

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-000874**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 24-Oct-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**NCR #:** ZPMC-0836**Type of problem:**

Welding	Concrete	Other	
Welding	Curing	Procedural	Bridge No: 34-0006
Joint fit-up	Coating	Other	Component: Bikepath BK004A2-053
Procedural	Procedural	Description: QA found 2 MT indications	

Reference Description: QA found 2 MT indications after ZPMC notified CT to inspect the welds at the Bikepath Assembly BK004A2-053

Description of Non-Conformance:

During the Quality Assurance (QA) MT review of welds located on BK004A2-053, this QA Inspector discovered the following issues:

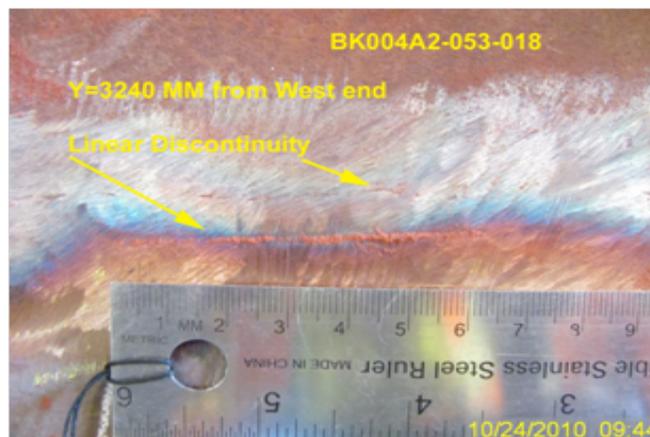
- One longitudinal linear indication measuring approximately 62mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 2740 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.

- One longitudinal linear indication measuring approximately 59mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 3240 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.

- The Notice of Witness Inspection Number (NWIT) is 7081. ZPMC has previously inspected and accepted the weld as indicated by the marking on the steel.
- After this QA discovered the above mentioned indications, ZPMC canceled the NDT notification, stating that they did not complete MT inspection on this weld.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002 Table 6.8: Specifies indications greater than 1.6mm in length in welds of this size (6mm) are rejectable.

Who discovered the problem: Robert DeArmond

Name of individual from Contractor notified: Luo Lai Quan

Time and method of notification: 9:00_10/24/2010_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:00_10/25/10_Email

QC Inspector's Name: Liu Fa Wen

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
Attention: Mr. Thomas Nilsson Project/Fabrication Manager
Subject: NCR No. ZPMC-0836

Job Name: SAS Superstructure
Document No: 05.03.06-000831

Reference Description: QA found 2 MT indications after ZPMC notified CT to inspect the welds at the Bikepath Assembly BK004A2-053

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) MT review of welds located on BK004A2-053, Caltrans QA Inspector discovered the following issues:

- One longitudinal linear indication measuring approximately 62mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 2740 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.
- One longitudinal linear indication measuring approximately 59mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 3240 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.
- The Notice of Witness Inspection Number (NWIT) is 7081. ZPMC has previously inspected and accepted the weld as indicated by the marking on the steel.
- After this QA discovered the above mentioned indications, ZPMC canceled the NDT notification, stating that they did not complete MT inspection on this weld.

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.

NCT

(Continued Page 2 of 2)

Transmitted by: Laraine Woo Transportation Engineer

Attachments: ZPMC-0836

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: 05.03.06-000831

Subject: NCR No. ZPMC-0836

Dated: 02-Nov-2010

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

Job Name: SAS Superstructure

Document No.: ABF-NPR-000829 Rev: 00

Contractor's Proposed Resolution:

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

ZPMC has repaired the indications 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 indications 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-000829R00;

Caltrans' comments:

Status: CLO

Date: 03-Nov-2010

The proposed resolution is acceptable. This NCR is closed.

Submitted by: Woo, Laraine

Date: 03-Nov-2010

Attachment(s):



No. B-922

LETTER OF RESPONSE

TO: American Bridge/Flour

DATE: 2010-11-01

REGARDING: NCR-000874(ZPMC-0836)

ZPMC acknowledged the indications were missed and has issued an internal NCR to address this problem. ZPMC has repaired the indications and is providing the NDT records to show the acceptance of this weld. Based on this, ZPMC is requesting closure of this NCR.

ATTACHMENT:

NCR-000874(ZPMC-0836)

B787-MT-30633

John W.
11/1/2010



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-000874
Prime Contractor: American Bridge/Fluor Enterprises, a JV **Date:** 24-Oct-2010
Submitting Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0836

Type of problem:

Welding Concrete Other
Welding Curing Procedural **Bridge No:** 34-0006
Joint fit-up Coating Other **Component:** Bikepath BK004A2-053
Procedural Procedural **Description:** QA found 2 MT indications

Reference Description: QA found 2 MT indications after ZPMC notified CT to inspect the welds at the Bikepath Assembly BK004A2-053

Description of Non-Conformance:

CWR 2/1/14

During the Quality Assurance (QA) MT review of welds located on BK004A2-053, this QA Inspector discovered the following issues:

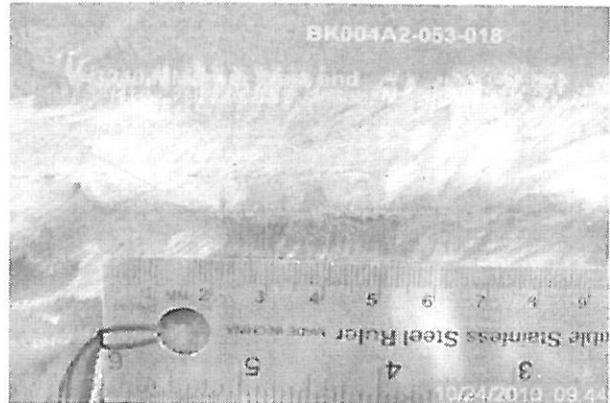
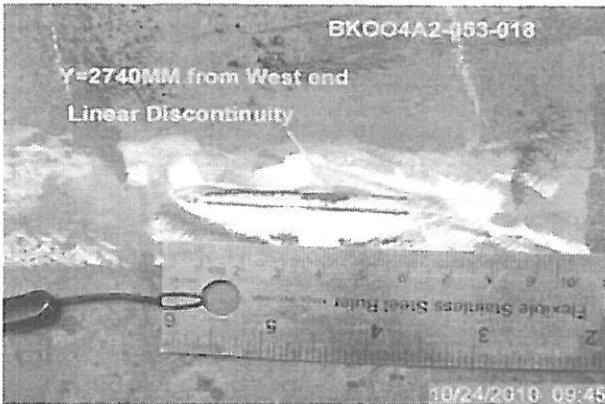
- One longitudinal linear indication measuring approximately 62mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 2740 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.

- One longitudinal linear indication measuring approximately 59mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 3240 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.

- The Notice of Witness Inspection Number (NWIT) is 7081. ZPMC has previously inspected and accepted the weld as indicated by the marking on the steel.
- After this QA discovered the above mentioned indications, ZPMC canceled the NDT notification, stating that they did not complete MT inspection on this weld.

QUALITY ASSURANCE -- NON-CONFORMANCE REPORT

(Continued Page 2 of 2)



Applicable reference:

AWS D1.5 2002 Table 6.8: Specifies indications greater than 1.6mm in length in welds of this size (6mm) are rejectable.

Who discovered the problem: Robert DeArmond

Name of individual from Contractor notified: Luo Lai Quan

Time and method of notification: 9:00_10/24/2010_Verbal

Name of Caltrans Engineer notified: Laraine Woo

Time and method of notification: 13:00_10/25/10_Email

QC Inspector's Name: Liu Fa Wen

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

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 #: xx.25A**QUALITY ASSURANCE -- NON-CONFORMANCE RESOLUTION****Location:** Changxing Island, Shanghai, P.R. China**Report No:** NCS-000827**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Date:** 03-Nov-2010**Submitting Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **NCR #:** ZPMC-0836**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-Oct-2010**Description of Non-Conformance:**

During the Quality Assurance (QA) MT review of welds located on BK004A2-053, this QA Inspector discovered the following issues:

- One longitudinal linear indication measuring approximately 62mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 2740 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.

- One longitudinal linear indication measuring approximately 59mm.
- The weld is identified as: BK004A2-053-018
- The Y location is approximately 3240 MM from the top of the weld as shown on drawing BK004A2.
- The Weld is a Complete Joint Penetration (CJP) splice weld joining the bike path bottom identified as BKPL5A to bike path bottom plate identified as BKPL4B.
- The weld is not SPCM.

-The Notice of Witness Inspection Number (NWIT) is 7081. ZPMC has previously inspected and accepted the weld as indicated by the marking on the steel.

-After this QA discovered the above mentioned indications, ZPMC canceled the NDT notification, stating that they did not complete MT inspection on this weld.

Contractor's proposal to correct the problem:

Contractor will repair the indications. Contractor will provide the the NDT report after repair. Contractor will identify the inspector and monitor his performance. Disciplinary action will be undertaken, if the inspector missed the indication continuously.

