

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-000807**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 19-Jul-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0769**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: OBG Lift 8 East Bottom Panel
Procedural	Procedural	Description:	

Reference Description: Lift 8 East was loaded onto the ship without final paint acceptance. Some areas requiring paint inspection are no longer accessible for inspection.

Description of Non-Conformance:

During Quality Assurance (QA) random in-process coatings observation, this QA discovered the following issue Lift 8 East:

- Lift 8 East was loaded onto the ship without final paint acceptance.
- Before its lifting onto the ship, the record shows that the external Interfine 979 Finish coat was rejected 3 times due to not meeting the dry-film thickness (DFT) requirement, grit contamination, orange peeling and issues with dry spray.
- ZPMC did not notify Caltrans or ABF for final inspection acceptance of the previously rejected areas.

Issues and locations:

- The final coating on the bolt heads at the FL3 bottom panels (PP 62, 63, 64, 68, 69, and 70) were not inspected by Caltrans or ABF prior to loading.
- High DFT at the edges of the two repaired touch-up areas (approximately 200mmx250mm and 300mmx150mm) were not inspected prior to loading. They are located at the FL3 bottom panel between PP 68 to 69 and PP 69 to 70.
- High DFT observed at the edges of the repaired touch-up area (approximately 250mmx300mm) was not inspected prior to loading. It is located at the bottom panel near PP 70.

Current access issues:

- After loading, access was limited to a clearance of approximately 600mm (ship deck to bottom plate).
- No inspection access at the supported areas (Section of the Bottom Panel and the FL3 Bottom Panel).

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Applicable reference:

- Contract Change Order (CCO77) Section 3.3 (j): "The QA approval form shall be issued for the following sub-assemblies Lift assembly and painting before loading onto ship."

- Notification of Inspection #3709 and #3712 issued 17 July 2010: Inspection results were rejected

- Notification of Inspection #3666 on 12 July 2010: Inspection result was rejected.

Who discovered the problem: Baskar Govindarajan

Name of individual from Contractor notified: Shi Stone

Time and method of notification: 1525 hours, 07/19/10, Verbal

Name of Caltrans Engineer notified: Ching Chao

Time and method of notification: 1530 hours, 07/19/10, Verbal

QC Inspector's Name: Dong Yao Fei

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 Jim Devey, (86) 150-0002-6784, who represents the

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

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Office of Structural Materials for your project.

Inspected By:	Tsang, Eric	SMR
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Reviewed By:	Devey, Jim	SMR
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NCT

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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: 05.03.06-000764

Subject: NCR No. ZPMC-0769

Dated: 30-Aug-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000750 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: Attached is the QA Approval form for painting which verifies that Lift 8 East was acceptable.

The areas referenced in the NCR were sanded and repainted prior to the shipment leaving. Attached is the QA Approval form for painting which verifies that Lift 8 East was acceptable. ZPMC requests closure based on these documents.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000750R00;

Caltrans' comments:

Status: CLO

Date: 22-Sep-2010

The proposed resolution is acceptable. This NCR is considered closed.

Submitted by: Woo, Laraine

Attachment(s):

Date: 22-Sep-2010

QA APPROVAL REQUEST FORM (Painting)

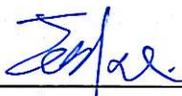
Component: L8E External

Date: 8/27/2010

Green tag No. P240

Item No. N/A

ITP Documentation Complete Yes No

 2010.7.26
ZPMC Team Representative Date

 26th July 2010
ABF Team Representative Date

 27 July 10
CT Team Representative Date

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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-000740**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Sep-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0769**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: 19-Jul-2010**Description of Non-Conformance:**

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Current access issues:

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Contractor's proposal to correct the problem:

Contractor proposed to repair and re-paint the defective area prior the shipment.

Corrective action taken:

Contractor completed the required repairs and re-painted area prior to the shipment. QA approval form was submitted verifying paint was in conformance with Contract specifications prior to shipping.

