

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-000714

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Apr-2010

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

NCR #: ZPMC-0681

Type of problem:

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Segment 7CE Bottom Panel to T-Rib
Procedural	Procedural	Description: Missed MT indication by QC	

Reference Description: Missed MT transverse indications by QC on Segment 7CE Bottom Panel to T-Rib

Description of Non-Conformance:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on OBG Segment 7CE, this QA Inspector discovered the following issues:

- Two (2) Longitudinal linear indications in the hold back weld between "T" Rib and Bottom panel.
- The longitudinal linear indications are located at Y locations 260mm and 277mm when measured from the end of the hold back fillet weld.
- The weld designation is BP118-001-044.
- The rib stiffener is identified as RSB24F.
- The indications are clearly marked on or near the weld.
- Length of indications measured approximately 14mm and 12mm.
- The OBG segment 7CE is located in the trial assembly.
- The Notice of Witness Inspection (NWIT) No. is 005581. The indications are located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel.



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: Shrikant Utekar

Name of individual from Contractor notified: CK Chan

Time and method of notification: 1600 hours, 04/23/10, Email

Name of Caltrans Engineer notified: Stanley Ku, Sean Eagen

Time and method of notification: 1730 hours, 04/23/10, Verbal

QC Inspector's Name: 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:	Tsang, Eric	SMR
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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: 26-Apr-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: 05.03.06-000671

Subject: NCR No. ZPMC-0681

Reference Description: Missed MT transverse indications by QC on Segment 7CE Bottom Panel to T-Rib

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:** 07

Remarks:

During the Quality Assurance (QA) Magnetic Particle Testing (MT) review of welds located on OBG Segment 7CE, this QA Inspector discovered the following issues:

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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-0681

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: 05.03.06-000671

Subject: NCR No. ZPMC-0681

Dated: 24-May-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000673 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has removed the indications by grinding and is submitting the NDT report to show that the weld is acceptable. Based on this ZPMC requests closure of this NCR.

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Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000673R00;

Caltrans' comments:

Status: CLO

Date: 30-May-2010

This proposed resolution is acceptable. The documentation received is sufficient and the Department concurs that Non-Conformance ZPMC-0681 is closed.

Submitted by: Eagen, Sean

Attachment(s):

Date: 30-May-2010



No. B-770

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-5-24

REGARDING: NCR-000714(ZPMC-0681)

After grinding, these linear indications were confirmed to be porosities. ZPMC is providing the NDT record shows these rejections have been removed and repaired and tested to be acceptable. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000714(ZPMC-0681)

B787-MT-22015 R1

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

5/24/10



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OAKLAND CA 95607

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04-SF-80-13.2 / 13.9

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Job Name: SAS Superstructure

Attention: Mr. Thomas Nilsson Project/Fabrication Manager

Document No: 05.03.06-000671

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Transmitted by: Sean Eagen Transportation Engineer

Attachments: ZPMC-0681

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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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Report No: NCR-000714

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 23-Apr-2010

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

NCR #: ZPMC-0681

Type of problem:

Welding Concrete Other

Welding Curing Procedural Bridge No: 34-0006

Joint fit-up Coating Other Component: Segment 7CE Bottom Panel to T-Rib

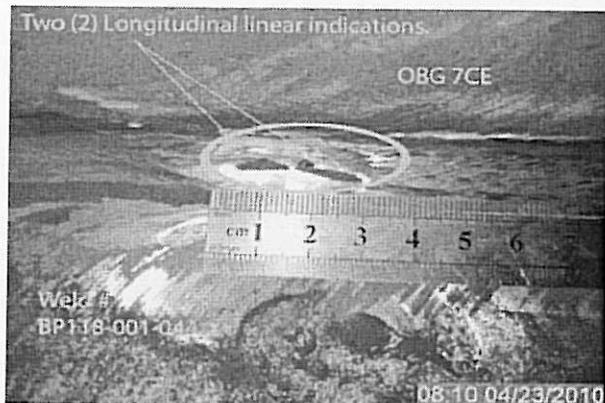
Procedural Procedural Description: Missed MT indication by QC

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Time and method of notification: 1730 hours, 04/23/10, Verbal

QC Inspector's Name: Wang Lu

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

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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-000665**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 30-May-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0681**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-Apr-2010**Description of Non-Conformance:**

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Contractor's proposal to correct the problem:

Remove indications by grinding and perform NDT required to verify weld quality.

Corrective action taken:

Contractor submitted NDT record verifying indications were successfully removed by grinding.

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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QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By: Simonis,Jim

Quality Assurance Inspector

Reviewed By: Wahbeh,Mazen

QA Reviewer