

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-000702**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Mar-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0669**Type of problem:**

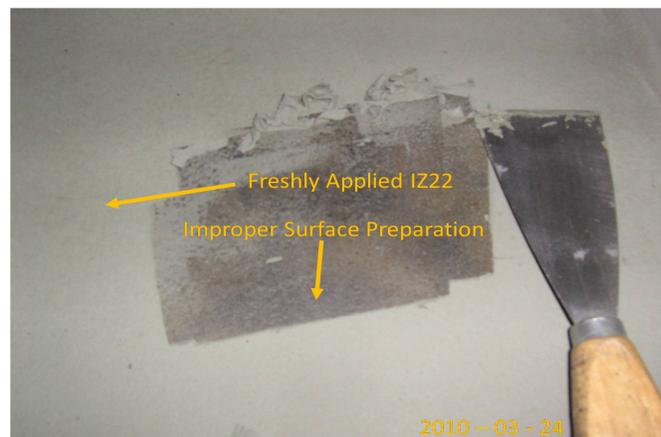
| | | | |
|---------------------|-------------------|---------------------|---------------------------|
| Welding | Concrete | Other | |
| Welding | Curing | Procedural | Bridge No: 34-0006 |
| Joint fit-up | Coating | Other | Component: Lift 6E |
| Procedural | Procedural | Description: | |

Reference Description: ZPMC personnel applied paint upon surfaces that were not prepared in accordance with SP-10 and while ambient conditions were unsuitable for painting.

Description of Non-Conformance:

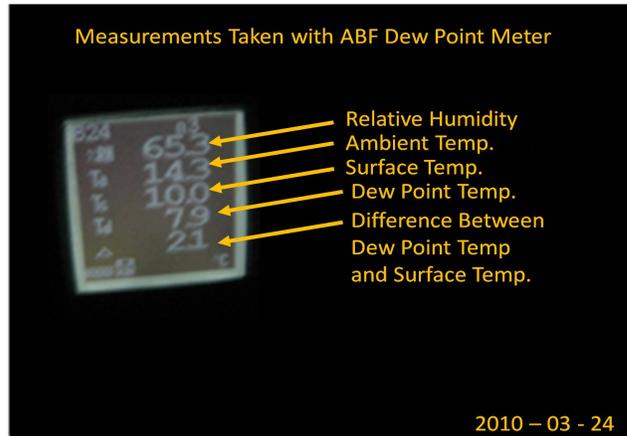
During in-process coating inspection of Lift 6 East Internal Bottom Plate field repair areas from Panel Points 41-43, this Caltrans Quality (QA) Inspector observed the following issues:

- ZPMC personnel applied inorganic zinc rich primer undercoating upon surfaces which were not prepared in accordance with SSPC SP-10 Surface Preparation Standard.
- ZPMC personnel applied inorganic zinc rich undercoating during non-compliant ambient conditions. The difference between the surface temperature of the steel which the coating was applied to and the dew point temperature was measured to at 2.1° Celsius.



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



2010 - 03 - 24

Applicable reference:

Special Provisions Section 10-1.69 'Clean and Paint Structural Steel', subsection 'Cleaning':

Exposed new metal surfaces, except where galvanized or metalized, shall be dry blast cleaned in conformance with the requirements in Surface Preparation Specification No.10 "Near White Blast Cleaning" of the SSPC: The Society for Protective Coatings.

The contractor shall provide suitable enclosures to permit cleaning and painting during inclement weather.

Provisions shall be made to control atmospheric conditions inside the enclosures within limits suitable for cleaning throughout the cleaning operation, painting throughout the painting operation, drying throughout the drying period to solvent insolubility, and throughout the curing period per the manufacturers' recommendations and these special provisions.

Special Provisions Section 10-1.69 'Clean and Paint Structural Steel', subsection 'Painting':

Inorganic zinc coating shall not be applied when the atmospheric or surface temperature, or relative humidity does not conform with the manufacturer's published application requirements.

Special Provisions Section 10-1.69 'Clean and Paint Structural Steel', subsection 'Field Repair of Damaged Areas':

Field repair painting shall comply with all provisions specified in the special provisions, and the following:

Damaged areas of paint and areas which do not comply with the requirements of this specification shall have the paint removed and all defects corrected. The steel shall then be blast cleaned to a near white condition to produce a profile of between 1.0 to 3.5 mils (25 to 90µm)

International Protective Coatings Product Data Sheet for Interzinc 22:

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Who discovered the problem: Caltrans QA Inspector, James Lumley

Name of individual from Contractor notified: Paint Quality Assurance Manager Don Walton

Time and method of notification: 15:55 / 03-24-2010 / Verbal - Telephone

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 08:00 / 03-25-2010 / Verbal

QC Inspector's Name: None Present

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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| | | |
|----------------------|--------------|--------------|
| Inspected By: | Simonis,Jim | QA Inspector |
| Reviewed By: | Wahbeh,Mazen | SMR |



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 **Date:** 26-Mar-2010
 375 BURMA ROAD
 OAKLAND CA 95607 **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:** 05.03.06-000659
Subject: NCR No. ZPMC-0669

Reference Description: ZPMC personnel applied paint upon surfaces that were not prepared in accordance with SP-10 and while ambient conditions were un

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 in-process coating inspection of Lift 6 East Internal Bottom Plate field repair areas from Panel Points 41-43, this Caltrans Quality (QA) Inspector observed the following issues:

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- ZPMC personnel applied inorganic zinc rich undercoating during non-compliant ambient conditions. The difference between the surface temperature of the steel which the coating was applied to and the dew point temperature was measured to at 2.1° Celsius.

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 7 days.

Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0669

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

File: 05.03.06

NCR PROPOSED RESOLUTION

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

Attention: Pursell, Gary
Resident Engineer

Ref: 05.03.06-000659

Subject: NCR No. ZPMC-0669

Dated: 29-Mar-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000639 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: The paint was found acceptable and this item removed from the punchlist to document this. Based on this ZPMC is requesting closure for this NCR.

ZPMC acknowledges this non conformance and has issued an internal warning to the paint department to prevent future occurrences. This item has been tested after drying to determine if the non conforming preparation conditions affected the acceptability of the paint. The paint was found acceptable and this item removed from the punchlist to document this. Based on this ZPMC is requesting closure for this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000639R00;

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-0669 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 05-Apr-2010



No. B-713

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-3-29

REGARDING: NCR-000702 (ZPMC-0669)

ZPMC has been noticed on the painting issue regarding the required ambient conditions of painting. ZPMC QA has issued Internal Warning Note to painting department. These painting areas have been cross checked by CT's painting inspector and were found to be acceptable. After that this issued has been removed from punchlist. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000702 (ZPMC-0669)

[Handwritten signature]
3/29/10



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: 26-Mar-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: 05.03.06-000659

Subject: NCR No. ZPMC-0669

Reference Description: ZPMC personnel applied paint upon surfaces that were not prepared in accordance with SP-10 and while ambient conditions were u

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- Non-Conformance Resolved.

Material Location: OBG

Lift: 06

Remarks:

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Action Required and/or Action Taken:

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Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0669

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

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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-000702

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 24-Mar-2010

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

NCR #: ZPMC-0669

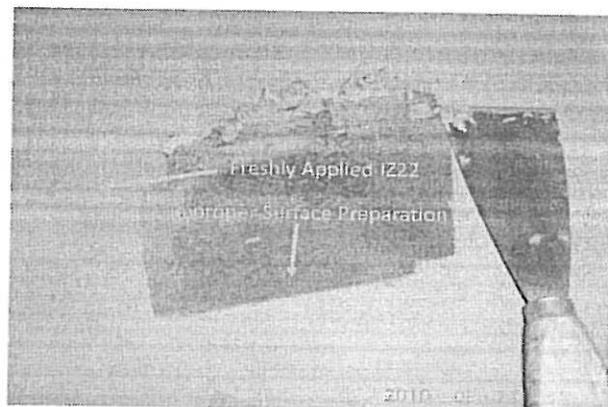
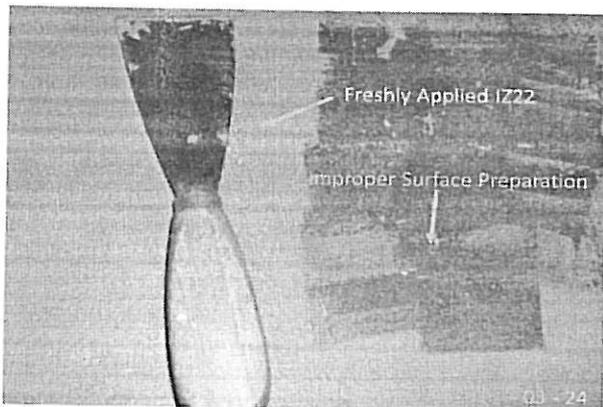
Type of problem:Welding Concrete Other Welding Curing Procedural Bridge No: 34-0006Joint fit-up Coating Other Component: Lift 6EProcedural Procedural Description:

Reference Description: ZPMC personnel applied paint upon surfaces that were not prepared in accordance with SP-10 and while ambient conditions were unsuitable for painting.

Description of Non-Conformance:

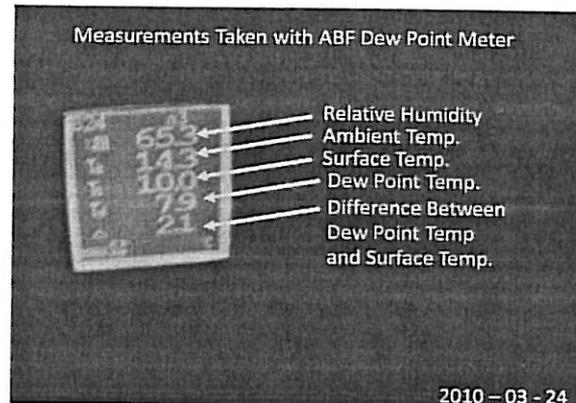
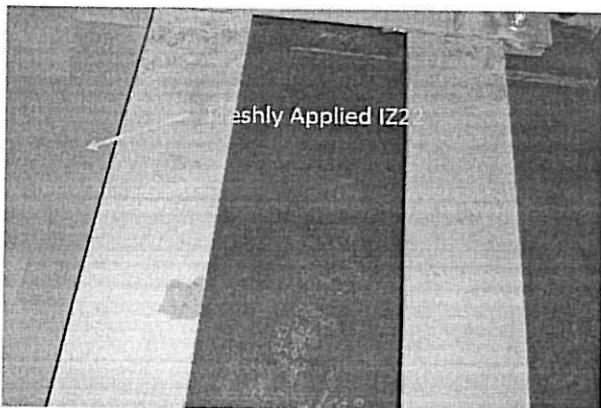
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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 3)



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Name of individual from Contractor notified: Paint Quality Assurance Manager Don Walton

Time and method of notification: 15:55 / 03-24-2010 / Verbal - Telephone

Name of Caltrans Engineer notified: Sean Eagen

Time and method of notification: 08:00 / 03-25-2010 / Verbal

QC Inspector's Name: None Present

Was QC Inspector aware of the problem: Yes No

Contractor's proposal to correct the problem:

N/A

Comments:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 3 of 3)

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Inspected By: Simonis,Jim

QA Inspector

Reviewed By: Wahbeh,Mazen

SMR

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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-000711**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 05-Apr-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0669**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: 24-Mar-2010**Description of Non-Conformance:**

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Contractor's proposal to correct the problem:

Perform pull tests on areas in question to verify adhesion properties.

Corrective action taken:

Contractor performed pull tests and paint was found to be in compliance with Contract adhesion 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:**

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Inspected By: Simonis, Jim

Quality Assurance Inspector

Reviewed By: Wahbeh, Mazen

QA Reviewer