Assurance Inspector (QA) discovered the following issues:

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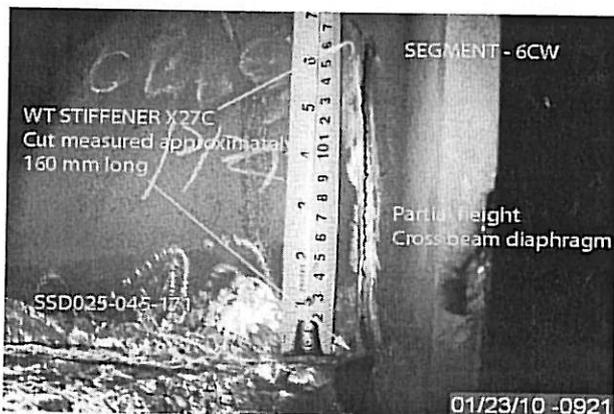
-The cut measured approximately 160mm in length, perpendicular to Complete Joint Penetration (CJP) weld identified as SSD025-045-171.

-This area will require the addition of a weld that is not designated on the approved shop drawings.

-The material is A709 Grade 345 Non Seismic Performance Critical Member (Non SPCM).

OBG segment 6CW is located in the Trial assembly area.

For further information, please see the pictures below.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

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Who discovered the problem: Dhanasingh Sukanthan

Name of individual from Contractor notified: Peter Shaw

Time and method of notification: 11:00 / 01-23-10 / e-mail

Name of Caltrans Engineer notified: Bill Howe

Time and method of notification: 18:00 / 01-23-10 / e-mail

QC Inspector's Name: Mr. 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,(818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Simonis,Jim

QA Inspector

Reviewed By: Wahbeh,Mazen

SMR



Nonconformance Report

不符合项报告

Project Name: S.F.O.B.B 项目名称: 美国加州海湾大桥		NCR Number: NCR 编号: NCR-B-414(ZPMC-0619)
Item: unapproved cutting 名称描述: 未进批准的切割	Item Number: 件号:	Drawing: 图号: 6CW
Location: 位置: 6CW	Date: 日期: 2010-01-29	

Description of Nonconformance:

During random in-process inspection of 6CW, CT inspector discovered the following issue:

- The member is identified as a partial height cross beam diaphragm.
- ZPMC has cut the flange from the web of WT stiffener identified as X27C.
- The stiffener is located on FL3 floor beam at PP46.
- The cut measured approximately 160mm in length, perpendicular to CJP weld identified as SSD025-045-171.
- This area will require the addition of a weld that is not designated on the approved shop drawings.
- The material is NON SPCM.

在加州的随机检查中发现如下问题:

- 该构件为联系梁内侧横隔板。
- ZPMC 对 WT 筋板翼缘板进行了开刀, 该筋板未 X27C。
- 该筋板位于 PP46, FL3 下侧。
- 开刀长度大约 160mm, 垂直于 CJP 焊缝 SSD025-045-171。
- 这个位置可能需要增加一条焊缝, 该焊缝本不属于施工图纸范围。
- 该处母材为非 SPCM。

037840

Work By: 施工方: <i>Lia Fu Ling</i>	Prepared by: 准备: <i>[Signature]</i>	Reviewed by QCE: 质量工程师批准: <i>[Signature]</i>
<input type="checkbox"/> Drawing Error 图纸错误	<input type="checkbox"/> Material Defect 材料缺陷	<input checked="" type="checkbox"/> Fabrication Error 制作错误
<input type="checkbox"/> Other 其他原因		

Disposition: 处理措施:	<input checked="" type="checkbox"/> Use as is 回用	<input type="checkbox"/> Repair 返修	<input type="checkbox"/> Reject 拒收
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Recommendation:

建议:

Prepared by: 准备	Approved by QCA: 质量经理批准
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Reason for Nonconformance:

不符合原因:

由于未进批准对 WT 筋板翼缘板进行开刀。
Cut WT stiffener flange plate without engineer approved.

Prevention of Re-occurrence:

预防措施:

加强现场监控和检查
Enhance supervision and inspection on-site.

Approved by/批准: Gao Jun 2.2

Technical Justification for Use-As-Is/Repair:

Attachment

Non-attachment

回用或返修的技术依据:

附件

无附件

对开孔焊缝进行NDT检测(UT, MT, VT), 合格回用, 加强
现场监控和检查, 确保质量
Perform NDT inspection (UT, MT, VT) to the welds which have been cutted
away, use-as-is can be done. Enhance supervision on site and ensure the
quality of product.

Reviewed /批准: Tang Jingbo

Verification:

Acceptable

Unacceptable

确认:

可接受

不可接受

Jin Yong Jian 07120671
2010. 3. 10.

Verified by QCI/质检确认: _____ Reviewed by QCA/质检主任审核: _____

DEPARTMENT OF TRANSPORTATION

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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-000598**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 14-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0619**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: 23-Jan-2010**Description of Non-Conformance:**

During random in-process inspection of Orthotropic Box Girder (OBG) Segment 6CW, this Quality Assurance Inspector (QA) discovered the following issues:

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-The material is A709 Grade 345 Non Seismic Performance Critical Member (Non SPCM).

OBG segment 6CW is located in the Trial assembly area.

For further information, please see the pictures below.

Contractor's proposal to correct the problem:

Perform NDT required to verify weld quality.

Corrective action taken:

Contractor issued an internal NCR in regards to this issue. NDT documentation was submitted verifying the quality of the weld complies with Contract specifications.

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

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Structural Materials for your project.

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer
