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-000873
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 24-Oct-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0835

Type of problem:

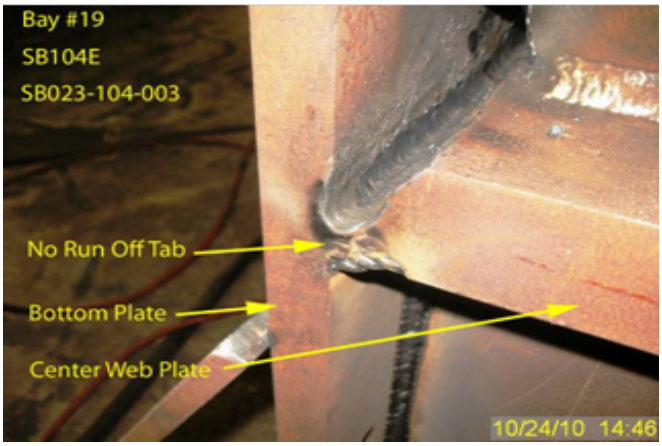
Welding	☑	**Concrete**	☐	**Other**	☐	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:** Lift 12 Suspender Brackets
Procedural	☑	**Procedural**	☐	**Description:**		

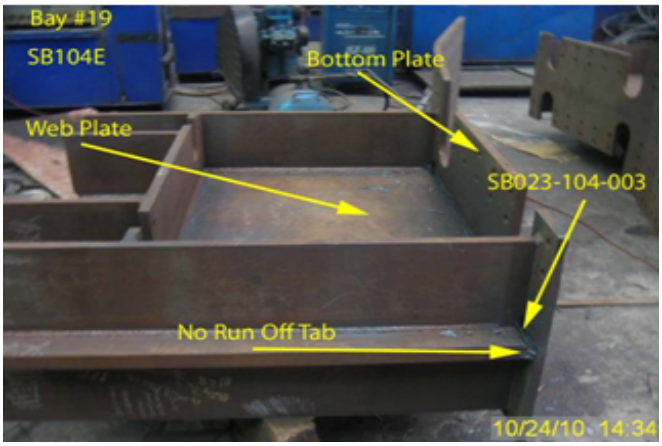
Reference Description: Contractor performed CJP welding on Lift 12 Suspender Brackets without following the D1.5 requirements (No run-off tap)

Description of Non-Conformance:

During Quality Assurance (QA) random in-process observations of the fabrication of Lift 12 Suspender Brackets SB104E, SB104W, SB106E, and SB106W, this Caltrans QA inspector discovered the following issues:

-Complete Joint Penetration (CJP) Welding was being performed without using run-off tabs.
-The members are identified as Suspender Brackets for Lift 12.
-The welds are CJP, T joints identified as; SB022-104-003, SB022-106-003, SB023-106-003, and SB023-106-003.
-The welds are joining the Suspender Bracket center web plate to bottom plate.
-OBG Suspender brackets are located in the Bay 19.





Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

American Weld Society (AWS) D1.5 2002 section 3.12.1 “Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done using weld tabs (extension bars and run off plates) placed in a manner that will duplicate the joint detail being welded”.

Who discovered the problem: Dennis Combs

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 15:00 hours, 10/24/2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:00 hours, 10/25/10, email

QC Inspector's Name: Xu Tao

Was QC Inspector aware of the problem: ☐ **Yes** ☑ **No**

Contractor's proposal to correct the problem:

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 Office of Structural Materials for your project.

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

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-Oct-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:**	05.03.06-000830
Subject:	NCR No. ZPMC-0835		

Reference Description: Contractor performed CJP welding on Lift 12 Suspender Brackets without following the D1.5 requirements (No run-off tap)

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:** 12

Remarks:

During Quality Assurance (QA) random in-process observations of the fabrication of Lift 12 Suspender Brackets SB104E, SB104W, SB106E, and SB106W, Caltrans QA inspector discovered the following issues:

-Complete Joint Penetration (CJP) Welding was being performed without using run-off tabs.

-The members are identified as Suspender Brackets for Lift 12.

-The welds are CJP, T joints identified as; SB022-104-003, SB022-106-003, SB023-106-003, and SB023-106-003.

-The welds are joining the Suspender Bracket center web plate to bottom plate.

-OBG Suspender brackets are located in the Bay 19.

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: Laraine Woo Transportation Engineer

Attachments: ZPMC-0835

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

File: 05.03.06

AMERICAN BRIDGE/FLUOR ENTERPRISES, a JV

P.O. BOX 23223 Oakland, CA 94623

Phone (510) 419-0120 / Fax (510) 839-0666

NCR PROPOSED RESOLUTION

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

Attention: Siegenthaler, Peter
Resident Engineer

Ref: 05.03.06-000830

Subject: NCR No. ZPMC-0835

Dated: **19-Nov-2010**

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

Job Name: SAS Superstructure

Document No.: **ABF-NPR-000839 Rev: 00**

Contractor's Proposed Resolution:

Reference Resolution: ZPMC is providing NDT of the weld performed with run off tabs to show that the weld was not adversely affected.

ZPMC is providing NDT of the weld performed with run off tabs to show that the weld was not adversely affected. In the future, ZPMC QC will look for this specifically to ensure that there are run off tabs in place before welding. Based on the acceptable NDT, ZPMC requests closure of this NCR.

Submitted by: Ishibashi, Joshua

Attachment(s): ABF-NPR-000839R00;

Caltrans' comments:

Status: CLO

Date: 22-Nov-2010

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

Submitted by: Woo, Laraine

Date: 22-Nov-2010

Attachment(s):

No. B-931

LETTER OF RESPONSE

TO: American Bridge/Flour
DATE: 2010-11-19
REGARDING: NCR-000873(ZPMC-0835)

ZPMC QA personnel have talked this issue with the floor QC to address the requirment to install run on tab end tabs during the welding of CJP joint. ZPMC is providing the NDT reocrds to show the acceptance of these welds. Please be noticed ZPMC has corrected the wrong weld ID in NCR. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:
NCR-000873(ZPMC-0835)
B787-UT-18178 R1
B787-UT-18179
B787-UT-18177
B787-UT-18176 R1

11/19/2010

STATE OF CALIFORNIA--BUSINESS,TRANSPORTACTION AND HOUSING AGENCY Arnold Schwarzenegger, Governor

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
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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-000873
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 24-Oct-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0835

Type of problem:

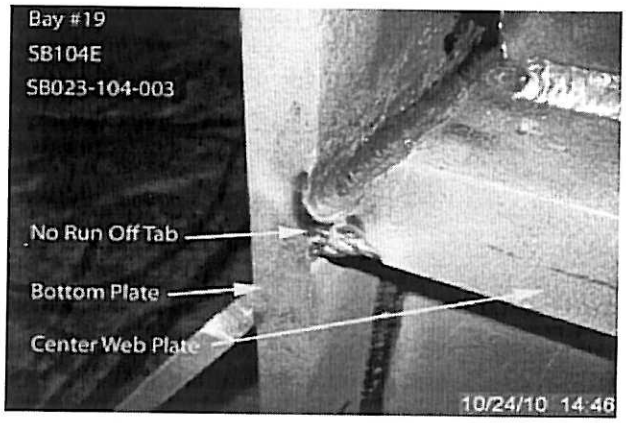
Welding	☑	**Concrete**	☐	**Other**	☐	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:** Lift 12 Suspender Brackets
Procedural	☑	**Procedural**	☐	**Description:**		

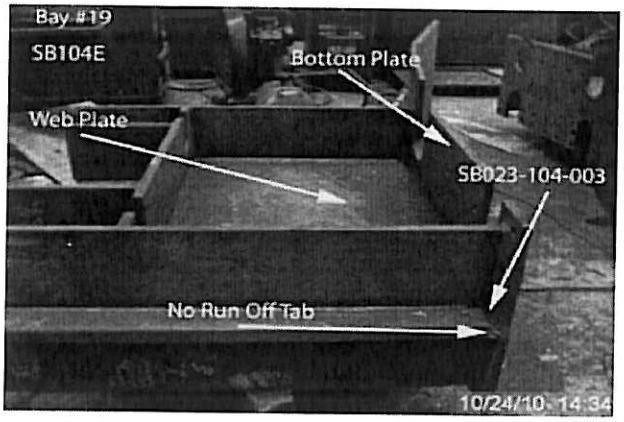
Reference Description: Contractor performed CJP welding on Lift 12 Suspender Brackets without following the D1.5 requirements (No run-off tap)

Description of Non-Conformance:

During Quality Assurance (QA) random in-process observations of the fabrication of Lift 12 Suspender Brackets SB104E, SB104W, SB106E, and SB106W, this Caltrans QA inspector discovered the following issues:

-Complete Joint Penetration (CJP) Welding was being performed without using run-off tabs.
-The members are identified as Suspender Brackets for Lift 12.
-The welds are CJP, T joints identified as; SB022-104-003, SB022-106-003, SB023-104-003, and SB023-106-003.
-The welds are joining the Suspender Bracket center web plate to bottom plate.
-OBG Suspender brackets are located in the Bay 19.





Applicable reference:

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)

American Weld Society (AWS) D1.5 2002 section 3.12.1 "Welds shall be terminated at the end of a joint in a manner that will ensure sound welds. Whenever possible, this shall be done using weld tabs (extension bars and run off plates) placed in a manner that will duplicate the joint detail being welded".

Who discovered the problem: Dennis Combs

Name of individual from Contractor notified: Peng Wen Jun

Time and method of notification: 15:00 hours, 10/24/2010, Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:00 hours, 10/25/10, email

QC Inspector's Name: Xu Tao

Was QC Inspector aware of the problem: ☐ **Yes** ☑ **No**

Contractor's proposal to correct the problem:

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 Office of Structural Materials for your project.

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

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号 B787-UT-18178R1	DATE 2010.11.11	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 部件名称 SUPPORT BEAM	DRAWING NO.: 图号 SB104E	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS 焊接方法	JOINT TYPE 焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
FCAW	T JOINT	Dec. 28ST ,2010

EQUIPMENT 设备	MANUFACTURER 制造商	MODEL NO. 样式编号	SERIAL NO. 序列编号
UT SCOPE	HANWEI	H610e	61e1733

CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度
AWS IIW BLOCK TYPE II	C.M.C	A709M-345T2 45/28mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
AMERICA	70°	2.25MHz	0.75×0.625 in				
				Reference Level 参考灵敏度		20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SB023-104-003	1R1	70				51								ACC.	100%
	3R1	70				51								ACC.	100%
AFTER B-WR16736															
BLANK															

EXAMINED BY主探 Dong Sheng Wei 2010.11.11
LEVEL - II SIGN / DATE

REVIEWED BY 审核 2010.11.11
LEVEL - II SIGN / DATE

质量经理 / QCM Tianhua 2010.11.11
签字 SIGN / 日期 DATE

用户CUSTOMER
签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号 B787-UT-18179	DATE 2010.11.07	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 部件名称 SUPPORT BEAM	DRAWING NO.: 图号 SB106E	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS 焊接方法	JOINT TYPE 焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
FCAW	T JOINT	Dec. 28ST ,2010

EQUIPMENT 设备	MANUFACTURER 制造商	MODEL NO. 样式编号	SERIAL NO. 序列编号
UT SCOPE	HANWEI	H610e	61e1733

CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度
AWS IIW BLOCK TYPE II	C.M.C	A709M-345T2 45/28mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
AMERICA	70°	2.25MHz	0.75×0.625 in				
				Reference Level 参考灵敏度		20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SB023-106-003	1	70	A	1	65	51	4	+10	15	80	28	+20	350	ACC.	100%
	2	70	A	1	72	51	10	+11	20	148	50	0	990	ACC.	100%
	3	70	A	2	72	51	13	+8	20	190	24	-22	1255	ACC.	100%
AFTER HSR1(B)-9727															
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EXAMINED BY主探 Dong Sheng Wei 2010.11.09
LEVEL - II SIGN / DATE

REVIEWED BY 审核 2010.11.9
LEVEL - II SIGN / DATE

质量经理 / QCM Lu Tanhua 2010.11.9
签字 SIGN / 日期 DATE

用户CUSTOMER
签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号 B787-UT-18177	DATE 2010.11.07	PAGE 1 OF 1	Revision No: 0

PROJECT NO. :工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 部件名称 SUPPORT BEAM	DRAWING NO.: 图号 SB106W	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS 焊接方法	JOINT TYPE 焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
FCAW	T JOINT	Dec. 28ST ,2010

EQUIPMENT 设备	MANUFACTURER 制造商	MODEL NO. 样式编号	SERIAL NO. 序列编号
UT SCOPE	HANWEI	H610e	61e1733
CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度	
AWS IIW BLOCK TYPE II	C.M.C	A709M-345T2	45/28mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
AMERICA	70°	2.25MHz	0.75×0.625 in				
				Reference Level 参考灵敏度		20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
					Indication Level	Reference Level	Attenuation Factor	Indication Rating	LOCATION OF DISCONTINUITY 不连续位置(mm)						
					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SB022-106-003		70				34								ACC.	100%
AFTER HSR1(B)-9724															
BLANK															

EXAMINED BY主探 DongSheng Wei 2010.11.07
LEVEL - II SIGN / DATE

REVIEWED BY 审核 Li Liming 2010.11.07
LEVEL - II SIGN / DATE

质量经理 / QCM Li Tonghua 2010.11.07
签字 SIGN / 日期 DATE

用户CUSTOMER
签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

REPORT OF ULTRASONIC EXAMINATION
UT探伤报告

REPORT NO. 报告编号 B787-UT-18176R1	DATE 2010.11.10	PAGE 1 OF 1	Revision No: 0

PROJECT NO. : 工程编号 ZP06-787		CONTRACTOR : CALTRANS
ITEMS NAME: 部件名称 SUPPORT BEAM	DRAWING NO.: 图号 SB104W	CALTRANS CONTRACT NO.: 04-0120F4 加州工程编号

REFERENCING CODE 参考规范	ACCEPTANCE STANDARD 接受标准	PROCEDURE NO. 程序编号
AWS D1.5-2002	AWS D1.5-2002(Table 6.3)	ZPQC-UT-01
WELDING PROCESS 焊接方法	JOINT TYPE 焊缝类型	CALIBRATION DUE DATE 仪器校正有效期
FCAW	T JOINT	Dec. 28ST ,2010

EQUIPMENT 设备	MANUFACTURER 制造商	MODEL NO. 样式编号	SERIAL NO. 序列编号
UT SCOPE	HANWEI	H610e	61e1733

CALIBRATION BLOCK 试块	COUPLANT 耦合剂	MATERIAL/THICKNESS 材料厚度
AWS IIW BLOCK TYPE II	C.M.C	A709M-345T2 45/28mm

TRANSDUCER 探头

MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸	MANUFACTURER 制造商	ANGLE 角度	FREQUENCY 频率	SIZE 尺寸
AMERICA	70°	2.25MHz	0.75×0.625 in				
				Reference Level 参考灵敏度		20dB	

Base metal inspected per AWS D1.5-2002 Section 6.19.5 0° UT OK.

WELD IDENTIFICATION 焊缝部件编号	INDICATION NO. 指示号	PROBE ANGLE 探测角度	FROM FACE 检测面	LEG (次数)	DECIBELS分贝				DISCONTINUITY 不连续性					Discontinuity Evaluation 缺陷估计	Remark 备注
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					a	b	c	d	Length 长度	Sound Path 声程	Depth from Surface 距表面深度	From'X 距X	From'Y 距Y		
SB022-104-003		70				65								ACC.	100%
AFTER B-WR16719															
BLANK															

EXAMINED BY主探 DongShengWei 2010.11.10
LEVEL - II SIGN / DATE

REVIEWED BY 审核 LinHJ 2010.11.10
LEVEL - II SIGN / DATE

质量经理 / QCM LvJianhua 2010.11.10
签字 SIGN / 日期 DATE

用户CUSTOMER
签字 SIGN / 日期 DATE

(FORM# ZPQC-UT01)

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 #: xx.25A

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

Location: Changxing Island, Shanghai, P.R. China **Report No:** NCS-000834
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 22-Nov-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0835

Type of problem:

Welding	☑	**Concrete**	☐	**Other**	☐	
Welding	☐	**Curing**	☐	**Procedural**	☐	**Bridge No:** 34-0006
Joint fit-up	☐	**Coating**	☐	**Other**	☐	**Component:**
Procedural	☑	**Procedural**	☐	**Descripton:**		

Date the Non-Conformance Report was written: 24-Oct-2010

Description of Non-Conformance:

During Quality Assurance (QA) random in-process observations of the fabrication of Lift 12 Suspender Brackets SB104E, SB104W, SB106E, and SB106W, this Caltrans QA inspector discovered the following issues:

-Complete Joint Penetration (CJP) Welding was being performed without using run-off tabs.
-The members are identified as Suspender Brackets for Lift 12.
-The welds are CJP, T joints identified as; SB022-104-003, SB022-106-003, SB023-106-003, and SB023-106-003.
-The welds are joining the Suspender Bracket center web plate to bottom plate.
-OBG Suspender brackets are located in the Bay 19.

Contractor's proposal to correct the problem:

Contractor will perform NDT of the welds without run off tabs to show the welds are not adversely affected. Contractor will remind QC to look for this specifically during fit-up inspections to ensure that run off tabs in place before welding.

Corrective action taken:

Contractor provided the NDT report to prove the welds are acceptable. QCs' were reminded tht specific check on runoff tabs have to be carried out during fit-up inspections.

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 Wahbeh, Mazen 818-292-0659, who represents the Office of Structural Materials for your project.

QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION

(Continued Page 2 of 2)

Inspected By:	Ng,Michael	Quality Assurance Inspector
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