

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-000850

Prime Contractor: American Bridge/Fluor Enterprises, a JV

Date: 26-Sep-2010

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

NCR #: ZPMC-0812

Type of problem:

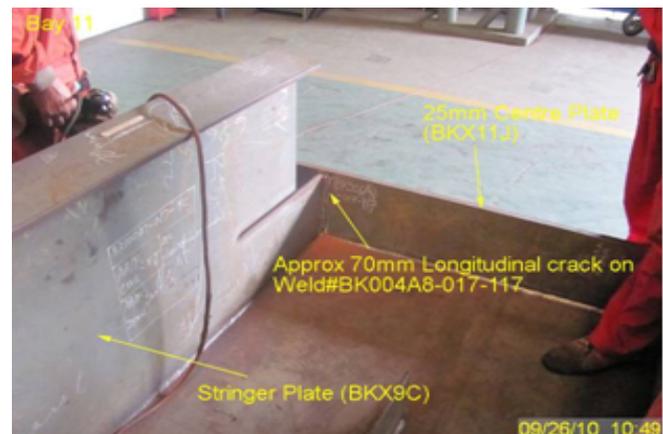
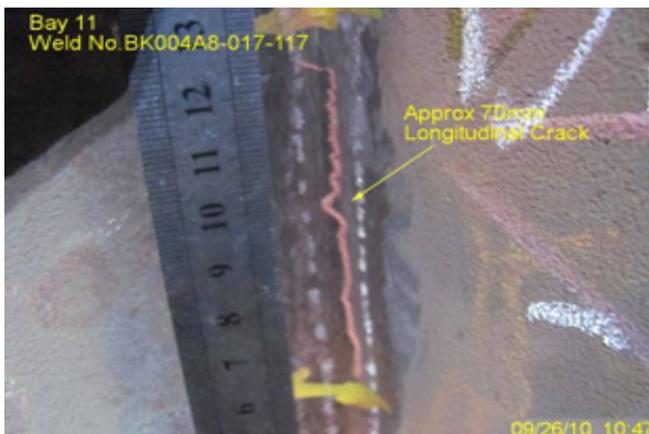
Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Bikepath Assembly BK004A8-017
Procedural	Procedural	Description: Missed MT crack by QC	

Reference Description: QA found a missed MT longitudinal crack after ZPMC had tested and accepted the welds in Bikepath Assembly

Description of Non-Conformance:

During the Quality Assurance (QA) Magnetic particle Testing (MT) review of welds located on Bike path BK004A-017, this QA Inspector discovered the following issue:

- One Longitudinal Crack that measured approximately 70mm in length.
- The weld is identified as BK004A8-017-117.
- The weld is a fillet joint, joining the Stringer plate (BKX9C) to the 25mm centre plate (BKX11J).
- The Y Location is 130mm from the cope hole.
- The OBG Bike path is located in BAY#11.
- This crack is clearly marked on the material on/near the weld.
- The bike path material is Non-Seismic performance critical (Non-SPCM) weld member.
- The Notice of Witness Inspection Number (NWIT) is 006773.
- The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC).



QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

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: Anand Upadhye

Name of individual from Contractor notified: Zhao Xian He

Time and method of notification: 1100 hours, 09/26/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 1000 hours, 09/27/10, Verbal

QC Inspector's Name: Shao Hai Lang

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:	Tsang, Eric	SMR
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Reviewed By:	Wahbeh, Mazen	SMR
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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: 27-Sep-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: 05.03.06-000807

Subject: NCR No. ZPMC-0812

Reference Description: QA found a missed MT longitudinal crack after ZPMC had tested and accepted the welds in Bikepath Assembly

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: Bike Path **Lift:**

Remarks:

- During the Quality Assurance (QA) Magnetic particle Testing (MT) review of welds located on Bike path BK004A-017, Caltrans QA Inspector discovered the following issue:
- One Longitudinal Crack that measured approximately 70mm in length.
 - The weld is identified as BK004A8-017-117.
 - The weld is a fillet joint, joining the Stringer plate (BKX9C) to the 25mm center plate (BKX11J).
 - The Y Location is 130mm from the cope hole.
 - The OBG Bike path is located in BAY#11.
 - This crack is clearly marked on the material on/near the weld.
 - The bike path material is Non-Seismic performance critical (Non-SPCM) weld member.
 - The Notice of Witness Inspection Number (NWIT) is 006773.
 - The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC).

Action Required and/or Action Taken:

Proposed 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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0812

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: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000807

Subject: NCR No. ZPMC-0812

Dated: 25-Oct-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000809 Rev: 00

Contractor's Proposed Resolution:

Reference Resolution: ZPMC has repaired the indication noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed

ZPMC has repaired the indication noted in the NCR and is providing NDT documentation after the repair to show the indication has been removed. ABFJV has noted which inspector was responsible for this missed indication and is monitoring his performance as well as all inspector performance, if he continues to miss indications disciplinary action will be undertaken. Based on these actions, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000809R00;

Caltrans' comments:

Status: CLO

Date: 27-Oct-2010

The proposed resolution is acceptable. This NCR is closed.

Submitted by: Woo, Laraine

Date: 27-Oct-2010

Attachment(s):



No. B-913

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-10-19

REGARDING: NCR-000850(ZPMC-0812)

ZPMC acknowledged this missed indication and has issued an internal NCR. The indication has been removed, repaired and tested to be acceptable. ZPMC is providing the NDT record to show the soundness of this weld after repair. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000850(ZPMC-0812)

B787-MT-28769 R1

A handwritten signature in black ink, appearing to be 'J. R.' with a stylized flourish.

10/19/2010



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: 27-Sep-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: 05.03.06-000807

Subject: NCR No. ZPMC-0812

Reference Description: QA found a missed MT longitudinal crack after ZPMC had tested and accepted the welds in Bikepath Assembly

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- Quality Control (QC) not performed in conformance with contract documents.
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- Non-Conformance Resolved.

Material Location: Bike Path

Lift:

Remarks:

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Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0812

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-000850
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 26-Sep-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0812

Type of problem:

- Welding Concrete Other
 Welding Curing Procedural Bridge No: 34-0006
 Joint fit-up Coating Other Component: Bikepath Assembly BK004A8-017
 Procedural Procedural Description: Missed MT crack by QC

Reference Description: QA found a missed MT longitudinal crack after ZPMC had tested and accepted the welds in Bikepath Assembly

Description of Non-Conformance:

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QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

Applicable reference:

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Name of individual from Contractor notified: Zhao Xian He

Time and method of notification: 1100 hours, 09/26/10, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 1000 hours, 09/27/10, Verbal

QC Inspector's Name: Shao Hai Lang

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: Tsang, Eric

SMR

Reviewed By: Wahbeh, Mazen

SMR

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(707) 649-5493

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-000859**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 27-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0812**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: 26-Sep-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) Magnetic particle Testing (MT) review of welds located on Bike path BK004A-017, this QA Inspector discovered the following issue:

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- The Notice of Witness Inspection Number (NWIT) is 006773.
- The indication is located within the area that has been previously tested and accepted by ZPMC Quality Control (QC).

Contractor's proposal to correct the problem:

Contractor proposes to repair the missed MT indication and provide NDT documentation showing weld is acceptable. Contractor will monitor the inspector who missed the indication, and take disciplinary action should be continuously making similar mistakes.

Corrective action taken:

Contractor repaired the indication and provided the NDT documentation to prove the weld is acceptable. Contractor has identified the inspector responsible and is monitoring his performance.

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

(Continued Page 2 of 2)

Yes No

Comments:

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Inspected By: Ng,Michael

Quality Assurance Inspector

Reviewed By: Devey,Jim

QA Reviewer